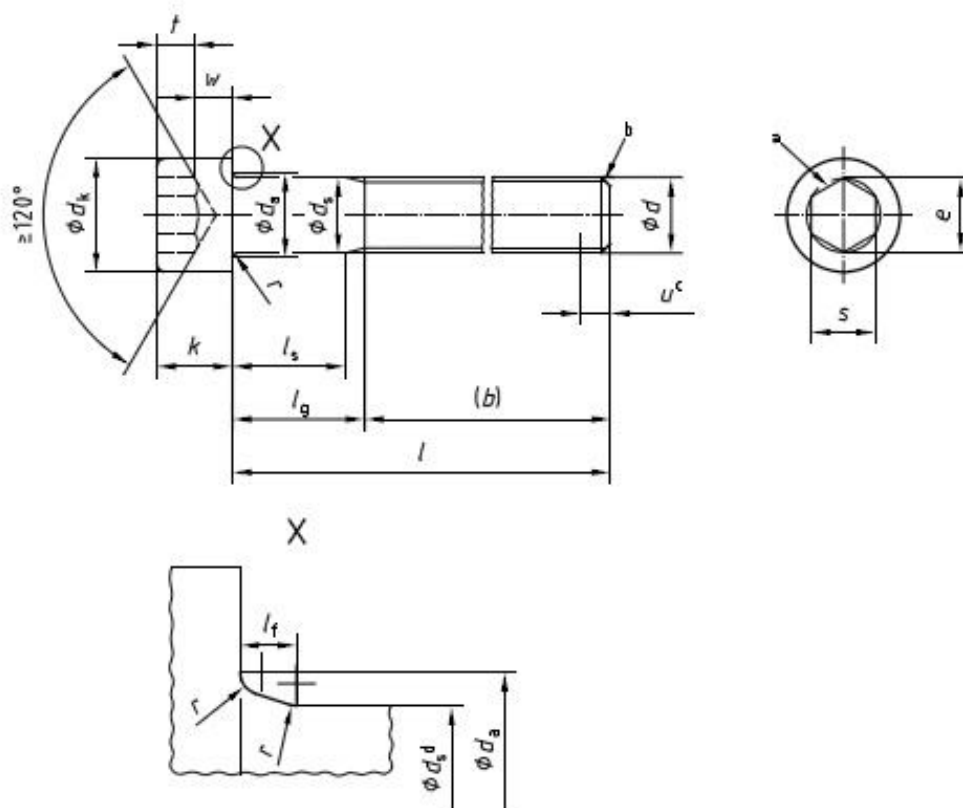


■ DIMENSION

Voir Figure 1 et Tableau 1.

Les symboles et désignations des dimensions sont spécifiés dans l'ISO 225.



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Filetage (d)		M3	M4	M5	M6	M8
P^a		0,5	0,7	0,8	1	1,25
b^b	réf.	18	20	22	24	28
d_k	max. ^c	5,50	7,00	8,50	10,00	13,00
	max. ^d	5,68	7,22	8,72	10,22	13,27
	min.	5,32	6,78	8,28	9,78	12,73
d_a	max.	3,6	4,7	5,7	6,8	9,2
d_s	max.	3,00	4,00	5,00	6,00	8,00
	min.	2,86	3,82	4,82	5,82	7,78
$e^{e, f}$	min.	2,873	3,443	4,583	5,723	6,863
l_f	max	0,51	0,6	0,6	0,68	1,02
k	max.	3,00	4,00	5,00	6,0	8,00
	min.	2,86	3,82	4,82	5,7	7,64
r	min.	0,1	0,2	0,2	0,25	0,4
s^f	nom.	2,5	3	4	5	6
	max.	2,58	3,08	4,095	5,14	6,14
	min.	2,52	3,02	4,020	5,02	6,02
t	min.	1,3	2	2,5	3	4
v	max.	0,3	0,4	0,5	0,6	0,8
d_w	min	5,07	6,53	8,03	9,38	12,33
w	min.	1,15	1,4	1,9	2,3	3,3

l^g			Longueur de tige lisse l_s et longueur de serrage l_g									
nom.	min.	max.	l_s min.	l_g max.	l_s min.	l_g max.	l_s min.	l_g max.	l_s min.	l_g max.	l_s min.	l_g max.
2,5	2,3	2,7										
3	2,8	3,2										
4	3,76	4,24										
5	4,76	5,24										
6	5,76	6,24										
8	7,71	8,29										
10	9,71	10,29										
12	11,65	12,35										

STANDARD PART

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16	15,65	16,35										
20	19,58	20,42										
25	24,58	25,42	4,5	7								
30	29,58	30,42	9,5	12	6,5	10	4	8				
35	34,5	35,5			11,5	15	9	13	6	11		
40	39,5	40,5			16,5	20	14	18	11	16	5,75	12
45	44,5	45,5					19	23	16	21	10,75	17
50	49,5	50,5					24	28	21	26	15,75	22
55	54,4	55,6							26	31	20,75	27
60	59,4	60,6							31	36	25,75	32
65	64,4	65,6									30,75	37
70	69,4	70,6									35,75	42
80	79,4	80,6									45,75	52
90	89,3	90,7										
100	99,3	100,7										
110	109,3	110,7										
120	119,3	120,7										
130	129,2	130,8										
140	139,2	140,8										
150	149,2	150,8										

- MATERIAL : TITANIUM(6Al-4V) IN ACCORDANCE WITH AMS4928 or AMS4967.
- FINISH : PASSIVATE IN ACCORDANCE WITH AMS2487 or AMS2488 AND
SOLID FILM LUBRICANT(MOLYKOTE 106 or EQUIVALENT)

**Caution) Apply solid film except the top of the screw head and
Hexagonal socket**



<SCREW WITH PASSIVATION AND SOLID FILM LUBRICANT>

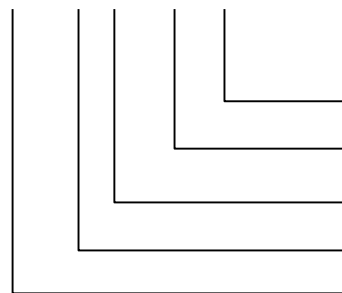
STANDARD PART

- COC REQUIREMENT: CONDUCT VERIFICATION TEST WITH SAMPLES AND SUBMIT ITS TEST REPORT AS SEEN IN THE FOLLOWING EXAMPLE.

Subject	Test	Reference	Requirement	No. of Specimen
Dimensional	Visual Inspection	ECSS-Q-ST-70-46C	Microscope (X 15)	all
	Thread	ECSS-Q-ST-70-46C	Thread Gage	all
	Dimension	ECSS-Q-ST-70-46C	Measurement	all
	Surface Roughness	ECSS-Q-ST-70-46C	Visual Inspection	all
Mechanical	Tensile Test Shear Test	ECSS-Q-ST-70-46C	YS > 950MPa UTS > 1100MPa	3EA per LOT
	Hardness Test	ECSS-Q-ST-70-46C	HrC 33-42	3EA per LOT
Metallurgical	Head Structure /Grain Flow	ECSS-Q-ST-70-46C or ASTM E112	Grain flow have to be continuous (Machining processing have to be avoided)	3EA per LOT
NDI	RT(Radiographic Test) Fluorescent Penetrant	ECSS-Q-ST-70-46C	No micro crack	80EA per LOT
optional	Fatigue test (if possible)	ECSS-Q-ST-70-46C	> 65,000 cycle	3EA per LOT

- PART NUMBER EXAMPLE :

KSP900912 - M 10 x 32 - 5



GRADE

LENGTH IN METRIC

SCREW SIZE

METRIC

BASIC PART NUMBER(DIN 912 or ISO 4762)

KSP900912-M10x32-5 = M10 SCREW, HEXAGON SOCKET HEAD CAP SCREW,
32MM LONG, SOLID FILM LUBRICANT.

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Korea Aerospace Research Institute
GEO-KOMPSAT PROGRAMREV.
NEW**KSP900912**

- IDENTIFICATION : PARTS MUST BE BAGGED AND TAGGED WITH PART NUMBER, MANUFACTURER AND DATE PER KPR12-6-0900.
- NOTES : UNLESS OTHERWISE SPECIFIED,
 1. DIMENSIONS IN METRICS.
 2. APPLY SOLID FILM LUBRICANT IN ACCORDANCE WITH KPR9-0902-5-1 AFTER PASSIVATE IN ACCORDANCE WITH AMS-QQ-P-35.
IF THE PASSIVATED SCREW PROCURED, IT CAN BE APPLIED SOLID FILM LUBRICANT IN ACCORDANCE WITH KPR9-0902-5-1 AFTER CLEANING IN ACCORDANCE WITH KPR2-8-3-1, KPR2-22-35 OR KPR2-22-49.
- ENGINEERING INFORMATION (REFERENCE) : THESE PARTS ARE BASICALLY EQUIVALENT PART WITH DIN 912(ISO 4762) EXCEPT FOR SOLID FILM LUBRICANT.
- PROCUREMENT INFORMATION : PARTS MAY BE PROCURED INITIALLY UNDER DIN NUMBER AND REPROCESSED AS REQUIRED TO COMPLY WITH KSP CODING, OR MAY BE PROCURED AS COMPLETELY FINISHED KSP PARTS.

STANDARD PART**KSP900912**

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GEO-KOMPSAT PROGRAM

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< Number of Procurement Unit>

L/I	Dimension	Number of Units
1	M3x12	100
2	M4x8	50
3	M4x10	1650
4	M4x12	200
5	M4x14	300
6	M4x16	100
7	M4x20	200
8	M4x26	100
9	M4x28	50
10	M4x32	50
11	M4x44	100
12	M5x10	100
13	M5x12	50
14	M5x14	170
15	M5x16	70
16	M5x18	115
17	M5x20	70
18	M5x22	450
19	M5x24	330
20	M5x26	70
21	M5x28	20
22	M5x42	130
23	M5x50	50
24	M6x14	160
25	M6x16	70
26	M6x18	120
27	M6x20	270

28	M6x22	250
29	M6x24	20
30	M6x26	40
31	M6x28	110
32	M6x30	550
33	M6x40	50
34	M6x46	350
35	M6x50	290
36	M6x52	50
37	M6x54	25
38	M6x60	25
39	M6x62	104
40	M8x14	35
41	M8x24	75
42	M8x26	70
43	M8x28	90
44	M8x30	60
45	M8x32	80
46	M8x34	20
47	M8x36	20
48	M8x40	20
49	M8x46	120
50	M8x52	120
51	M8x56	20
52	M8x60	50
53	M10x32	25
54	M10x56	25
55	M10x60	50
56	M12x60	50
sum		7939