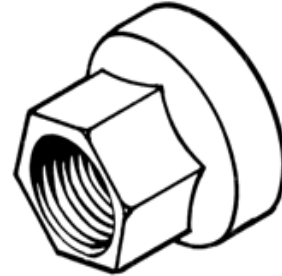


# **K-FAST™**

## **self-locking nuts**



### **low-cost and 1-man installation**

K-Fast™ nuts, as part of an overall system, provide the airframe industry with high-speed efficiency and cost effectiveness in production. Low-cost and 1-man installation as well as self-locking features combine with extended fatigue life and optimum strength/weight ratios to make the K-Fast an economic choice. Tamper-proof and interchangeable with all approved aerospace fastener systems, K-Fast nuts can be retorqued after sealant setting.

Manufactured under license by Kaynar, a Microdot Company

# **K-FAST™**

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## TECHNICAL INFORMATION

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### MATERIAL SELECTION

Alloy Steel, A-286, 17-4 PH, 305 Stainless Steel,  
7075 Aluminum Alloy

### PLATING AND FINISHES

Cadmium plate, Silver Plate, Anodize

### DIAMETERS

#6 through 5/8"

### TEMPERATURE RANGE

K-Fast Locknuts are compatible with every material  
and fuel ranging from — 423°F to 850°F

### LUBRICATION

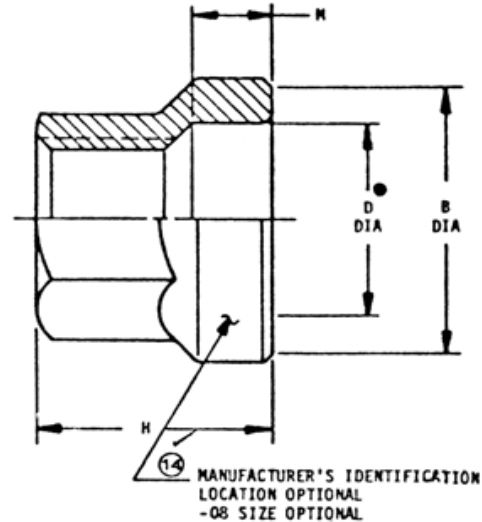
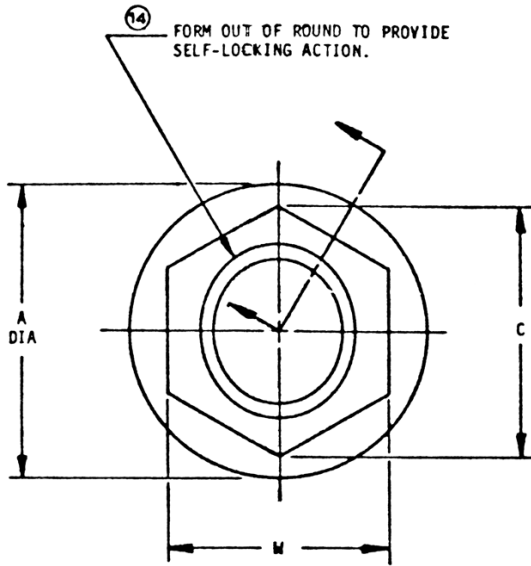
Molybdenum Disulphide and other dry film and non-dry film  
lubricants are used to prevent galling and seizure

Additional technical information, standards  
pages, and tooling data are available from  
the Voi-Shan sales service staff.

# K-FAST® SYSTEMS ENGINEERING COMMITTEE

K-FAST IS REGISTERED TRADE MARK OF  
KAYNAR, A MICRODOT COMPANY  
LICENSEES:  
DEUTSCH FASTENER CORPORATION  
VOI-SHAN/A DIVISION OF VSI CORP.

SPS TECHNOLOGIES INCORPORATED



(14)

KAYLOCK PART NO	THREADS PER MIL-S-8879	A	B	C	D	H	M	W	Y	AXIAL TENSILE STRENGTH LBS MIN	REC'M SEATING TORQUE IN-LBS	APPROX WEIGHT LBS/100	
		MAX	MIN	MIN		MAX							
KFN305-	08	.1640-32UNJC-3B	.290	.273	.242	.202 .198	.270	.112 .102	.220 .212	.005	2,300	30-40	.15
	3	.1900-32UNJF-3B	.330	.295	.277	.228 .224	.280	.112 .102	.251 .243	.005	2,750	40-50	.21
	4	.2500-28UNJF-3B	.425	.398	.348	.288 .284	.340	.117 .107	.313 .305	.005	5,000	110-130	.41
	5	.3125-24UNJF-3B	.525	.497	.419	.350 .346	.430	.127 .117	.376 .367	.005	8,300	200-250	.68
	6	.3750-24UNJF-3B	.605	.577	.491	.413 .409	.470	.127 .117	.439 .430	.006	11,900	360-420	.96
	7	.4375-20UNJF-3B	.725	.677	.561	.476 .472	.565	.142 .132	.502 .492	.006	19,000	600-675	1.52
	8	.5000-20UNJF-3B	.825	.777	.631	.538 .534	.615	.142 .132	.564 .553	.006	25,500	900-1000	2.13
	9	.5625-18UNJF-3B	.902	.862	.702	.601 .597	.661	.142 .132	.627 .616	.008	29,000	1075-1150	2.90
	10	.6250-18UNJF-3B	1.043	1.003	.843	.663 .659	.726	.142 .132	.752 .741	.008	32,000	1400-1550	5.27

14 J.I.  
4-24-85

REVISION

APPROVAL DATE

K.E.C. K-FAST® ENGINEERING COMMITTEE 800 SOUTH STATE COLLEGE BLVD. FULLERTON, CALIFORNIA 92631	TITLE  NUT - K-FAST, 6 POINT DEEP C'BORE, 160 KSI	PART NUMBER  KFN305-(*)
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# K-FAST® SYSTEMS ENGINEERING COMMITTEE

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KAYNAR, A MICRODOT COMPANY  
LICENSEES:  
DEUTSCH FASTENER CORPORATION  
VOI-SHAN/A DIVISION OF VSI CORP.  
⑫ SPS TECHNOLOGIES INCORPORATED

**MATERIAL:** 304 CORROSION RESISTANT STEEL PER AMS 5697A, OR AMS 5639, OR  
305 CORROSION RESISTANT STEEL PER AMS 5686.

**FINISH:** KFN305C(\*) — CADMIUM PLATED PER FED. SPEC. QQ-P-416, TYPE II, CLASS 3, AND  
CETYL ALCOHOL LUBRICANT.  
KFN305CD(\*) — CADMIUM PLATED PER FED. SPEC. QQ-P-416, TYPE II, CLASS 2, AND  
KAYLUBE MOLYBDENUM DISULFIDE DRY LUBRICANT COATED PER MIL-L-8937 OR  
MIL-L-46010.  
KFN305DL(\*) — KAYLUBE MOLYBDENUM DISULFIDE DRY LUBRICANT COATED PER MIL-L-8937, OR  
MIL-L-46010.  
KFN305E(\*) — SILVER PLATED PER AMS 2410, AND CETYL ALCOHOL LUBRICANT.  
KFN305J(\*) — SILVER PLATED PER AMS 2410.  
KFN305PK(\*) — CADMIUM PLATED PER FED. SPEC. QQ-P-416, TYPE II, CLASS 2, OLIVE COLOR,  
AND CETYL ALCOHOL LUBRICANT.

**PERFORMANCE:** LOCKING TORQUE PER MIL-N-25027, EXCEPT AS FOLLOWS:  
A) REUSABILITY 5 CYCLES REQUIRED.  
B) AXIAL TENSILE STRENGTH OBTAINED WHEN TESTED ON 180 KSI MIN BOLTS.

⑫ **TEMPERATURE:** "C", "CD", "DL", "K", AND "PK" CODES — 450°F MAX.  
"E", AND "J" CODES — 750° MAX.

**APPLICATION:** FOR USE ON STANDARD TO .032 OVERSIZE SHANK BOLTS.

**PACKAGING:** PARTS ARE NORMALLY SUPPLIED IN BULK PACKAGING.  
ADD "S" AFTER DASH NUMBER FOR SPINDLE PACKAGED NUTS FOR USE WITH STANDARD K-FAST  
AUTOMATIC TOOLS, OR "SS" FOR PARTS PACKAGED ON "SHORT SPINDLES" FOR USE ON  
LIGHTWEIGHT K-FAST AUTOMATIC TOOLS.  
EXAMPLE OF PART NO.: KFN305C4S OR KFN305C4SS  
SPINDLE PACKAGED PARTS APPLY THRU -5 NUTS ONLY.

**NOTES:** 1. "D" DIAMETER CONCENTRIC TO THREAD PITCH DIAMETER WITHIN "Y" TIR VALUES.

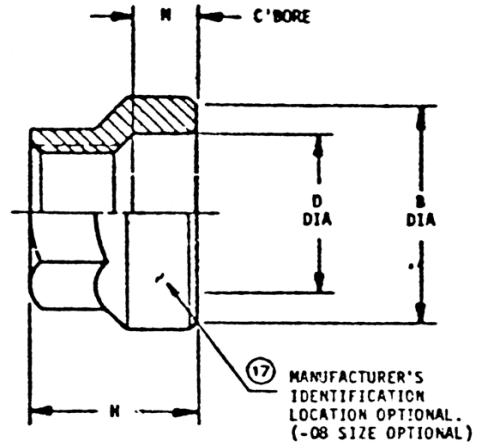
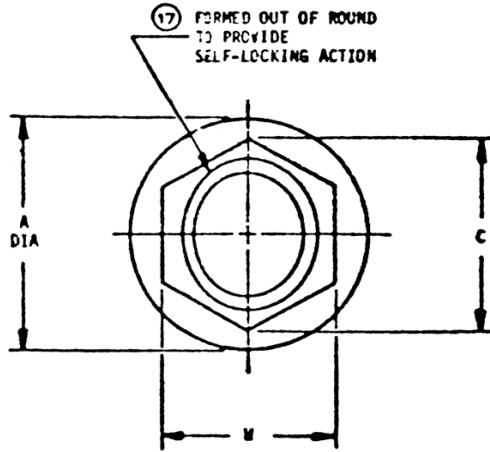
⑫ BLE 04-07-83  
 ⑪ BLE 05-26-82  
 ⑩ BLE 11-16-81  
 ⑨ REDRAWN BLE 06-02-80  
 REVISION  
 APPROVAL DATE

K.E.C. K-FAST® ENGINEERING COMMITTEE 800 SOUTH STATE COLLEGE BLVD. FULLERTON, CALIFORNIA 92631	TITLE  NUT - K-FAST, 6 POINT DEEP C'BORE, 160 KSI	PART NUMBER  KFN305-(*)
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# K-FAST® SYSTEMS ENGINEERING COMMITTEE

K-FAST IS A REGISTERED TRADEMARK OF  
KAYNAR, A MICRODOT COMPANY

⑰ LICENSEES:  
DEUTSCH FASTENER CORPORATION  
VOI-SHAN / A DIVISION OF VSI CORP.  
SPS TECHNOLOGIES INCORPORATED  
SIMMONDS S.A., FRANCE



K-FAST PART NO	THREADS PER MIL-S-8879	A		B		C		D		H	M		W		APPROX WEIGHT LBS/100
		MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN		MAX	MIN			
KFN541L	08F	.1640-32UNJF-3B	.290	.273	.242	.202	.197	.235	.112	.102	.220	.212	.15		
	3F	.1900-32UNJF-3B	.330	.300	.277	.228	.223	.245	.112	.102	.251	.243	.21		
	4F	.2500-28UNJF-3B	.425	.400	.348	.288	.283	.295	.117	.107	.313	.305	.41		
	5F	.3125-24UNJF-3B	.525	.497	.419	.350	.345	.355	.127	.117	.376	.367	.68		
	6F	.3750-24UNJF-3B	.605	.577	.491	.413	.408	.406	.127	.117	.439	.420	.96		
	7F	.4375-20UNJF-3B	.705	.677	.561	.476	.471	.455	.142	.132	.502	.492	1.52		
	8F	.5000-20UNJF-3B	.806	.777	.631	.538	.533	.525	.142	.132	.564	.553	2.13		

MATERIAL: ALLOY STEEL.  
 HEAT TREAT: Rc. 39-43.  
 FINISH: CADMIUM PLATED PER FED. SPEC. QQ-P-416, TYPE II, CLASS 3, AND KAYLUBE MOLYBDENUM DISULFIDE DRY LUBRICANT COATED.  
 PERFORMANCE: KFS 1009.  
 APPLICATION: FOR USE ON STANDARD TO .032 OVERSIZE SHANK BOLTS.  
 PACKAGING: PARTS ARE NORMALLY SUPPLIED IN BULK PACKAGING. ADD "S" AFTER DASH NUMBER FOR SPINDLE PACKAGED NUTS FOR USE WITH K-FAST AUTOMATIC TOOLS. EXAMPLE: KFN541L3FS.

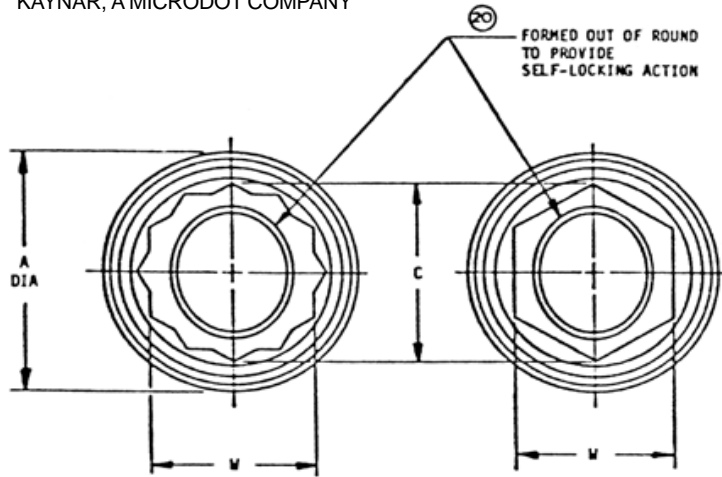
K.E.C. K-FAST® ENGINEERING COMMITTEE 800 SOUTH STATE COLLEGE BLVD. FULLERTON, CALIFORNIA 92631	TITLE NUT - 6 POINT, SELF-LOCKING, 160 KSI, 450°F	PART NUMBER KFN541L(*)F
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APPROVAL DATE  
 REVISION ⑰ REDRAWN ⑰  
 BLe 11-15-82 BLe 11-26-84

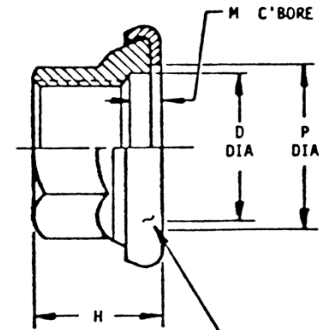
# K-FAST® SYSTEMS ENGINEERING COMMITTEE

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KAYNAR, A MICRODOT COMPANY

LICENSEES:  
DEUTSCH FASTENER CORPORATION  
VOI-SHAN / A DIVISION OF VSI CORP.  
SPS TECHNOLOGIES INCORPORATED  
SIMMONDS S.A., FRANCE



-9 THRU -1612 CONFG.



K-FAST PART NO	THREADS PER MIL-S-8879	A	C	D	H	M	P	W	AXIAL TENSILE STRENGTH LBS MIN	APPROX WEIGHT LBS/100	
		MAX	MIN		MAX		MAX				
KFN542-	06	.1380-32UNJC-3B	.320	.207	.176 .171	.200	.097 .087	.181	.189 .181	1,670	.10
	05▲	.1640-36UNJF-3B	.340	.242	.202 .197	.220	.097 .087	.207	.220 .212	2,800	.17
	08	.1640-32UNJC-3B	.340	.242	.202 .197	.240	.097 .087	.207	.220 .212	2,800	.17
	3	.1900-32UNJF-3B	.363	.277	.228 .223	.243	.097 .087	.233	.251 .243	3,470	.24
	4	.2500-28UNJF-3B	.460	.348	.288 .283	.280	.097 .087	.293	.313 .306	6,200	.47
	5	.3125-24UNJF-3B	.560	.419	.352 .347	.340	.097 .087	.357	.376 .367	9,800	.78
	6	.3750-24UNJF-3B	.660	.491	.417 .412	.355	.097 .087	.422	.439 .430	13,000	.93
	7	.4375-20UNJF-3B	.760	.561	.484 .479	.400	.097 .087	.489	.502 .492	18,000	1.44
	8	.5000-20UNJF-3B	.860	.631	.551 .546	.430	.097 .087	.556	.564 .553	24,000	1.94
	9	.5625-18UNJF-3B	1.005	.700	.640 .635	.530	.115 .105	.645	.627 .616	33,000	3.08
	10	.6250-18UNJF-3B	1.100	.846	.710 .705	.575	.115 .105	.715	.752 .741	43,000	5.00
	12	.7500-16UNJF-3B	1.310	.987	.845 .840	.670	.125 .115	.850	.877 .865	61,000	7.88
	14	.8750-14UNJF-3B	1.480	1.130	.985 .980	.770	.145 .135	.990	1.002 .990	73,900	11.45
	1612	1.0000-12UNJF-3B	1.690	1.271	1.125 1.120	.870	.165 .155	1.130	1.127 1.115	85,700	16.00

BLE  
07-15-85

(20)

REDRAWN

(19)

REVISION

03-31-83

APPROVAL DATE

K.E.C.  
K-FAST® ENGINEERING COMMITTEE  
800 SOUTH STATE COLLEGE BLVD.  
FULLERTON, CALIFORNIA 92631

TITLE  
6 POINT, CAPTIVE WASHER

PART NUMBER  
KFN542 - (\*)

# K-FAST® SYSTEMS ENGINEERING COMMITTEE

MATERIAL: NUT --- ALLOY STEEL PER MIL-S-6049 (8740) , MIL-S-5000 (4340), OR MIL-S-5626 (4140).  
WASHER --- CARBON STEEL.

HEAT TREAT: NUT --- Rc. 39 - 43 PER MIL-H-6875.  
WASHER --- Rc. 40 - 45.

FINISH: KFN542 - (\*) --- NUT AND WASHER --- CADMIUM PLATED PER FED. SPEC. QQ-P-416, TYPE II, CLASS 2. (SEE NOTE 1 FOR FINISH ON -.05 SIZE).  
KFN542 - (\*)CD - NUT AND WASHER --- CADMIUM PLATED PER FED. SPEC. QQ-P-416, TYPE II, CLASS 2, AND KAYLUBE MOLYBDENUM DISULFIDE DRY FILM LUBRICANT COATED PER MIL-L-8937.

② PERFORMANCE: KFS 1009, EXCEPT AXIAL TENSILE AS NOTED.

TEMPERATURE: 450°F MAX.

PACKAGING: ADD "S" AFTER DASH NUMBER FOR SPINDLE PACKAGED NUTS FOR USE WITH K-FAST AUTOMATIC TOOL (-.05 THRU. -.5 SIZES ONLY).  
EXAMPLE: KFN542-45.

NOTES: ▲ 1. -.05 SIZE FINISH: CADMIUM PLATED PER FED. SPEC. QQ-P-416, TYPE II, CLASS 2, PLUS OLIVE DRAB CHROMATE FINISH FOR IDENTIFICATION PURPOSES.  
2. "C" AND "W" DIMENSIONS APPLY BEFORE FORMING SELF-LOCKING ACTION.

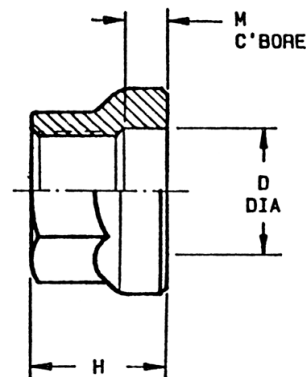
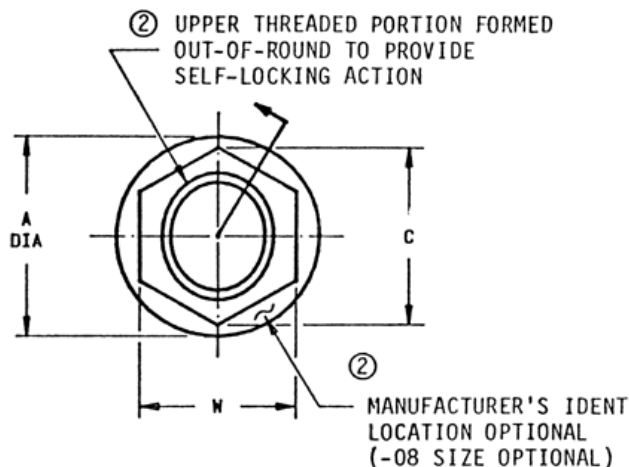
APPROVAL DATE  
 REVISION 19  
 REDRAWN 20  
 BLE 07-15-85  
 03-31-83

K.E.C. K-FAST® ENGINEERING COMMITTEE 800 SOUTH STATE COLLEGE BLVD. FULLERTON, CALIFORNIA 92631	TITLE  NUT - 6 POINT, CAPTIVE WASHER	PART NUMBER  KFN542 - (*)
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# K-FAST® SYSTEMS ENGINEERING COMMITTEE

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LICENSEES:  
DEUTSCH FASTENER CORPORATION  
VIO-SHAN / A DIVISION OF VSI CORP.  
SPS TECHNOLOGIES INCORPORATED  
SIMMONDS S. A., FRANCE



KAYLOCK PART NO	THREADS PER MIL-S-8879	A	C	D	H	M	W	AXIAL TENSILE STRENGTH LBS MIN	REC'M SEATING TORQUE IN-LBS
			MIN		MAX				
KFN587-	08	.1640-32UNJC-3B .292 .288	.242	.173 .169	.230	.092 .082	.220 .212	1,400	15.25
	3	.1900-32UNJF-3B .307 .303	.277	.200 .198	.240	.092 .082	.251 .243	1,800	25-35
	4	.2500-28UNJF-3B .412 .408	.348	.261 .257	.280	.097 .087	.313 .305	3,000	60-80
	5	.3125-24UNJF-3B .518 .512	.419	.325 .319	.325	.102 .092	.376 .367	5,000	110-140
	6	.3750-24UNJF-3B .628 .622	.491	.388 .382	.365	.102 .092	.439 .430	7,000	180-200
	7	.4375-20UNJF-3B .713 .707	.561	.450 .444	.415	.107 .097	.502 .492	9,500	220-280
	8	.5000-20UNJF-3B .815 .809	.631	.513 .507	.445	.107 .097	.564 .553	12,500	340-410

MATERIAL: 7075 ALUMINUM ALLOY PER QQ-A-225/9.

HEAT TREAT: AGE TO T73 CONDITION PER MIL-H-6088.

FINISH: ANODIZED PER MIL-A-8625, TYPE II, CLASS 2, DYE COLOR ORANGE.  
AND CETYL ALCOHOL PER MIL-L-87132, TYPE I, GRADE A.

② PERFORMANCE: KFS1008, EXCEPT REC'M SEATING TORQUE AS TABULATED AND ONE CYCLE USE.

② NOTES: 1. PARTS ARE NORMALLY SUPPLIED IN BULK PACKAGING, ADD "S" FOR SPINDLE  
PACKAGED NUTS FOR USE WITH K-FAST AUTOMATIC TOOLS.  
(EXAMPLE: KFN587-5S).

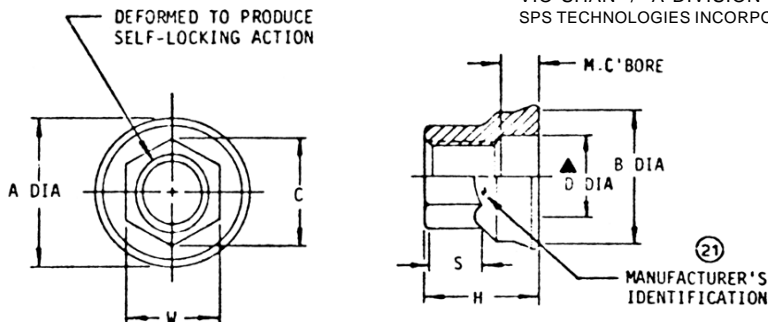
K.E.C. K-FAST® ENGINEERING COMMITTEE 800 SOUTH STATE COLLEGE BLVD. FULLERTON, CALIFORNIA 92631	TITLE NUT - 6 POINT, SELF-LOCKING SHEAR APPLICATION	PART NUMBER KFN587 - (*)
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APPROVAL DATE 10-19-83  
BLe REVISION ① 2-13-84  
BLe Kirk VW ② 8-6-85



# K-FAST® SYSTEMS ENGINEERING COMMITTEE

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DEUTSCH FASTENER CORPORATION  
VIO-SHAN / A DIVISION OF VSI CORP.  
SPS TECHNOLOGIES INCORPORATED



PART NO.	THREADS PER MIL-S-8879	A	B	C	D	H	M	S	W	AXIAL TENSILE STRENGTH LBS MIN	REC'M SEATING TORQUE IN-LBS	MAX LOCKING TORQUE IN-LBS	APPROX WEIGHT LBS/100
		MIN	MIN		MAX		MIN	MIN					
KFN600-	08	.292 .288	.273	.242	.202 .198	.270	.112 .102	.060	.220 .212	1,400	15-25	7	.07
	3	.322 .318	.295	.277	.228 .224	.280	.112 .102	.070	.251 .243	1,600	25-35	12	.09
	4	.422 .418	.398	.348	.288 .284	.340	.117 .107	.090	.313 .305	3,000	60,80	17	.18
	5	.538 .532	.497	.419	.350 .346	.430	.127 .117	.160	.376 .367	5,000	130-160	35	.33
	6	.649 .642	.577	.491	.413 .409	.470	.127 .117	.180	.439 .430	7,000	200-240	40	.55
	7	.740 .730	.677	.561	.476 .472	.565	.142 .132	.220	.502 .492	9,500	270-330	60	.75
	8	.860 .850	.777	.631	.538 .534	.615	.142 .132	.260	.564 .553	12,500	370-430	85	1.05

MATERIAL: 7075 ALUMINUM ALLOY PER QQ-A-225/9 OR 7175 ALUMINUM ALLOY PER QQ-A-430. HEAT TREATED - T73 CONDITION.

FINISH:  
 KFN600 - (\*) -- ANODIZED PER MIL-A-8625, DYE RED COLOR, AND CETYL ALCOHOL LUBRICANT.  
 KFN600B(\*) -- ANODIZED PER MIL-A-8625, DYE BLUE COLOR, AND CETYL ALCOHOL. (FOR OVERSIZE PINS).  
 KFN600D(\*) -- ANODIZED PER MIL-A-8625, DYE BROWN COLOR, AND CETYL ALCOHOL. (FOR ALUMINUM PINS).  
 KFN600F(\*) -- ANODIZED PER MIL-A-8625, AND SOLID FILM LUBRICANT PER MIL-L-8937.  
 KFN600N(\*) -- ANODIZED PER MIL-A-8625, AND SOLID FILM LUBRICANT PER LUBECO 905.

21 PERFORMANCE: MIL-N-25027, EXCEPT AS NOTED. MAXIMUM LOCKING AND MINIMUM BREAKAWAY TESTS SHALL BE LIMITED TO THREE SEATED INSTALLATION AND REMOVAL CYCLES, USING CADMIUM PLATED ALLOY STEEL BOLTS WITH THREADS CONFORMING TO BPS-F-67 AND BACB30FM.  
 BREAKAWAY TORQUE TEST TO BE PERFORMED AFTER THE NUT HAS BEEN INSTALLED TO INSTALLATION TORQUE (SEATING TORQUE) BY THE NORMAL FACTORY INSTALLATION METHOD AND THE PRELOAD REMOVED FROM THE NUT WITHOUT NUT ROTATION. THREAD PROTRUSION DURING THE BREAKAWAY TORQUE TEST SHALL BE A MINIMUM OF ONE THREAD. THE NUT SHALL BE SEATED TO INSTALLATION TORQUE ON ALL THREE CYCLES.

APPLICATION: FOR USE ON STANDARD TO. 032 OVERSIZE SHANK BOLTS.

PACKAGING: PARTS ARE NORMALLY SUPPLIED IN BULK PACKAGING.  
 ADD "S" AFTER DASH NUMBER FOR SPINDLE PACKAGED NUTS FOR USE WITH K-FAST AUTOMATIC TOOLS.  
 EXAMPLE: KFN600 - 35.

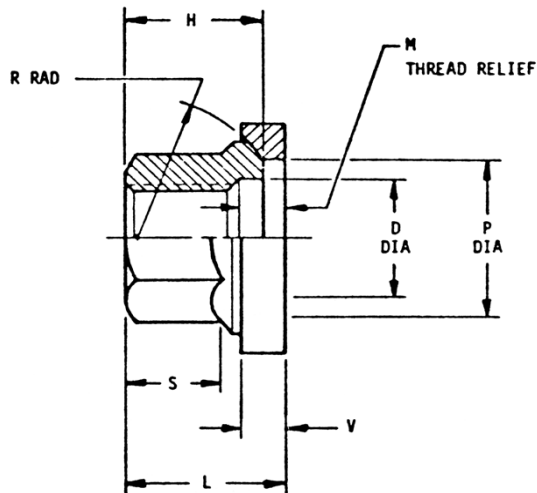
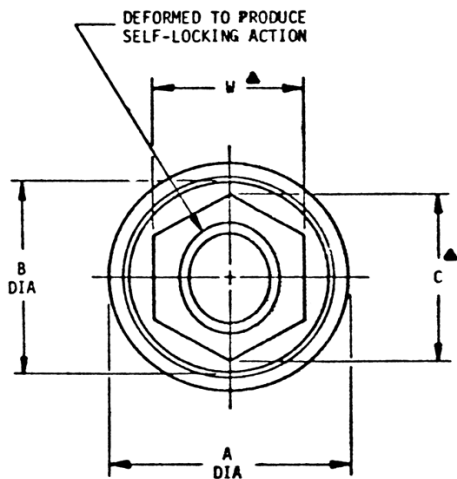
NOTES:  
 ▲ 1. "D" DIAMETER CONCENTRIC TO THREAD PITCH DIAMETER WITHIN .005 TIR FOR -5 AND SMALLER SIZES, AND .006 TIR FOR LARGER SIZES.  
 2. H600 AND KFN600 ARE DIMENSIONALLY AND FUNCTIONALLY INTERCHANGEABLE.

K.E.C. K-FAST® ENGINEERING COMMITTEE 800 SOUTH STATE COLLEGE BLVD. FULLERTON, CALIFORNIA 92631	TITLE NUT - K-FAST, 6 POINT, SHEAR PIN	PART NUMBER KFN600 - (*)
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APPROVAL DATE  
 REVISION (19) REDRAWN (20) BLE 05-25-82 (21) BLE 1-13-84

# K-FAST® SYSTEMS ENGINEERING COMMITTEE

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LICENSEES:  
DEUTSCH FASTENER CORPORATION  
VIO-SHAN / A DIVISION OF VSI CORP.  
SPS TECHNOLOGIES INCORPORATED



K-FAST PART NO	THREADS PER MIL-S-8879	A	B	C	D	H	L	M	P	R	S	V	W	AXIAL TENSILE STRENGTH LBS MIN	LOCKING TORQUE IN. LB MAX
		MIN	MAX	MAX	MIN	REF	MIN	MIN	REF	MIN	MIN	MIN	MIN		
KFN624-	06	.1380-32UNJC-3B	.315 .305	.265 .260	.207	.155 .147	.175	.204	.200	.174 .169	.060	.065 .055	.189 .181	1,200	5
	08	.1640-32UNJC-3B	.335 .325	.292 .288	.242	.180 .173	.180	.224	.235	.174 .169	.060	.095 .085	.220 .212	1,650	8
	3	.1900-32UNJF-3B	.385 .375	.322 .318	.277	.228 .224	.180	.234	.261	.195 .190	.070	.095 .085	.251 .243	1,900	9
	4	.2500-28UNJF-3B	.515 .505	.422 .418	.348	.288 .284	.225	.289	.351	.255 .250	.090	.110 .100	.313 .305	3,400	15
	5	.3125-24UNJF-3B	.660 .650	.538 .532	.419	ÑÑ	.285	.369	.436	.380 .375	.160	.130 .120	.376 .367	5,500	30
	6	.3750-24UNJF-3B	.710 .700	.649 .642	.491	ÑÑ	.325	.409	.534	.440 .435	.180	.142 .132	.439 .430	7,500	40
	7	.4375-20UNJF-3B	.893 .883	.740 .730	.561	ÑÑ	.400	.489	.595	.501 .496	.220	.155 .145	.502 .492	.10,500	50
	8	.5000-20UNJF-3B	1.005 .995	.860 .850	.631	ÑÑ	.460	.539	.663	.561 .556	.260	.175 .165	.564 .553	13,500	75

BLE 03-30-83

REVISION 2

REDRAWN 03-24-83

REVISION 1

APPROVAL DATE

K.E.C. K-FAST® ENGINEERING COMMITTEE 800 SOUTH STATE COLLEGE BLVD. FULLERTON, CALIFORNIA 92631	TITLE NUT - 6 POINT, SELF-ALIGNING	PART NUMBER KFN624 - (*)
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# K-FAST® SYSTEMS ENGINEERING COMMITTEE

K-FAST IS A REGISTERED TRADE MARK OF  
KAYNAR, A MICRODOT COMPANY  
LICENSEES:  
DEUTSCH FASTENER CORPORATION  
VIO-SHAN / A DIVISION OF VSI CORP.  
SPS TECHNOLOGIES INCORPORATED

**MATERIAL:** NUT --- 7075 ALUMINUM ALLOY PER QQ-A-225/9.  
WASHER --- ALLOY STEEL 8740 PER MIL-S-6049, OR 4340 PER MIL-A-5000.

**HEAT TREAT:** NUT --- T73 CONDITION PER MIL-H-6088  
WASHER --- Rc. 38 - 44 PER MIL-H-6875.

**FINISH:** NUT --- ANODIZE PER MIL-A-8625, TYPE II, CLASS 1, NATURAL COLOR, PLUS  
CETYL ALCOHOL LUBRICANT PER MIL-L-87132, TYPE I, GRADE A.  
② WASHER --- CADMIUM PLATE PER FED. SPEC. QQ-P-416, TYPE II, CLASS 2, PLUS  
CETYL ALCOHOL LUBRICANT PER MIL-L-87132, TYPE I, GRADE A.

**PERFORMANCE:** MIL-N-25027, EXCEPT AS FOLLOWS:  
A) AXIAL TENSILE STRENGTH AND MAXIMUM LOCKING TORQUE AS TABULATED.  
B) REUSABILITY LIMITED TO 5 CYCLES.

② **MISALIGNMENT:** UP TO 7° IN ANY DIRECTION FROM CENTERED POSITION.

**PACKAGING:** PARTS ARE NORMALLY SUPPLIED IN BULK PACKAGING.  
ADD "5" AFTER DASH NUMBER FOR SPINDLE PACKAGED NUTS FOR USE WITH K-FAST  
AUTOMATIC TOOLS. EXAMPLE: KFN624 - 4S.

**NOTES:** ▲ 1. "C" AND "W" DIMENSIONS APPLY BEFORE FORMING SELF-LOCKING ACTION.  
2. PARTS ARE SUPPLIED IN ASSEMBLE (BONDED) CONDITION.  
TO ORDER INDIVIDUALLY, AD "N" FOR NUT ONLY OR ADD "B" FOR WASHER ONLY.  
EXAMPLE: KFN624N4 OR KFN624B4.

APPROVAL DATE **BLE** 03-08-83  
 REVISION ① **BLE** 03-24-83  
 ② **BLE** 03-30-83

K.E.C. K-FAST® ENGINEERING COMMITTEE 800 SOUTH STATE COLLEGE BLVD. FULLERTON, CALIFORNIA 92631	<b>TITLE</b>  NUT - 6 POINT, SELF-ALIGNING	<b>PART NUMBER</b>  KFN624 - (*)
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