


southco

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SOUTHCO No. 47 CAPTIVE FASTENER
1/4-20 THREAD, FLARE-IN STYLE

DATE	DRAWN	CHKD	SCALE	DRAWING NUMBER
5/23/91	JAD		2 : 1	J-47-1-120

REV.	DATE	DRAWN	REVISION	PART NUMBER	SCREW PROJECTION			PANEL THICKNESS		"B"	"L"	DIMENSIONS IN INCHES DIMENSIONS WITHOUT TOLERANCES ARE FOR REFERENCE ONLY
A	15JUN93	MPF	PRN: 47-136		*P1*	*P2*	*T*	A, MIN	A, MAX			
B	12APR93	ALC	PRN: S-1-03	47-10-6X2-YZ	.05	.31	.81	.058	.125	.015	.070	 THIRD ANGLE PROJECTION A3 PAPER SIZE
C	25APR96	KGS	PRN: 47-213	47-10-6X4-YZ	.11	.37	.87	.126	.187	.062	.135	
D	30JUN99	RJB	PRN: 47-447	47-10-6X6-YZ	.17	.43	.93	.188	.250	.125	.197	
E	27AUG2001	RJB	PRN: P2001-0454	47-10-6X8-YZ	.24	.50	1.00	.251	.312	.187	.260	
F	25APR2002	JPA/DLH	PRN: P2002-0237	47-11-6X2-YZ	.11	.37	.87					
				47-12-6X2-YZ	.17	.43	.93	.058	.125	.015	.070	
				47-13-6X2-YZ	.24	.50	1.00					
				47-11-6X4-YZ	.17	.43	.93	.126	.187	.062	.135	
				47-12-6X4-YZ	.24	.50	1.00	.188	.250	.125	.197	
				47-11-6X6-YZ	.24	.50	1.00					

MATERIAL AND FINISH
 KNOB: 6000 SERIES ALUMINUM, NATURAL.
 SCREW: FOR SLOTTED, AND PHILLIPS;
 400 SERIES STAINLESS STEEL, PASSIVATED
 FOR TORX® TORX®/SLOT COMBINATION
 AND PHILLIPS/SLOT COMBINATION:
 HARDENED CARBON STEEL, ZINC PLATE,
 CHROMATE PLUS SEALER.
 (NOTE: KNOB AND TOP OF SCREW AVAILABLE WITH
 POWDER COATING; SEE PART NUMBER TABLE).
 FERRULE: 6000 SERIES ALUMINUM, NATURAL.
 SPRING: 300 SERIES STAINLESS STEEL; PASSIVATED.

TORX® IS A REGISTERED TRADEMARK OF THE CAMCAR DIVISION OF TEXTRON, INC.

"X" SCREW RECESS

"Y" FINISH ON KNOB & SCREW HEAD

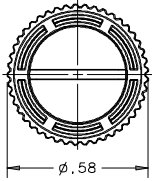
"Z" KNOB

- 0- SLOTTED
- 2- No.2 PHILLIPS
- 4- T30 TORX®
- 6- T30 TORX®/SLOT
- 8- No.2 PHILLIPS SLOT

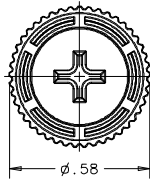
- 1- BRIGHT
- 4- CUSTOM COLOR, SEE J-47-0-3 FOR ADDITIONAL SUFFIX.
- 5- BLACK POWDER COATED

- 0- KNURLED
- 1- SMOOTH

KNURLED KNOBS



SLOTTED
WIDTH=.06
DEPTH=.06
LENGTH=.40



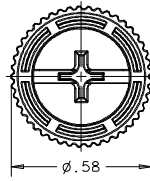
No. 2
PHILLIPS RECESS



T30 .09 DEEP
TORX® RECESS

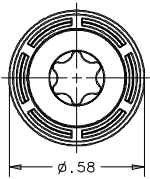
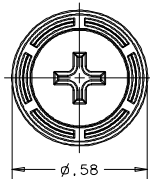
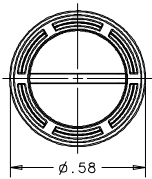


T30 TORX®/SLOT
DEPTH=.09
SLOT WIDTH=.07
SLOT DEPTH=.08
SLOT LENGTH=.36



PHILLIPS/SLOT RECESS
No. 2 PHILLIPS
SLOT WIDTH=.06
SLOT DEPTH=.06
SLOT LENGTH=.40

SMOOTH KNOBS

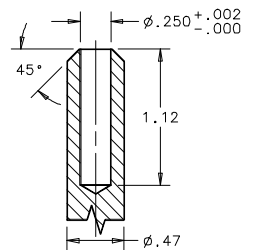


NOTE: KNOB AND SCREW ARE SPRING LOADED OUTWARD, AS SHOWN BELOW.

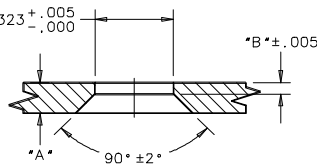
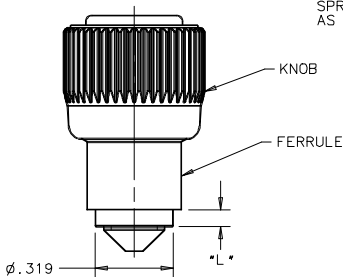
TO INSTALL FASTENER

1. DRILL, THEN COUNTERSINK ACCORDING TO THE REQUIRED "B" DIMENSION.
2. INSTALL TOOL PART No. 47-125 IN SUITABLE PRESS. ONLY LIGHT PRESSURE WILL BE REQUIRED.
3. INSERT SCREW ASSEMBLY INTO PREPARED HOLE IN PANEL.
4. PLACE WORK UNDER PRESS, CENTER TOOL OVER SCREW THREAD AND FLARE FERRULE INTO COUNTERSINK IN PANEL. USE LIGHT PRESSURE.

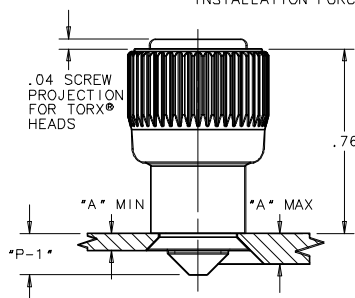
INSTALLATION FORCE: 350 lbs. TO 550 lbs.
INSTALLATION FORCE DEPENDS ON THREAD SIZE.



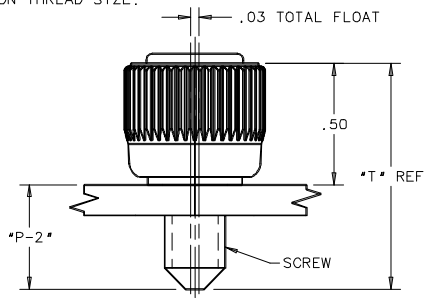
FLARE INSTALLATION TOOL GEOMETRY
SCALE 1:1



PANEL PREPARATION



UNFASTENED



FASTENED