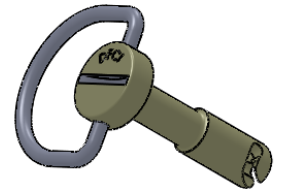
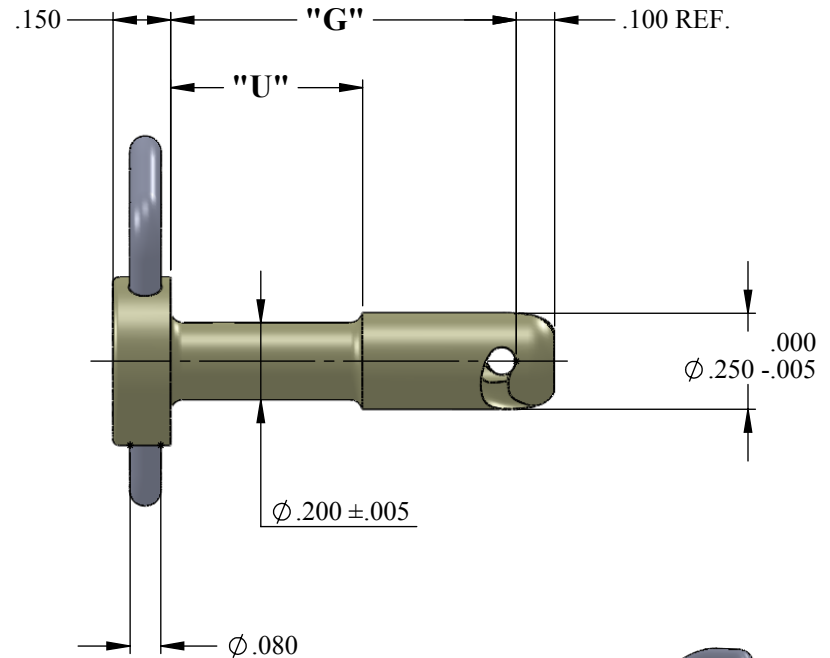
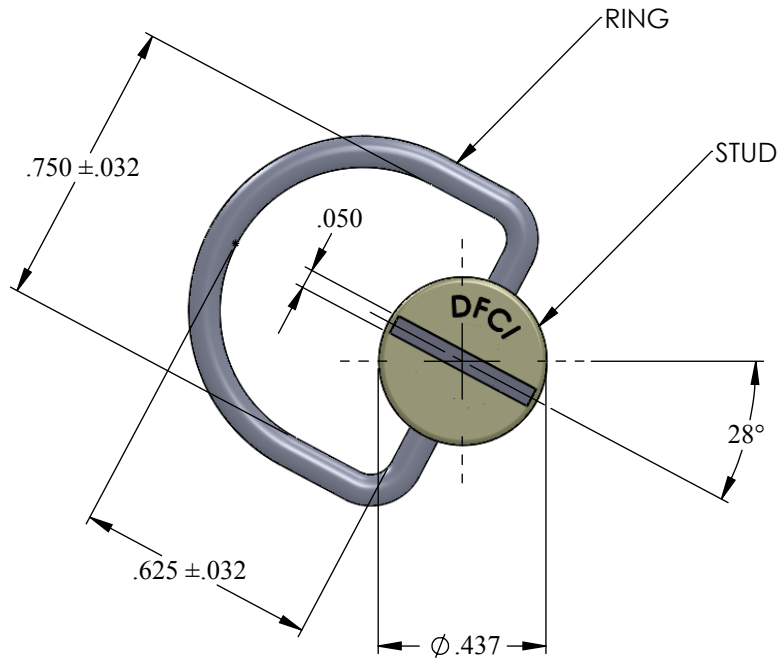


REVISIONS			
SYS	DESCRIPTION	DATE	APPROV
C	PER ECN 1168 & 1197	05-20-11	



UNCONTROLLED

MATERIAL: SEE NOTE 2 ON SHEET 2 OF 2

HEAT TREAT: SEE NOTE 3 ON SHEET 2 OF 2

FINISH: SEE NOTE 1 ON SHEET 2 OF 2

THE FASTENER PARTS SHOWN IN THIS PRINT ARE PROPRIETARY ARTICLES TO WHICH DFCI SOLUTIONS INC., RETAINS THE EXCLUSIVE RIGHTS OF MANUFACTURE, USE AND SALE. THE PRINT OR DRAWING IS SUBMITTED IN CONFIDENCE AND DOES NOT CONVEY A LICENSE OR PERMISSION TO MANUFACTURE THE FASTENER OR FASTENER PARTS.

(C) COPYRIGHT 2009, DFCI SOLUTIONS INC. ALL RIGHTS RESERVED.

TOLERANCES ON DIMENSIONS UNLESS OTHERWISE SPECIFIED

X* = ±2° .XX = ±.015 MACHINE FINISH = .125
 X/X = ±1/32 .XXX = ±.010

PART NO.	SEE TABLE	DRN	Frank Basile	DATE	5-23-11
		CHK.	Frank Basile	DATE	5-23-11
		ENG.	Robert Altkorn	DATE	5-23-11
		MFG.	Charles J. Paniel	DATE	5-23-11
		G.C.	Robert Altkorn	DATE	5-23-11
NEXT ASSY	USED ON	SALES.		DATE	



DFCI SOLUTIONS INC.
 425 UNION BOULEVARD.
 WEST ISLIP, NEW YORK 11795

TITLE **ST-1200 LINE RING HEAD STUD ASSEMBLY
 122J-R4**-Z3CT**

SIZE **A** FSCM NO. **72794** DWG. NO. **C122J-R4** REV. **C**

SCALE: NTS

WEIGHT:

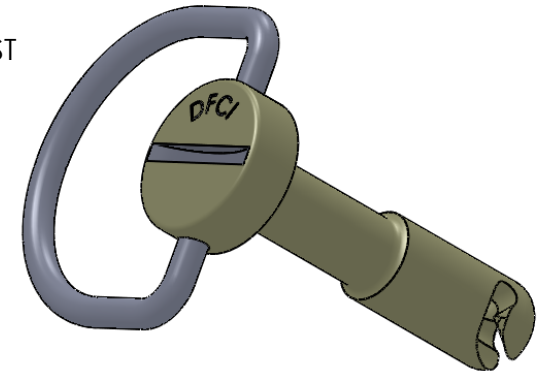
SHEET 1 OF 2

REVISIONS			
SYS	DESCRIPTION	DATE	APPROV
C	PER ECN 1168 & 1197	05-20-11	

ASSEMBLY PART NUMBER	G	U
122J-R425-Z3CT	.250	.100
122J-R430-Z3CT	.300	.100
122J-R435-Z3CT	.350	.150
122J-R440-Z3CT	.400	.200
122J-R445-Z3CT	.450	.225
122J-R450-Z3CT	.500	.250
122J-R455-Z3CT	.550	.275
122J-R460-Z3CT	.600	.300
122J-R465-Z3CT	.650	.350
122J-R470-Z3CT	.700	.350
122J-R475-Z3CT	.750	.400
122J-R480-Z3CT	.800	.400
122J-R485-Z3CT	.850	.500
122J-R490-Z3CT	.900	.500
122J-R4100-Z3CT	1.000	.600
122J-R4110-Z3CT	1.100	.600
122J-R4120-Z3CT	1.200	.600
122J-R4130-Z3CT	1.300	.600
122J-R4140-Z3CT	1.400	.600
122J-R4150-Z3CT	1.500	.600

NOTES:

- FINISH:**
ZINC PLATE PER ASTM-B-633, TYPE III, SC2 CLEAR TRIVALENT CHROMATE WITH SEALER.
- MATERIAL:**
STUD- A.I.S.I. 8620 OR 10B21 STEEL
RING- HIGH CARBON STEEL
- HEAT TREAT:**
STUD- ROCKWELL C27 - 33
RING- ROCKWELL C40 - 45
- FOR A STAINLESS STEEL STUD ASSEMBLY CONSISTING OF A TYPE 303 STAINLESS STEEL STUD AND A TYPE 420 STAINLESS STEEL RING, REMOVE SUFFIX -Z3CT FROM THE PART NUMBER AND ADD -SS EXAMPLE 122J-R425-SS
- FOR ALTERNATE FINISHES, REMOVE SUFFIX -Z3CT FROM THE PART NUMBER AND ADD THE REQUIRED FINISH SUFFIX. EXAMPLE: 122J-R425-Z3YT
- PLEASE VISIT www.dfci.com/dzfinish.html FOR A LIST OF AVAILABLE FINISHES



UNCONTROLLED

MATERIAL: SEE NOTE 2 ON SHEET 2 OF 2	TOLERANCES ON DIMENSIONS UNLESS OTHERWISE SPECIFIED X* = ±2* .XX = ±.015 X/X = ±1/32 .XXX = ±.010 MACHINE FINISH = .125		
HEAT TREAT: SEE NOTE 3 ON SHEET 2 OF 2	PART NO. SEE TABLE	DRN <i>Frank Basile</i>	DATE 5-23-11
FINISH: SEE NOTE 1 ON SHEET 2 OF 2		CHK. <i>Frank Basile</i>	DATE 5-23-11
THE FASTENER PARTS SHOWN IN THIS PRINT ARE PROPRIETARY ARTICLES TO WHICH DFCI SOLUTIONS INC., RETAINS THE EXCLUSIVE RIGHTS OF MANUFACTURE, USE AND SALE. THE PRINT OR DRAWING IS SUBMITTED IN CONFIDENCE AND DOES NOT CONVEY A LICENSE OR PERMISSION TO MANUFACTURE THE FASTENER OR FASTENER PARTS. (C) COPYRIGHT 2009, DFCI SOLUTIONS INC. ALL RIGHTS RESERVED.		ENG. <i>Robert Altkorn</i>	DATE 5-23-11
		MFG. <i>Charles J. Pinnell</i>	DATE 5-23-11
	NEXT ASSY	USED ON	G.C. <i>Robert Altkorn</i>
	APPLICATION BLOCK	SALES.	DATE



DFCI SOLUTIONS INC.
425 UNION BOULEVARD.
WEST ISLIP, NEW YORK 11795

TITLE ST-1200 LINE RING HEAD STUD ASSEMBLY 122J-R4**-Z3CT			
SIZE A	FSCM NO. 72794	DWG. NO. C122J-R4	REV. C
SCALE: NTS		WEIGHT:	SHEET 2 OF 2