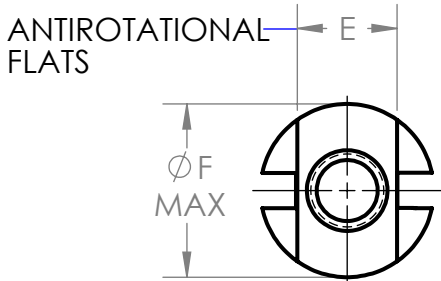
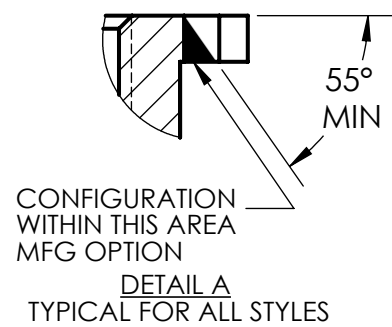
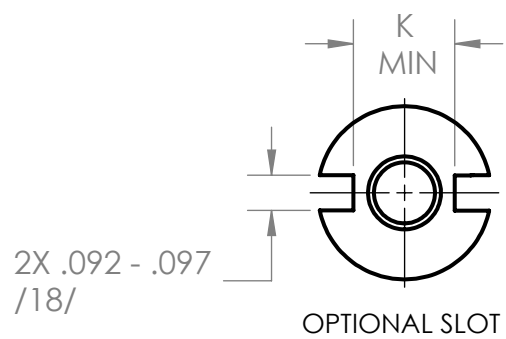
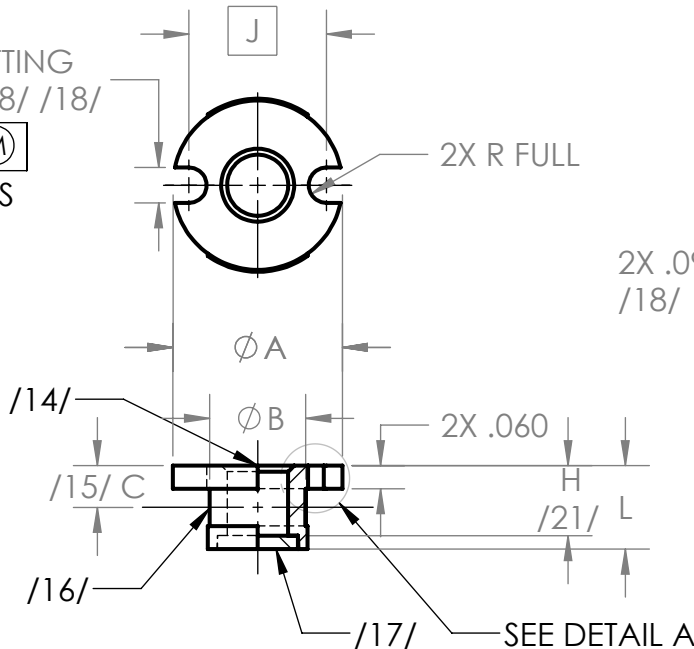


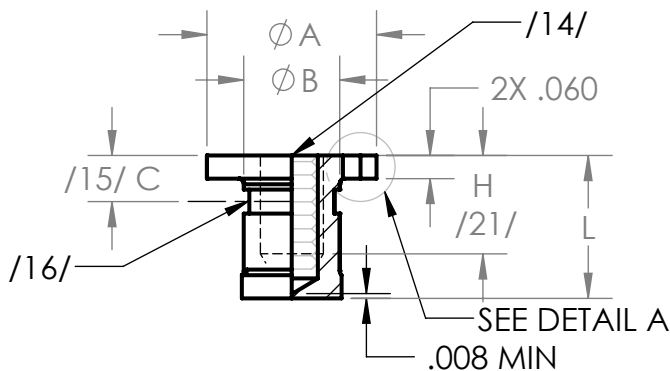
**W1836**

**INSERT, MOLDED IN, BLIND THREADED, SELF-LOCKING, NONSELF-LOCKING, LIGHTWEIGHT, SANDWICH PANEL**

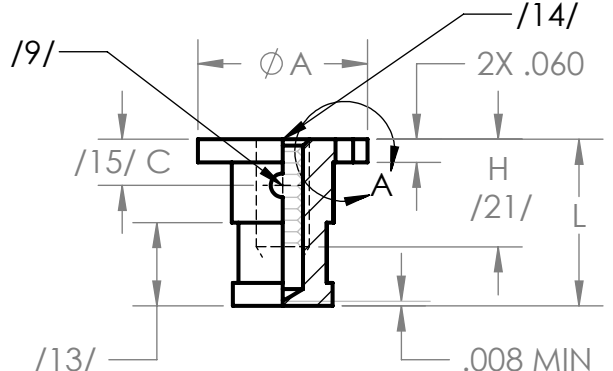
2X .092 -.097 POTTING AND VENT SLOTS /8/ /18/  
 $\oplus \phi .020 \text{ (M) A (M)}$   
 TYPICAL ALL STYLES



SHIMMED STYLE FOR SHORT LENGTHS (MANUFACTURER'S OPTION)



BLIND TAPPED STYLE FOR LONG LENGTHS ALL STEEL AND CRES SELF-LOCKING AND NONSELF-LOCKING OR NONSELF-LOCKING ALUMINUM STYLE.



ALUMINUM SELF-LOCKING STYLE OR ALTERNATE NONSELF-LOCKING ALUMINUM STYLE

WITTEN COMPANY  
918-272-9567

APPROVAL REV:C 3/26/2024

CAGE CODE: 0JHK5

# W1836

## INSERT, MOLDED IN, BLIND THREADED, SELF-LOCKING, NONSELF-LOCKING, LIGHTWEIGHT, SANDWICH PANEL

TABLE I - IMPERIAL DIMENSIONS

FIRST DASH NO.	THREAD CLASS 3B MINOR DIA -A-	ØA +.000 -.010	ØB	C	E	ØF MAX	H /21/	J BASIC	K MIN	L /22/ MIN	INSTALLATION HOLE SIZE
04	.1120-40 UNJC	.451	.250	.10	.260	.45	.130	.358	.251	.217	.452 - .457
06	.1380-32 UNJC	.451	.250	.12	.260	.45	.187	.358	.251	.217	.452 - .457
08	.1640-32 UNJC	.451	.250	.12	.260	.45	.187	.358	.251	.217	.452 - .457
3	.1900-32 UNJF	.451	.250	.12	.260	.45	.187	.358	.251	.217	.452 - .457
4	.2500-28 UNJF	.498	.300	.14	.312	.49	.250	.405	.298	.279	.499 - .504

TABLE IA - METRIC DIMENSIONS

FIRST DASH NO.	THREAD FED-STD-H28/21	ØA +.000 -.010	ØB	C	E	ØF MAX	H /21/	J BASIC	K MIN	L /22/ MIN	INSTALLATION HOLE SIZE
M3	M3X0.5-4H6H	11.46	6.35	3.0	3.30	11.4	4.75	9.09	6.38	5.54	11.48-11.61
M3.5	M3.5X0.6-4H6H	11.46	6.35	3.0	3.30	11.4	4.75	9.09	6.38	5.54	11.48-11.61
M4	M4X0.7-4H6H	11.46	6.35	3.0	3.30	11.4	4.75	9.09	6.38	5.54	11.48-11.61
M5	M5X0.8-4H6H	11.46	6.35	3.0	3.30	11.4	4.75	9.09	6.38	5.54	11.48-11.61
M6	M6X1-4H5H	12.65	7.62	3.6	7.92	12.4	6.35	10.29	7.09	7.14	12.67-12.80
M8	M8X1.25-4H5H	13.82	8.89	4.2	12.54	13.4	7.35	11.49	7.8	8.74	13.84-13.97

**MATERIAL:**

CARBON STEEL PER ASTM A108, ASTM A576 OR MATERIAL COMPOSITION PER AIR4127, ULTIMATE TENSILE STRENGTH , 85 KSI MINIMUM.  
AL ALLOY, GRADE 2024 (UNS A92024) TEMPER T4 OR T351 PER AMS-QQ-A-225/6.  
CRES 303 (UNS S30300) PER ASTM A582/A582M.  
NONMETALLIC LOCKING ELEMENT - POLYAMIDE PER FED SPEC L-P-410.

**FINISH:**

CARBON STEEL - CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.  
AL ALLOY - ANODIZE PER MIL-PRF-8625, TYPE I, CLASS OPTIONAL.  
CRES - PASSIVATE PER ASTM-A967; SILVER PLATE PER AMS 2410 OR AMS 2411; OR CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.

**LUBRICATION:**

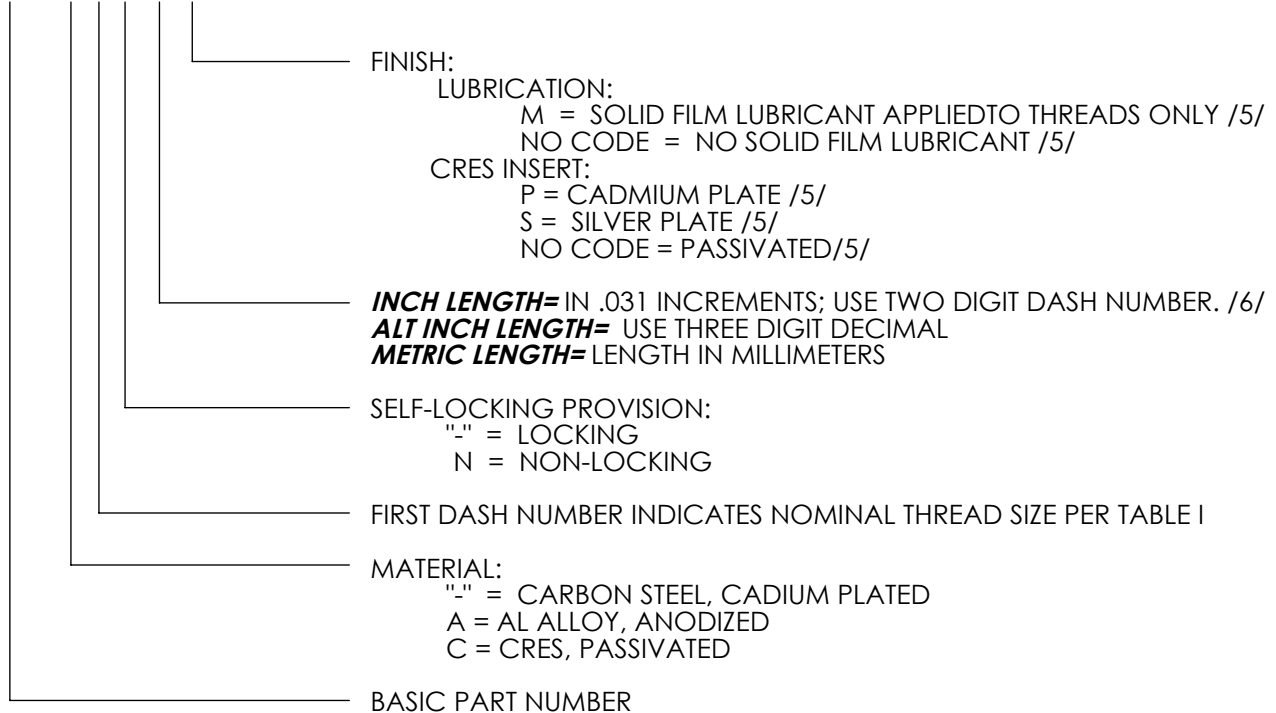
SOLID FILM LUBRICANT PER AS5272, TYPE I, APPLIED TO THREADS ONLY.

# W1836

## INSERT, MOLDED IN, BLIND THREADED, SELF-LOCKING, NONSELF-LOCKING, LIGHTWEIGHT, SANDWICH PANEL

**CODE:**

W1836 - 3 - 08 M


**EXAMPLE OF PART NUMBER:**

W1836-3-08M = .1900-32 UNJF-3B THREAD, CARBON STEEL,  
 CADMIUM PLATED, WITH SOLID FILM LUBRICANT, .248" LONG, SELF-LOCKING.  
 W1836A3N09 = .1900-32 UNJF-3B THREAD, AL ALLOY, ANODIZED, .279" LONG, NONSELF-LOCKING.  
 W1836C08-10S = .1640-32 UNJC-3B THREAD, CRES, SILVER PLATED, .310" LONG, SELF-LOCKING.  
 W1836C08-10P = .1640-32 UNJC-3B THREAD, CRES, CADMIUM PLATED, .310" LONG, SELF-LOCKING.  
 W1836C4N12 = .2500-28 UNJF-3B THREAD, CRES, PASSIVATED, .372" LONG, NONSELF-LOCKING.  
 W1836CM6N25.4 = M6X1 4H5H THREAD, CRES PASSIVATED, 25.4 MM LONG, NONSELF-LOCKING.

**NOTE:**

- (1) INCH THREADS PER AS8879, CLASS 3B. METRIC THREAD PER FED-STD-H28/21.
- (2) NOT USED
- (3) TOLERANCES UNLESS OTHERWISE SPECIFIED: .XXX ±.010, .XX ±.02.

**W1836****INSERT, MOLDED IN, BLIND THREADED, SELF-LOCKING,  
NONSELF-LOCKING, LIGHTWEIGHT,  
SANDWICH PANEL****NOTE:**

- (4) AN ADHESIVE-BACKED INSTALLATION TAB (PLASTIC) SHALL BE FURNISHED WITH EACH INSERT.
- /5/ PLATING OR SOLID FILM LUBRICANT IS RECOMMENDED ON SELF-LOCKING CRES INSERTS.
- /6/ SELECT A LENGTH WHICH WILL ALLOW A MINIMUM OF .040 CLEARANCE BETWEEN BOTTOM OF INSERT AND INSIDE SURFACE OF BOTTOM SKIN.
- (7) MAXIMUM BOLT ENGAGEMENT SHOULD NOT EXCEED "L" MINUS .060.
- /8/ BURRS CAUSED BY MACHINING POTTING HOLES OR SLOTS PERMISSIBLE UNDER FLANGE.
- /9/ NONMETALLIC THREAD LOCK WHEN APPLICABLE. LOCATE PELLETT NO CLOSER THAN 10° FROM EDGE OF EITHER POTTING HOLE OR SLOT.
- (10) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.
- (11) DIMENSIONS IN INCHES AND APPLY AFTER FINISH AND PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- (12) NOT USED.
- /13/ EXTERNAL CONFIGURATION OPTIONAL IN THIS AREA FOR SHORT LENGTHS THROUGH .375.
- /14/ MINIMUM "GO" THREAD GAGE PENETRATION SHALL BE ONE HALF REVOLUTION BEFORE LUBRICATION. MINIMUM BOLT THREAD PENETRATION SHALL BE THREE QUARTER REVOLUTION AFTER LUBRICATION.
- /15/ CENTERLINE OF THREAD LOCK WHEN APPLICABLE.
- /16/ SHANK DEFORMED IN THIS AREA TO PROVIDE THREAD LOCK WHEN APPLICABLE.
- /17/ SHIM TO PROVIDE MAXIMUM THREAD ON SHORT LENGTH INSERT IF NECESSARY.
- /18/ POTTING AND VENT HOLES OR SLOTS (MANUFACTURER'S OPTION).
- (19) ALL DIAMETERS SHALL BE WITHIN .010 CIRCULAR RUNOUT TO DATUM A.
- (20) REMOVE ALL BURRS AND SHARP EDGES.
- /21/ MINIMUM THREAD "H" IN SHORT LENGTHS. MINIMUM THREAD "H" WHERE LENGTH PERMITS SHALL BE 2X DIAMETER OF THREAD.
- /22/ MINIMUM LENGTH WHICH MAY BE SPECIFIED.
- /23/ NOT USED.
- (24) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (25) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (26) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.