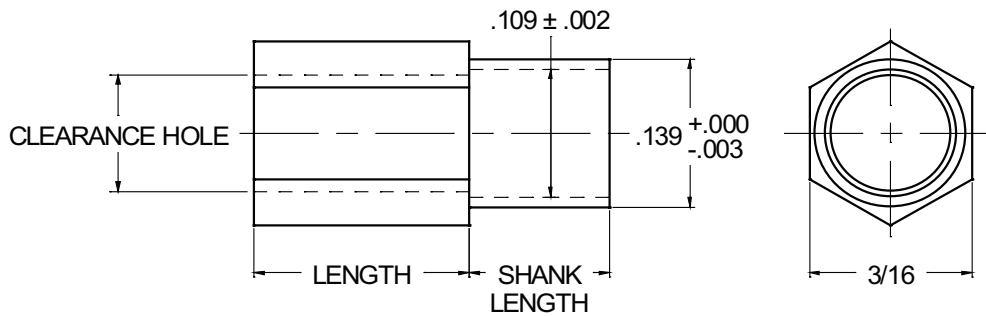




3/16 HEX SWAGE SPACERS .139 Shank Diameter



| | | | | | | | |
|----------------------|----------------|---------------------------|-----------------|---|----------------------|---|--------------|
| ORDERING CODE | XX MATERIAL | XXXX BASIC PART NUMBER | X SHANK CODE | — | X.XXX LENGTH CODE | — | XX FINISH |
|----------------------|----------------|---------------------------|-----------------|---|----------------------|---|--------------|

| MATERIAL | CODE |
|-----------------|------|
| ALUMINUM | AL |
| BRASS | BR |
| STAINLESS STEEL | SS |

NOTE: See Page A4 for additional materials and specifications.

| PANEL THICKNESS | SHANK LENGTH ± .003 | CODE |
|-----------------|------------------------|------|
| 1/32 | .075 | A |
| 1/16 | .105 | B |
| 3/32 | .135 | C |
| 1/8 | .165 | D |

NOTE: See Page A5 for additional shank lengths.

| LENGTH | CODE |
|--------|-------|
| 1/8 | 0.125 |
| 3/16 | 0.187 |
| 1/4 | 0.250 |
| 5/16 | 0.312 |
| 3/8 | 0.375 |
| 7/16 | 0.437 |
| 1/2 | 0.500 |
| 9/16 | 0.562 |
| 5/8 | 0.625 |
| 11/16 | 0.687 |
| 3/4 | 0.750 |
| 13/16 | 0.812 |
| 7/8 | 0.875 |
| 15/16 | 0.937 |
| 1" | 1.000 |

| CLEARANCE HOLE +.010 / -.000 | BASIC PART NO. |
|---------------------------------|----------------|
| .088 | 6324 |
| .101 | 6336 |

| PANEL HOLE SIZE |
|-----------------|
| .141 - .144 |

| SWAGE TOOLING | | |
|---------------|-------|-------------|
| PUNCH | ANVIL | BODY LENGTH |
| 139 | 220-1 | 1/8 - 3/16 |
| | 220-2 | 1/4 - 7/16 |
| | 220-3 | 1/2 - 11/16 |
| | 220-4 | 3/4 - 1" |

| CODE | FINISH | CODE | FINISH |
|------|--|------|--|
| 00 | Plain — None | 32 | Cadmium QQ-P-416, CL 2 — Color Chromate |
| 01 | Passivate ASTM A967-05 | 33 | Black Zinc |
| 02 | Caustic Etch | 34* | Zinc QQ-Z-325, Type II, CL 3 — Clear Chromate |
| 03 | Bright Dip — Brass | 35 | Zinc QQ-Z-325, Type I, CL 3 |
| 11 | Anodize MIL-A-8625C, Type I Chromic Hot Water Seal — Dark Grey | 36 | Zinc QQ-Z-325, Type II, CL 3 — Yellow Chromate |
| 12 | Anodize MIL-A-8625C, Type II Sulphuric Hot Water Seal — Clear | 42 | Electro Tin MIL-T-10727, Type I (Dull) |
| 13 | Anodize MIL-A-8625C, Type II Sulphuric Dichromate Seal — Yellow Green | 43 | Electro Tin MIL-T-10727 C, Type I (Bright) |
| 14 | Anodize MIL-A-8625C — Black | 44 | Electro Tin (Solder) MIL-F-14072 M230/M222 |
| 21 | Iridite MIL-C-5541 — Clear | 48 | Copper / Nickel / Bright Tin |
| 22* | Iridite MIL-C-5541 — Gold #14 | 50 | Black Oxide MIL-C-13924 — Steel |
| 25 | Clear Iridite -- Class 3 (RoHS) MIL-DTL-5541F | 51 | Black Oxide MIL-F-495 — Brass |
| 31 | Cadmium QQ-P-416, CL 2 — Clear Chromate | 52 | Black Oxide MIL-C-13924 — Stainless Steel |
| | | 61 | Nickel QQ-N-290 CL 1, Type VI KC |
| | | 63 | Ductile Nickel |
| | | 66 | Electroless Nickel |
| | | 91 | Silver QQ-S-365 |

*Standard finishes: Zinc (Clear Chromate) on brass material, Iridite (Gold #14) on aluminum material.

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