

FINAL INSPECTION REPORT-LOCKING

PART NO. MS21209F1-15 DWG.NO. 1032L0285 HEAT NO. F4V3 PART NAME: INSERT, SCREW THREAD, LOCKING

LOT NO. W117553 MFG. DATE 11/11/2013 QTY. MFG. 134,094 OPER. 85

NASM8846 VISUAL/DIMENSIONAL REQUIREMENTS: O.D. .236-.256 TANG .131-.182 COILS 6.875 NOTCH DESIGN

#	O.D.	TANG	NOTCH	DESIGN	COILS	#	O.D.	TANG	NOTCH	DESIGN	COILS
1	0.239	0.153	OK	OK	6.75	33	0.237	0.153	OK	OK	6.75
2	0.238	0.158	OK	OK	6.75	34	0.237	0.171	OK	OK	6.75
3	0.239	0.143	OK	OK	6.75	35	0.237	0.154	OK	OK	6.75
4	0.239	0.159	OK	OK	6.75	36	0.237	0.156	OK	OK	6.75
5	0.237	0.158	OK	OK	6.75	37	0.237	0.162	OK	OK	6.75
6	0.237	0.167	OK	OK	6.75	38	0.238	0.136	OK	OK	6.75
7	0.237	0.157	OK	OK	6.75	39	0.237	0.161	OK	OK	6.75
8	0.237	0.158	OK	OK	6.75	40	0.237	0.149	OK	OK	6.75
9	0.237	0.142	OK	OK	6.75	41	0.238	0.147	OK	OK	6.75
10	0.238	0.164	OK	OK	6.75	42	0.237	0.152	OK	OK	6.75
11	0.237	0.159	OK	OK	6.75	43	0.237	0.168	OK	OK	6.75
12	0.237	0.163	OK	OK	6.75	44	0.238	0.161	OK	OK	6.75
13	0.238	0.144	OK	OK	6.75	45	0.237	0.159	OK	OK	6.75
14	0.238	0.152	OK	OK	6.75	46	0.238	0.149	OK	OK	6.75
15	0.238	0.148	OK	OK	6.75	47	0.237	0.159	OK	OK	6.75
16	0.237	0.159	OK	OK	6.75	48	0.237	0.157	OK	OK	6.75
17	0.238	0.149	OK	OK	6.75	49	0.238	0.159	OK	OK	6.75
18	0.237	0.153	OK	OK	6.75	50	0.238	0.152	OK	OK	6.75
19	0.238	0.148	OK	OK	6.75	51	0.239	0.148	OK	OK	6.75
20	0.238	0.147	OK	OK	6.75	52	0.238	0.157	OK	OK	6.75
21	0.238	0.173	OK	OK	6.75	53	0.239	0.171	OK	OK	6.75
22	0.237	0.167	OK	OK	6.75	54	0.239	0.148	OK	OK	6.75
23	0.238	0.173	OK	OK	6.75	55	0.239	0.143	OK	OK	6.75
24	0.238	0.158	OK	OK	6.75	56	0.239	0.159	OK	OK	6.75
25	0.237	0.142	OK	OK	6.75	57	0.239	0.149	OK	OK	6.75
26	0.237	0.165	OK	OK	6.75	58	0.239	0.164	OK	OK	6.75
27	0.237	0.153	OK	OK	6.75	59	0.239	0.156	OK	OK	6.75
28	0.239	0.136	OK	OK	6.75	60	0.239	0.147	OK	OK	6.75
29	0.237	0.167	OK	OK	6.75	61	0.238	0.139	OK	OK	6.75
30	0.239	0.169	OK	OK	6.75	62	0.238	0.154	OK	OK	6.75
31	0.238	0.146	OK	OK	6.75	63	0.238	0.158	OK	OK	6.75
32	0.237	0.162	OK	OK	6.75	64	0.239	0.142	OK	OK	6.75

NASM8846 TORQUE TEST

MEASURING EQUIPMENT/TEST BOLTS/TEST BLOCK

Sample	Maximum Torque			Minimum Torque			Bolt Certification #	
	9 In. Lbs.			4 In. Lbs.			Bolts Issued	
	Cycle			Cycle			Ring Gage Go #	
	1	7	15	1	7	15	46682	
1	9	6	4	7	6	4	1	
2	8	7	6	8	7	5	1660304	
3	7	6	5	7	6	5	1742141	
4	8	7	6	7	6	5	10-32	
5	9	6	5	8	6	4	13	
6	8	7	6	8	7	5	974414	
7	9	6	5	7	6	4	5138	
8	9	7	6	8	7	5	1	

Note: Bolt per NASM8846 Revision 1, Table IV
P/N NAS6605 or Equivalent per Note /3/.

O.D, TANG, NOTCH, DESIGN

REMARKS

INSPECTED RCP DATE 1/22/2014



TORQUE INSPECTED RCP DATE 1/22/2014

COILS INSPECTED RCP DATE 1/22/2014

REVIEWED *[Signature]* DATE 1/22/2014