



#4-40 UNC-2B
INSTALL HELI-COIL INSERT
THIS SIDE AS SHOWN.
6X

#6-32 UNC-2B
INSTALL HELI-COIL INSERT
THIS SIDE AS SHOWN.
8X

- NOTES:
1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE, SULPHUR-BASED CUTTING FLUIDS AND ABRASIVES IS PROHIBITED. USE TRIM SOL OR APPROVED EQUAL LUBRICANT.
 2. FOR COMPLETE SPECIFICATIONS ON MACHINING, CLEANING, VACUUM REQUIREMENTS, TESTING AND DELIVERY PREPARATION, SEE ANL DOCUMENT #410201-00095.
 3. DIMENSIONS IN BRACKETS [] ARE MILLIMETERS.

SUGGESTED SOURCE:

1 HELI-COIL DIVISION
SHELTER ROCK LANE
DANBURY, CN 06810
PHONE: (203)-743-7651
FAX: (203)-798-2540

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
2	HELI-COIL # 3585-06CNV207	HELI-COIL INSERT, SCREW LOCK, SILVER FINISH	18-8 STAINLESS STEEL	8
1	HELI-COIL # 1185-04CNV280	#6-32 UNC-2B x .21 LG. #4-40 UNC-2B x .28 LG.	18-8 STAINLESS STEEL	6

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES:		LOG NUMBER		THIS DRAWING IS THE PROPERTY OF	
DECIMALS	ANGULAR	A11700		ARGONNE NATIONAL LABORATORY	
X .001 (0.025)	± .05	DRAWN BY	DATE	CHIEF DESIGN ENGINEER	DATE
XX .01 (0.254)	± .05	PJE	6/93	D. SHU	01/94
XXX .001 (0.025)	± .05	DESIGNED BY	DATE	PROJECT MGR.	DATE
SURFACE ROUGHNESS 125		C. BRITE	11/93	T.M. KUZAY	01/94
REMOVE ALL BURRS AND BREAK SHARP EDGES (R&M)		DESIGNER	DATE	RESPONSIBLE ENGINEER	DATE
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AMS-B4		C. BRITE	8/93	C. BRITE	11/93
DIMENSIONS & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		APPROVED/RELEASED			
		MATERIAL			
		OFHC GRADE 1			
		PER ANL SPEC. #B 170			

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE

SCALE	SHEET	SIX	DRAWING NUMBER
1:1	1 of 1	D	P4102010107-210102-00