



*Schroff*®

# SPECIFIER'S GUIDE

DESIGN WITH CONFIDENCE™

CALMARK™

RETAINERS

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Calmark, the home of the Card-Lok, designs and manufactures rugged printed circuit board guides, conduction frame assemblies and extractors for use in non-benign - airborne, shipborne, and rugged land transportation - environments.

Today, Pentair markets the Calmark brand of products along with Birtcher™ globally and Schroff® in the Americas, while complimenting these standard product brands with its own customer-specific enclosure capabilities.

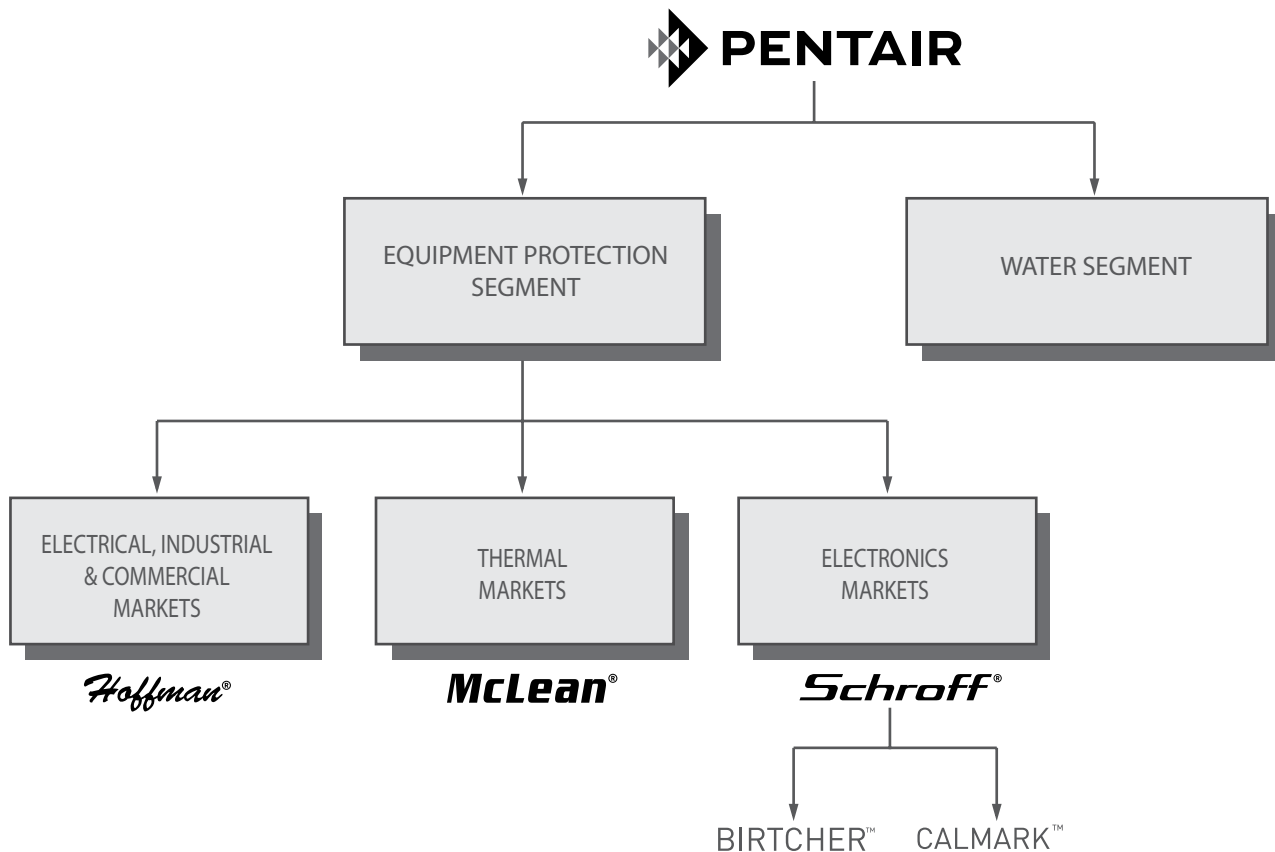
Pentair is a manufacturer of standard, modified standard and customer specific enclosure systems: capabilities range from backplane design, to NEBS enclosures, to outdoor (Telecordia compliant) aluminum enclosures, to high volume stamped chassis, and systems integration.

Pentair, Inc. (PNR-NYSE) is a highly successful, diversified corporation consisting of two core business groups.

Water Segment – a global leader in providing innovative products and systems used world wide in the movement, treatment, storage and enjoyment of water.

Equipment Protection Segment – is a leader in the global enclosures market, designing and manufacturing standard, modified, custom, thermal enclosures that house and protect sensitive electronics and electrical components.

Pentair brands are market specific (see below) and are complimented by the groups' thermal division which supports all markets.





|          |             | NPI | Steel | Aluminum<br>Outside<br>Plant | Backplane<br>Design | Chassis<br>Assembly | Stamping | Testing | Finishing | System<br>Integration | Capacity<br>(SQ FT) |
|----------|-------------|-----|-------|------------------------------|---------------------|---------------------|----------|---------|-----------|-----------------------|---------------------|
| Americas | New England | ✓   | ✓     | ✓                            | ✓                   | ✓                   |          | ✓       | ✓         | Level 1 to 4          | 113,000             |
|          | Illinois    | ✓   | ✓     | ✓                            |                     | ✓                   | ✓        | ✓       |           | Level 1 to 4          | 35,000              |
|          | Minnesota   | ✓   | ✓     | ✓                            |                     |                     |          | ✓       | ✓         | Level 1 to 2          | 945,000             |
|          | California  |     | ✓     |                              |                     |                     | ✓        | ✓       |           | Level 1 to 2          | 50,000              |
|          | Brazil      | ✓   | ✓     | ✓                            |                     | ✓                   |          | ✓       | ✓         | Level 1 to 4          | 170,000             |
|          | Mexico      |     | ✓     | ✓                            |                     | ✓                   | ✓        |         | ✓         | Level 1 to 2          | 250,000             |
| Asia     | China       | ✓   | ✓     | ✓                            |                     | ✓                   | ✓        | ✓       | ✓         | Level 1 to 3          | 220,000             |
|          | Japan       |     | ✓     |                              |                     | ✓                   | ✓        | ✓       | ✓         | Level 1 to 3          | 40,000              |
| Europe   | Germany     | ✓   | ✓     |                              | ✓                   | ✓                   | ✓        | ✓       | ✓         | Level 1 to 5          | 577,000             |
|          | France      | ✓   | ✓     | ✓                            |                     | ✓                   | ✓        | ✓       | ✓         | Level 1 to 3          | 205,000             |
|          | Poland      | ✓   | ✓     | ✓                            |                     | ✓                   |          | ✓       | ✓         | Level 1 to 3          | 110,000             |



## Card-Lok

| Product Series | 3 or 5 pc. | Actuation | Profile Width (nominal) x Relaxed Height (max) | Profile Height Expanded (min) | Length (min)  | Approximate Clamping Force <sup>2</sup> N(lbs) | Recommended Torque Setting N-cm (in-lbs) | DSCC  | DSCC CID |
|----------------|------------|-----------|------------------------------------------------|-------------------------------|---------------|------------------------------------------------|------------------------------------------|-------|----------|
| 223            | 5          | Screw     | 5.72 (.225) x 6.86 (.270)                      | 8.26 (.325)                   | 71.12 (2.80)  | tbd                                            | limited                                  |       |          |
| 224            | 5          | Screw     | 5.33 (.210) x 7.24 (.285)                      | 8.64 (.340)                   | 71.12 (2.80)  | tbd                                            | limited                                  |       |          |
| 225            | 3          | Screw     | 5.72 (.225) x 6.86 (.270)                      | 8.26 (.325)                   | 54.61 (2.15)  | 489 (110)                                      | 68 (6)                                   | 84103 | 59590    |
| E225           | 3          | Screw     | 5.72 (.225) x 6.86 (.270)                      | 8.26 (.325)                   | 71.12 (2.80)  | 489 (110)                                      | 68 (6)                                   |       |          |
| L225           | 3          | Lever     | 5.72 (.225) x 6.86 (.270)                      | 8.26 (.325)                   | 54.61 (2.15)  | 533 (120)                                      | N/A                                      |       |          |
| 226            | 5          | Screw     | 5.72 (.225) x 6.86 (.270)                      | 8.26 (.325)                   | 121.92 (4.80) | 800 (180)                                      | 68 (6)                                   | 89064 | 59789    |
| 230            | 3          | Screw     | 5.59 (.220) x 5.72 (.225)                      | 6.99 (.275)                   | 54.61 (2.15)  | 489 (110)                                      | 68 (6)                                   | 84103 | 59590    |
| 231            | 5          | Screw     | 5.59 (.220) x 5.72 (.225)                      | 6.99 (.275)                   | 121.92 (4.80) | 800 (180)                                      | 68 (6)                                   | 89064 | 59789    |
| 235            | 3          | Screw     | 5.84 (.230) x 7.32 (.288)                      | 8.64 (.340)                   | 71.12 (2.80)  | 445 (100)                                      | 68 (6)                                   |       |          |
| 236            | 5          | Screw     | 5.84 (.230) x 7.32 (.288)                      | 8.64 (.340)                   | 147.32 (5.80) | 800 (180)                                      | 68 (6)                                   |       |          |
| 240            | 3          | Screw     | 6.10 (.240) x 4.57 (.180)                      | 5.59 (.220)                   | 54.61 (2.15)  | 489 (110)                                      | 68 (6)                                   | 84103 | 59590    |
| 245            | 3          | Screw     | 6.60 (.260) x 6.86 (.270)                      | 8.26 (.325)                   | 54.61 (2.15)  | 622 (140)                                      | 113 (10)                                 |       | 59590    |
| 250            | 3          | Screw     | 9.53 (.375) x 9.78 (.385)                      | 11.94 (.470)                  | 63.50 (2.50)  | 1111 (250)                                     | 227 (20)                                 |       | 59590    |
| 255            | 3          | Screw     | 12.70 (.500) x 11.68 (.460)                    | 15.24 (.600)                  | 54.61 (2.15)  | 1778 (400)                                     | 351 (31)                                 |       | 59590    |
| 260            | 5          | Screw     | 6.35 (.250) x 6.26 (.270)                      | 8.26 (.325)                   | 54.61 (2.15)  | 1778 (400)                                     | 68 (6)                                   | 89024 |          |
| 261            | 3          | Screw     | 6.35 (.250) x 6.26 (.270)                      | 8.26 (.325)                   | 54.61 (2.15)  | 667 (150)                                      | 68 (6)                                   |       | 59789    |
| L260           | 5          | Lever     | 6.35 (.250) x 6.26 (.270)                      | 8.26 (.325)                   | 54.61 (2.15)  | 556 (125)                                      | N/A                                      |       | 59789    |
| LE260          | 5          | Lever     | 6.35 (.250) x 6.26 (.270)                      | 8.26 (.325)                   | 54.61 (2.15)  | 556 (125)                                      | N/A                                      |       | 59789    |
| 263            | 5          | Screw     | 6.35 (.250) x 7.44 (.293)                      | 8.89 (.350)                   | 54.61 (2.15)  | 1778 (400)                                     | 68 (6)                                   |       |          |
| 264            | 3          | Screw     | 6.35 (.250) x 7.44 (.293)                      | 8.89 (.350)                   | 54.61 (2.15)  | 667 (150)                                      | 68 (6)                                   |       | 59789    |
| 265            | 5          | Screw     | 5.72 (.225) x 5.84 (.230)                      | 7.37 (.290)                   | 54.61 (2.15)  | 1556 (350)                                     | 68 (6)                                   |       |          |
| 266            | 3          | Screw     | 5.72 (.225) x 5.84 (.230)                      | 7.37 (.290)                   | 54.61 (2.15)  | 600 (135)                                      | 68 (6)                                   |       |          |
| 267            | 5          | Screw     | 6.35 (.250) x 5.00 (.197)                      | 5.99 (.236)                   | 54.61 (2.15)  | 1556 (350)                                     | 68 (6)                                   |       |          |
| 280            | 5          | Screw     | 9.27 (.365) x 9.65 (.380)                      | 11.68 (.460)                  | 60.96 (2.40)  | 3334 (750)                                     | 227 (20)                                 |       | 59789    |
| 281            | 3          | Screw     | 9.27 (.365) x 9.65 (.380)                      | 11.68 (.460)                  | 60.96 (2.40)  | 1245 (280)                                     | 227 (20)                                 |       |          |

## Channel-Lok

| Product Series | 3 or 5 pc. | Actuation | Width x Height (max)        | Board Thickness            | Length <sup>1</sup> (min) | Approximate Clamping Force <sup>2</sup> N(lbs) | Recommended Torque Setting N-cm (in-lbs) |
|----------------|------------|-----------|-----------------------------|----------------------------|---------------------------|------------------------------------------------|------------------------------------------|
| 227            | 3          | Screw     | 12.57 (.495) to 8.89 (.350) | 1.14 (.045) to 2.62 (.103) | 76.20 (3.00)              | 489 (110)                                      | 68 (6)                                   |
| 228            | 5          | Screw     | 12.57 (.495) to 8.89 (.350) | 1.14 (.045) to 2.62 (.103) | 101.6 (4.00)              | 801 (180)                                      | 68 (6)                                   |

## Retainers & Card Guides

| Product Series | Material      | Conductive | Application | Board Thickness         | Length <sup>1</sup> (min)                                       | UL rating           |
|----------------|---------------|------------|-------------|-------------------------|-----------------------------------------------------------------|---------------------|
| 125/126        | CR            | Yes        | Sheet Metal | 1.6 (.063) & 2.4 (.094) | 31.75 (1.25) to 311.15 (12.25)                                  | N/A                 |
| 165/166        | BeCu          | Yes        | Sheet Metal | 1.6 (.063) & 2.4 (.094) | 31.75 (1.25) to 311.15 (12.25)                                  | N/A                 |
| NW125/NW126    | CR            | Yes        | Cold Wall   | N/A                     | 31.75 (1.25) to 311.15 (12.25)                                  | N/A                 |
| NW165/NW166    | BeCu          | Yes        | Cold Wall   | N/A                     | 31.75 (1.25) to 311.15 (12.25)                                  | N/A                 |
| 120            | Nylon         | No         | Sheet Metal | 1.6 (.063) & 2.4 (.094) | 101.60(4.00),152.40(6.00),177.8(7.00),215.90(8.50),241.30(9.50) | V-2 (V-0 available) |
| C120           | Polycarbonate | Yes        | Sheet Metal | 1.6 (.063) & 2.4 (.094) | 101.60(4.00),152.40(6.00),177.8(7.00),215.90(8.50),241.30(9.50) | V-2 (V-0 available) |

## Nylon Extractors & Inserter-Extractors

| Product Series | Material                         | Function <sup>4</sup> | Mechanical Advantage | Board Thickness                        | UL Rating                               |
|----------------|----------------------------------|-----------------------|----------------------|----------------------------------------|-----------------------------------------|
| 107            | Glass-filled Nylon               | I & E                 | 4.5:1                | 1.6 (.063) & 2.4 (.094)                | V-0                                     |
| 107-10         | Glass-filled Nylon               | I & E                 | 3.3:1                | 1.6 (.063) & 2.4 (.094)                | V-0                                     |
| 107-20         | Glass-filled Nylon               | I, E & L              | 4.5:1                | 1.6 (.063) & 2.4 (.094)                | V-2 (V-0 available)                     |
| 107-30         | Glass-filled Nylon               | I & E                 | 5.5:1                | 1.6 (.063)                             | V-0                                     |
| 107-40-3       | Glass-filled Nylon               | I & E                 | 4.5:1                | 1.6 (.063) & 2.4 to 3.2 (.094 to .125) | V-0                                     |
| 107-70         | Glass-filled Nylon Latch - Nylon | I, E & L              | 4.5:1                | 1.6 (.063), 2.4 (0.94) & 3.2 (.125)    | V-0 (Inserter-Extractor)<br>V-2 (Latch) |

## Metal Extractors & Inserter-Extractors

| Product Series | Material | Function <sup>4</sup> | Mechanical Advantage | Board Thickness                     |
|----------------|----------|-----------------------|----------------------|-------------------------------------|
| 107-35         | Al       | I & E                 | 5.5:1                | 1.6 (.063), 2.4 (.094) & 3.2 (.125) |
| 107-50         | Al       | I & E                 | 4.5:1                | 1.6 (.063), 2.4 (.094) & 3.2 (.125) |
| 107-51         | Al       | I & E                 | 3.3:1                | 1.6 (.063), 2.4 (.094) & 3.2 (.125) |
| 107-55         | Al       | I & E                 | 8.0:1                | 1.6 (.063), 2.4 (.094) & 3.2 (.125) |
| 107-73         | Al       | I, E & L              | 4.2:1                | 1.6 (.063), 2.4 (.094) & 3.2 (.125) |
| 107-75         | Al       | I, E & L              | 7.0:1                | 1.6 (.063), 2.4 (.094) & 3.2 (.125) |
| 109            | Al or CR | E                     | 4.5:1                | 1.6 (.063), 2.4 (.094) & 3.2 (.125) |

1-Other assembly lengths available upon request 2-Clamping forces based on Chemical Film Option - Other finishes and options will yield different results  
3-101 available in 1.6 (.063) only 4-Function: E=Extract I=Insert L=Latch or Lock 5-Units are metric (inch)

## Finish & Plating

The Calmark product line offers a wide variety of standard finishes for products. Most of the components are made of aluminum or stainless steel. The standard finishes are:

### For Aluminum, standard finishes include:

- Chemical Film per Mil-DTL-5541 Type 1 (non-RoHS) Class 1A or 3, Gold
- Chemical Film per Mil-DTL-5541 Class 3, Type I, Gold for Shafted Products
- Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear
- Black Anodize per Mil-A-8625 Type II, Class 2
- Hard Black Anodize per Mil-A-8625 Type III, Class 2
- Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright

### For Stainless steel, standard finish is:

- Passivation per AMS 2700

### For BeCu, standard finishes include:

- Tin Plate per Mil-T-10727 Type I, Bright
- Nickel Plate per QQ-N-290 Class I, Grade F
- Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright
- Zinc Plate per ASTM-B633 Type III (Clear), SC1

### For Nylon card guides and extractors:

- Color coding is available for Natural/White card guides and extractors
- Standard colors are BLK and Natural; other colors available upon request.

## RoHS - Restriction of Hazardous Substances

The Calmark product line offers several product configurations to meet the requirements of the European Directive 2002/95/EC for Restriction of Hazardous Substances. This European Directive affects primarily the aluminum components that are finished with a gold chemical film process. This process uses a hexavalent chromium (Cr+6). An option for clear chemical film process using a trivalent chromium (Cr+3) has been added for those needing to meet this requirement. Contact one of our applications engineers for more details regarding the RoHS requirements of specific items.

## DFARS 252.225-7014 & Alt 1. Preference for Domestic Specialty Metals Clause

Calmark products can support the needs of Prime Contractors and Subcontractors supplying product to the DOD, particularly the Preference for Domestic Specialty Metals Clause. This clause is applicable to DOD Prime Contract Awards exceeding the simplified acquisition threshold, of products, components and assemblies for use in Aircraft, Missile and Space Systems, Ships, Tank and Automotive Items, Weapon Systems or Ammunition. For the Calmark product line, this affects the hardware, components and materials that are made of stainless steel. At the time of this writing, all COTS items which include all part numbers configurable in this catalog are exempt from the Preference for Domestic Specialty Metals Clause for Prime Contract Awards after October 25, 2007. Fastener DNAD waivers are also available for Prime Contract Awards between April 10, 2007, and July 26, 2008. There are many other exemptions available.

We recognize that each of our customers has a different method for handling this requirement, so we have implemented a process that we feel will handle the great majority of our customers' requirements. Because at this time, the Class Deviations are not retro-active, in order to best respond to your needs, we do require that all quotations and purchase orders note this requirement along with the Prime Contract Number. We do charge for a signed DFARS 252.225-7014 & Alt 1. Statement Sheet that must go along with your order. For those customers that can use the COTS exemption, we offer free of charge documents that you can download from our website. The Product Sheets will indicate from the Statement Sheet which statement applies for your product of interest. If these documents meet your needs, please indicate this in your quotation or P.O. Of course, for those customers that need a signed Statement Sheet, we can also accommodate this requirement at an additional fee.

## DSCC - Defense Supply Center - Columbus

Calmark also provides as a standard offering products that meet many of the specifications defined by Defense Supply Center – Columbus.

Calmark has incorporated the DSCC part numbers as a standard product offering to get the proper specification requirements by the addition of a "CM-" prefix to the DSCC part configuration for our internal part number system. The DSCC part number will be part of the description.

All part numbers defined in the DSCC specifications are considered COTS items for Calmark.

## Design Flexibility – Common Modifications

The Calmark product line offers an extremely broad range of configurations, not all of which are detailed in this catalog. Calmark is set up to handle these requests. Contact one of our Applications Engineers and a unique part number will be assigned for you for a product that meets your specification. Some of the modifications available include:

- 7 and 9 or more wedge segments
- Lengths outside of our standard catalog product offering
- Relocation or addition of mounting holes
- Tapped holes other than the standard catalog product offering
- Screw head activation different from M2.5 and 3/32 hex socket
- Specific individual wedge dimensions different from the catalog offering
- Replacement of split washers with Belleville washers
- Materials with different alloys from the catalog offering
- Different finish from those offered in the catalog
- Different lever lengths than those offered in the catalog
- Different hardware than standard offering including screw threads, thread-locking mechanism and bonded washers
- Secured wedges
- Ejection feature similar to E225 may be implemented on other Series profiles
- Modification of extractors
- Hot stamp of plastic parts to your requirements
- Silkscreen per your requirements
- Add chamfers

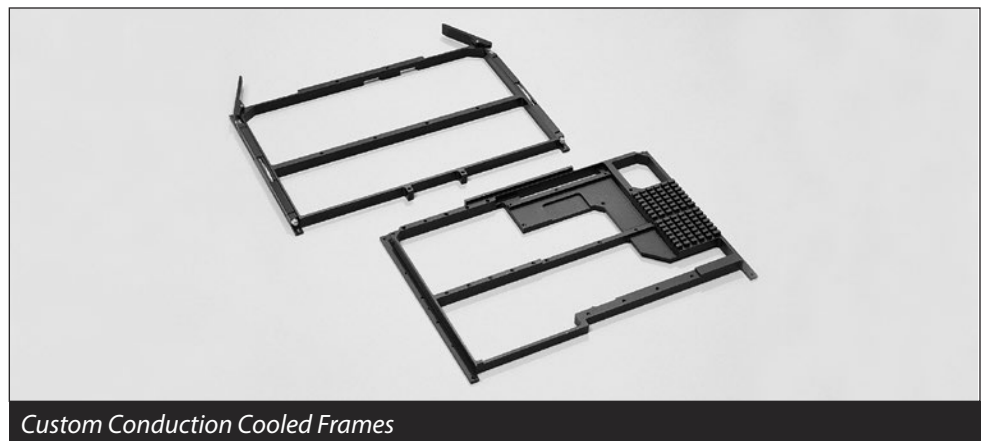
Our applications engineers can help you specify a cost effective design that will work for your application. The catalog offers the configurations that meet most applications, but if you don't see what you're looking for in the catalog, please call us. Odds are, we've already done something very similar.

## Warranty

Pentair Technical Products' Warranty is guaranteed from defects for 1 (one) year after shipment.

Conduction Cooled Assemblies consist of a conduction cooled frame, backing plate or backing strips, extractors and wedge clamps. They are designed for circuit boards requiring cooling in severe environments where convection cooling is not practical. The assembly also provides needed structural support of the plug-in module during extremely high shock and vibration applications. Optional configuration for compliance to IEEE 1101.2 and VITA 30.1.

Calmark offers a standard design that takes the guesswork out of the perimeter of the assembly. The component area can be customized to match your board and application.



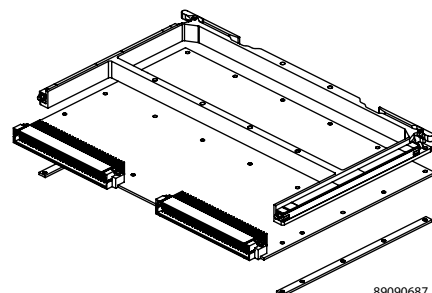
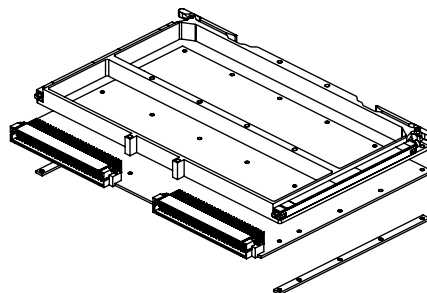
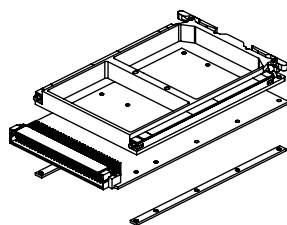
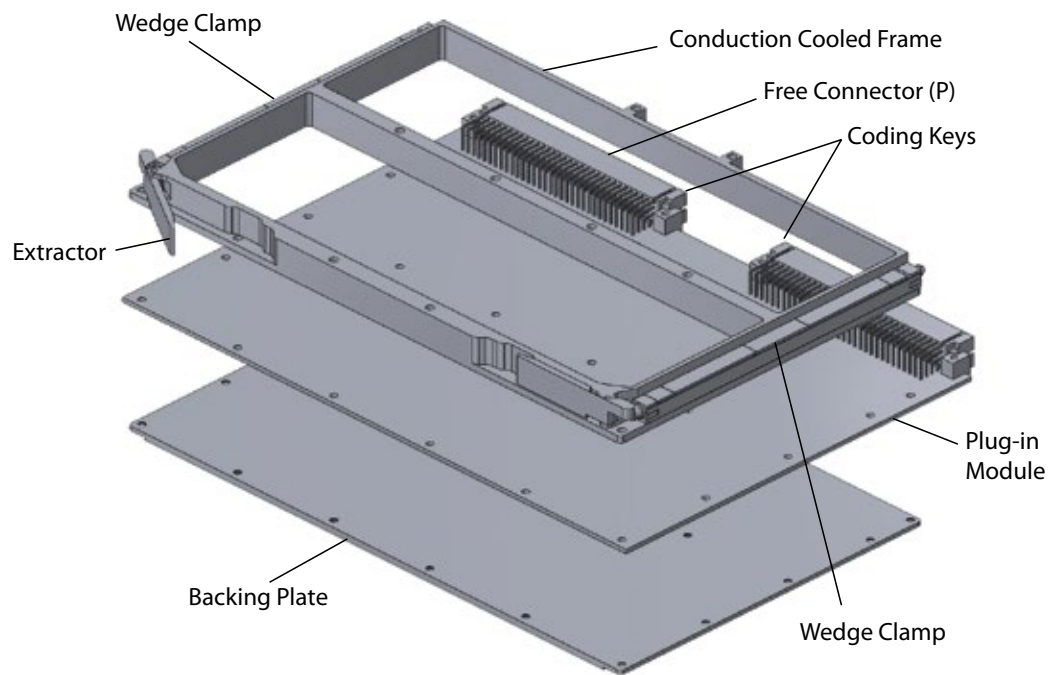
Custom Conduction Cooled Frames

## FEATURES

- Conduction frames available in 3U or 6U, VME or cPCI based designs
- Can accommodate ccPMC or XMCs
- Extractors provide ample force to disengage board connectors
- Available in Black Anodize, Chem film or Electroless Nickel plating for excellent corrosion resistance
- 6061-T651 aluminum provides high thermal conductivity as well as lightweight support
- Locking Helicoils secure board fasteners in extreme vibration environments
- High performance five piece wedge clamp provides high clamping force with even pressure distribution for low thermal resistance
- Frame and backing plate are each machined from a solid piece to assure high heat transfer and structural integrity
- Custom silkscreen available

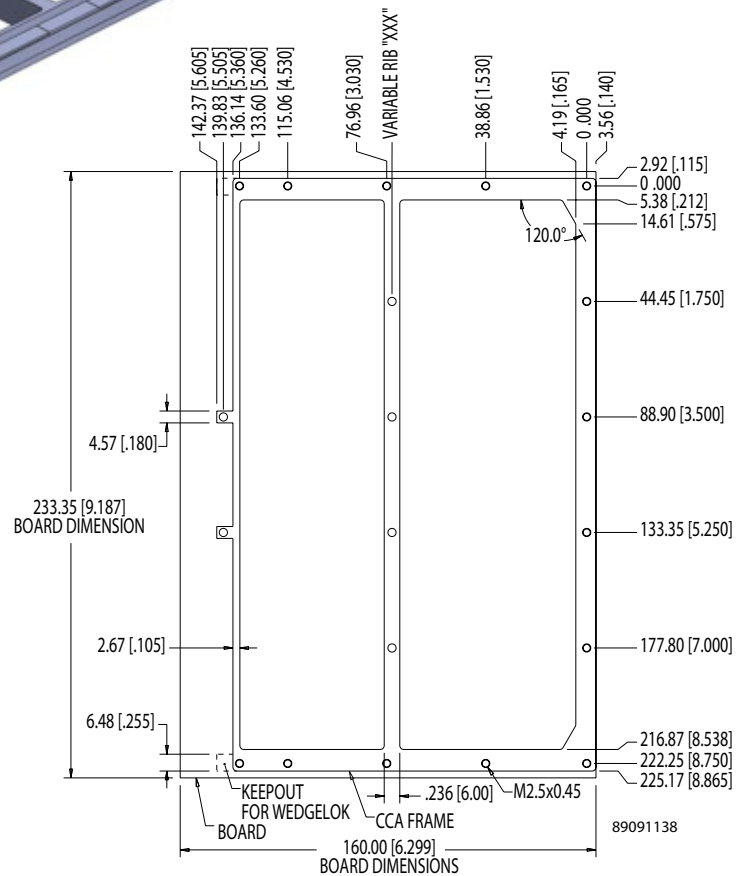
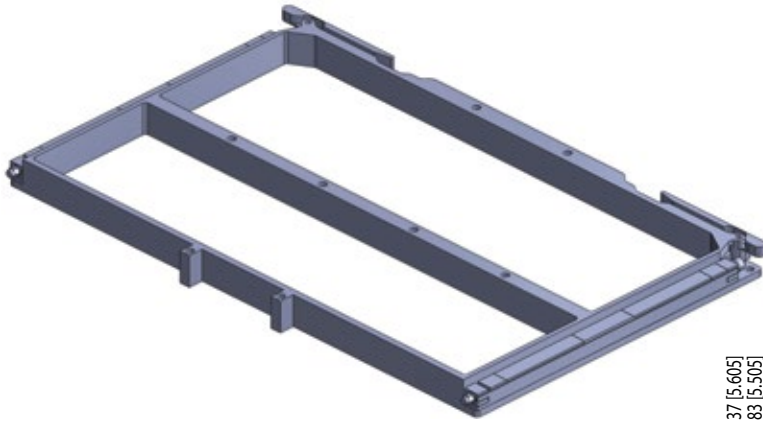
## ACCESSORY

- Code Keys prevent VME64x Conduction Cooled Assemblies from inadvertent insertion into the wrong slot



89090687

3U and 6U designs are available with compliance to IEEE 1101.2 and VITA 30.1 specifications.  
Conduction Cooled PMC modules can be incorporated per VITA 20.



## Part Number Code Conduction Cooled Assemblies

|                                                          | CC | B | 3 | V | XXX | G | B16 | L       |
|----------------------------------------------------------|----|---|---|---|-----|---|-----|---------|
| Version _____                                            |    | B |   |   |     |   |     |         |
| 3U _____                                                 |    |   | 3 |   |     |   |     |         |
| 6U _____                                                 |    |   | 6 |   |     |   |     |         |
| VME (1101.2) _____                                       |    |   |   | V |     |   |     |         |
| cPCI (VITA 30.1) _____                                   |    |   |   | C |     |   |     |         |
| Center rib location (mm.m) _____                         |    |   |   |   | XXX |   |     |         |
| PMC for ccPMC mounting _____                             |    |   |   |   | PMC |   |     |         |
| Gold Chemical Film Finish<br>or choose from Finish Table |    |   |   |   |     | G |     |         |
| Backing Thermal strip 1.6mm _____                        |    |   |   |   |     |   | B16 |         |
| Backing Thermal strip 2.4mm _____                        |    |   |   |   |     |   | B24 |         |
| Backing Plate 1.6mm _____                                |    |   |   |   |     |   | P16 |         |
| Backing Plate 2.4mm _____                                |    |   |   |   |     |   | P24 |         |
| Latching Extractor handle _____                          |    |   |   |   |     |   |     | L       |
| no latching _____                                        |    |   |   |   |     |   |     | [blank] |

## Part Number Code Example:

CCB3VPMCBP16L

Conduction Cooled Assembly 3U VME designed with ccPMC mounting, black anodized, with 1.6mm backing plate and latching extractors

## FINISH TABLE

| Code Letter | Finish                                                      |
|-------------|-------------------------------------------------------------|
| "G"         | Gold Chemical Film per Mil-DTL-5541 Class 1A, Type 1        |
| "R"         | Clear Chemical Film per Mil-DTL-5541 Class 3, Type II       |
| "CC"        | Clear Chemical Film per Mil-DTL-5541 Class 1A, Type II      |
| "B"         | Black Anodize per Mil-A-8625 Type II, Class 2               |
| "N"         | Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright |

Calmark has the answer for those IEEE 1101.10 applications with keying requirements, but do not have front panels. IEEE 1101.10 specifications provides a method for keying slots using programming keys inserted into the front panel assembly and card guide.

Conduction Cooled Modules used in military and ruggedized systems do not use this front panel system. VITA 1.6 standard provides a method of keying for these types of systems.

## FEATURES

- Complies with ANSI VITA 1.6 Standard
- Gold or Clear Chem Film aluminum bracket
- 6 configurations per coding bracket set
- 36 configurations in a 6U conduction cooled application
- Up to 1296 Keying combinations in a 6U non-conduction cooled application
- Complimentary mounting hardware included

## CODEKEY BRACKETS

### Material:

Aluminum Alloy  
6061-T6 QQ-A-200/8

### Finish:

Mil-C Class 1A, Type 1, Gold or  
Mil-DTL-5541 Class 3, Type II, Clear

## CODE PINS

### Material:

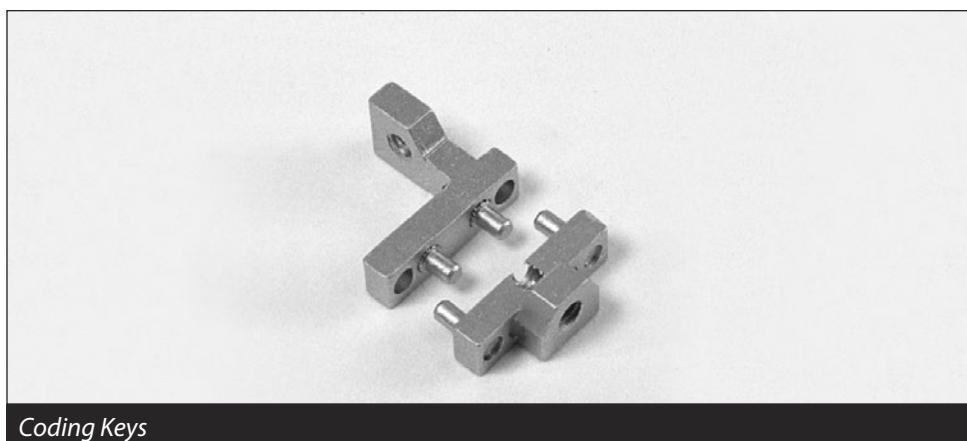
Austenitic Stainless Steel

### Finish:

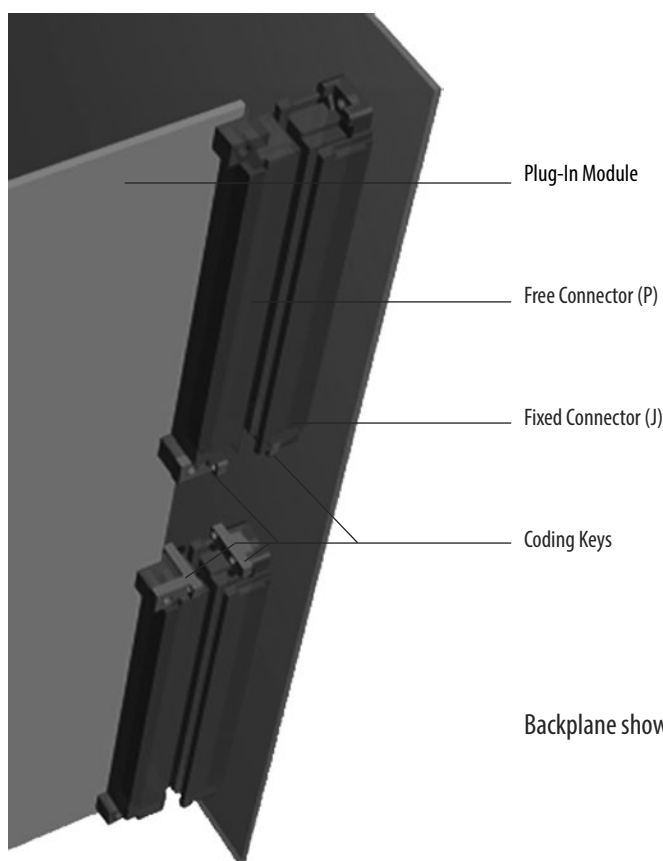
None

## WEIGHT

100 pcs. = 0.32 lbs.

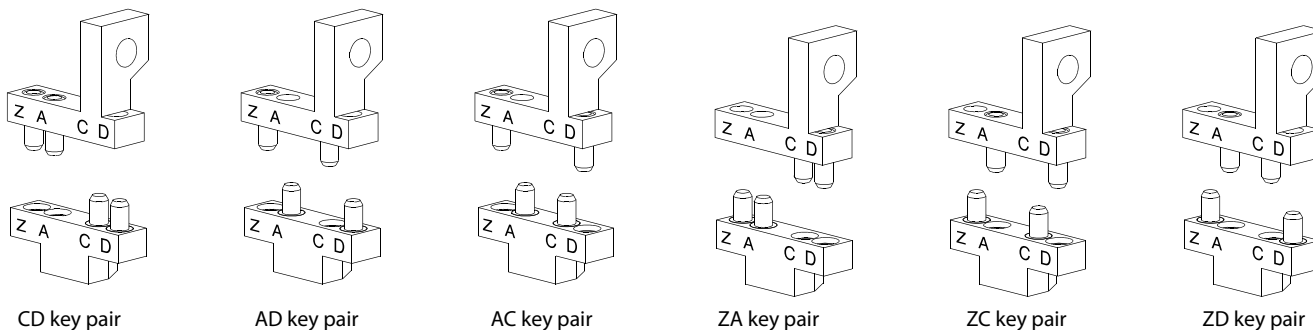


Coding Keys



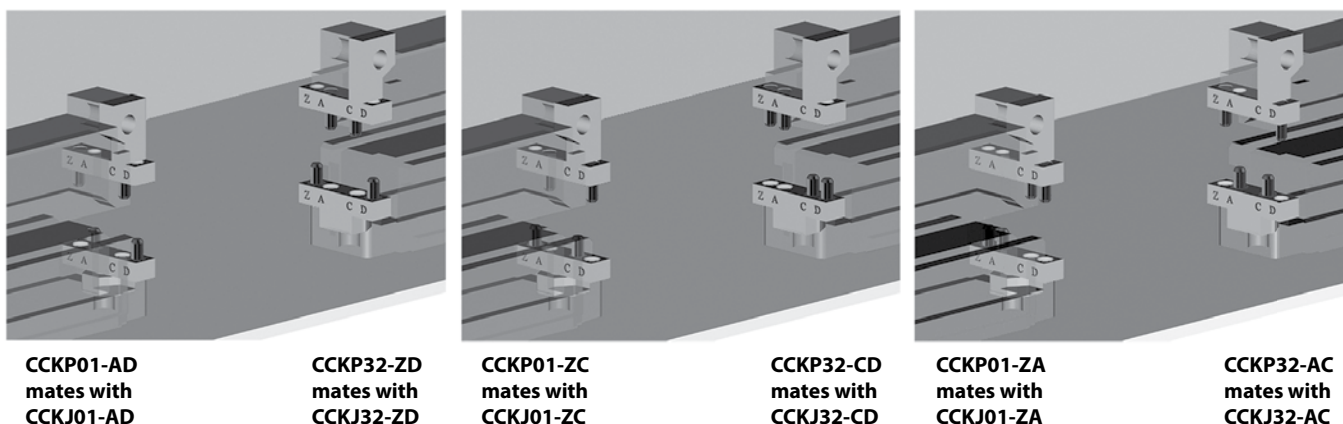
Backplane shown - without J0 for clarity





The drawings above are representative of the J32 and P32 configurations. J01 and P01 are mirror images.

## Samples of coding key usage



### Part Number Code Conduction Cooled Keying

#### Board or Backplane

Free Connector: \_\_\_\_\_ **P**  
Fixed Connector: \_\_\_\_\_ **J**

#### Connector End

01 \_\_\_\_\_ **01**  
32 \_\_\_\_\_ **32**

#### Keying Configuration

ZA \_\_\_\_\_ **ZA**  
ZC \_\_\_\_\_ **ZC**  
ZD \_\_\_\_\_ **ZD**  
AC \_\_\_\_\_ **AC**  
AD \_\_\_\_\_ **AD**  
CD \_\_\_\_\_ **CD**

#### Thread Type

Metric 2.5mm x .45 thread: \_\_\_\_\_ **[blank]**  
Imperial 2-56 thread: \_\_\_\_\_ **1**  
Imperial 2-56 locking helicoil: \_\_\_\_\_ **2**  
Metric 2.5mm x .45 locking helicoil: \_\_\_\_\_ **3**

#### Finish Type

Chem Film Gold \_\_\_\_\_ **[blank]**  
Chem Film Clear \_\_\_\_\_ **CC**

### Also available in Kit Form (see contents example below)

#### Keying Configuration

ZA \_\_\_\_\_ **ZA**  
ZC \_\_\_\_\_ **ZC**  
ZD \_\_\_\_\_ **ZD**  
AC \_\_\_\_\_ **AC**  
AD \_\_\_\_\_ **AD**  
CD \_\_\_\_\_ **CD**

#### Thread Type

Metric 2.5mm x .45 thread: \_\_\_\_\_ **[Blank]**  
Imperial 2-56 thread: \_\_\_\_\_ **-1**  
Imperial 2-56 locking helicoil: \_\_\_\_\_ **-2**  
Metric 2.5mm x .45 locking helicoil: \_\_\_\_\_ **-3**

#### Example of Kit Contents:

##### CCK-KIT-ZA

| Qty | Item                          |
|-----|-------------------------------|
| 1   | CCKP01-ZA                     |
| 1   | CCKJ01-ZA                     |
| 1   | CCKP32-ZA                     |
| 1   | CCKJ32-ZA                     |
| 4   | Complimentary Mounting Screws |
| 4   | Washers                       |

Calmark offers the New Series 223 and 224 Card-Lok retainer for cold plate – heat exchanger applications. Available in a 5.72 x 6.60 (.225 x .260, Series 223) profile and a 5.33 x 6.99 (.210 x .275, Series 224) profile, these series of Card-Loks feature a torque-limiting design to eliminate the need for a torque wrench. The torque-limiting feature will prevent the Card-Lok from damage to itself or the board module assembly due to over-tightening.

## FEATURES

- **Torque-Limiting Action** – A standard hex wrench locks the board module assembly into the cold wall providing a safe clamping force without the need for a torque wrench
- **High Reliability** – Screw actuated wedge action locks board module assemblies into place
- **Maximum Thermal Transfer** – Wedge action design provides maximum contact between thermal paths on board module assembly and heat sinking surface
- **Maximum Resistance to Shock & Vibration** – Wedge action design locks board module assembly in place to provide maximum resistance to shock and vibration
- **Zero Insertion & Extraction Forces** – Screw actuation provides zero insertion and extraction force on board module
- **Alignment Spring Feature** – returns wedge bodies to relaxed position when unclamping

## WEDGES

### Material:

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

### Finish:

See Finish Table

## TORQUE-LIMITING MECHANISM

### Material:

Stainless Steel 17-4 PH

### Finish:

Dry Film Lube per Mil-L-46010 Type 1

## SCREW

### Material:

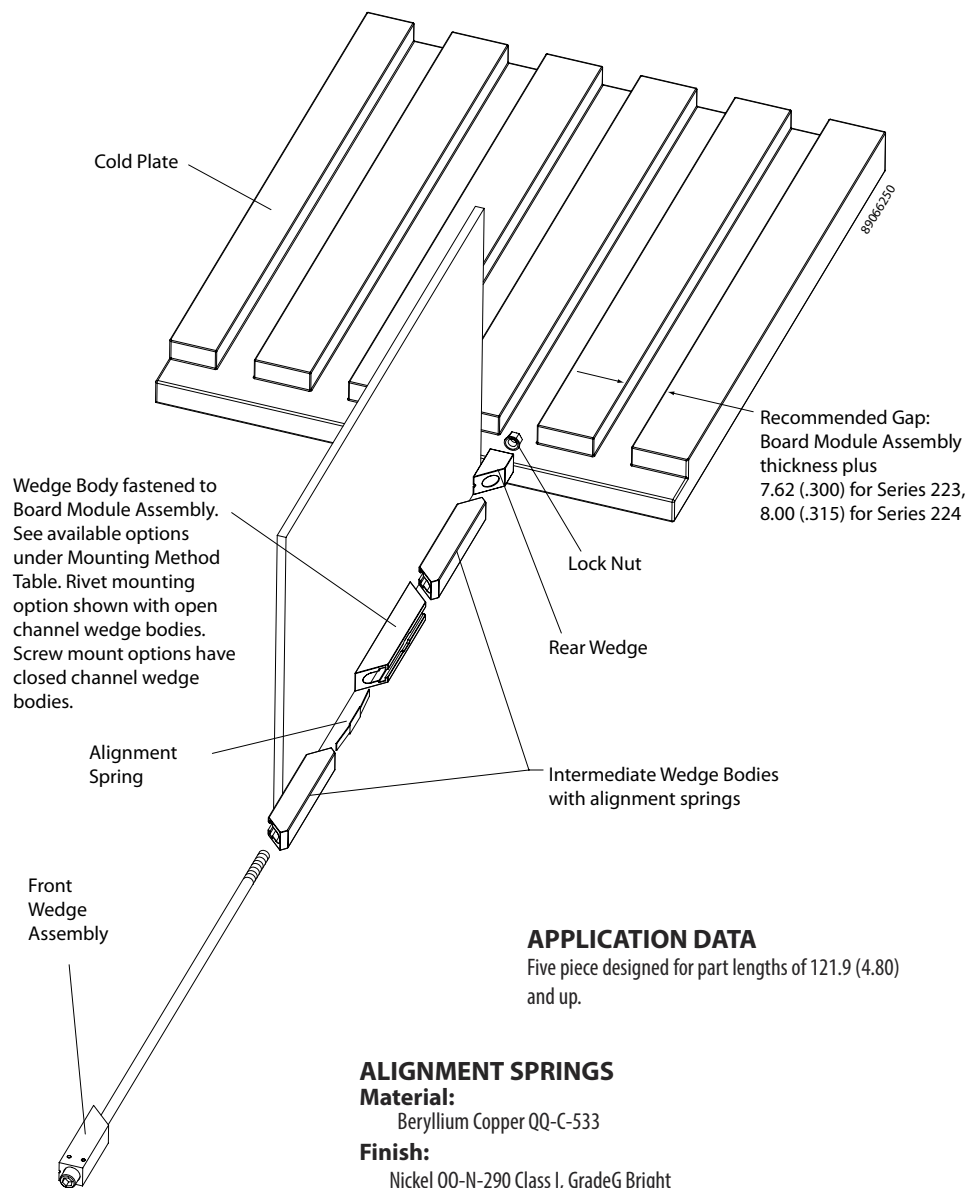
Stainless steel per ASTM-A582

### Finish:

Passivate per AMS2700



Series 223 & Series 224 Torque-Limiting "Card-Lok" Patent no. 7,883,289



## APPLICATION DATA

Five piece designed for part lengths of 121.9 (4.80) and up.

## ALIGNMENT SPRINGS

### Material:

Beryllium Copper QQ-C-533

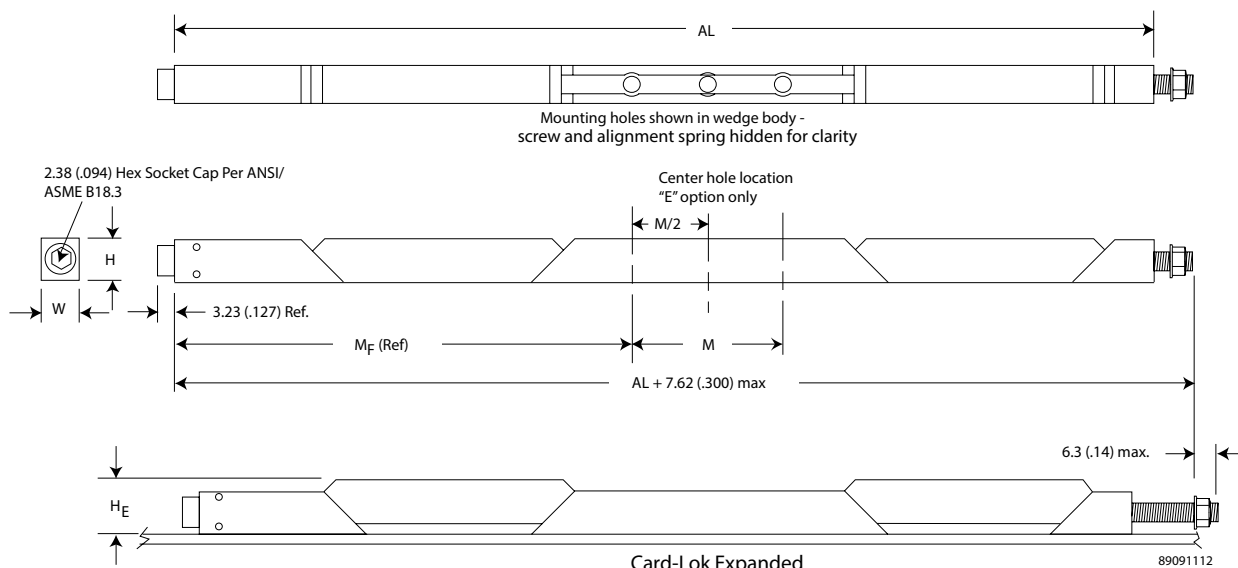
### Finish:

Nickel QQ-N-290 Class I, GradeG Bright

## WEIGHT

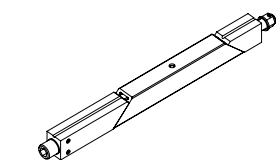
1.12g/cm (.1oz/in)

# Series 223 & Series 224 Torque-Limiting "Card-Lok" CALMARK™

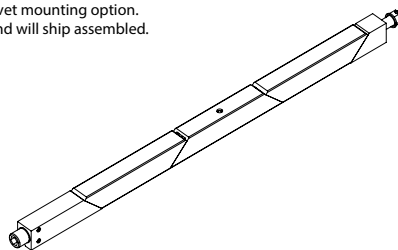


Card-Lok above shown with open channel wedge bodies for rivet mounting option. Screw mounting options have closed channel wedge bodies and will ship assembled.

Units: mm (in)  
Unless otherwise specified:  
.xx ± .25, .x ± .5 (.xxx ± .010, .xx ± .02)  
Note: Each piece has a tolerance of ± .010



Lengths < 4 inches must be three segments.



Lengths ≥ 4 inches will be five segments.

| Series | W           | H max       | H <sub>E</sub> min. |
|--------|-------------|-------------|---------------------|
| 223    | 5.72 (.225) | 6.86 (.270) | 8.26 (.325)         |
| 224    | 5.33 (.210) | 7.24 (.285) | 8.64 (.340)         |

| AL range ± 1.3 (.050)             | M ± .13 (.005) | M <sub>E</sub> ± .76 (.030) |
|-----------------------------------|----------------|-----------------------------|
| From 71.12 (2.80) - 190.4 (7.49)  | 22.86 (.90)    | $AL + 12.5 (.500) - M$<br>2 |
| From 190.5 (7.50) - 215.9 (8.49)  | 48.26 (1.90)   |                             |
| From 216.0 (8.50) - 329.9 (12.99) | 73.66 (2.90)   |                             |

## Part Number Code

### Series 223 TL Card-Lok Three or Five Piece

### Series 224 TL Card-Lok Three or Five Piece

#### Prefix options

Black Anodize \_\_\_\_\_ A  
or choose from Finish Table

#### Suffix options

Assembly length in inches. Standard lengths are 71.12 (2.80), 96.52 (3.80), 121.9 (4.80) and 147.32 (5.80). Other lengths available upon request. length.xx

Additional Center Mounting Hole \_\_\_\_\_ E  
None \_\_\_\_\_ [blank]

#### Mounting options

2-56 tapped mounting hole \_\_\_\_\_ T2  
or choose from Mounting Method Table

## Part Number Code Example:

A224- 5.00T2R

Series 224 Card-Lok 5 piece 127.0 (5.0) long assembly length, black anodized with two 2-56 threaded mounting holes and lock nut

## FINISH TABLE

| Code Letter | Finish                                                       |
|-------------|--------------------------------------------------------------|
| [blank]     | Chemical Film Finish Gold per Mil-DTL-5541, Type 1 Class 1A  |
| "R"         | Chemical Film Finish Clear per Mil-DTL-5541, Class 3 Type II |
| "A"         | Black Anodize per Mil-A-8625, Type II, Class 2               |
| "HA"        | Hard Black Anodize per Mil-A-8625, Type III, Class 2         |
| "EN"        | Electroless Nickel per Mil-C-26074, Class 4 Grade B, Bright  |

## MOUNTING METHOD TABLE

| Code Letter | Method                                                                                                                                                                 |
|-------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| "H"         | Rivet Mounting Ø1.70 (.067) hole with 3.96 (.156) counterbore x 5.08 (.200) deep and 100° x 3.56 (.140) countersink<br>"H" is available only for open channel version. |
| "T0"        | 0-80 tapped hole                                                                                                                                                       |
| "T2"        | 2-56 tapped hole                                                                                                                                                       |
| "TM2"       | M2 x 0.40 tapped hole                                                                                                                                                  |
| "TM2.5"     | M2.5 x 0.45 tapped hole                                                                                                                                                |

Calmark offers the Series 225 "Card-Lok" Retainer for cold plate-heat exchanger applications. This is an economical wedge clamp retainer for high efficiency heat transfer from Board Module Assembly to Cold Wall.

### FEATURES

- Maximum Reliability – Screw-actuated wedge action locks Board Module Assembly in place
- Maximum Thermal Transfer – Wedge action design provides maximum contact between thermal paths on Board Module Assembly and the heat sinking surface
- Maximum Resistance to Shock & Vibration – Wedge action design locks Board Module Assembly in place to provide maximum resistance to shock and vibration
- Zero Insertion & Extraction Forces – Screw actuation provides zero insertion and extraction force on Board Module Assembly
- Design Flexibility – Special lengths, finishes or other design variations available on request

### BODIES & WEDGES

#### Material:

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

#### Finish:

See Finish Table

### SCREW

.093 in or 2.5 mm hex. drive socket head cap screw

#### Material:

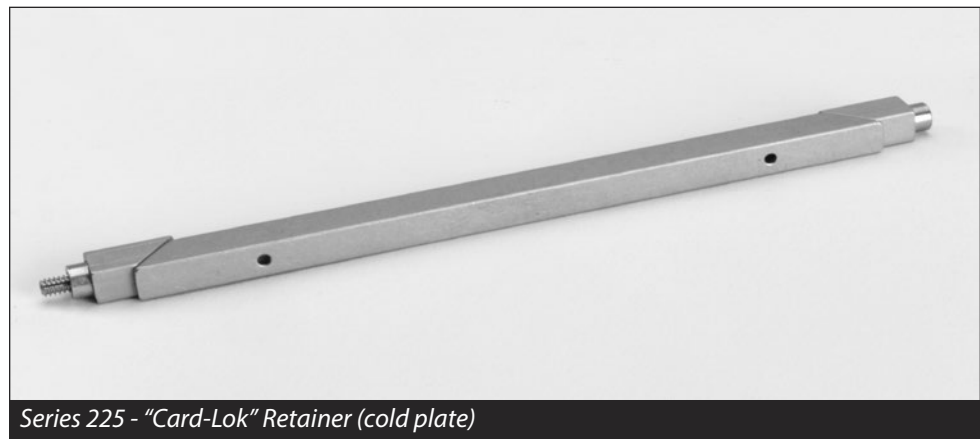
Stainless steel per ASTM-A582

#### Finish:

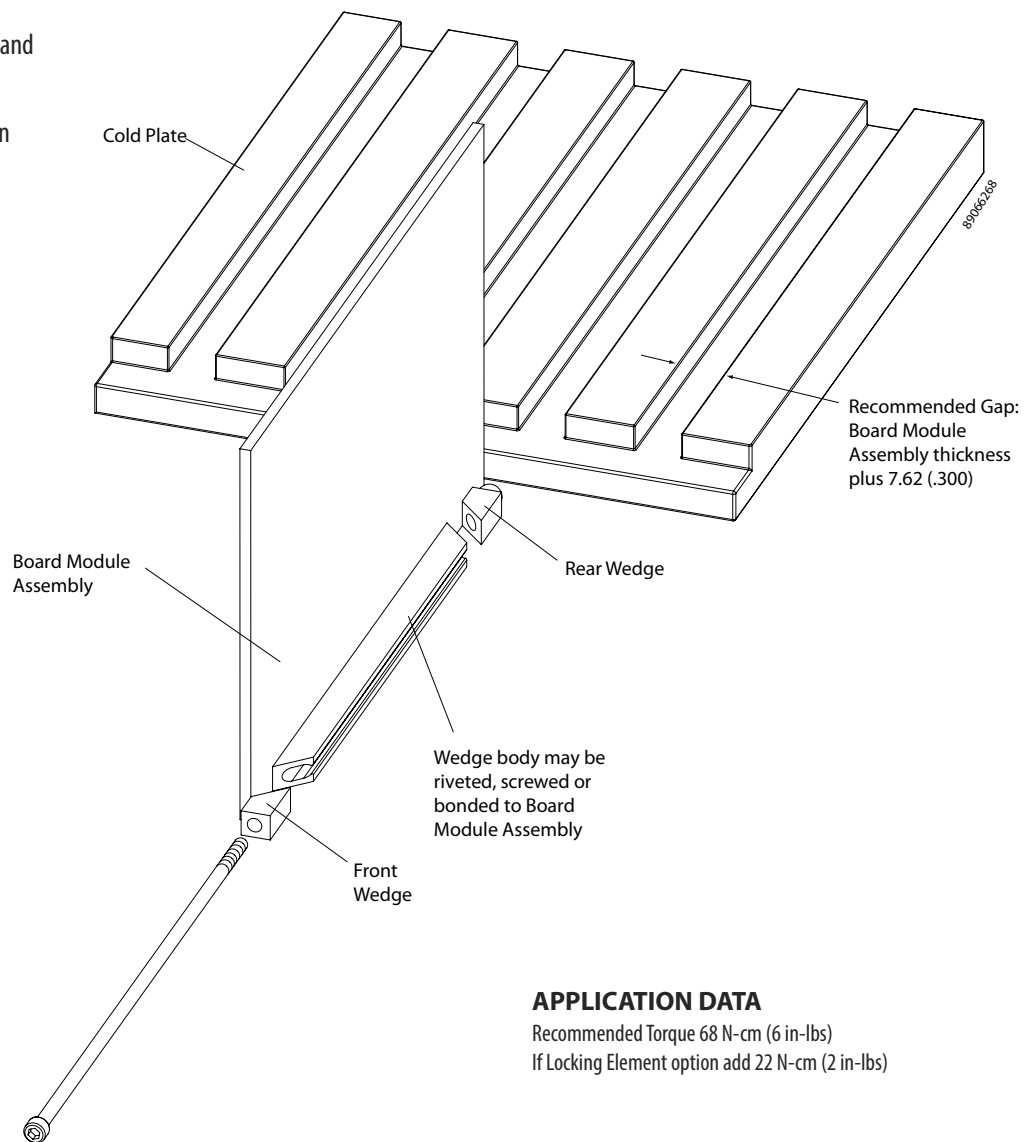
Passivate per AMS2700

### WEIGHT

1.34 g/cm (.120 oz/in)



Series 225 - "Card-Lok" Retainer (cold plate)



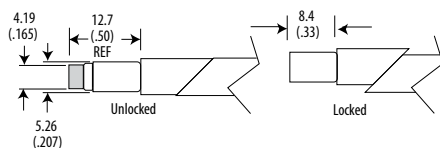
### APPLICATION DATA

Recommended Torque 68 N-cm (6 in-lbs)  
If Locking Element option add 22 N-cm (2 in-lbs)

## OPTION PREFIX

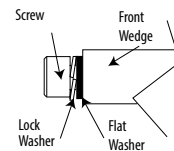
### Detail "V"

Provides visual lock indication.



### Detail "W"

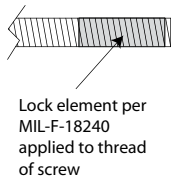
Provides added resistance to loosening from shock and vibration. This option adds 2.5 (.10) to the screw length unless combined with the "R" suffix option, then adds 5.1 (.20) total.



## OPTION SUFFIX

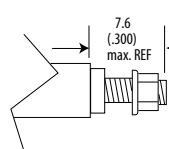
### Detail "L"

Provides prevailing torque for resistance to loosening from shock and vibration. Adds 22 N-cm (2 in-lbs) of torque to assembly. See application data on previous sheet.



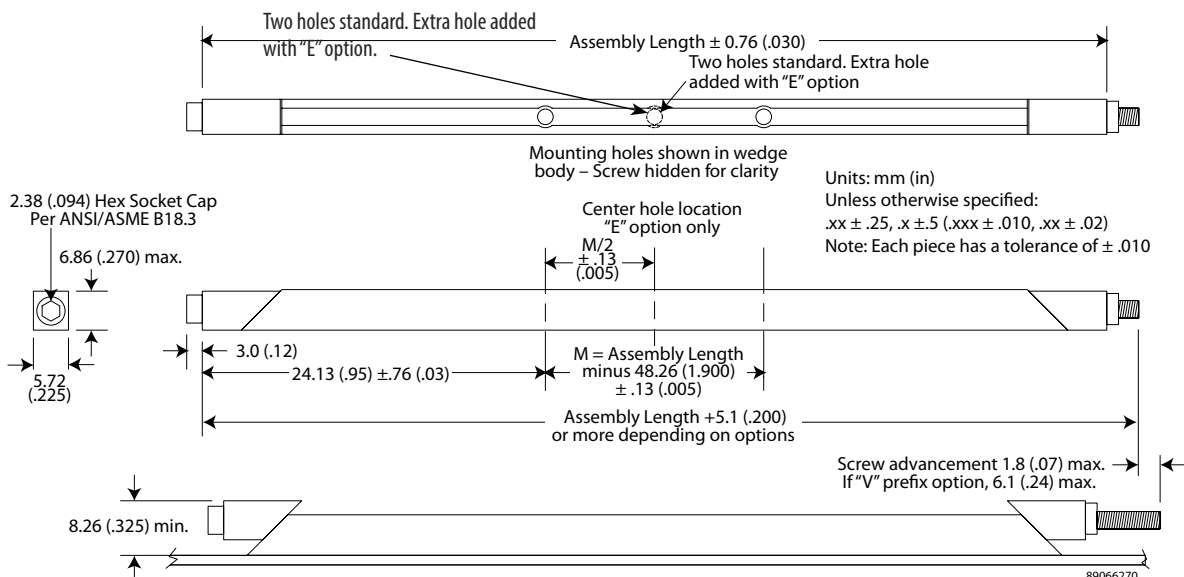
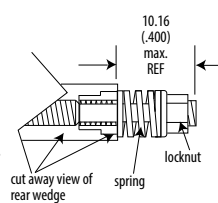
### Detail "R"

Reduces the possibility of unintentional disassembly of the screw from rear wedge. This option adds 2.5 (.10) to the screw length unless combined with the "W" suffix option, then 5.1 (.20) total.



### Detail "K"

Prevents the unintentional disassembly of screw from rear wedge. This option adds 5.1 (.20) to the screw length.



## Part Number Code

### Series 225 Card-Lok Three Piece

None [blank]

### Prefix options

Metric Screw Head M2.5 Hex Drive **M**  
Standard Screw Head 3/32 [blank]  
Lock and Flat Washer **W**  
None [blank]  
Visual Indicator **V**  
No Visual Indicator [blank]  
Black Anodize **A**  
or choose from Finish Table **see table**

### Suffix options

Stainless Steel Captive (and Lock Nut if "R" option is also selected) **CR**  
Standard Plated Steel **"-"**

Assembly length in inches. Standard lengths are 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80). Other lengths available upon request. **length.xx**

Additional Center Mounting Hole **E**  
None [blank]  
Mounting Options - holes for rivet mounting **H**  
or choose from Mounting Option Table **see table**  
Lock Element **L**  
None [blank]  
Lock Nut **R**  
Captive Screw **K**  
None [blank]

## Part Number Code Example:

VA225CR4.80HR

Series 225 Card-Lok three piece 121.9 (4.80) long with Visual Indicator, Black Anodized Finish, standard rivet mounting hole and stainless steel captive nut and lock nut option

## Code

Letter  
[blank]  
"R"  
"A"  
"HA"  
"EN"

## FINISH TABLE

Finish  
Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold  
Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear  
Black Anodize per Mil-A-8625 Type II, Class 2  
Hard Black Anodize per Mil-A-8625 Type III, Class 2  
Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright

## Code

Letter  
[blank]  
"H"  
"TO"  
"T2"  
"TM2"  
"TM2.5"

## MOUNTING METHOD TABLE

Method  
No mounting holes  
Rivet Mounting Ø1.70 (.067) hole with 3.96 (.156) counterbore x 5.08 (.200) deep and 100° x 3.56 (.140) countersink  
0-80 tapped hole  
2-56 tapped hole  
M2 x 0.40 tapped hole  
M2.5 x 0.45 tapped hole



Calmark offers the feature of Ejection of the PC Card with its Series 225 "Card-Lok" Retainer. The Series E225 provides initial ejection of the PC card without damaging circuits, components or bending connector pins. Ejector feature E is also available on other Card-Lok Series on request.

### FEATURES

- **Safe and Easy Ejection of PC Card** – Screw actuation produces a jacking force that disengages the PC card from its mating connector
- **Maximum Reliability** – Screw-actuated wedge action locks PC card in place
- **Maximum Thermal Transfer** – Wedge-action design provides maximum contact between thermal path on PC card and the heat sink surface
- **Maximum Resistance to Shock & Vibration** – Wedge action design locks PC card in place to provide maximum resistance to shock and vibration
- **Zero Insertion & Extraction Forces** – Screw actuation provides zero insertion and extraction force on PC card
- **Design Flexibility** – Special lengths, finishes or other design variations available on request

### MATERIALS & FINISHES

#### BODY & WEDGES

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

#### Finish:

See Finish Table

#### SCREW

Stainless Steel per ASTM-A582 or

#### Finish:

Passivate per MIL-S-5002

#### RETAINER RING

Stainless Steel per ASTM-A582

#### Finish:

Passivate per MIL-S-5002

#### THREADED INSERT

MS122116, MS21209-C0210 (locking), 50253-1064

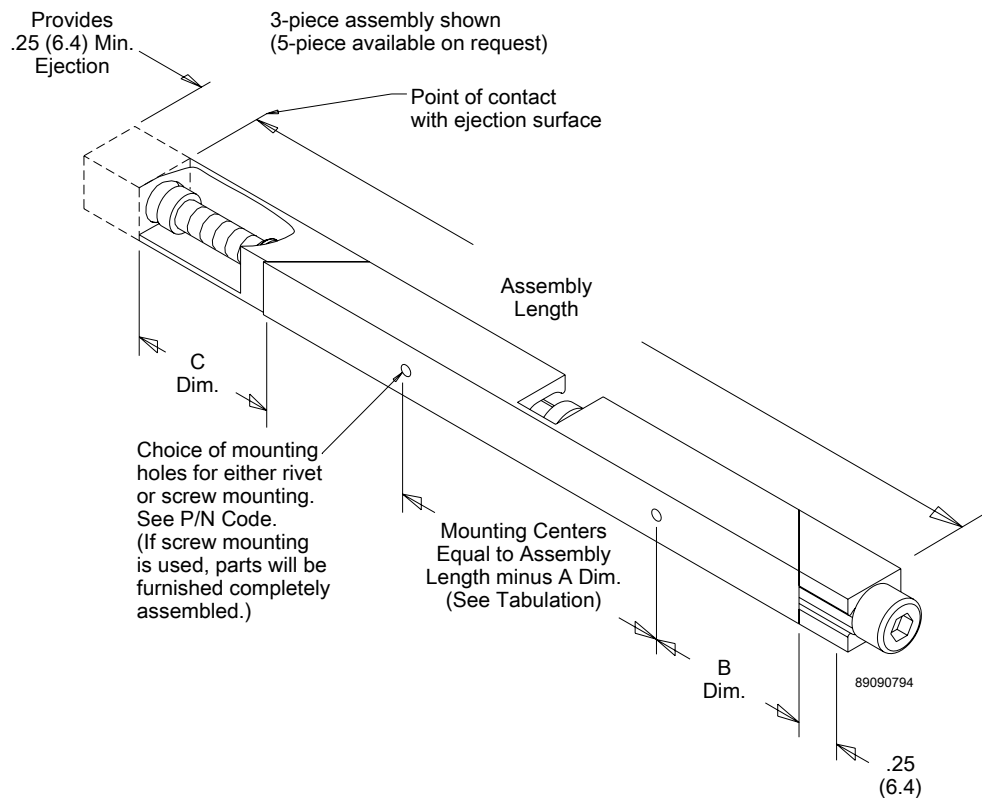
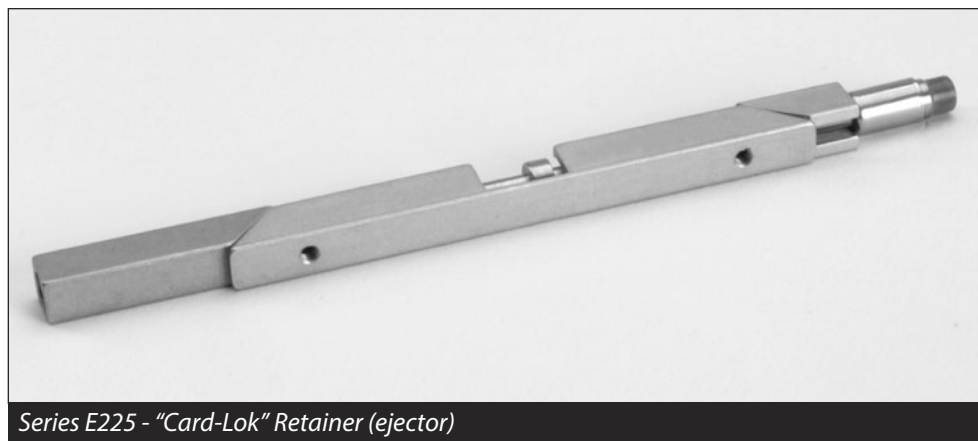
#### TOLERANCES

.xxx +/- .010    .xx +/- .02  
(.xx +/- 0.25    .x +/- 0.5)

#### NOTES

Clamping characteristics are the same as standard Series 225.

"E" feature available on other Card-Lok series on request.



### APPLICATION DATA

All mounting options except for "H" (rivet mounting), parts are completely assembled for shipping.

For "H" (rivet) Mounting Option, the screw assembly and wedge body are shipped unassembled.

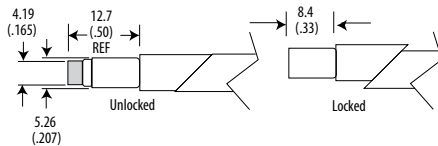
Assemble parts as follows:

1. Rivet Wedge Body to Printed Circuit Board.
2. Insert Screw Assembly into Wedge Body.
3. Collapse Wedge Body to captivate screw assembly.

## OPTION PREFIX

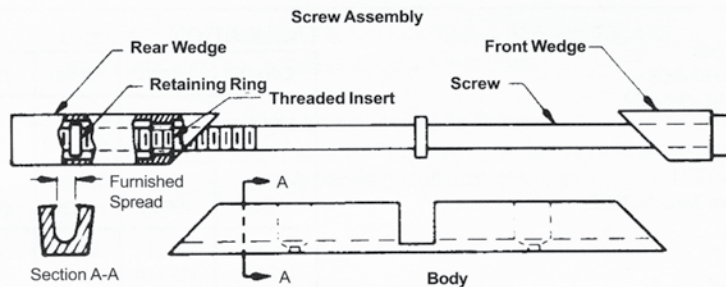
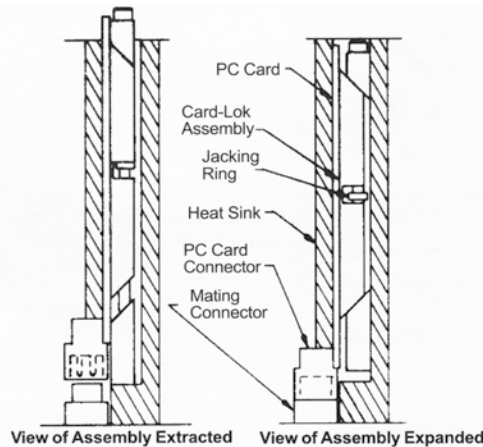
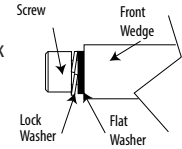
### Detail "V"

Provides visual lock indicator.



### Detail "W"

Provides added resistance to loosening from shock and vibration.



## Part Number Code Series E225 Card-Lok Three Piece

### Prefix options

Metric Screw Head M2.5 Hex Drive **M**  
Standard Screw Head 3/32 Hex Drive **[blank]**  
Lock and Flat Washer **W**  
None **[blank]**  
Visual Indicator **V**  
No Visual Indicator **[blank]**  
Black Anodize **A**  
or choose from Finish Table **see table**

### Suffix options

Assembly length in inches. Standard lengths are 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80). Other lengths available upon request. **length.xx**

Mounting Options - holes for rivet mounting **H**  
or choose from Mounting Method Table **see table**

## Part Number Code Example:

WVE225-4.80T2

Series E225 Ejecting Card-Lok three piece 121.9 (4.80) long with Lock and Flat Washer, Visual Indicator, Gold Chemical Film Finish, mounting holes drilled and tapped for 2-56 screw

## FINISH TABLE

| Code Letter    | Finish                                                      |
|----------------|-------------------------------------------------------------|
| <b>[blank]</b> | Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold       |
| <b>"R"</b>     | Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear      |
| <b>"A"</b>     | Black Anodize per Mil-A-8625 Type II, Class 2               |
| <b>"HA"</b>    | Hard Black Anodize per Mil-A-8625 Type III, Class 2         |
| <b>"EN"</b>    | Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright |

## MOUNTING METHOD TABLE

| Code Letter    | Method                                                                                                              |
|----------------|---------------------------------------------------------------------------------------------------------------------|
| <b>[blank]</b> | No mounting holes                                                                                                   |
| <b>"H"</b>     | Rivet Mounting Ø1.70 (.067) hole with 3.96 (.156) counterbore x 5.08 (.200) deep and 100° x 3.56 (.140) countersink |
| <b>"T0"</b>    | 0-80 tapped hole                                                                                                    |
| <b>"T2"</b>    | 2-56 tapped hole                                                                                                    |
| <b>"TM2"</b>   | M2 x 0.40 tapped hole                                                                                               |
| <b>"TM2.5"</b> | M2.5 x 0.45 tapped hole                                                                                             |

Calmark offers Series L225 Lever-Lok ("Card-Lok") Retainer which provides tool free, lever action locking on the Series 225 configuration "Card-Lok."

### FEATURES

- High Reliability – Lever-actuated wedge action locks Board Module Assembly in place
- High Thermal Transfer – Wedge action design provides maximum contact between thermal path on Board Module Assembly and heat sink
- High Resistance to Shock & Vibration – Wedge action design locks Board Module Assembly in place to provide excellent protection against severe shock and vibration
- Zero Insertion & Extraction Forces – Lever actuation provides zero insertion and extraction force on Board Module Assembly
- Design Flexibility – Special lengths, finishes or other design variations available on request

### MATERIALS & FINISHES

#### BODY & WEDGES

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

#### Finish:

Black Anodize per MIL-A-8625, Type II, Class 2

#### SCREW

Stainless steel per QQ-S-763

#### Finish:

Passivate per MIL-S-5002

#### LEVER ARM

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

#### Finish:

Hard Black Anodize per MIL-A-8625, Type III, Class 2

#### FLAT WASHER & BELLEVILLE WASHERS

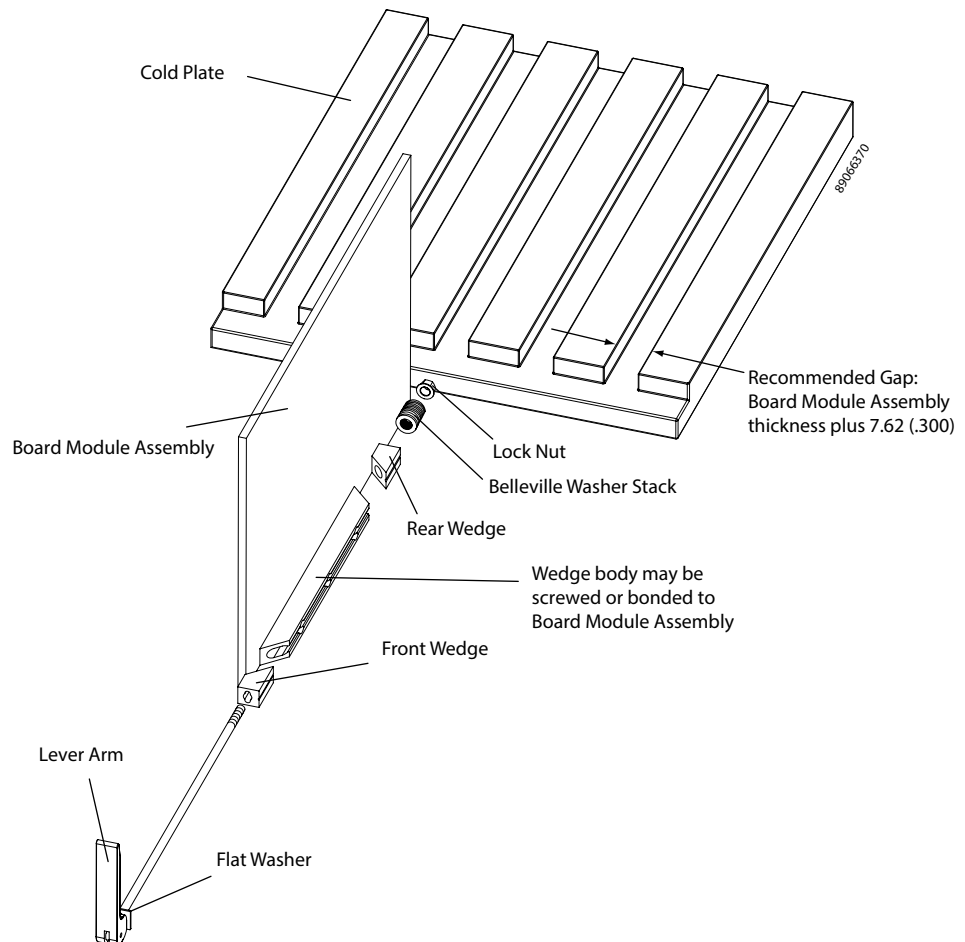
Stainless Steel. QQ-S-763.  
Passivate per MIL-S-5002.

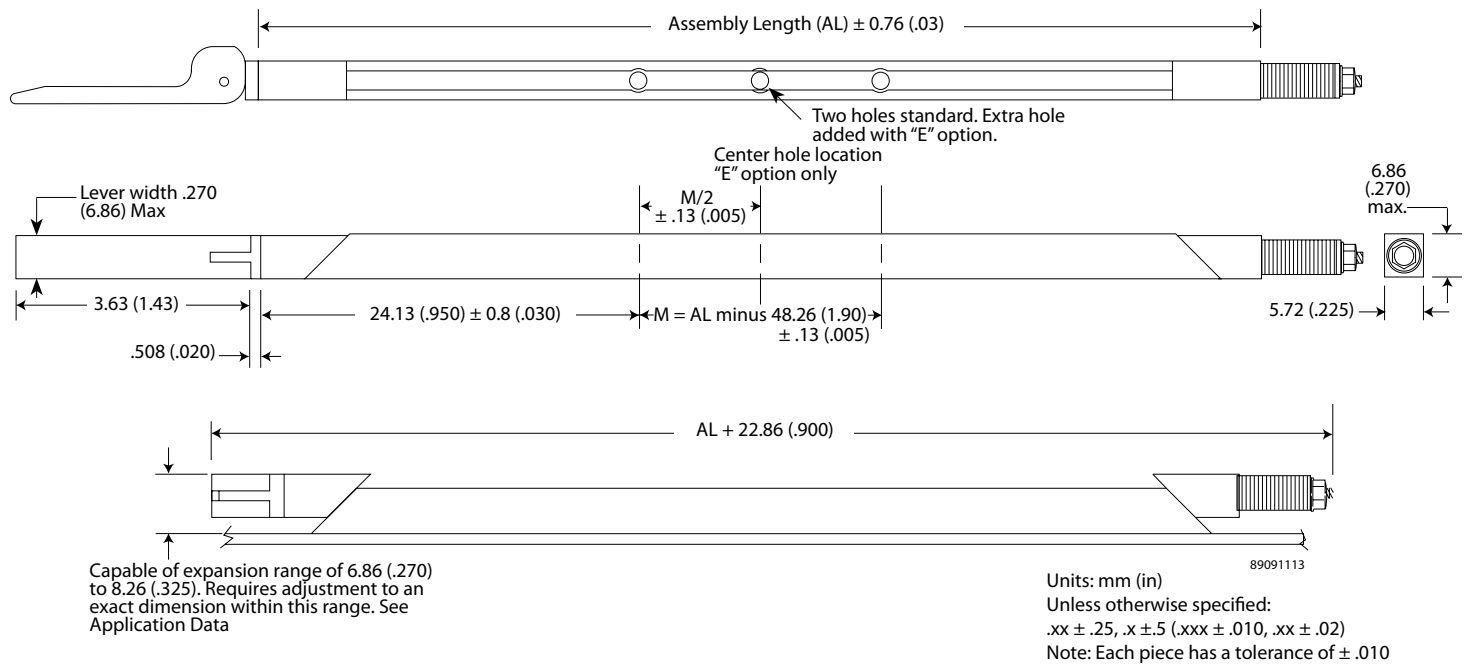
#### WEIGHT

1.65g/cm (.15oz/in)



Series L225 - "Card-Lok" Retainer (lever-lok)





## APPLICATION DATA

### CLAMPING FORCE ADJUSTMENT PROCEDURE

NOTE: Lever-Lok furnished assembled but not adjusted.

1. Fasten Lever-Lok to Board Module Assembly.
2. Insert Board Module Assembly into slot in cold plate.
3. Actuate lever to locked/closed position.
4. Tighten locknut on end of screw until wedges initially contact wall of cold plate slot, or slight insertion/extraction drag is felt.
5. Additionally tighten locknut two (2) full turns.  
**DO NOT EXCEED TWO (2) TURNS.**
6. Lever-Lok is now ready for use.

**NOTE: Factory adjustment of clamping force available on request.**

### CLAMPING FORCE DATA

Direct force of assembly is approximately 534N (120 lbs), when adjusted per recommended procedure.

Direct force of assembly is affected as follows: 8N (1.8 lbs) per each .025 (.001) variation of cold plate slot width, or 200N (45 lbs) per each full turn of locknut.

#### Part Number Code

Series L225 Card-Lok Three Piece

L225 - 3.80 E TO

#### Suffix options

Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80).

Other lengths available upon request

Additional Center Mounting Hole

No additional center mounting hole

Mounting Options - 0-80 tapped holes or choose from Mounting Option Table

length.xx

E

[blank]

TO

#### Part Number Code Example:

L225-2.80

Series L225 Ejecting Card-Lok three piece 71.12 (2.80) long with black anodize finish and 2-56 tapped holes

#### MOUNTING METHOD TABLE

| Code Letter | Method                  |
|-------------|-------------------------|
| [blank]     | 2-56` tapped hole       |
| "TO"        | 0-80 tapped hole        |
| "TM2"       | M2 x 0.40 tapped hole   |
| "TM2.5"     | M2.5 x 0.45 tapped hole |

Calmark offers the Series 226 "Card-Lok" retainer for cold plate-heat exchanger applications. A maximum efficiency heat sinking Board Module Assembly retainer designed specifically for part length of 4.80 (121.9) inches or longer with five or more wedge and body segments. The Series 226 design incorporates a Self-Positioning feature which minimizes wedge and body misalignment and provides easy insertion.

### FEATURES

- Self-positioning design minimizes wedge and body misalignment providing easy insertion
- Positive locking provides maximum reliability
- Maximum thermal transfer
- Maximum resistance to shock and vibration
- Zero insertion and extraction forces
- Design Flexibility - Special lengths, finishes or other design variations available on request

### BODIES & WEDGES

#### Material:

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

#### Finish:

See Finish Table

### SCREW

#### Material:

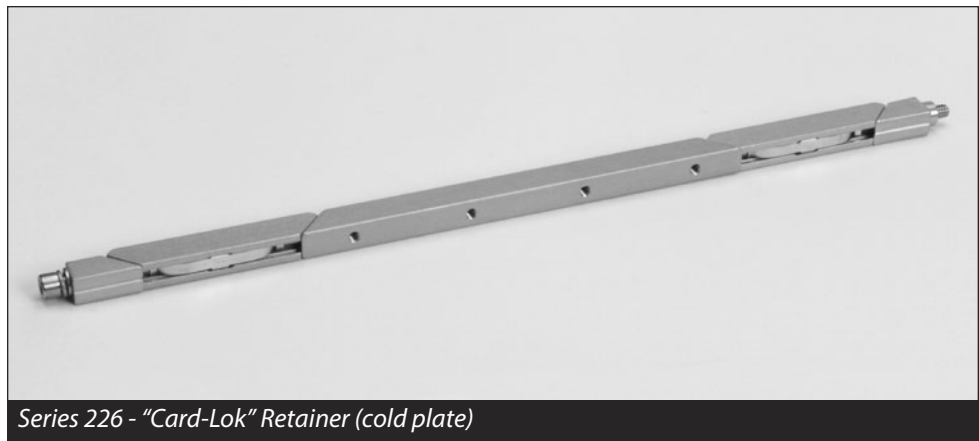
Stainless steel per ASTM-A582

#### Finish:

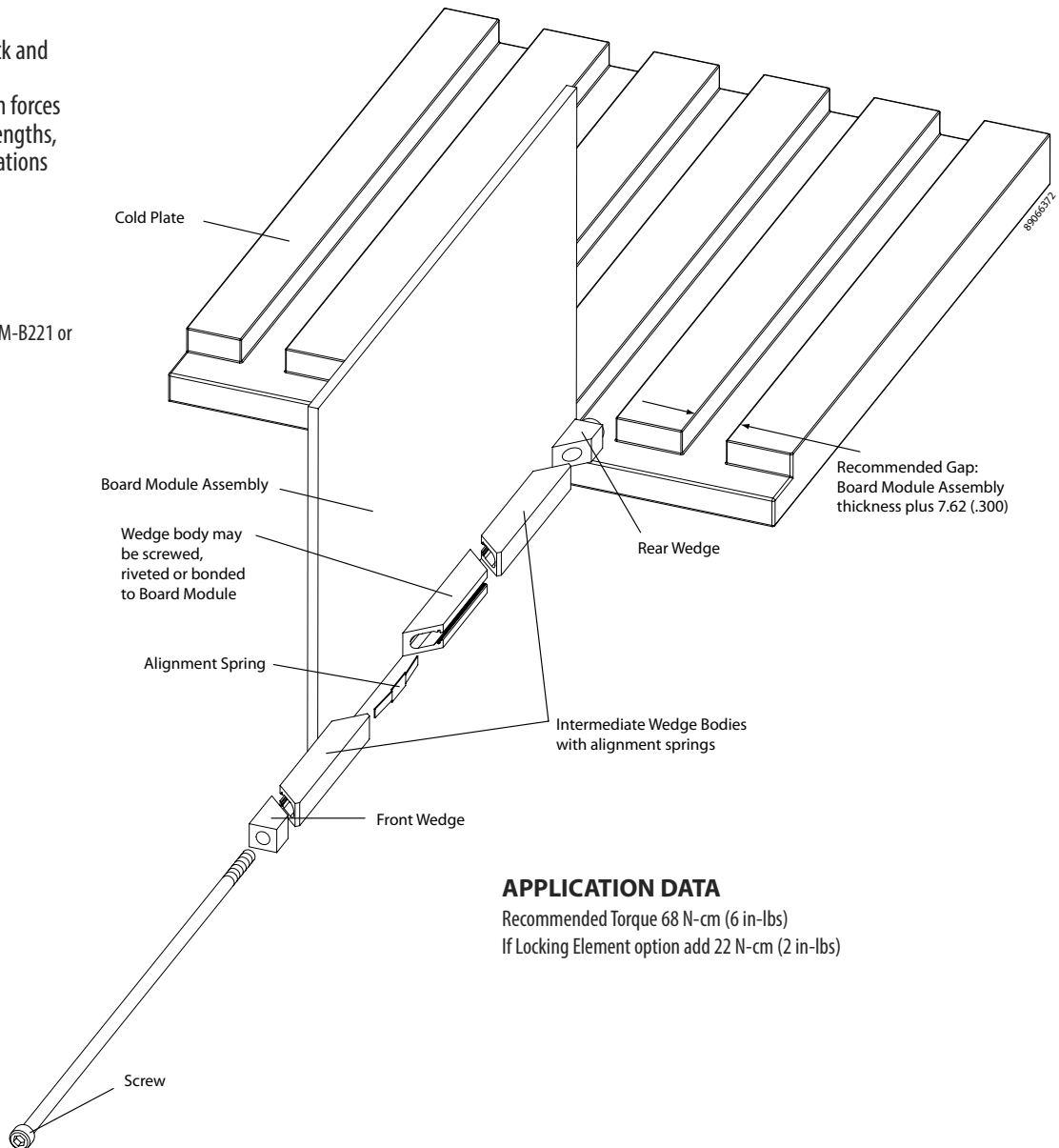
Passivate per AMS2700

### WEIGHT

1.34 g/cm (.120 oz/in)



Series 226 - "Card-Lok" Retainer (cold plate)



### APPLICATION DATA

Recommended Torque 68 N-cm (6 in-lbs)

If Locking Element option add 22 N-cm (2 in-lbs)



## OPTION PREFIX

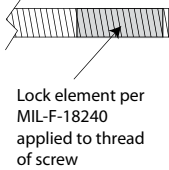
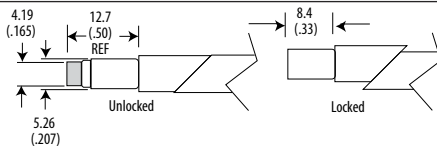
### Detail "V"

Provides visual lock indication.

## OPTION SUFFIX

### Detail "L"

Provides prevailing torque for resistance to loosening from shock and vibration. Adds 22 N-cm (2 in-lbs) of torque to assembly. See application data on previous sheet.

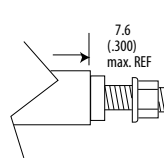


### Detail "R"

Reduces the possibility of unintentional disassembly of the screw from rear wedge. This option adds 2.5 (.10) to the screw length unless combined with the "W" suffix option, then 5.1 (.20) total.

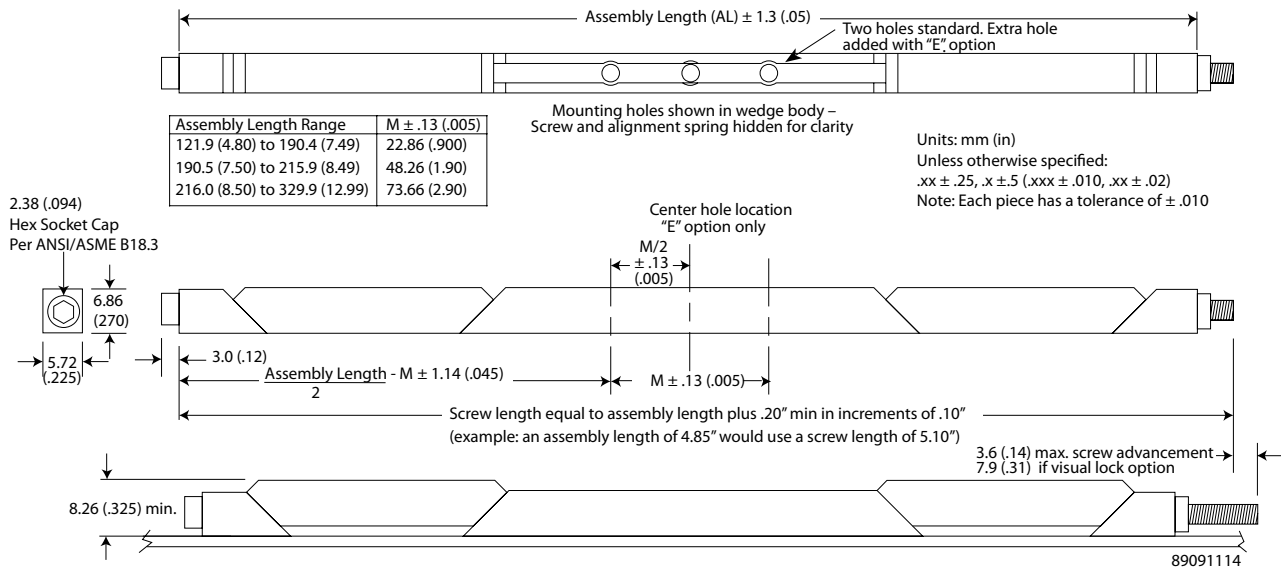
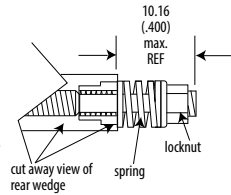
### Detail "W"

Provides added resistance to loosening from shock and vibration. This option adds 2.5 (.10) to the screw length unless combined with the "R" suffix option, then adds 5.1 (.20) total.



### Detail "K"

Prevents the unintentional disassembly of screw from rear wedge. This option adds 5.1 (.20) to the screw length.



## Part Number Code Series 226 Card-Lok Five Piece

None [blank]

M W V A 226 - 4.80 E H L R

**Prefix options**

Metric Screw Head M2.5 Hex Drive **M**

Standard Screw Head 3/32 Hex Drive [blank]

Lock and Flat Washer **W**

None [blank]

Visual Indicator **V**

No Visual Indicator [blank]

Black Anodize **A**

or choose from Finish Table **see table**

**Suffix options**

Stainless Steel Captive (and Lock Nut if "R" option is also selected) **CR**

Standard Plated Steel **"-"**

Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80). **length.xx**

Other lengths available upon request

Additional Center Mounting Hole **E**

None [blank]

Mounting Options - holes for rivet mounting or choose from Mounting Option Table **see table**

Lock Element **L**

None [blank]

Lock Nut **R**

Captive Screw **K**

None [blank]

## Part Number Code Example:

MWA226-4.80HK

Series 226 Card-Lok five piece 121.9 (4.80) long with M2.5 hex drive, lock and flat washer, black anodize finish, holes for rivet mounting and captive screw feature

## FINISH TABLE

| Code    | Letter | Finish                                                      |
|---------|--------|-------------------------------------------------------------|
| [blank] |        | Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold       |
| "R"     |        | Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear      |
| "A"     |        | Black Anodize per Mil-A-8625 Type II, Class 2               |
| "HA"    |        | Hard Black Anodize per Mil-A-8625 Type III, Class 2         |
| "EN"    |        | Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright |

## MOUNTING METHOD TABLE

| Code    | Letter | Method                                                                                                              |
|---------|--------|---------------------------------------------------------------------------------------------------------------------|
| [blank] |        | No mounting holes                                                                                                   |
| "H"     |        | Rivet Mounting Ø1.70 (.067) hole with 3.96 (.156) counterbore x 5.08 (.200) deep and 100° x 3.56 (.140) countersink |
| "T0"    |        | 0-80 tapped hole                                                                                                    |
| "T2"    |        | 2-56 tapped hole                                                                                                    |
| "TM2"   |        | M2 x 0.40 tapped hole                                                                                               |
| "TM2.5" |        | M2.5 x 0.45 tapped hole                                                                                             |

Calmark offers the Series 230 "Card-Lok" retainer for cold plate-heat exchanger applications. A mid-width configuration, to meet Board Module Assembly retainer expansion requirements between the Series 225 and 240.

### FEATURES

- Maximum Reliability – Screw-actuated wedge action locks Board Module Assembly in place
- Maximum Thermal Transfer – Wedge action design provides maximum contact between thermal paths on Board Module Assembly and the heat sinking surface
- Maximum Resistance to Shock & Vibration – Wedge action design locks Board Module Assembly in place to provide maximum resistance to shock and vibration
- Zero Insertion & Extraction Forces – Screw actuation provides zero insertion and extraction force on Board Module Assembly
- Design Flexibility – Special lengths, finishes or other design variations available on request

### BODIES & WEDGES

#### Material:

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

#### Finish:

See Finish Table

### SCREW

#### Material:

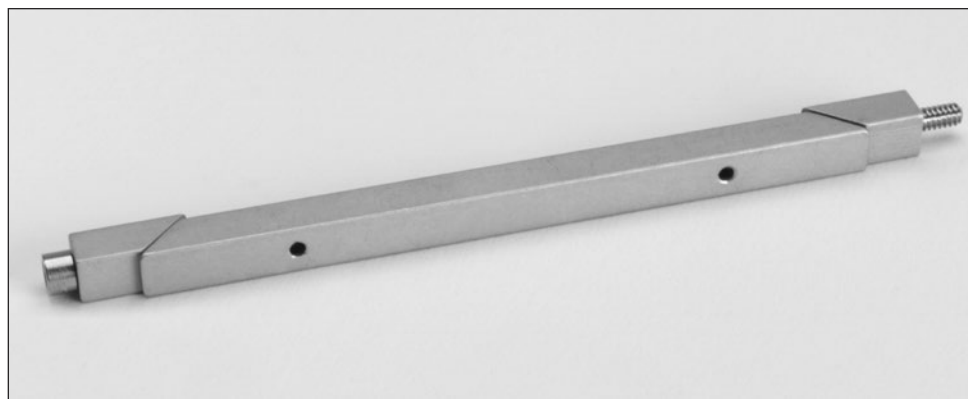
Stainless steel per ASTM-A582

#### Finish:

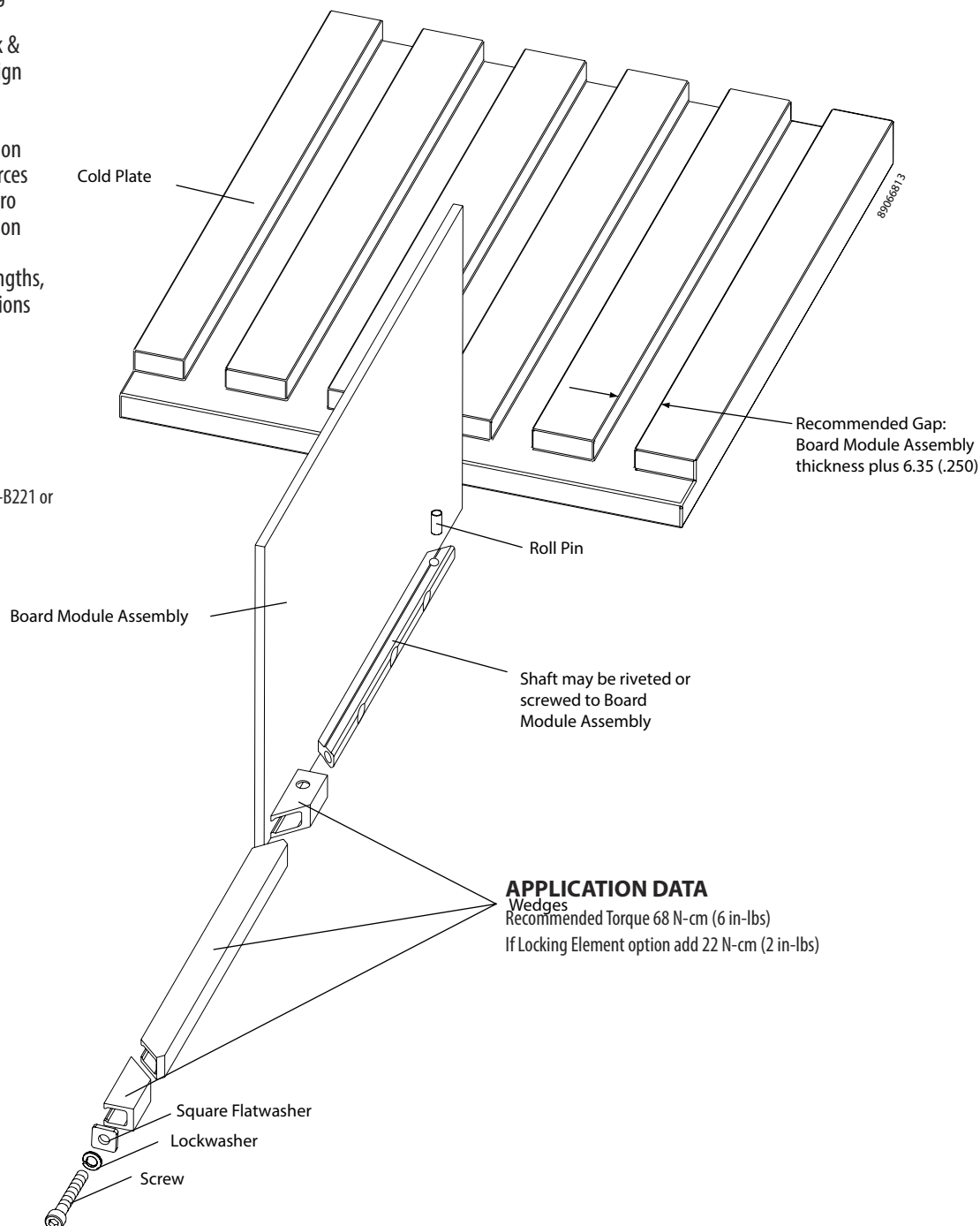
Passivate per AMS2700

### WEIGHT

1.34 g/cm (.120 oz/in)



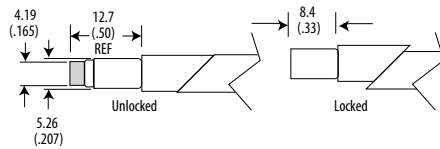
Series 230 - "Card-Lok" Retainer (cold plate)



## OPTION PREFIX

### Detail "V"

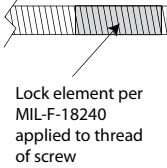
Provides visual lock indication.



## OPTION SUFFIX

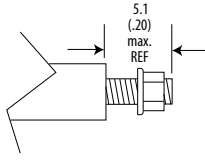
### Detail "L"

Provides prevailing torque for resistance to loosening from shock and vibration.



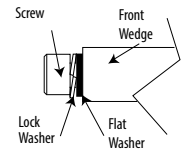
### Detail "R"

Reduces the possibility of unintentional disassembly of the screw from rear wedge. This option adds no additional screw length with or without "CR" unless included with "W" option, then 2.5 (.10) total.



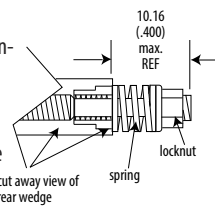
### Detail "W"

Provides added resistance to loosening from shock and vibration. This option adds no additional screw length unless combined with the "R" suffix option, then adds 2.5 (.10) total.



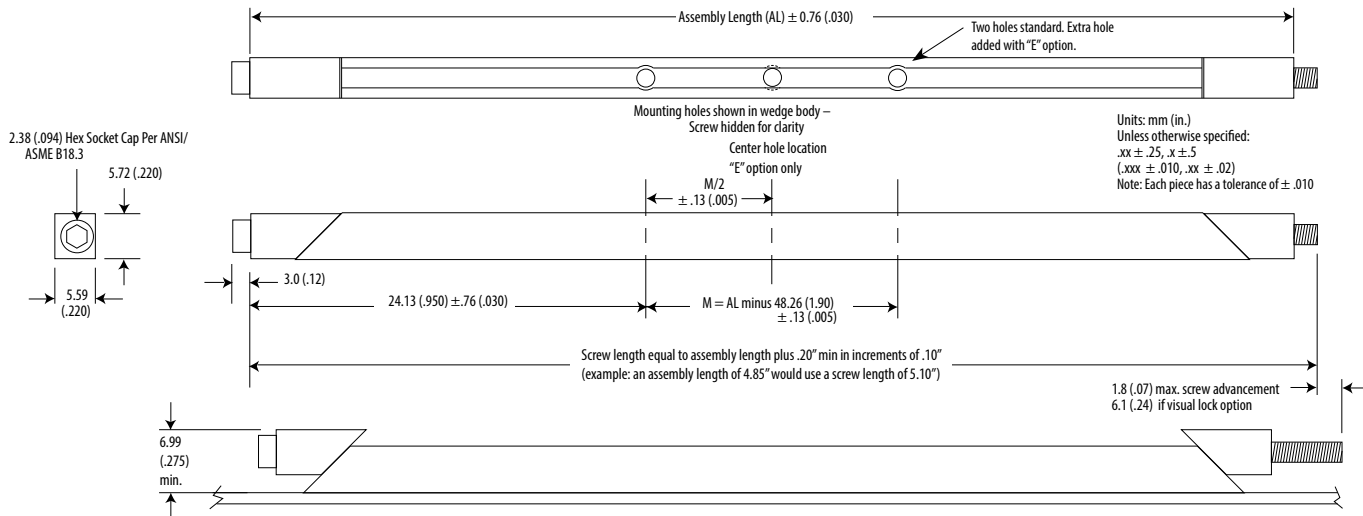
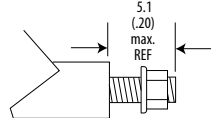
### Detail "K"

Prevents the unintentional disassembly of screw from rear wedge. This option adds 5.1 (.20) to the screw length.



### Detail "CR"

If the "R" option is included with this "CR" option, then the locknut is stainless steel.



## Part Number Code

### Series 230 Card-Lok Three Piece

None [blank] M W V A 230 - 3.80 E H L R

### Prefix options

Metric Screw Head M2.5 Hex Drive **M**  
Standard Screw Head 3/32 Hex Drive [blank]  
Lock and Flat Washer **W**  
None [blank]  
Visual Indicator **V**  
No Visual Indicator [blank]  
Black Anodize **A**  
or choose from Finish Table **see table**

### Suffix options

Stainless Steel Lock Nut if "R" option is selected **CR**  
Standard Steel Lock Nut **"\_"**

Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80). **length.xx**  
Other lengths available upon request

Additional Center Mounting Hole **E**  
None [blank]  
Mounting Options - holes for rivet mounting **H**  
or choose from Mounting Option **see table**  
Lock Element **L**  
None [blank]  
Lock Nut **R**  
Captive Screw **K**  
None [blank]

## Part Number Code Example:

VA230CR4.80HR

Series 230 Card-Lok three piece 121.9 (4.80) long with visual indicator, black anodize finish, standard rivet mounting holes and stainless steel lock nut option

## FINISH TABLE

| Code Letter | Finish                                                      |
|-------------|-------------------------------------------------------------|
| [blank]     | Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold       |
| "R"         | Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear      |
| "A"         | Black Anodize per Mil-A-8625 Type II, Class 2               |
| "HA"        | Hard Black Anodize per Mil-A-8625 Type III, Class 2         |
| "EN"        | Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright |

## MOUNTING METHOD TABLE

| Code Letter | Method                                                                                                              |
|-------------|---------------------------------------------------------------------------------------------------------------------|
| [blank]     | No mounting holes                                                                                                   |
| "H"         | Rivet Mounting Ø1.70 (.067) hole with 3.96 (.156) counterbore x 4.19 (.165) deep and 100° x 3.56 (.140) countersink |
| "T0"        | 0-80 tapped hole                                                                                                    |
| "T2"        | 2-56 tapped hole                                                                                                    |
| "TM2"       | M2 x 0.40 tapped hole                                                                                               |
| "TM2.5"     | M2.5 x 0.45 tapped hole                                                                                             |

Calmark offers the Series 231 "Card-Lok" retainer for cold plate-heat exchanger applications. A mid-width configuration, to meet Board Module Assembly retainer expansion requirements between the Series 225 and 240.

### FEATURES

- Maximum Reliability – Screw-actuated wedge action locks Board Module Assembly in place
- Maximum Thermal Transfer – Wedge action design provides maximum contact between thermal paths on Board Module Assembly and the heat sinking surface
- Maximum Resistance to Shock & Vibration – Wedge action design locks Board Module Assembly in place to provide maximum resistance to shock and vibration
- Zero Insertion & Extraction Forces – Screw actuation provides zero insertion and extraction force on Board Module Assembly
- Design Flexibility – Special lengths, finishes or other design variations available on request

### BODIES & WEDGES

#### Material:

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

#### Finish:

See Finish Table

### SCREW

#### Material:

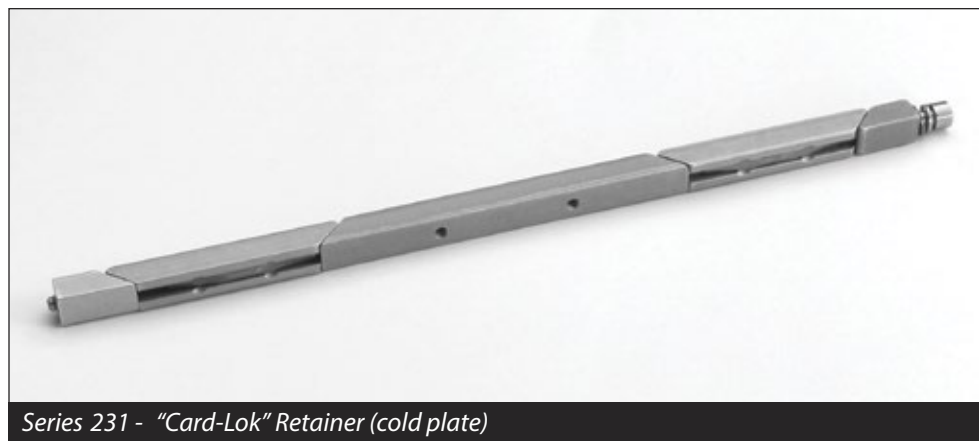
Stainless steel per ASTM-A582

#### Finish:

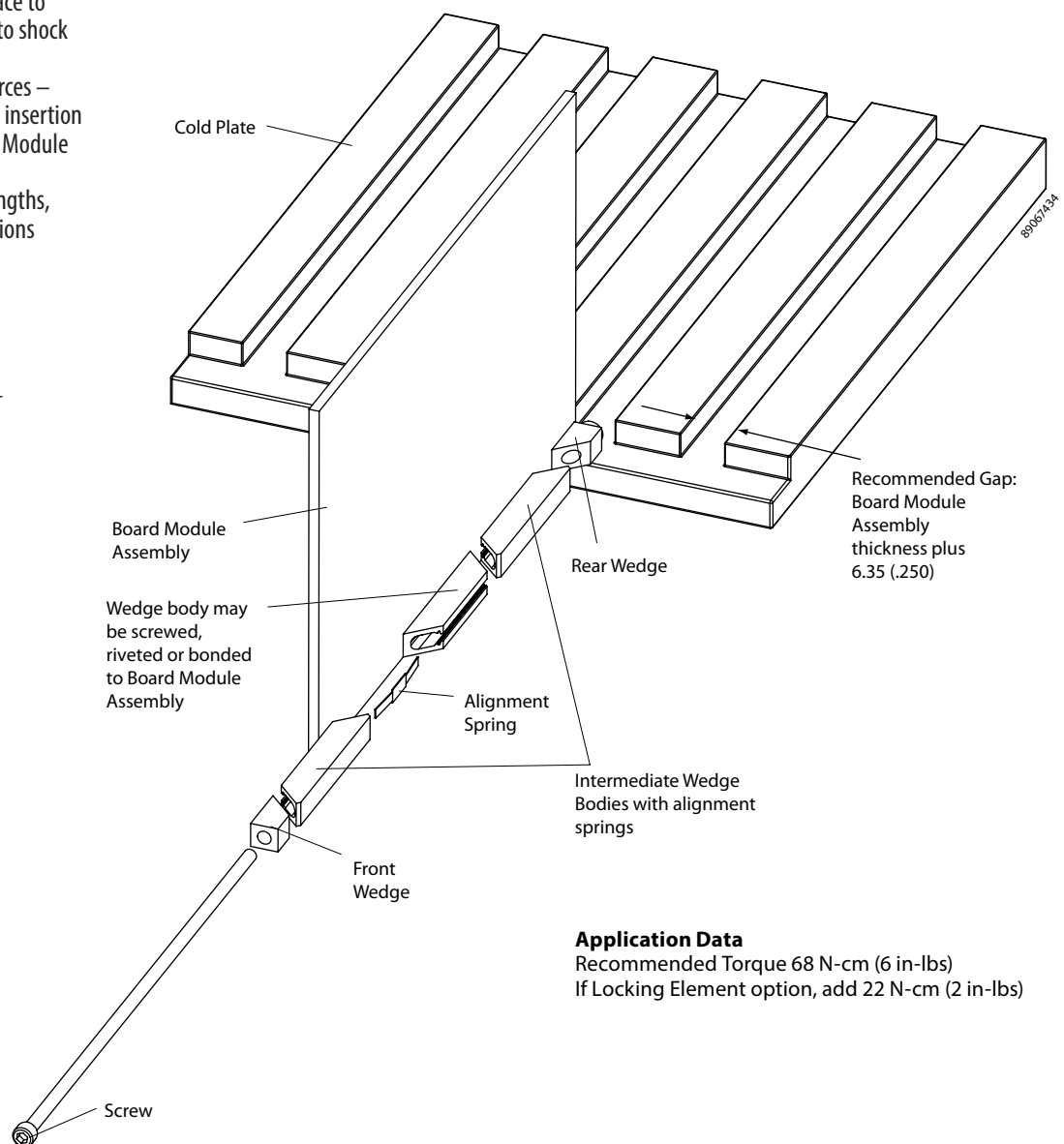
Passivate per AMS2700

### WEIGHT

1.34 g/cm (.120 oz/in)



Series 231 - "Card-Lok" Retainer (cold plate)



### Application Data

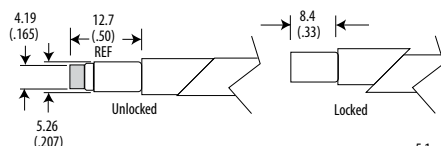
Recommended Torque 68 N-cm (6 in-lbs)

If Locking Element option, add 22 N-cm (2 in-lbs)

## OPTION PREFIX

### Detail "V"

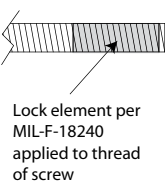
Provides visual lock indication.



## OPTION SUFFIX

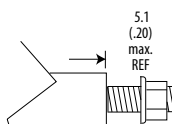
### Detail "L"

Provides prevailing torque for resistance to loosening from shock and vibration.



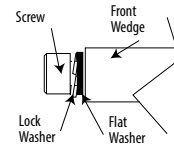
### Detail "R"

Reduces the possibility of unintentional disassembly of the screw from rear wedge. This option adds no additional screw length with or without "CR" unless included with "W" option, then 2.5 (.10) total.



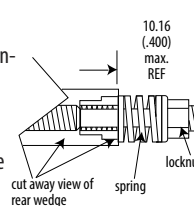
### Detail "W"

Provides added resistance to loosening from shock and vibration. This option adds no additional screw length unless combined with the "R" suffix option, then adds 2.5 (.10) total.



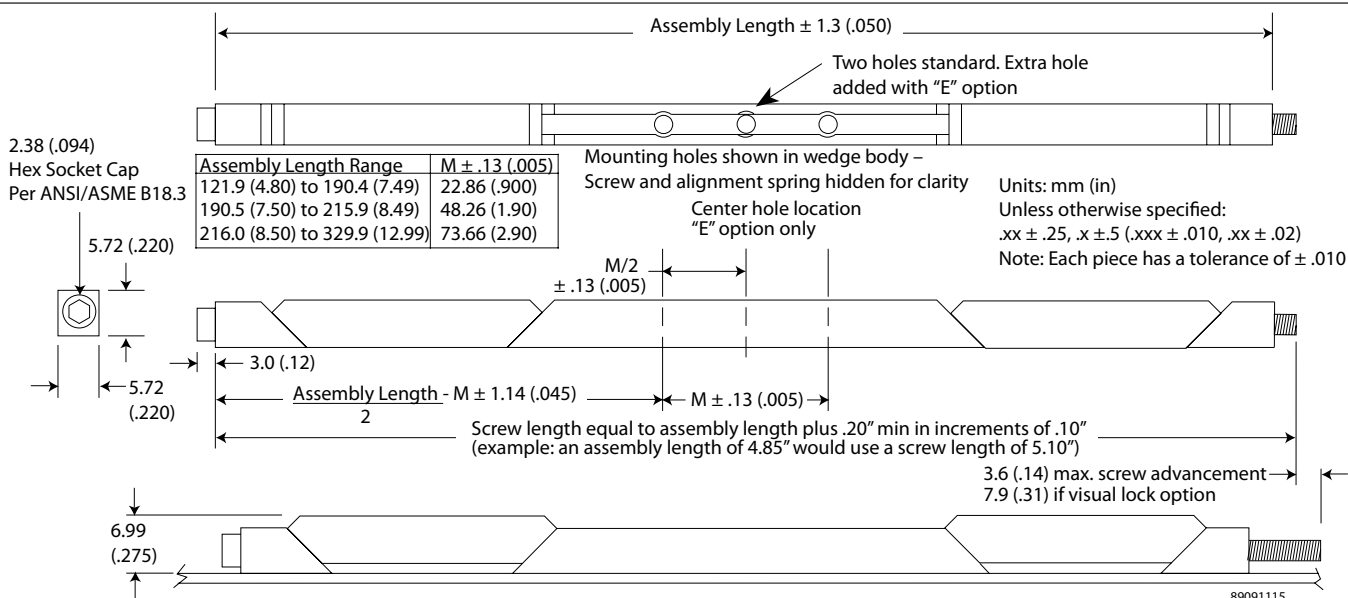
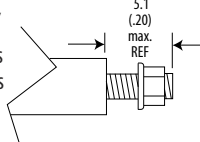
### Detail "K"

Prevents the unintentional disassembly of screw from rear wedge. This option adds 5.1 (.20) to the screw length.



### Detail "CR"

If the "R" option is included with this "CR" option, then the locknut is stainless steel.



## Part Number Code

### Series 231 Card-Lok Five Piece

#### Prefix options

Metric Screw Head M2.5 **M**  
Standard Screw Head 3/32 **[blank]**  
Lock and Flat Washer **W**  
None **[blank]**  
Visual Indicator **V**  
No Visual Indicator **[blank]**  
Black Anodize **A**  
or choose from Finish Table **see table**

#### Suffix options

Stainless Steel Lock Nut if "R" option is selected **CR**  
Standard Plated Steel **..**

Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80). **length.xx**  
Other lengths available upon request

Additional Center Mounting Hole **E**  
None **[blank]**  
Mounting Options - holes for rivet mounting **H**  
or choose from Mounting Option Table **see table**  
Lock Element **L**  
None **[blank]**  
Lock Nut **R**  
Captive Screw **K**  
None **[blank]**

## Part Number Code Example:

W231-4.80LR

Series 231 Card-Lok five piece 121.9 (4.80) long with lock and flat washer, gold chemical finish, lock element, no mounting holes and a plated steel lock nut

## Code

Letter

Finish

**[blank]** Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold  
**"R"** Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear  
**"A"** Black Anodize per Mil-A-8625 Type II, Class 2  
**"HA"** Hard Black Anodize per Mil-A-8625 Type III, Class 2  
**"EN"** Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright

## FINISH TABLE

## Code

Letter

Method

**[blank]** No mounting holes  
**"H"** Rivet Mounting Ø1.70 (.067) hole with 3.96 (.156) counterbore x 4.19 (.165) deep and 100° x 3.56 (.140) countersink  
**"T0"** 0-80 tapped hole  
**"T2"** 2-56 tapped hole  
**"TM2"** M2 x 0.40 tapped hole  
**"TM2.5"** M2.5 x 0.45 tapped hole

Calmark offers the 3 piece Series 235 metric "Card-Lok" retainer for cold plate-heat exchanger applications. Closed shape segments provide maximum rigidity and resistance to distortion under load. Dual front and rear threads accomplishes rapid clamp and release action. Enclosed spring maintains alignment of segments providing easy insertion.

### FEATURES

- Closed shape segments provide maximum rigidity and resistance to distortion under load
- Dual threads provide rapid clamp and release action
- Enclosed springs maintain alignment of segments providing easy insertion
- Maximum resistance to shock and vibration
- Zero insertion and extraction forces
- Design Flexibility - Special lengths, finishes or other design variations available on request

### BODIES & WEDGES

#### Material:

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

#### Finish:

See Finish Table

### SCREW

#### Material:

Stainless steel per ASTM-A582

#### Finish:

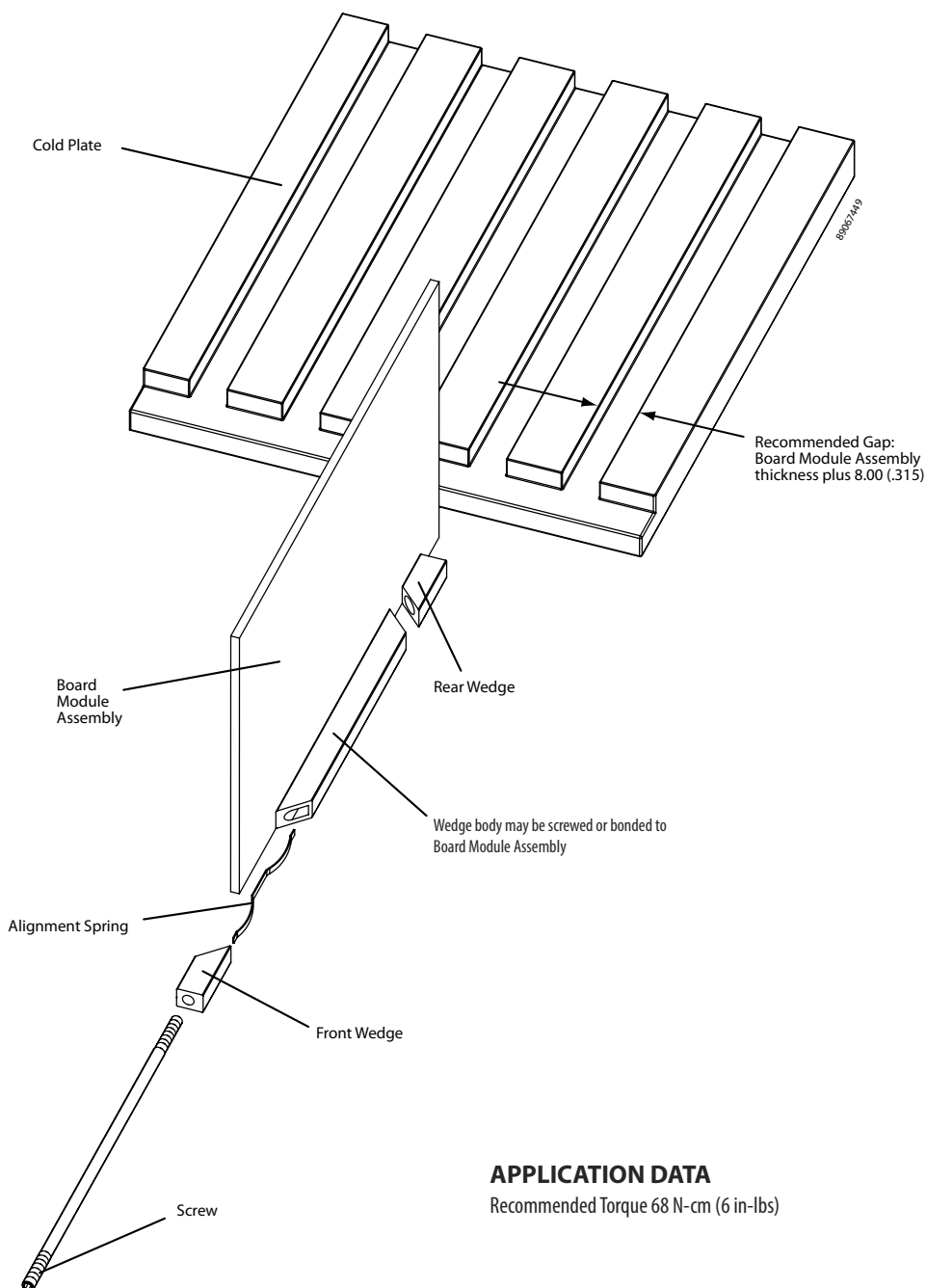
Passivate per MIL-S-5002

### WEIGHT

1.34 g/cm (.120 oz/in)



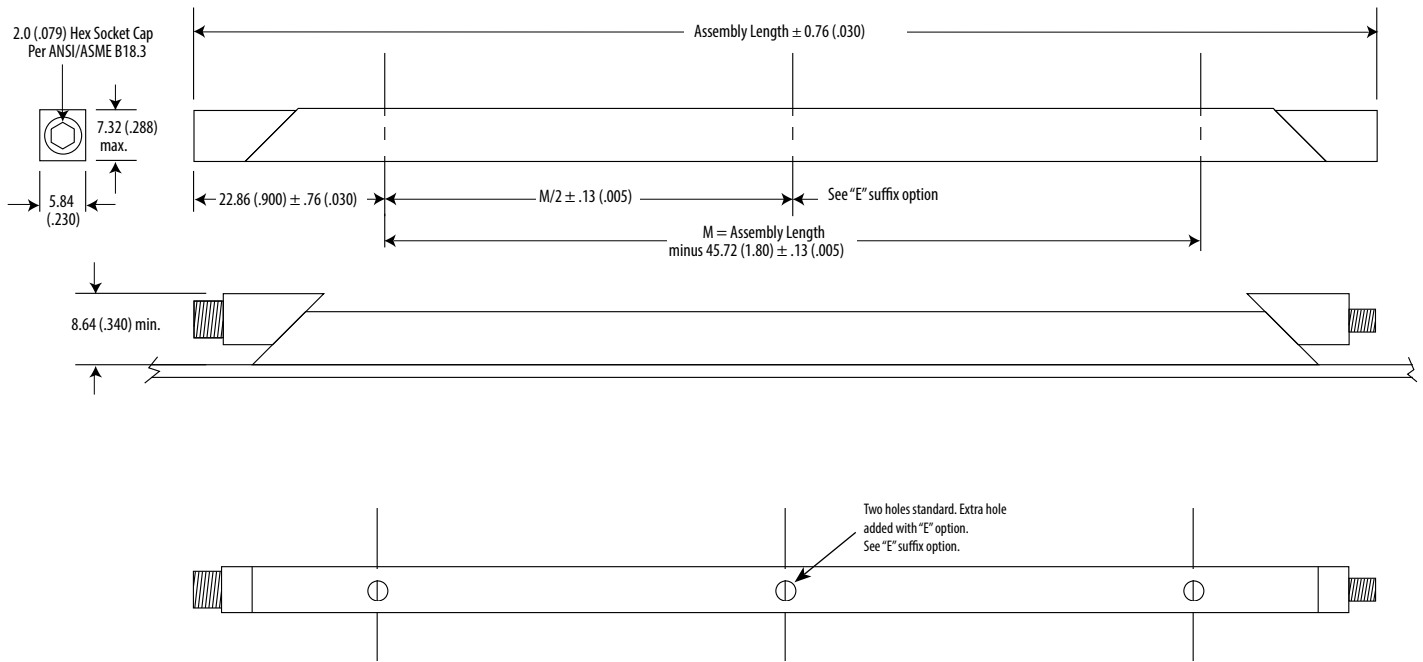
Series 235 - "Card-Lok" Retainer (cold plate)



### APPLICATION DATA

Recommended Torque 68 N-cm (6 in-lbs)





Units: mm (in.)  
 Unless otherwise specified:  
 .xx  $\pm .25$ , x  $\pm .5$   
 (.xxx  $\pm .010$ , xx  $\pm .02$ )  
 Note: Each piece has a tolerance of  $\pm .010$

## Part Number Code Series 235 Card-Lok Three Piece

### Prefix options

Slotted Drive S  
 2mm Hex Drive [blank]

### Finish options

Black Anodize A  
 or choose from Finish Table

Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80). length.xx  
 Other lengths available upon request

Additional Center Mounting Hole E  
 None [blank]

Mounting Options - M2.5 tapped hole TM2.5  
 or choose from Mounting Option Table see table

Locking Insert Option P  
 None [blank]

## Part Number Code Example:

A235-2.80ETM2.5

Series 235 Card-Lok three piece, black anodized, 71.12 (2.80) assembly length, with three M2.5 tapped mounting holes.

## FINISH TABLE

| Code Letter    | Finish                                                      |
|----------------|-------------------------------------------------------------|
| <u>[blank]</u> | Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold       |
| <u>"R"</u>     | Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear      |
| <u>"A"</u>     | Black Anodize per Mil-A-8625 Type II, Class 2               |
| <u>"HA"</u>    | Hard Black Anodize per Mil-A-8625 Type III, Class 2         |
| <u>"EN"</u>    | Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright |

## MOUNTING METHOD TABLE

| Code Letter    | Method                  |
|----------------|-------------------------|
| <u>[blank]</u> | No mounting holes       |
| <u>"T0"</u>    | 0-80 tapped hole        |
| <u>"T2"</u>    | 2-56 tapped hole        |
| <u>"TM2"</u>   | M2 x 0.40 tapped hole   |
| <u>"TM2.5"</u> | M2.5 x 0.45 tapped hole |

Calmark offers the 5 piece Series 236 metric "Card-Lok" retainer for cold plate-heat exchanger applications. Closed shape segments provide maximum rigidity and resistance to distortion under load. Dual front and rear threads accomplishes rapid clamp and release action. Enclosed springs maintain alignment of segments providing easy insertion.

### FEATURES

- Closed shape segments provide maximum rigidity and resistance to distortion under load
- Dual threads provide rapid clamp and release action
- Enclosed springs maintain alignment of segments providing easy insertion
- Maximum resistance to shock and vibration
- Zero insertion and extraction forces
- Design Flexibility - Special lengths, finishes or other design variations available on request

### BODIES & WEDGES

#### Material:

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

#### Finish:

See Finish Table

### SCREW

#### Material:

Stainless steel per ASTM-A582

#### Finish:

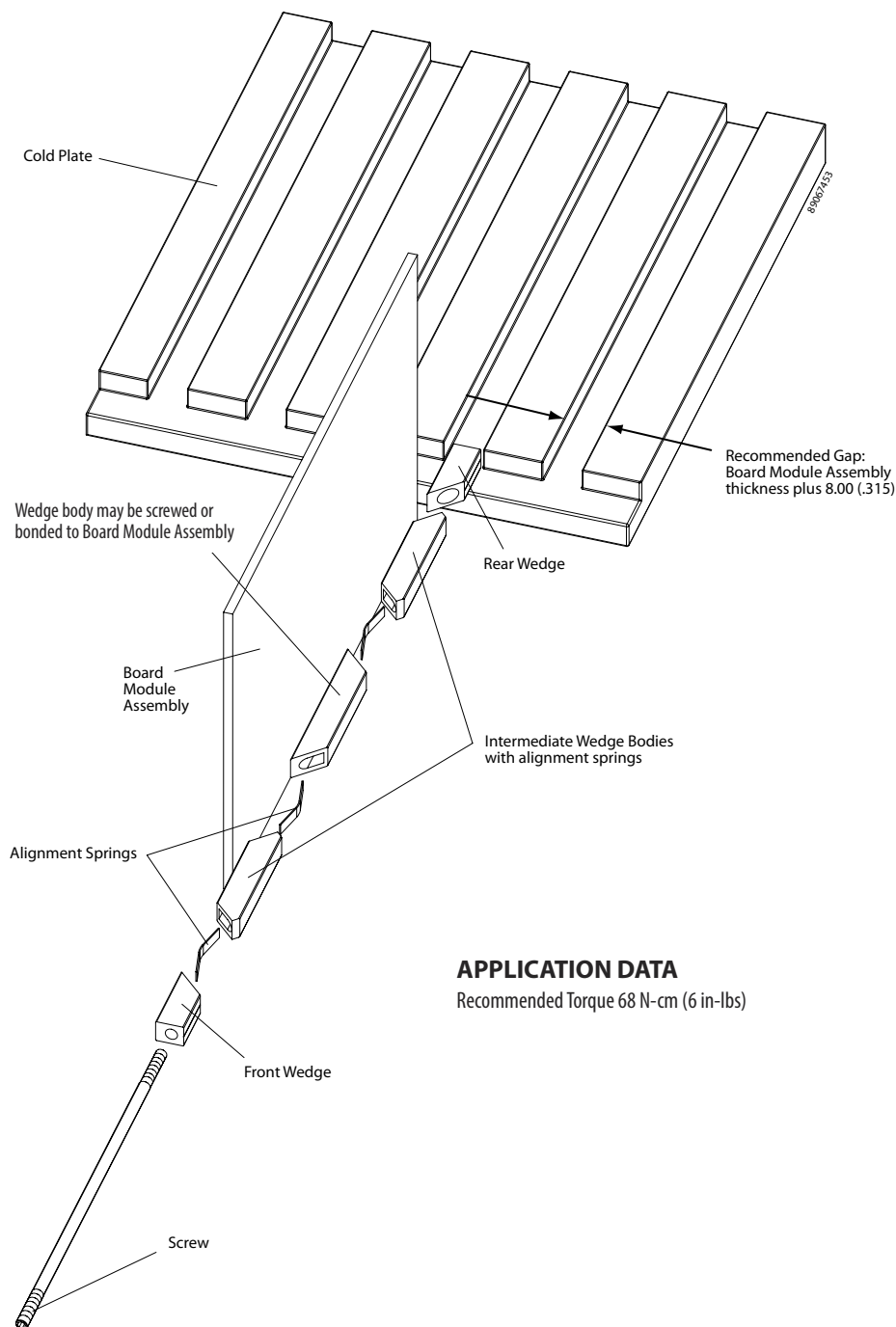
Passivate per MIL-S-5002

### WEIGHT

1.34 g/cm (.120 oz/in)

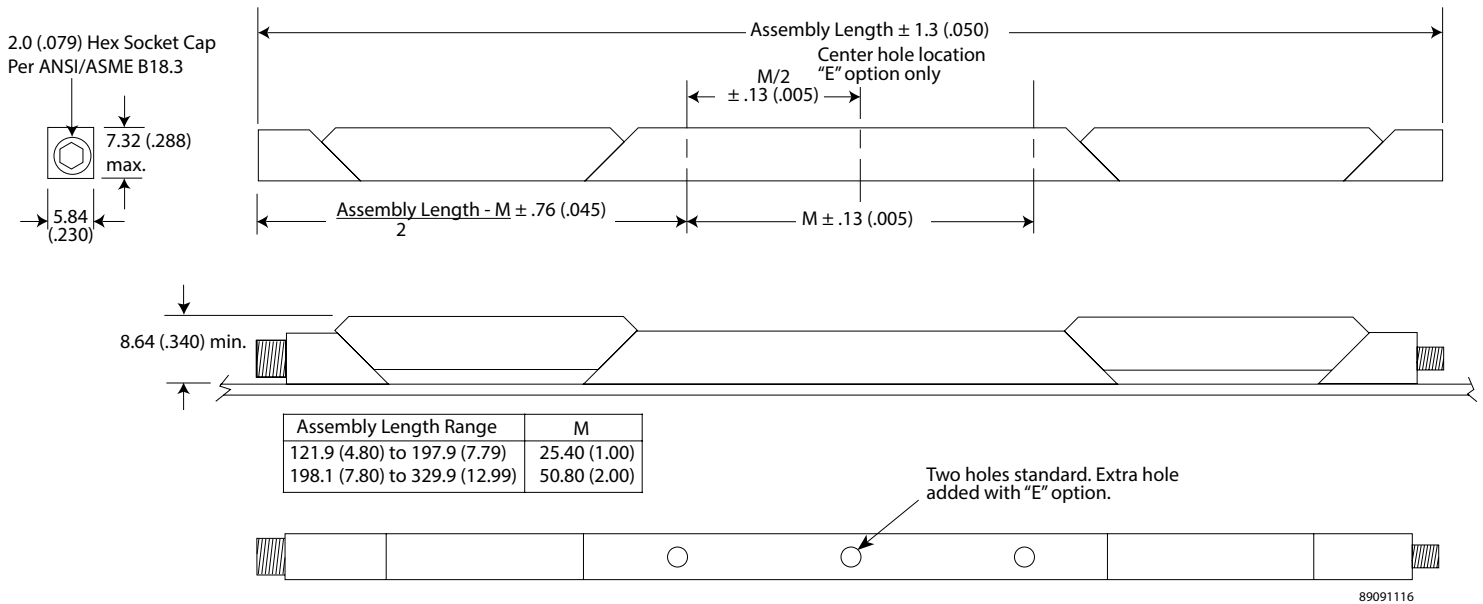


Series 236 - "Card-Lok" Retainer (cold plate)



### APPLICATION DATA

Recommended Torque 68 N-cm (6 in-lbs)



Units: mm (in)  
 Unless otherwise specified:  
 .xx ± .25, .x ± .5 (.xxx ± .010, .xx ± .02)  
 Note: Each piece has a tolerance of ± .010

## Part Number Code Series 236 Card-Lok Five Piece

### Prefix options

Slotted Drive S  
 2mm Hex Drive [blank]

### Finish options

Black Anodize A  
 or choose from Finish Table

### Suffix options

Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80). length.xx  
 Other lengths available upon request

Additional Center Mounting Hole E  
 None [blank]

Mounting Options - M2.5 tapped hole TM2.5  
 or choose from Mounting Option Table see table

Locking Insert Option P  
 None [blank]

## Part Number Code Example:

A236-2.80ETM2.5

Series 236 Card-Lok five piece, black anodized, 71.12 (2.80) assembly length, with three M2.5 tapped mounting holes.

## FINISH TABLE

| Code Letter | Finish                                                      |
|-------------|-------------------------------------------------------------|
| [blank]     | Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold       |
| "R"         | Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear      |
| "A"         | Black Anodize per Mil-A-8625 Type II, Class 2               |
| "HA"        | Hard Black Anodize per Mil-A-8625 Type III, Class 2         |
| "EN"        | Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright |

## MOUNTING METHOD TABLE

| Code Letter | Method                  |
|-------------|-------------------------|
| [blank]     | No mounting holes       |
| "T0"        | 0-80 tapped hole        |
| "T2"        | 2-56 tapped hole        |
| "TM2"       | M2 x 0.40 tapped hole   |
| "TM2.5"     | M2.5 x 0.45 tapped hole |

Calmark offers the Series 240 "Card-Lok" retainer for cold plate-heat exchanger applications. A narrow configuration Board Module Assembly retainer that provides maximum heat sinking efficiency for high density card spacing.

### FEATURES

- Narrow width allows minimum card spacing
- Positive locking provides maximum reliability
- Maximum thermal transfer
- Maximum resistance to shock and vibration
- Zero insertion and extraction forces
- Design Flexibility - Special lengths, finishes or other design variations available on request

### BODIES & WEDGES

#### Material:

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

#### Finish:

See Finish Table

### SCREW

#### Material:

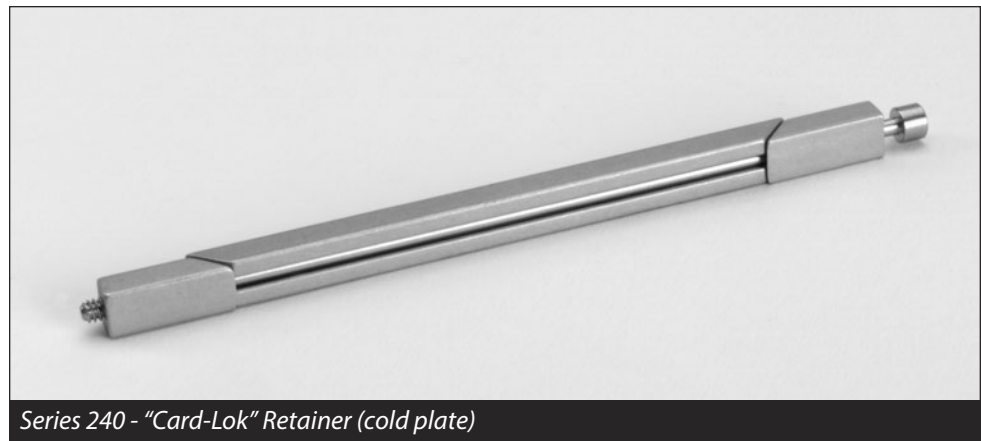
Stainless steel per ASTM-A582

#### Finish:

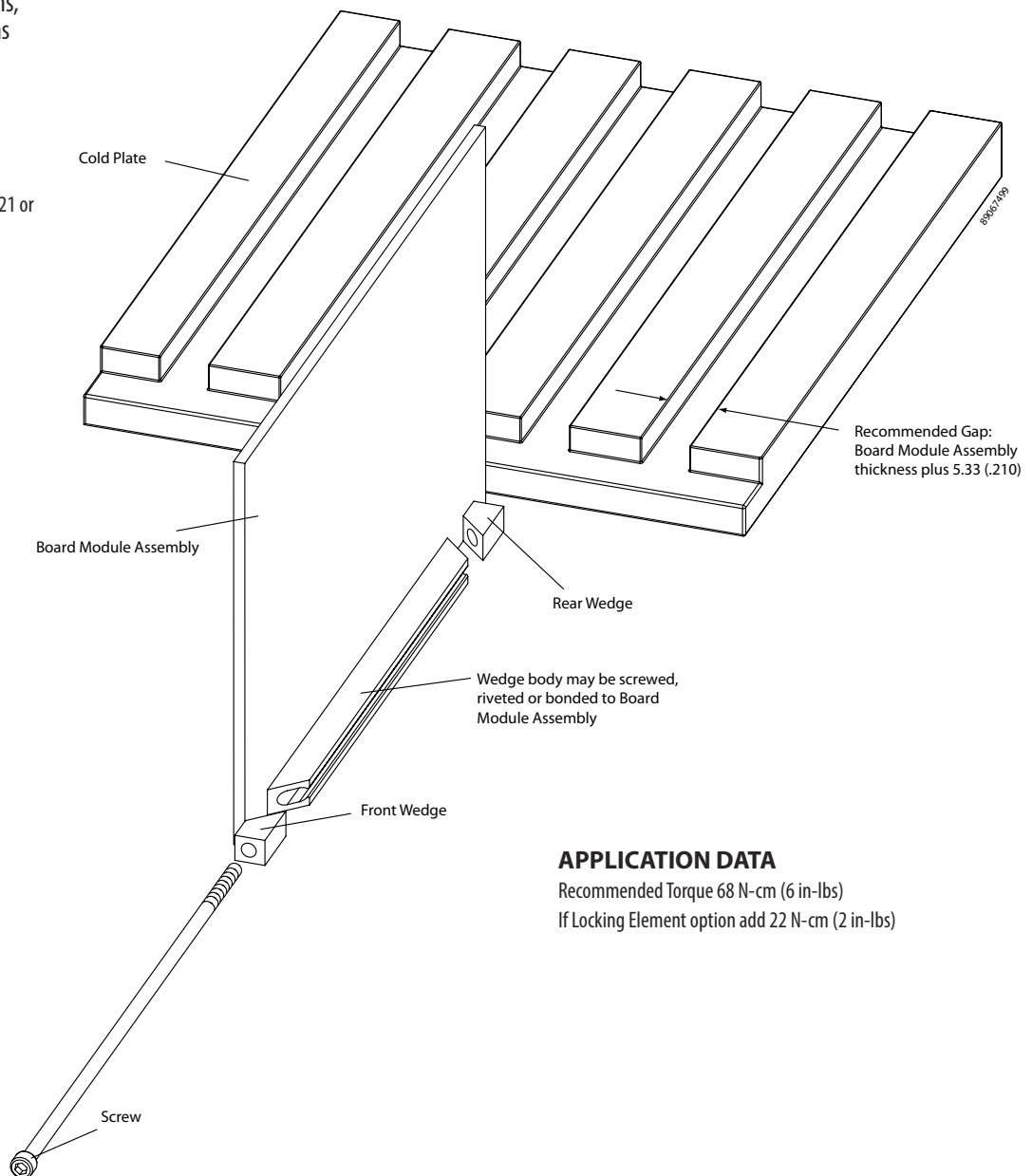
Passivate per MIL-S-5002

### WEIGHT

.86 g/cm (.077 oz/in)



Series 240 - "Card-Lok" Retainer (cold plate)



### APPLICATION DATA

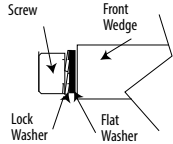
Recommended Torque 68 N-cm (6 in-lbs)

If Locking Element option add 22 N-cm (2 in-lbs)

## OPTION PREFIX

### Detail "W"

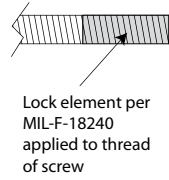
Provides added resistance to loosening from shock and vibration. This option adds 2.54 (.100) to the screw length when combined with the "R" option.



## OPTION SUFFIX

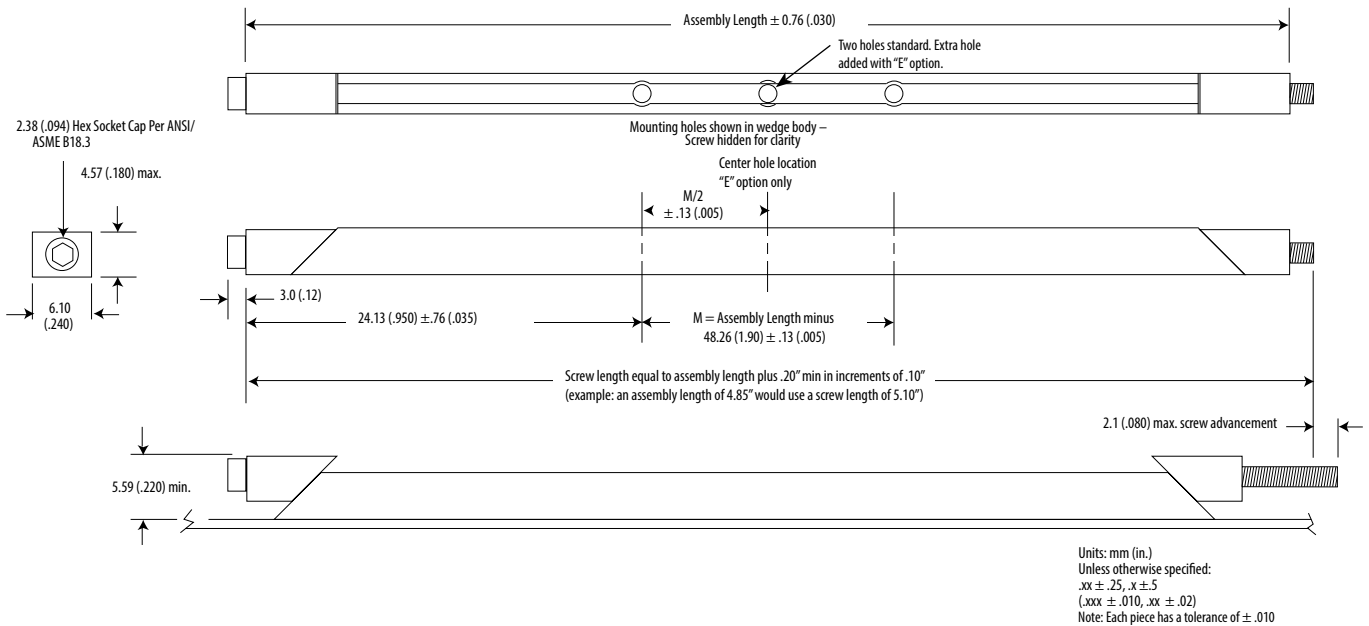
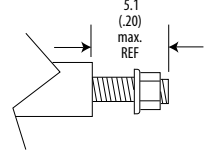
### Detail "L"

Provides prevailing torque for resistance to loosening from shock and vibration. Adds 22 N-cm (2 in-lbs) torque to assembly. See application data on previous sheet.



### Detail "R"

Reduces the possibility of unintentional disassembly of the screw from rear wedge. This option adds 2.54 (.100) to the screw length when combined with the "W" option. Lock Nut material: stainless steel.



## Part Number Code Series 240 Card-Lok Three Piece

### Prefix options

Metric Screw Head M2.5 Hex Drive **M**  
Standard Screw Head 3/32 Hex Drive **[blank]**  
Lock and Flat Washer **W**  
None **[blank]**  
Black Anodize **A**  
or choose from Finish Table **see table**

### Suffix options

Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80). **length.xx**  
Other lengths available upon request

Additional Center Mounting Hole **E**  
None **[blank]**

Mounting Options - holes for rivet mounting **H**  
or choose from Mounting Option Table **see table**

Lock Element **L**  
None **[blank]**

Lock Nut **R**  
None **[blank]**

## Part Number Code Example:

A240CR3.80EHLR

Series 240 three piece Card-Lok, black anodized finish, 96.52 (3.80) long, holes for rivet mounting including an extra center mounting hole, with locking element on the screw thread and a stainless steel locknut

## FINISH TABLE

| Code Letter    | Finish                                                      |
|----------------|-------------------------------------------------------------|
| <b>[blank]</b> | Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold       |
| <b>"R"</b>     | Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear      |
| <b>"A"</b>     | Black Anodize per Mil-A-8625 Type II, Class 2               |
| <b>"HA"</b>    | Hard Black Anodize per Mil-A-8625 Type III, Class 2         |
| <b>"EN"</b>    | Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright |

## MOUNTING METHOD TABLE

| Code Letter    | Method                                                                                                                           |
|----------------|----------------------------------------------------------------------------------------------------------------------------------|
| <b>[blank]</b> | No mounting holes                                                                                                                |
| <b>"H"</b>     | Rivet Mounting $\varnothing 1.70 (.067)$ hole with 3.96 (.156) counterbore x 5.08 (.200) deep and 100° x 3.56 (.140) countersink |
| <b>"T0"</b>    | 0-80 tapped hole                                                                                                                 |
| <b>"T2"</b>    | 2-56 tapped hole                                                                                                                 |
| <b>"TM2"</b>   | M2 x 0.40 tapped hole                                                                                                            |
| <b>"TM2.5"</b> | M2.5 x 0.45 tapped hole                                                                                                          |

Calmark offers the Series 245 "Card-Lok" retainer for cold plate-heat exchanger applications. A maximum efficiency heat sinking Board Module Assembly retainer offered to retrofit the Series 225 but uses a 6-32 screw to provide greater clamping force and load capacity.

### FEATURES

- Maximum reliability - Screw-actuated wedge action locks Board Module Assembly in place
- Maximum thermal transfer - Wedge action design provides maximum contact between thermal paths on Board Module Assembly and the heat sinking surface
- Maximum resistance to shock and vibration - Wedge action design locks Board Module Assembly in place to provide maximum resistance to shock and vibration
- Zero insertion and extraction forces - Screw actuation provides zero insertion and extraction force on Board Module Assembly
- Design flexibility - Special lengths, finishes or other design variations available on request

### BODIES & WEDGES

#### Material:

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

#### Finish:

See Finish Table

### SCREW

#### Material:

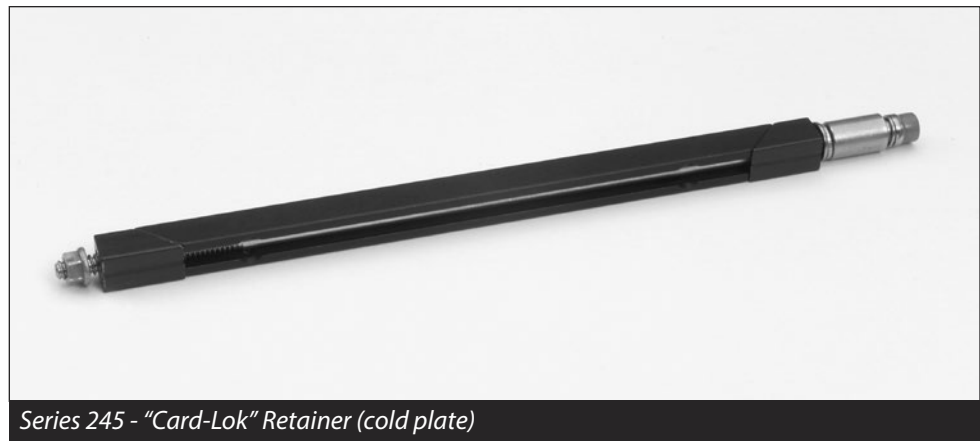
Stainless steel per ASTM-A582

#### Finish:

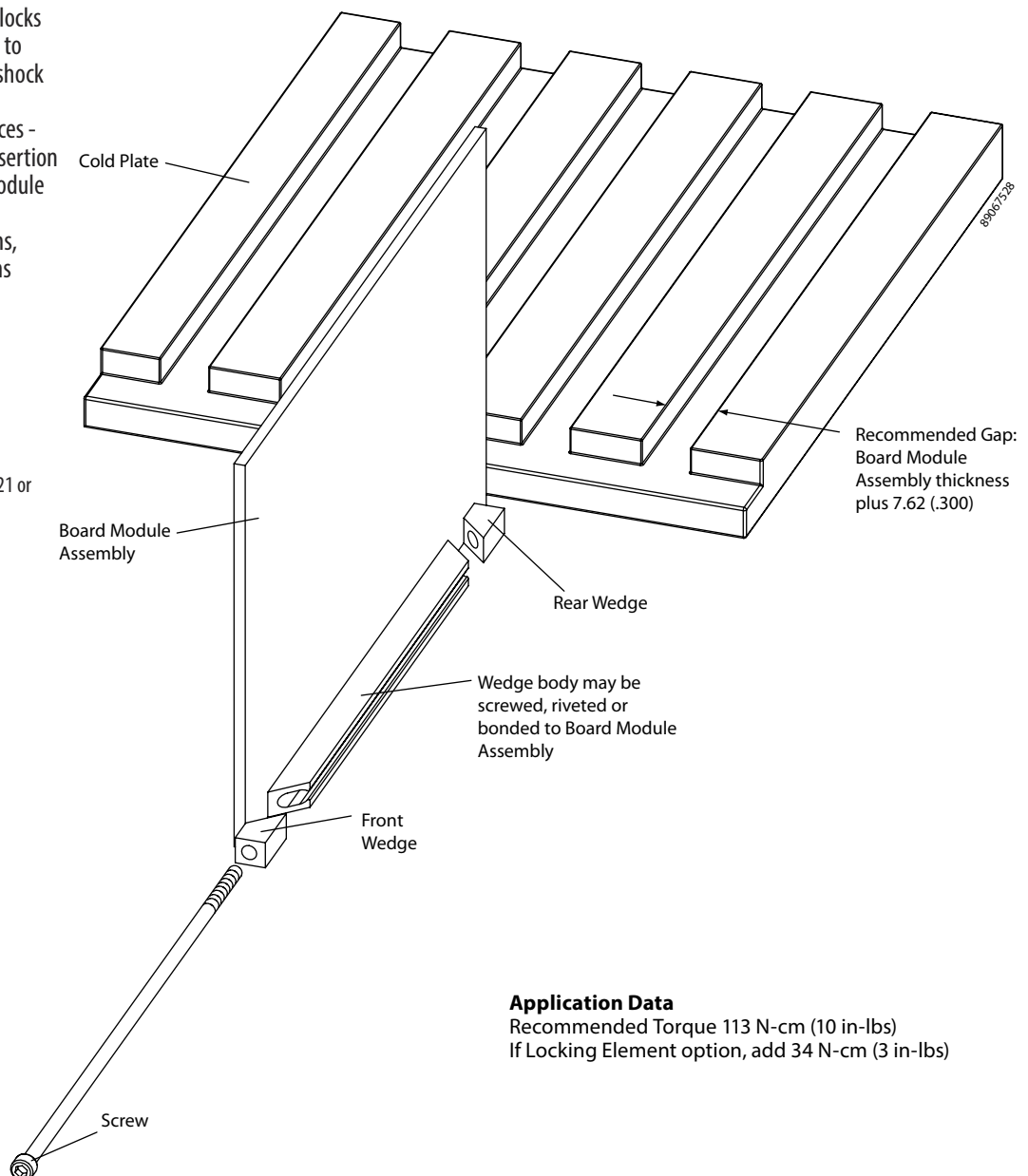
Passivate per MIL-S-5002

### WEIGHT

1.77 g/cm (.159 oz/in)



Series 245 - "Card-Lok" Retainer (cold plate)



### Application Data

Recommended Torque 113 N-cm (10 in-lbs)  
If Locking Element option, add 34 N-cm (3 in-lbs)



## OPTION PREFIX

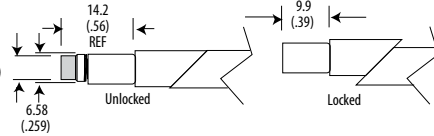
### Detail "V"

Provides visual lock indication. Changes hex drive to 2.38 (.094). This option adds 5.08 (.20) to screw length

## OPTION SUFFIX

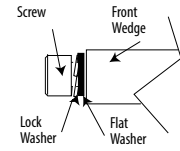
### Detail "L"

Provides prevailing torque for resistance to loosening from shock and vibration. Adds 34 N-cm (3 in-lbs) torque to assembly. See application data on previous sheet.



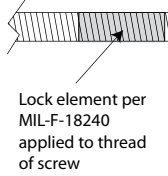
### Detail "W"

Provides added resistance to loosening from shock and vibration. This option adds 2.5 (.10) to the screw length when combined with the "R" suffix option.



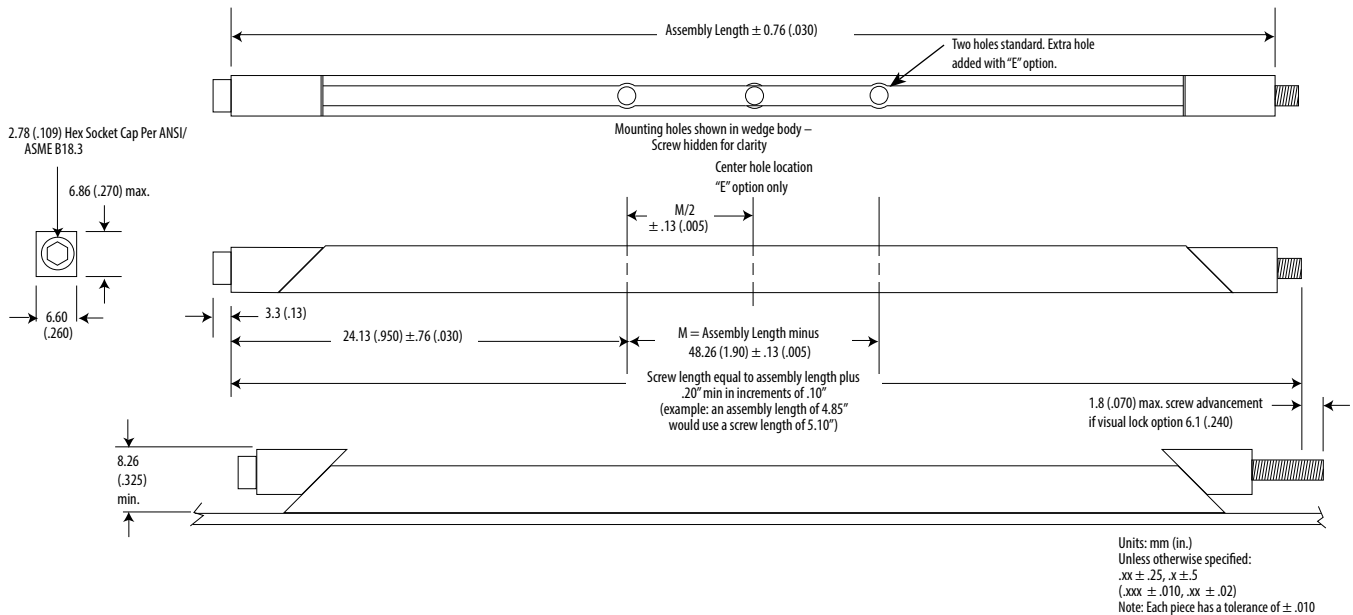
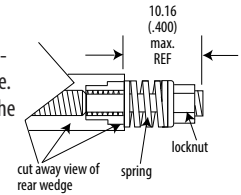
### Detail "R"

Reduces the possibility of unintentional disassembly of the screw from rear wedge. This option adds 2.54 (.10) to the screw length unless when combined with the "W" suffix option, then it adds 5.08 (.20).



### Detail "K"

Prevents the unintentional disassembly of screw from rear wedge. This option adds 5.08 (.200) to the screw length.



## Part Number Code

### Series 245 Card-Lok Three Piece

M W V A 245 - 4.80 E H L R

## Prefix options

Metric Screw Head M2.5 **M**  
Standard Screw Head 7/64 **[blank]**  
Lock and Flat Washer **W**  
None **[blank]**  
Visual Indicator (changes hex drive to 3/32) **V**  
No Visual Indicator **[blank]**  
Black Anodize **A**  
or choose from Finish Table **see table**

## Suffix options

Stainless Steel Lock Nut if "R" option is selected **CR**  
Standard Plated Steel **"-"**  
Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80). **length.xx**  
Other lengths available upon request  
Additional Center Mounting Hole **E**  
None **[blank]**  
Mounting Options - holes for rivet mounting **H**  
or choose from Mounting Option Table **see table**  
Lock Element **L**  
None **[blank]**  
Lock Nut **R**  
None **[blank]**  
Captive Screw **K**  
None **[blank]**

## Part Number Code Example:

245-3.80H Series 245 three piece Card-Lok, 96.52 (3.80) long, gold chemical film finish with holes for rivet mounting

## FINISH TABLE

| Code Letter    | Finish                                                      |
|----------------|-------------------------------------------------------------|
| <b>[blank]</b> | Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold       |
| <b>"R"</b>     | Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear      |
| <b>"A"</b>     | Black Anodize per Mil-A-8625 Type II, Class 2               |
| <b>"HA"</b>    | Hard Black Anodize per Mil-A-8625 Type III, Class 2         |
| <b>"EN"</b>    | Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright |

## MOUNTING METHOD TABLE

| Code Letter    | Method                                                                                                              |
|----------------|---------------------------------------------------------------------------------------------------------------------|
| <b>[blank]</b> | No mounting holes                                                                                                   |
| <b>"H"</b>     | Rivet Mounting Ø1.70 (.067) hole with 3.96 (.156) counterbore x 5.08 (.200) deep and 100° x 3.56 (.140) countersink |
| <b>"T0"</b>    | 0-80 tapped hole                                                                                                    |
| <b>"T2"</b>    | 2-56 tapped hole                                                                                                    |
| <b>"TM2"</b>   | M2 x 0.40 tapped hole                                                                                               |
| <b>"TM2.5"</b> | M2.5 x 0.45 tapped hole                                                                                             |

Calmark offers the Series 250 "Card-Lok" Retainer for cold plate-heat exchanger applications. A maximum efficiency heat sinking Board Module Assembly retainer offered to provide greater clamping force and load capacity for Board Module Assembly of greater weight and mass.

### FEATURES

- Maximum reliability - Screw-actuated wedge action locks Board Module Assembly in place
- Maximum thermal transfer - Wedge action design provides maximum contact between thermal paths on Board Module Assembly and the heat sinking surface
- Maximum resistance to shock and vibration - Wedge action design locks Board Module Assembly in place to provide maximum resistance to shock and vibration
- Zero insertion and extraction forces - Screw actuation provides zero insertion and extraction force on Board Module Assembly
- Design flexibility - Special lengths, finishes or other design variations available on request

### BODIES & WEDGES

#### Material:

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

#### Finish:

See Finish Table

### SCREW

#### Material:

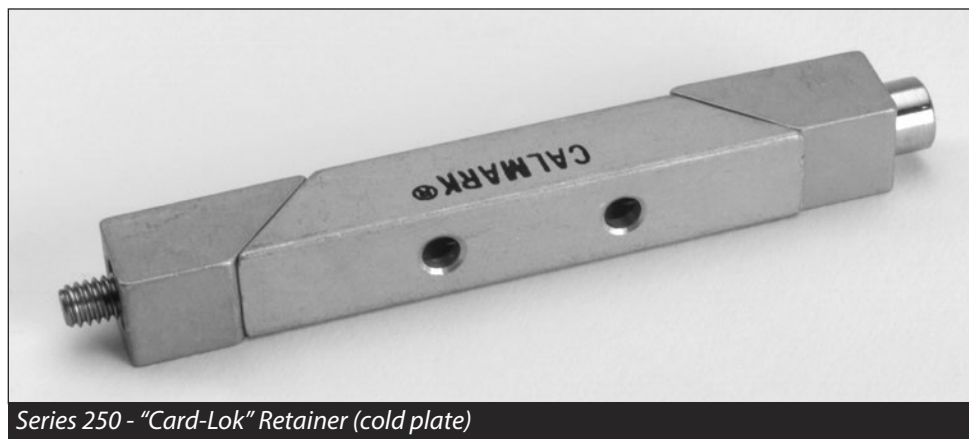
Stainless steel per ASTM-A582

#### Finish:

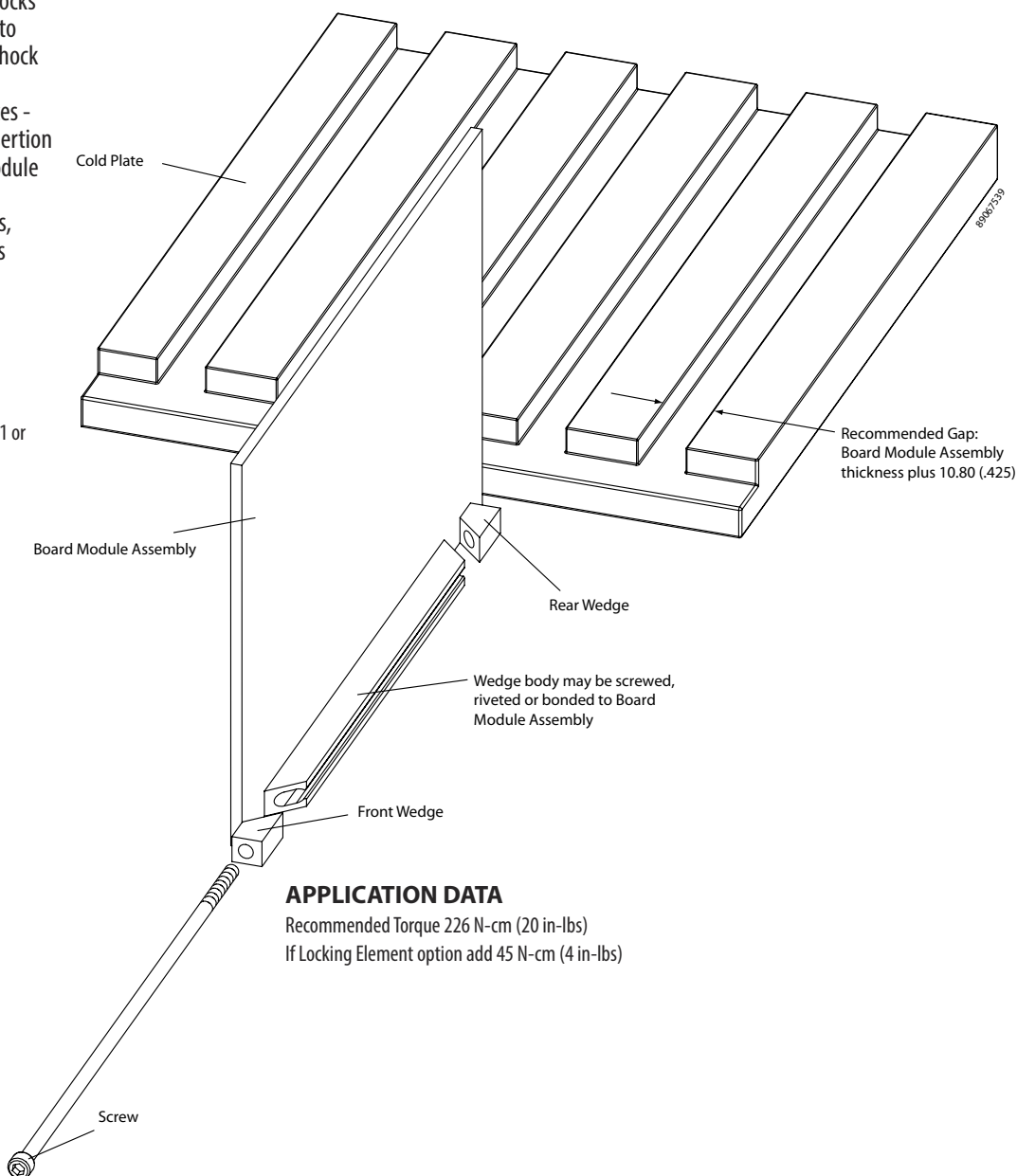
Passivate per MIL-S-5002

### WEIGHT

3.63 g/cm (.325 oz/in)



Series 250 - "Card-Lok" Retainer (cold plate)



### APPLICATION DATA

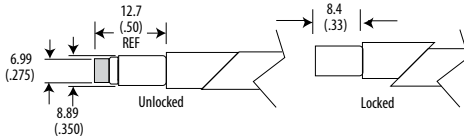
Recommended Torque 226 N-cm (20 in-lbs)

If Locking Element option add 45 N-cm (4 in-lbs)

## OPTION PREFIX

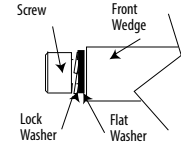
### Detail "V"

Provides visual lock indication. This option adds 5.08 (.20) to the screw length.



### Detail "W"

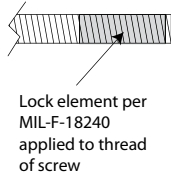
Provides added resistance to loosening from shock and vibration. This option adds 5.08 (.20) to the screw length when combined with the "R" suffix option.



## OPTION SUFFIX

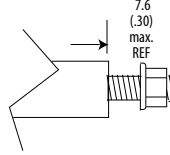
### Detail "L"

Provides prevailing torque for resistance to loosening from shock and vibration. Adds 45 N-cm (4 in-lbs) torque to assembly. See application data on previous sheet.



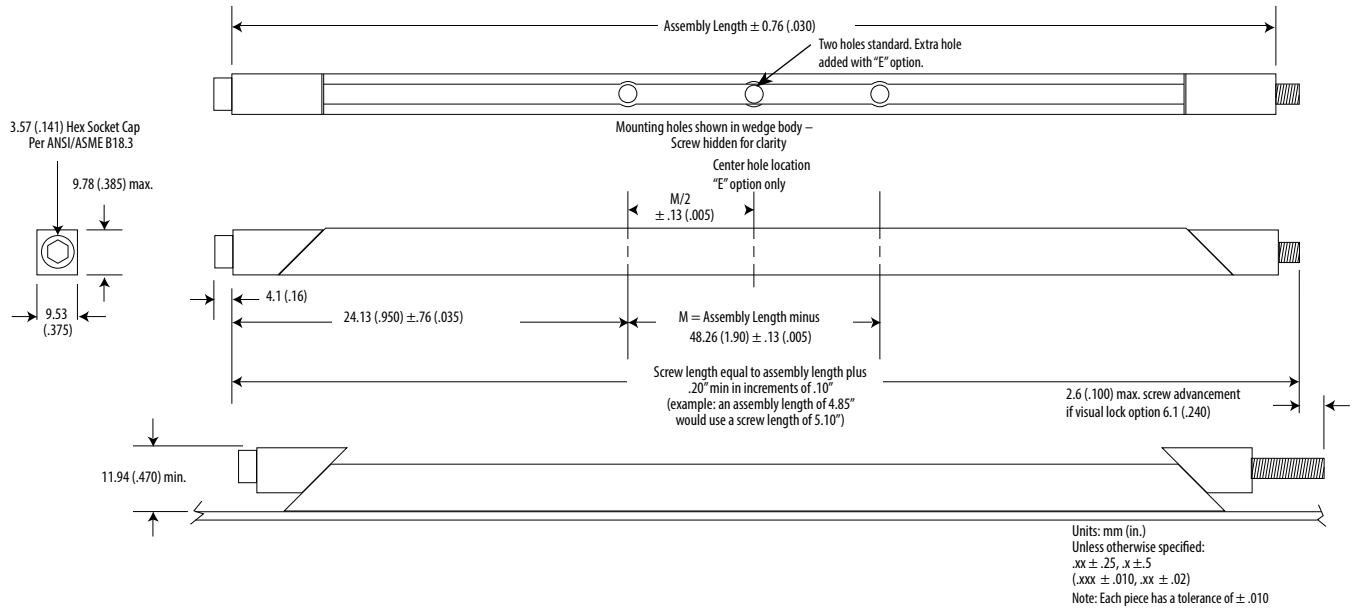
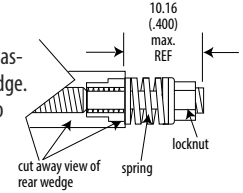
### Detail "R"

Reduces the possibility of unintentional disassembly of the screw from rear wedge. This option adds no additional screw length unless included with "W" option, then 5.08 (.20) total.



### Detail "K"

Prevents the unintentional disassembly of screw from rear wedge. This option adds 5.08 (.200) to the screw length.



## Part Number Code

### Series 250 Card-Lok Three Piece

#### Prefix options

Metric Screw Head M4 Hex Drive **M**

Standard Screw Head 9/64 Hex Drive **[blank]**

Lock and Flat Washer **W**

None **[blank]**

Visual Indicator **V**

No Visual Indicator **[blank]**

Black Anodize **A**

or choose from Finish Table **see table**

#### Suffix options

Stainless Steel Lock Nut if "R" option is selected **CR**

Standard Plated Steel Lock Nut **"\_"**

Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80). **length.xx**

Other lengths available upon request

Additional Center Mounting Hole **E**

None **[blank]**

Mounting Options - holes for rivet mounting **H**

or choose from Mounting Option Table **see table**

Lock Element **L**

None **[blank]**

Lock Nut **R**

None **[blank]**

Captive Screw **K**

None **[blank]**

## Part Number Code Example:

V250CR4.80HR

Series 250 Card-Lok three piece 121.9 (4.80) long with Visual Indicator, gold chemical film finish, standard rivet mounting hole and stainless steel lock nut option

## FINISH TABLE

| Code Letter    | Finish                                                      |
|----------------|-------------------------------------------------------------|
| <b>[blank]</b> | Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold       |
| <b>"R"</b>     | Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear      |
| <b>"A"</b>     | Black Anodize per Mil-A-8625 Type II, Class 2               |
| <b>"HA"</b>    | Hard Black Anodize per Mil-A-8625 Type III, Class 2         |
| <b>"EN"</b>    | Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright |

## MOUNTING METHOD TABLE

| Code Letter    | Method                                                                                                              |
|----------------|---------------------------------------------------------------------------------------------------------------------|
| <b>[blank]</b> | No mounting holes                                                                                                   |
| <b>"H"</b>     | Rivet Mounting Ø3.45 (.136) hole with 4.95 (.195) counterbore x 7.62 (.300) deep and 100° x 4.95 (.195) countersink |
| <b>"T0"</b>    | 0-80 tapped hole                                                                                                    |
| <b>"T2"</b>    | 2-56 tapped hole                                                                                                    |
| <b>"TM2"</b>   | M2 x 0.40 tapped hole                                                                                               |
| <b>"TM2.5"</b> | M2.5 x 0.45 tapped hole                                                                                             |

Calmark offers the Series 255 "Card-Lok" Retainer for cold plate-heat exchanger applications. A maximum efficiency heat sinking Board Module Assembly retainer offered to provide greater clamping force and load capacity for Board Module Assembly of greater weight and mass.

### FEATURES

- Maximum reliability - Screw-actuated wedge action locks Board Module Assembly in place
- Maximum thermal transfer - Wedge action design provides maximum contact between thermal paths on Board Module Assembly and the heat sinking surface
- Maximum resistance to shock and vibration - Wedge action design locks Board Module Assembly in place to provide maximum resistance to shock and vibration
- Zero insertion and extraction forces - Screw actuation provides zero insertion and extraction force on Board Module Assembly
- Design flexibility - Special lengths, finishes or other design variations available on request

### BODIES & WEDGES

#### Material:

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

#### Finish:

See Finish Table

### SCREW

#### Material:

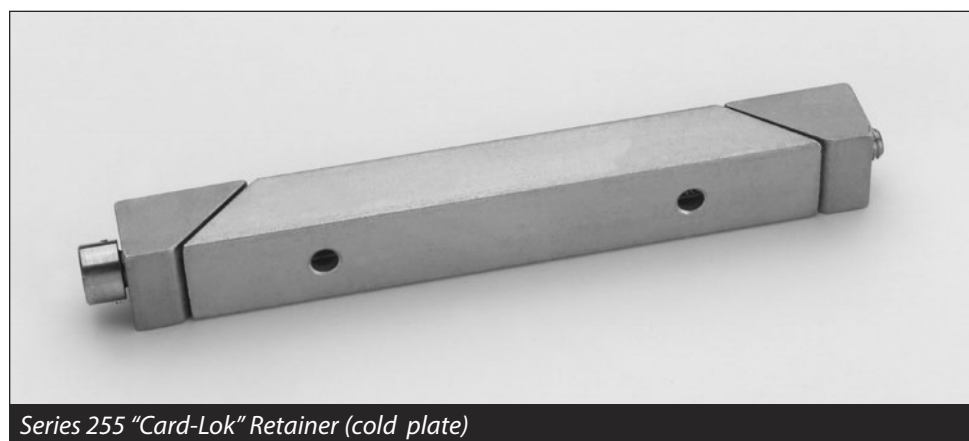
Stainless steel per ASTM-A582

#### Finish:

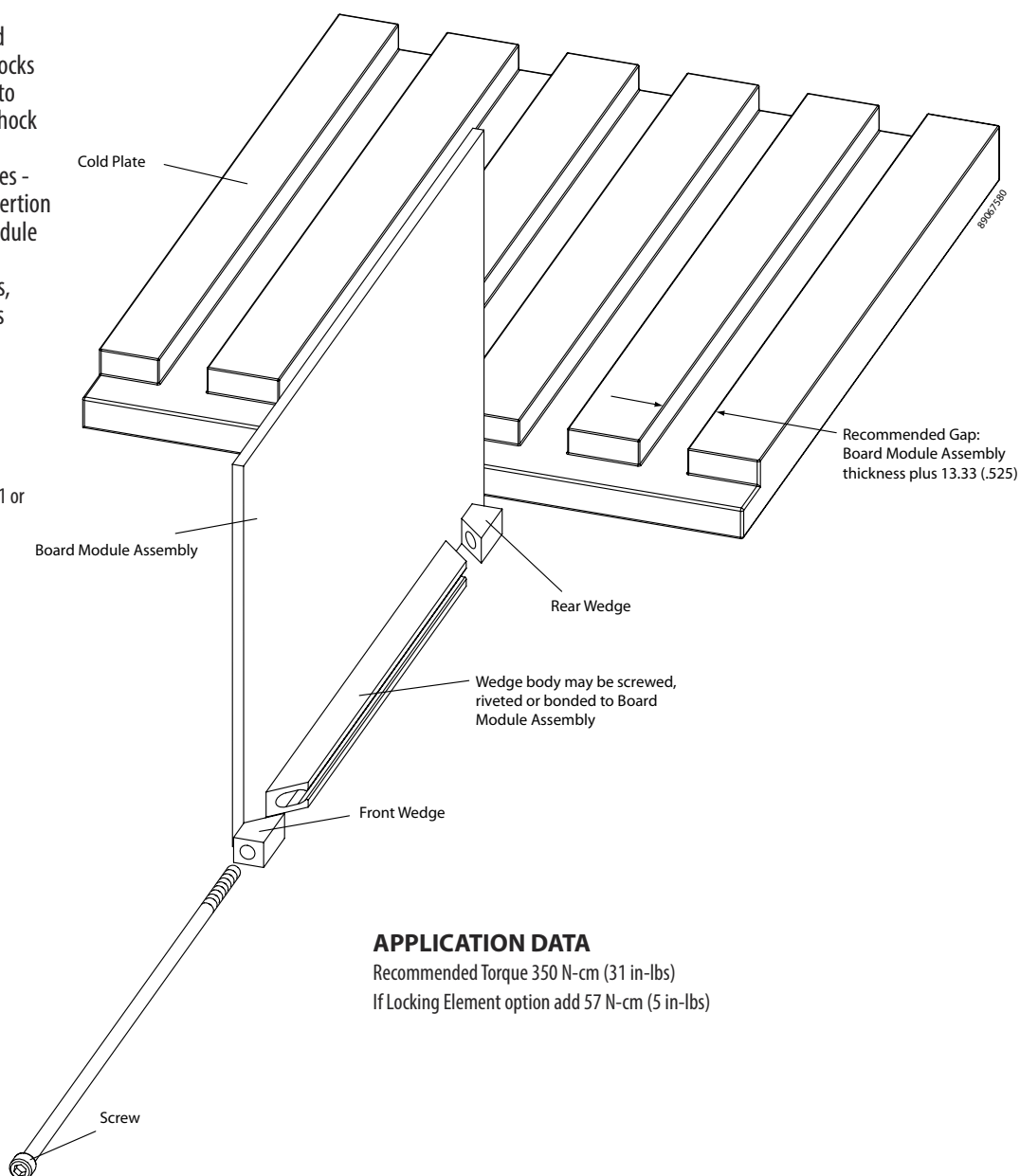
Passivate per MIL-S-5002

### WEIGHT

4.74 g/cm (.425 oz/in)



Series 255 "Card-Lok" Retainer (cold plate)



### APPLICATION DATA

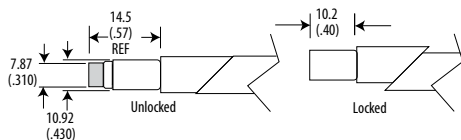
Recommended Torque 350 N-cm (31 in-lbs)

If Locking Element option add 57 N-cm (5 in-lbs)

## OPTION PREFIX

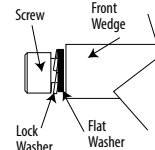
### Detail "V"

Provides visual lock indication. This option adds 5.08 (.20) to the screw length.



### Detail "W"

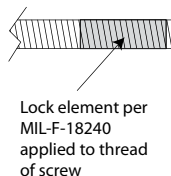
Provides added resistance to loosening from shock and vibration. This option adds 5.08 (.20) to the screw length when combined with the "R" suffix option.



## OPTION SUFFIX

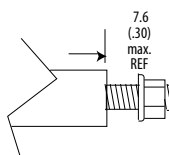
### Detail "L"

Provides prevailing torque for resistance to loosening from shock and vibration. Adds 57 N-cm (5 in-lbs) torque to assembly. See application data on previous sheet.



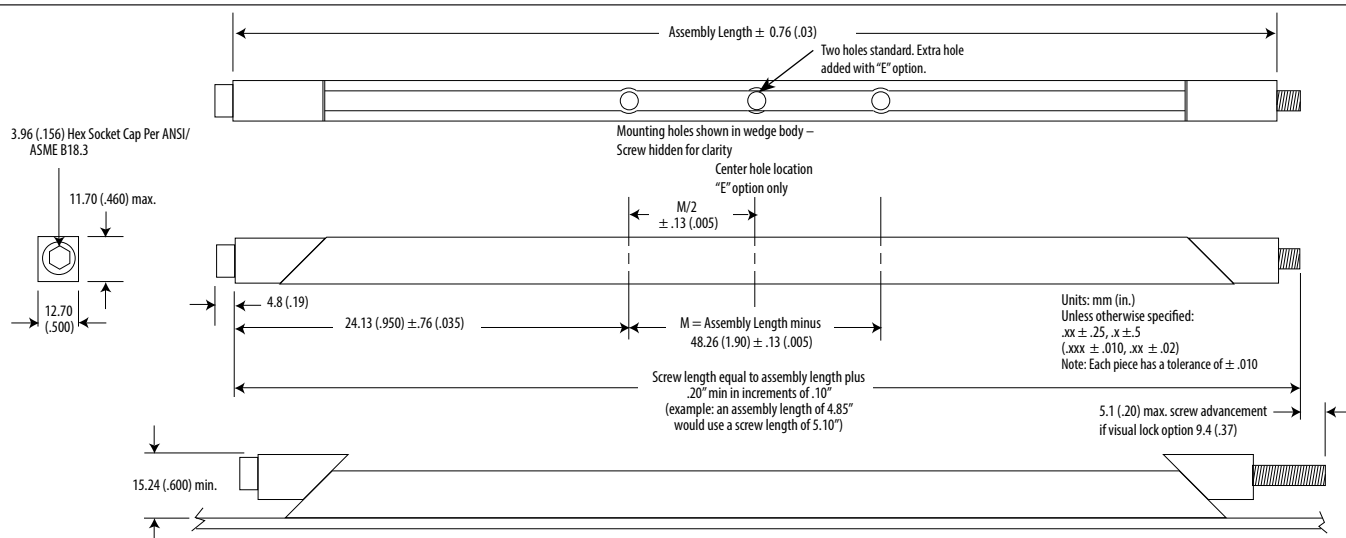
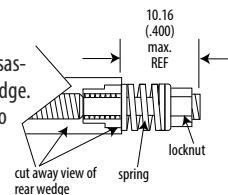
### Detail "R"

Reduces the possibility of unintentional disassembly of the screw from rear wedge. This option adds no additional screw length unless included with "W" option, then 5.1 (.20) total.



### Detail "K"

Prevents the unintentional disassembly of screw from rear wedge. This option adds 5.08 (.20) to the screw length.



## Part Number Code Series 255 Card-Lok Three Piece

### Prefix options

Metric Screw Head M4 Hex Drive **M**  
Standard Screw Head 5/32 Hex Drive **[blank]**  
Lock and Flat Washer **W**  
None **[blank]**  
Visual Indicator **V**  
No Visual Indicator **[blank]**  
Black Anodize **A**  
or choose from Finish Table **see table**

### Suffix options

Stainless Steel Lock Nut if "CR" option is selected **CR**  
Standard Plated Steel Lock Nut **"\_"**  
Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80). **length.xx**  
Other lengths available upon request

Additional Center Mounting Hole **E**  
None **[blank]**  
Mounting Options - holes for rivet mounting or choose from Mounting Option Table **see table**  
Lock Element **L**  
None **[blank]**  
Lock Nut **R**  
None **[blank]**  
Captive Screw **K**  
None **[blank]**

## Part Number Code Example:

VA255CR4.80HR

Series 255 Card-Lok three piece 121.9 (4.80) long with Visual Indicator, black anodized finish, standard rivet mounting hole and stainless steel lock nut option

## FINISH TABLE

| Code Letter    | Finish                                                      |
|----------------|-------------------------------------------------------------|
| <b>[blank]</b> | Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold       |
| <b>"R"</b>     | Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear      |
| <b>"A"</b>     | Black Anodize per Mil-A-8625 Type II, Class 2               |
| <b>"HA"</b>    | Hard Black Anodize per Mil-A-8625 Type III, Class 2         |
| <b>"EN"</b>    | Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright |

## MOUNTING METHOD TABLE

| Code Letter    | Method                                                                                                              |
|----------------|---------------------------------------------------------------------------------------------------------------------|
| <b>[blank]</b> | No mounting holes                                                                                                   |
| <b>"H"</b>     | Rivet Mounting Ø3.45 (.136) hole with 4.95 (.195) counterbore x 9.91 (.390) deep and 100° x 4.95 (.195) countersink |
| <b>"T0"</b>    | 0-80 tapped hole                                                                                                    |
| <b>"T2"</b>    | 2-56 tapped hole                                                                                                    |
| <b>"TM2"</b>   | M2 x 0.40 tapped hole                                                                                               |
| <b>"TM2.5"</b> | M2.5 x 0.45 tapped hole                                                                                             |

Calmark offers the advance design Series 260 "Card-Lok" retainer for cold plate/heat exchanger applications. This totally unique design incorporates design advancements that provide increased thermal transfer, easy insertion and lighter weight. Conforms to DSSC 89024.

### FEATURES

- Maximum uniform clamping force
- Increased thermal transfer
- Maintains wedge and body alignment for easy insertion
- Captivated rear wedge
- Choice of screw head style
- Dimensionally compatible with Series 225 & 245
- Lighter weight
- Design Flexibility - Special lengths, finishes or other design options available on request

### BODIES, WEDGES & SHAFTS

#### Material:

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

#### Finish:

See Part Number Code

### SCREW, LOCK & FLAT WASHER

#### Screw:

Stainless steel per ASTM-A582  
Passivated per AMS2700  
or NAS1352C (depending on option)

#### Washer:

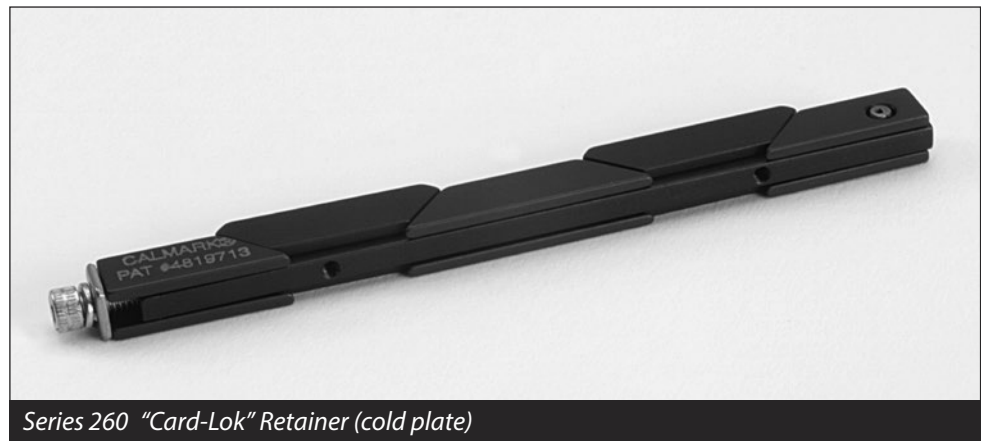
Stainless steel per ASTM-A240  
Passivated per AMS2700

#### Lock Washer:

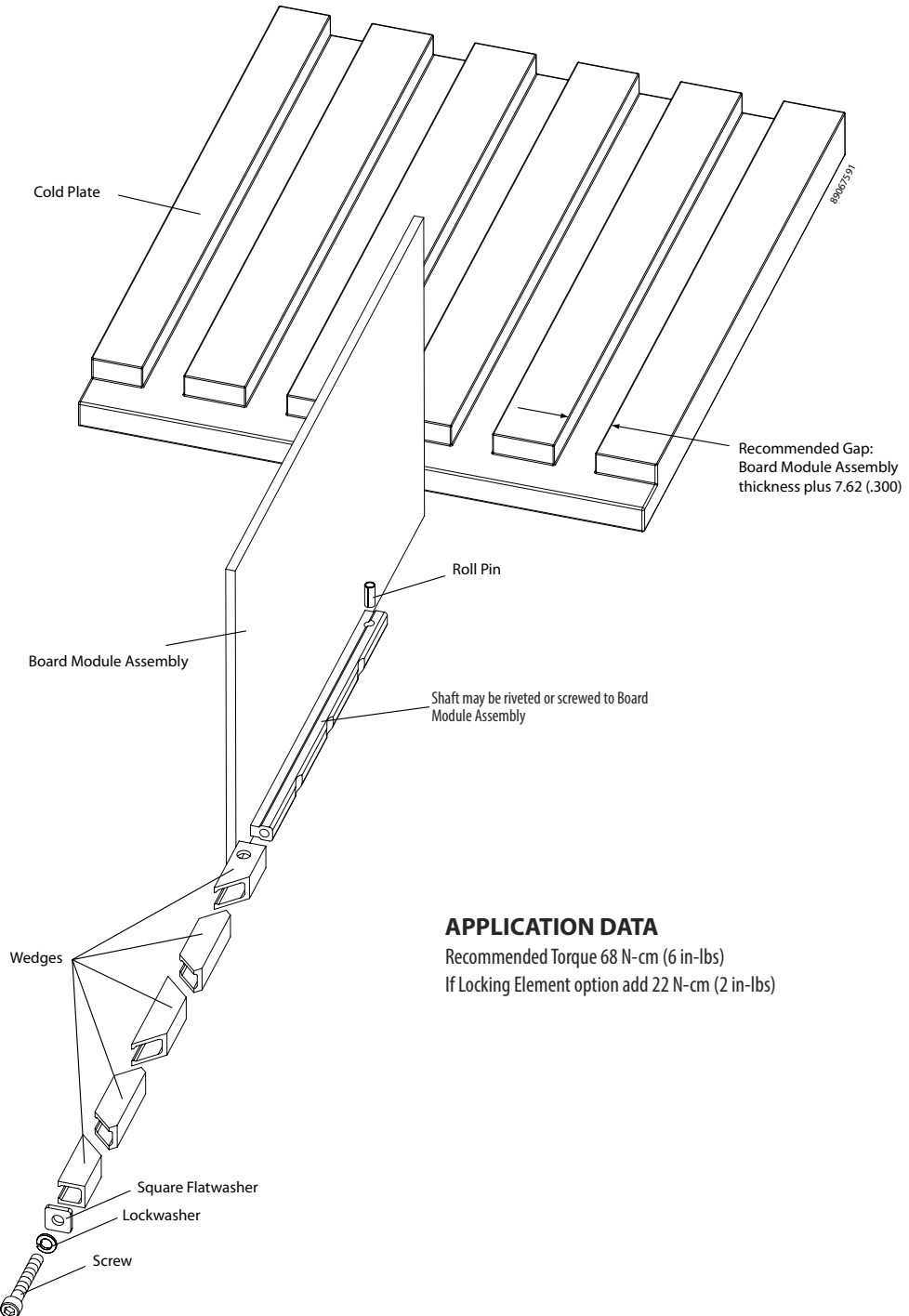
MS35338-135

### WEIGHT

.95 g/cm (.085 oz/in)



Series 260 "Card-Lok" Retainer (cold plate)



### APPLICATION DATA

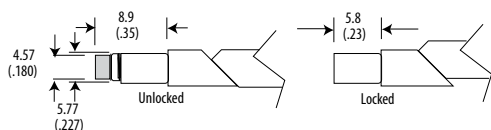
Recommended Torque 68 N-cm (6 in-lbs)  
If Locking Element option add 22 N-cm (2 in-lbs)



## OPTION PREFIX

### Detail "V"

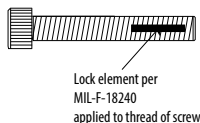
Provides visual lock indication.



## OPTION SUFFIX

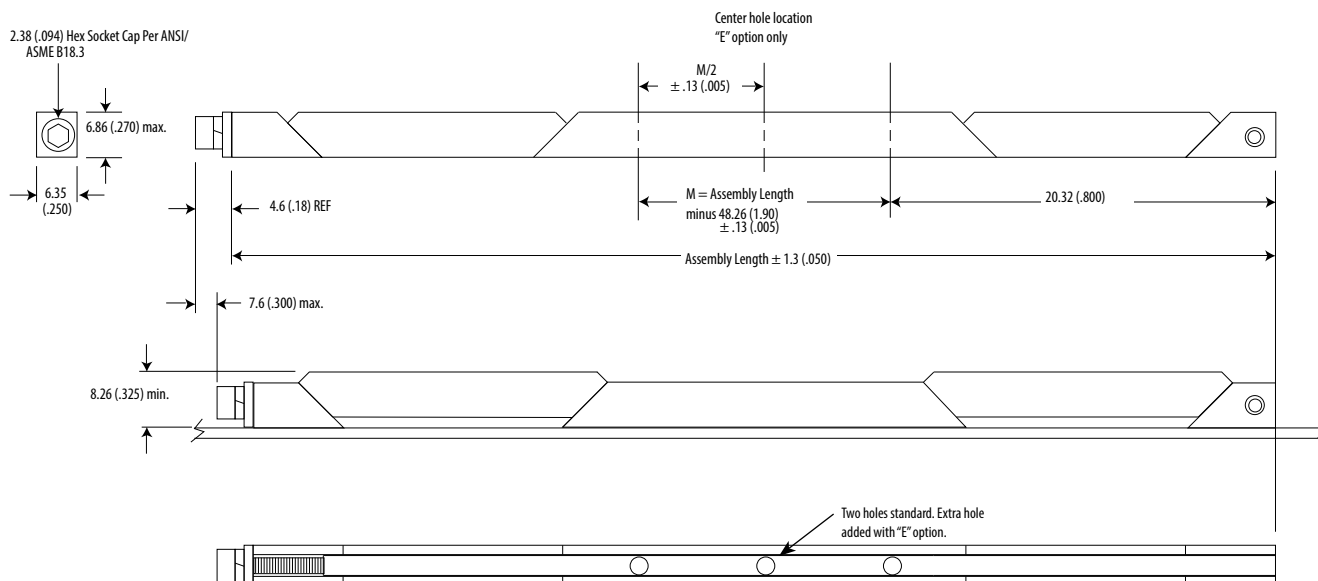
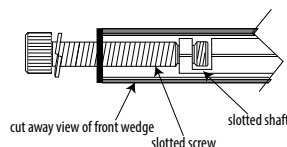
### Detail "L"

Provides prevailing torque for resistance to loosening from shock and vibration. Adds 22 N-cm (2 in-lbs) torque to assembly. See application data on previous sheet.



### Detail "K"

Prevents the unintentional disassembly of screw from front wedge.



Units: mm (in.)  
Unless otherwise specified:  
.xx ± .25, x ± 5  
(xxx ± .010, xx ± .02)  
Note: Each piece has a tolerance of ± .010

## Part Number Code Series 260 Card-Lok Five Piece

### Prefix options

Metric Screw Head M2.5 Hex Drive **M**  
Standard Screw Head 3/32 Hex Drive **[blank]**  
Visual Indicator **V**  
No Visual Indicator **[blank]**  
Black Anodize **A**  
or choose from Finish Table **see table**

### Suffix options

Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80). **length.xx**  
Other lengths available upon request  
Additional Center Mounting Hole **E**  
None **[blank]**  
Mounting Options - through mounting holes **H**  
or choose from Mounting Option Table **see table**  
Lock Element **L**  
None **[blank]**  
Captive Screw **K**  
None **[blank]**

## Part Number Code Example:

MVA260-3.80ET2LK

Series 260 Card-Lok five piece 96.52 (3.80) long black anodized with M2.5 hex drive, visual indicator, three mounting holes tapped for 2-56 thread, locking element and captive screw feature

| Code           | Letter | Finish                                                      |
|----------------|--------|-------------------------------------------------------------|
| <b>[blank]</b> |        | Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold       |
| <b>"R"</b>     |        | Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear      |
| <b>"A"</b>     |        | Black Anodize per Mil-A-8625 Type II, Class 2               |
| <b>"HA"</b>    |        | Hard Black Anodize per Mil-A-8625 Type III, Class 2         |
| <b>"EN"</b>    |        | Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright |

| Code           | Letter | Method                                                                        |
|----------------|--------|-------------------------------------------------------------------------------|
| <b>"H"</b>     |        | Ø1.73/1.85 (.068/.073) dia. through holes countersink 100° x 1.50 (.060) deep |
| <b>"T0"</b>    |        | 0-80 tapped hole                                                              |
| <b>"T2"</b>    |        | 2-56 tapped hole                                                              |
| <b>"TM2"</b>   |        | M2 x 0.40 tapped hole                                                         |
| <b>"TM2.5"</b> |        | M2.5 x 0.45 tapped hole                                                       |

Calmark offers the Series L260 Lever-Lok "Card-Lok" retainer for cold plate/heat exchanger applications. This totally unique design provides tool free, lever action locking on the advance design Series 260 Card-Lok. The Series L260 provides visual indication of accurate, repeatable locking to a preset clamping force.

### FEATURES

- Tool-free actuation
- Visual indication of locked or unlocked status
- Preset and adjustable clamping force
- Clamping force consistently repeated
- Maintains wedge and body alignment for easy installation
- Design Flexibility - Special lengths, finishes, or other design options available on request

### MATERIALS & FINISHES

#### WEDGE, BODY, SHAFT & LEVER

##### Material:

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

##### Finish:

Wedge, Body, Shaft & Lever: Black Anodize per MIL-A-8625, Type II, Class 2.

Wedges: also have Dry Film Lube per MIL-PRF-46010

Lever: Hard Black Anodize per MIL-A-8625, Type III, Class 2

#### ADJUSTMENT SCREW

##### Material:

Stainless Steel per ASTM-A582\QQ-S-763

##### Finish:

Passivate per AMS2700

#### HARDWARE

##### Material:

Front Washer: MPIF Standard 35

Rear Washer: ASTM-A240

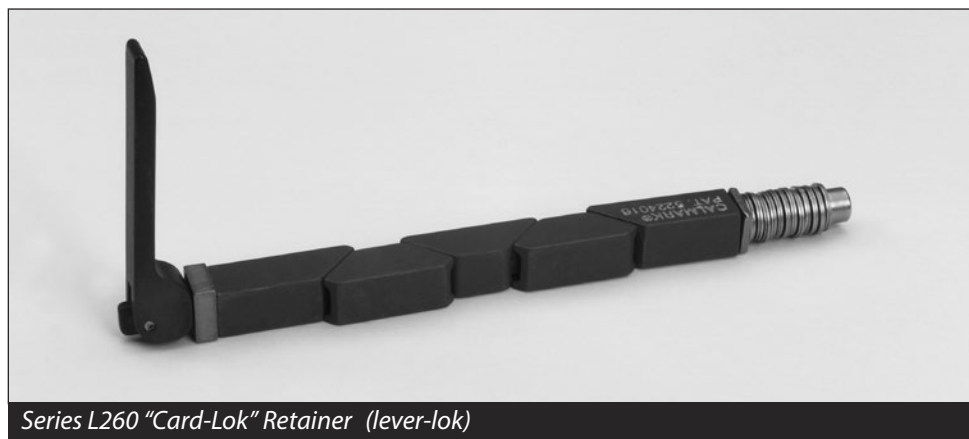
Belleville Washers: ASTM-A666

##### Finish:

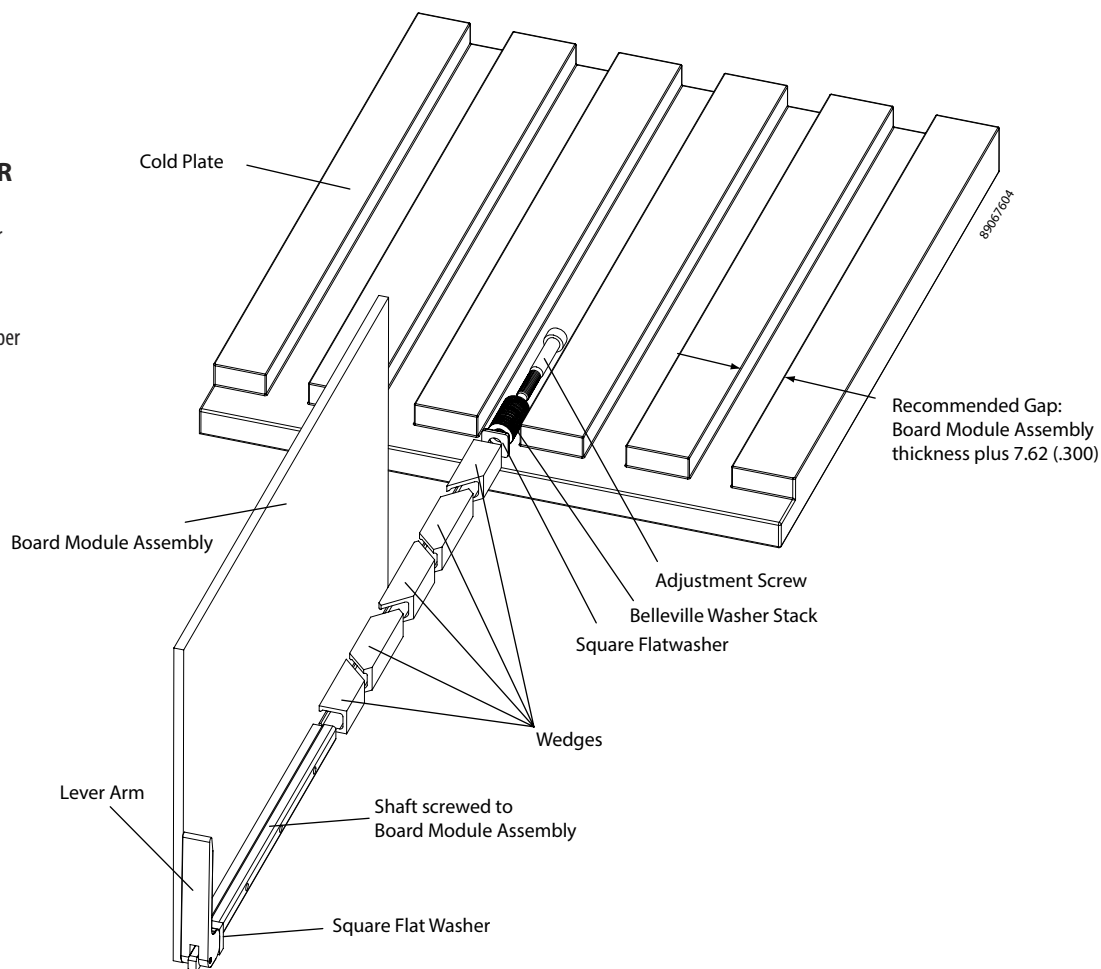
Passivate per Mil-S-5002

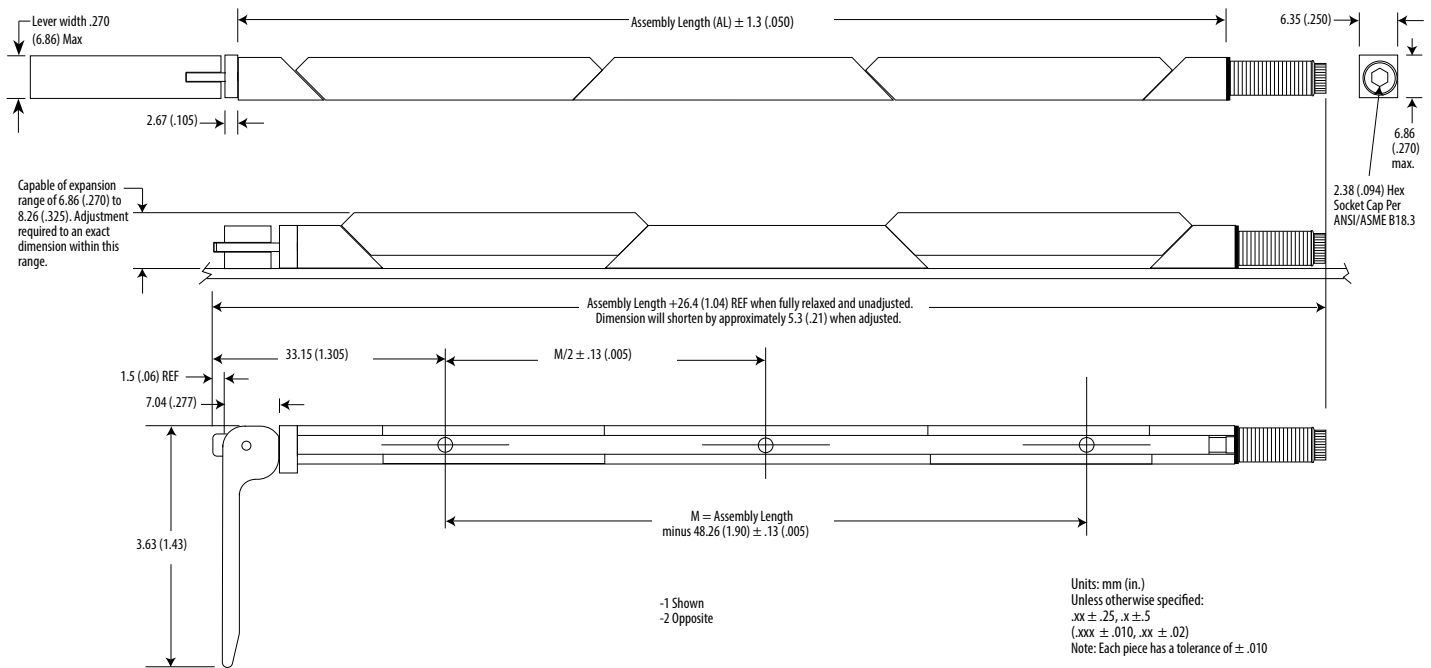
#### WEIGHT

1.17 g/cm (.105 oz/in)



Series L260 "Card-Lok" Retainer (Lever-Lok)





## CLAMPING FORCE ADJUSTMENT PROCEDURE

Lever-Lok is furnished unadjusted and will require the use of the following procedure to achieve proper clamping.

NOTE: Factory preset adjustment available on request. (See part number code)

1. Fasten Lever-Lok to Board Module Assembly
2. Insert Board Module Assembly into slot in cold plate
3. Actuate lever to locked/closed position
4. Tighten screw on end of shaft until wedges initially contact wall of cold plate slot, or slight insertion extraction drag is felt
5. Additionally tighten screw 2 full turns.

**DO NOT EXCEED TWO (2) TURNS**

6. Lever-Lok is now ready to use

**Note: Factory adjustment of clamping force available on request. See P and P2 suffix option in Part Number Code table.**

## CLAMPING FORCE DATA

Direct force of assembly is approximately 556N (125lbs), when adjusted per recommended procedure.

Direct force of assembly is affected approximately as follows: 26.7N (6lbs) per each .025 (.001) variation of cold plate slot width, or 169N (38lbs) per each full turn of screw.

### Part Number Code

#### Series L260 Card-Lok Five Piece

#### Suffix options

Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80)

Other lengths available upon request

Mounting Options - M2 x 0.40 tapped holes

or choose from Mounting Option Table

Lever Direction

Factory Preset clamping force when expanded to 7.63 (.300)

556N (125lbs)

645N (145lbs)

None

L260 - 3.80 TM2 -1 P

length.xx

TM2

see table

-1

-2

P

P2

[blank]

### Part Number Code Example:

L260-3.80TM2-1

Series L260 five piece lever actuated Card-Lok 96.52 (3.80) long with black anodized finish, -1 lever direction and no factory preset clamping load

### MOUNTING METHOD TABLE

| Code    | Method                  |
|---------|-------------------------|
| [blank] | 2-56 tapped hole        |
| "TM2"   | M2 x 0.40 tapped hole   |
| "TM2.5" | M2.5 x 0.45 tapped hole |

Calmark offers the Series LE260 Extracting/Lever-Lok ("Card-Lok") retainer for cold plate/heat-exchanger applications. This totally unique design provides the significant feature of Board Module Assembly extraction in addition to tool free lever action locking. The Series LE260 provides visual indication of accurate, repeatable locking to a preset clamping force.

### FEATURES

- Safe and easy Board Module Assembly extraction with 4:1 mechanical advantage
- Tool-free actuation
- Visual indication of locked or unlocked status
- Preset and adjustable clamping force
- Clamping force consistently repeated
- Maintains wedge and body alignment for easy installation
- Design Flexibility - Special lengths, finishes, or other design options available on request

### MATERIALS & FINISHES

#### WEDGE, BODY, SHAFT & LEVER

##### Material:

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

##### Finish:

Wedge & Shaft: Black Anodize per MIL-A-8625, Type II, Class 2

Wedges: also have Dry Film Lube per MIL-PRF-46010

Lever: Hard Black Anodize per MIL-A-8625, Type III, Class 2

#### ADJUSTMENT SCREW

##### Material:

Stainless steel per ASTM-A582 or AMS-QQ-S-763

##### Finish:

Passivate per AMS2700

#### HARDWARE

##### Material:

Front Washer: MPIF Standard 35

Rear Washer: ASTM-A240

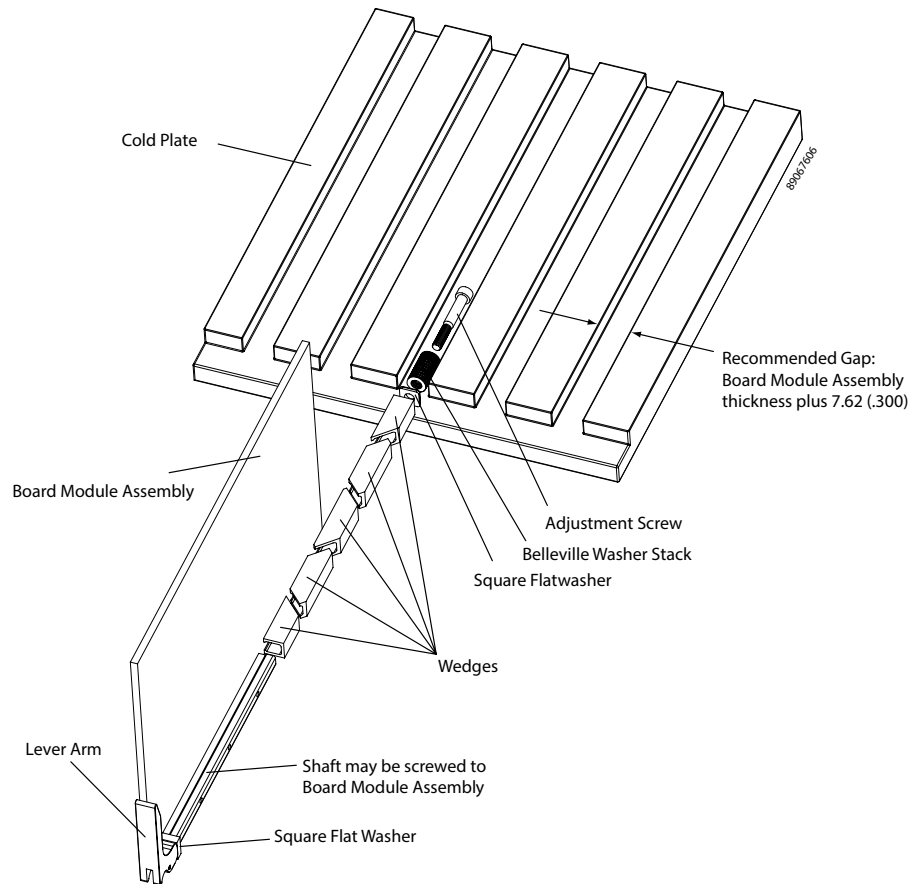
Belleville Washers: ASTM-A266

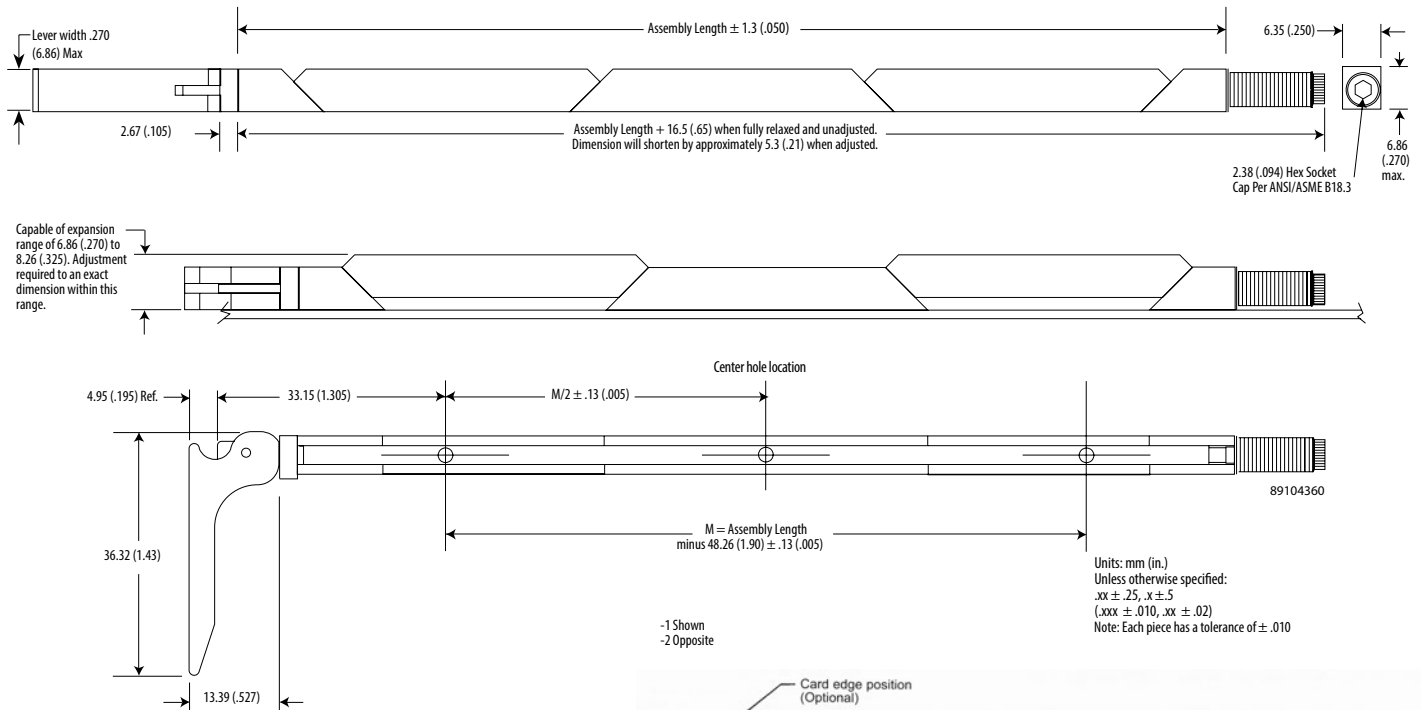
##### Finish:

Passivate per Mil-S-5002

#### WEIGHT

1.17 g/cm (.105 oz/in)



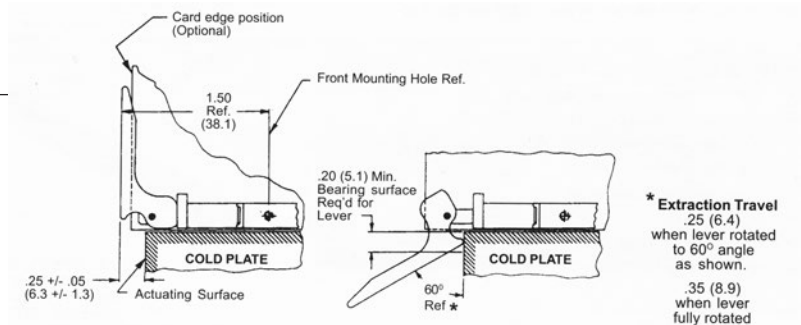


## CLAMPING FORCE ADJUSTMENT PROCEDURE

Lever-Lok furnished assembled with spring stack preloaded but not adjusted.

1. Fasten Lever-Lok to Board Module Assembly
2. Insert Board Module Assembly into slot in cold plate
3. Actuate lever to locked/closed position
4. Tighten screw on end of shaft until wedges initially contact wall of cold plate slot, or slight insertion extraction drag is felt
5. Additionally tighten locknut two full turns.  
**DO NOT EXCEED TWO (2) TURNS.**
6. Lever-Lok is now ready to use

**NOTE: Factory adjustment of clamping force available on request. See part number code.**



## CLAMPING FORCE DATA

Direct force of assembly is approximately 556N (125lbs), when adjusted per recommended procedure.

Direct force of assembly is affected approximately as follows: 26.7N (6lbs) per each .025 (.001) variation of cold plate slot width, or 169N (38lbs) per each full turn of screw.

### Part Number Code

#### Series LE260 Card-Lok Five Piece

#### Suffix options

Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80). **length.xx**  
Other lengths available upon request

Mounting Options - 0-80 tapped holes **TO**  
or choose from Mounting Option Table **see table**  
Lever Direction **-1**  
**-2**

Factory Preset clamping force when expanded to 7.62 (.300)

556N (125lbs)

645N (145lbs)

None

LE260 - 3.80 TO -1 P

P

P

P

P

P

P

P

P

P

P

P

P

P

P

P

P

P

P

### Part Number Code Example:

LE260-2.80TM2-1P2

Series LE260 five piece lever actuated Card-Lok with extractor feature, 71.12 (2.80) long with M2 x .40 tapped mounting holes, -1 lever direction and factory preset for 645N (145lbs) clamping force when expanded to .300 DIM

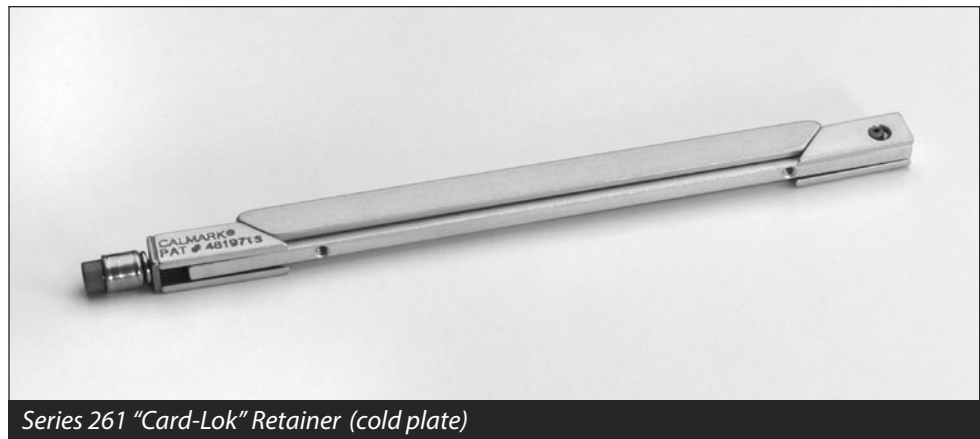
### MOUNTING METHOD TABLE

| Code Letter | Method                  |
|-------------|-------------------------|
| [blank]     | 2-56 tapped hole        |
| "TO"        | 0-80 tapped hole        |
| "TM2"       | M2 x 0.40 tapped hole   |
| "TM2.5"     | M2.5 x 0.45 tapped hole |

Calmark offers the Series 261 "Card-Lok" Retainer for cold-plate, heat exchanger applications.

### FEATURES

- Maximum uniform clamping force
- Increased thermal transfer
- Maintains wedge and body alignment for easy installation
- Captivated rear wedge
- Choice of screw head style
- Lighter weight
- Design Flexibility - Special lengths, finishes, or other design options available on request



Series 261 "Card-Lok" Retainer (cold plate)

### WEDGES, BODY & SHAFT

#### Material:

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

#### Finish:

See Finish Table

### SCREW, LOCK & FLAT WASHER

#### Material:

300 Series Stainless Steel

#### Finish:

Passivate per Mil-S-5002

### ROLL PIN

#### Material:

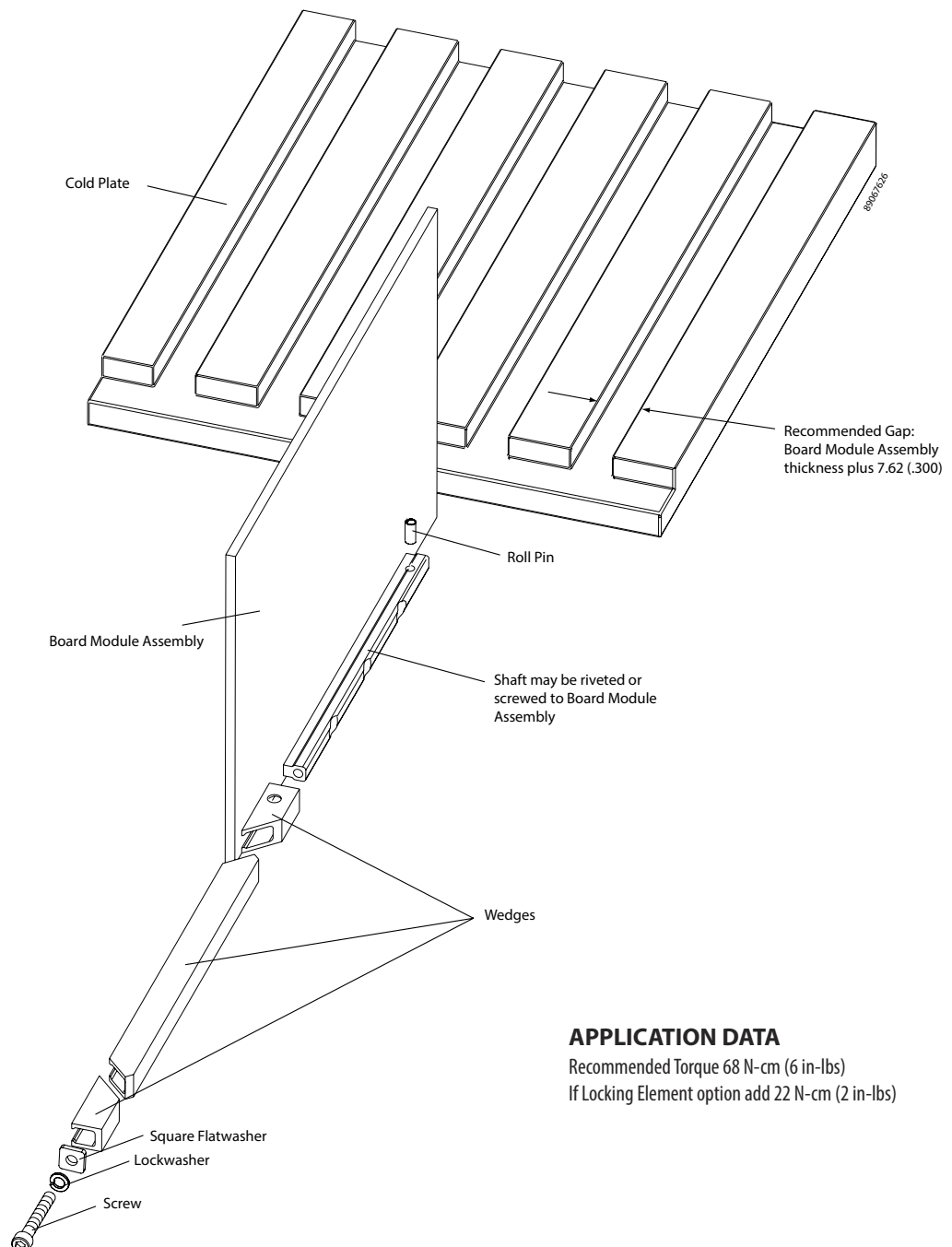
MS39086-125

#### Finish:

Passivate per Mil-S-5002

### WEIGHT

.95 g/cm (.085 oz/in)



### APPLICATION DATA

Recommended Torque 68 N-cm (6 in-lbs)

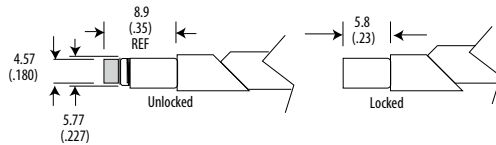
If Locking Element option add 22 N-cm (2 in-lbs)



## OPTION PREFIX

### Detail "V"

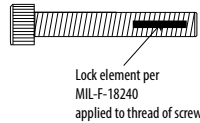
Provides visual lock indication.



## OPTION SUFFIX

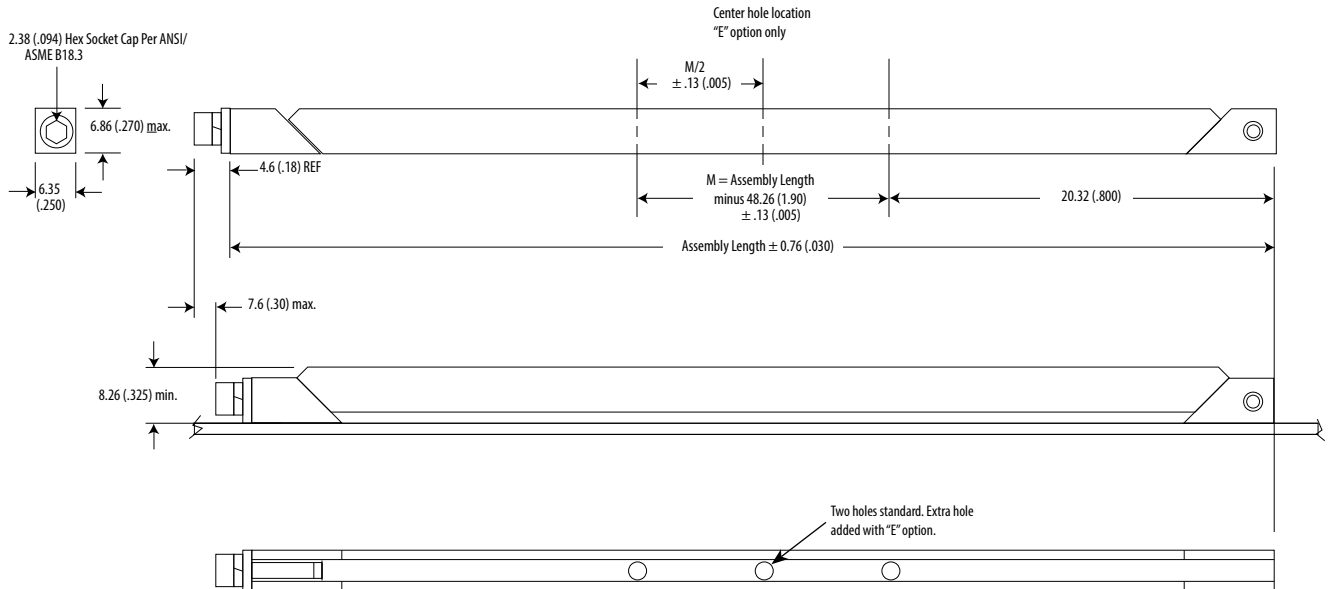
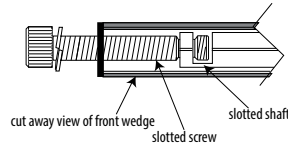
### Detail "L"

Provides prevailing torque for resistance to loosening from shock and vibration. Adds 22 N-cm (2 in-lbs) torque to assembly. See application data on previous sheet.



### Detail "K"

Prevents the unintentional disassembly of screw from front wedge.



Units: mm (in.)  
Unless otherwise specified:  
.xx ± .25, .x ± .5  
(.xxx ± .010, .xx ± .02)  
Note: Each piece has a tolerance of ± .010

## Part Number Code Series 261 Card-Lok Three Piece

### Prefix options

Metric Screw Head M2.5 Hex Drive **M**  
Standard Screw Head 3/32 Hex Drive **[blank]**  
Visual Indicator **V**  
No Visual Indicator **[blank]**  
Black Anodize **A**  
or choose from Finish Table **see table**

### Suffix options

Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80). **length.xx**  
Other lengths available upon request  
Additional Center Mounting Hole **E**  
None **[blank]**  
Mounting Options - Through mounting holes **H**  
or choose from Mounting Option Table **see table**  
Lock Element **L**  
None **[blank]**  
Captive Screw **K**  
None **[blank]**

## Part Number Code Example:

MVA261-3.80H

Series 261 Card-Lok three piece 96.52 (3.80) long with M2.5 socket head screw, visual indicator, black anodize finish and standard rivet mounting hole

## FINISH TABLE

| Code Letter    | Finish                                                      |
|----------------|-------------------------------------------------------------|
| <b>[blank]</b> | Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold       |
| <b>"R"</b>     | Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear      |
| <b>"A"</b>     | Black Anodize per Mil-A-8625 Type II, Class 2               |
| <b>"HA"</b>    | Hard Black Anodize per Mil-A-8625 Type III, Class 2         |
| <b>"EN"</b>    | Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright |

## MOUNTING METHOD TABLE

| Code Letter    | Method                                                                        |
|----------------|-------------------------------------------------------------------------------|
| <b>"H"</b>     | Ø1.73/1.85 (.068/.073) dia. through holes countersink 100° x 1.50 (.060) deep |
| <b>"T0"</b>    | 0-80 tapped hole                                                              |
| <b>"T2"</b>    | 2-56 tapped hole                                                              |
| <b>"TM2"</b>   | M2 x 0.40 tapped hole                                                         |
| <b>"TM2.5"</b> | M2.5 x 0.45 tapped hole                                                       |

Calmark offers the Series 263 "Card-Lok" Retainer for cold-plate, heat exchanger applications. This "Card-Lok" configuration offers a larger cross sectional profile for increased clamping force and thermal transfer.

### FEATURES

- Maximum uniform clamping force
- Increased thermal transfer
- Maintains wedge and body alignment for easy installation
- Captivated rear wedge
- Choice of screw head style
- Lighter weight
- Lower cost - faster delivery
- Design Flexibility - Special lengths, finishes, or other design options available on request

### WEDGES, BODIES & SHAFT

#### Material:

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

#### Finish:

See Finish Table

### SCREW

#### Material:

NAS1352C, Modified NAS1352C04 or 18-8 stainless steel

#### Finish:

Passivate per Mil-S-5002

### LOCK WASHER

#### Material:

MS35338-135

#### Finish:

Passivate per Mil-S-5002

### FLAT WASHER

#### Material:

300 Series Stainless Steel

#### Finish:

Passivate per Mil-S-5002

### ROLL PIN

#### Material:

400 Series Stainless Steel

#### Finish:

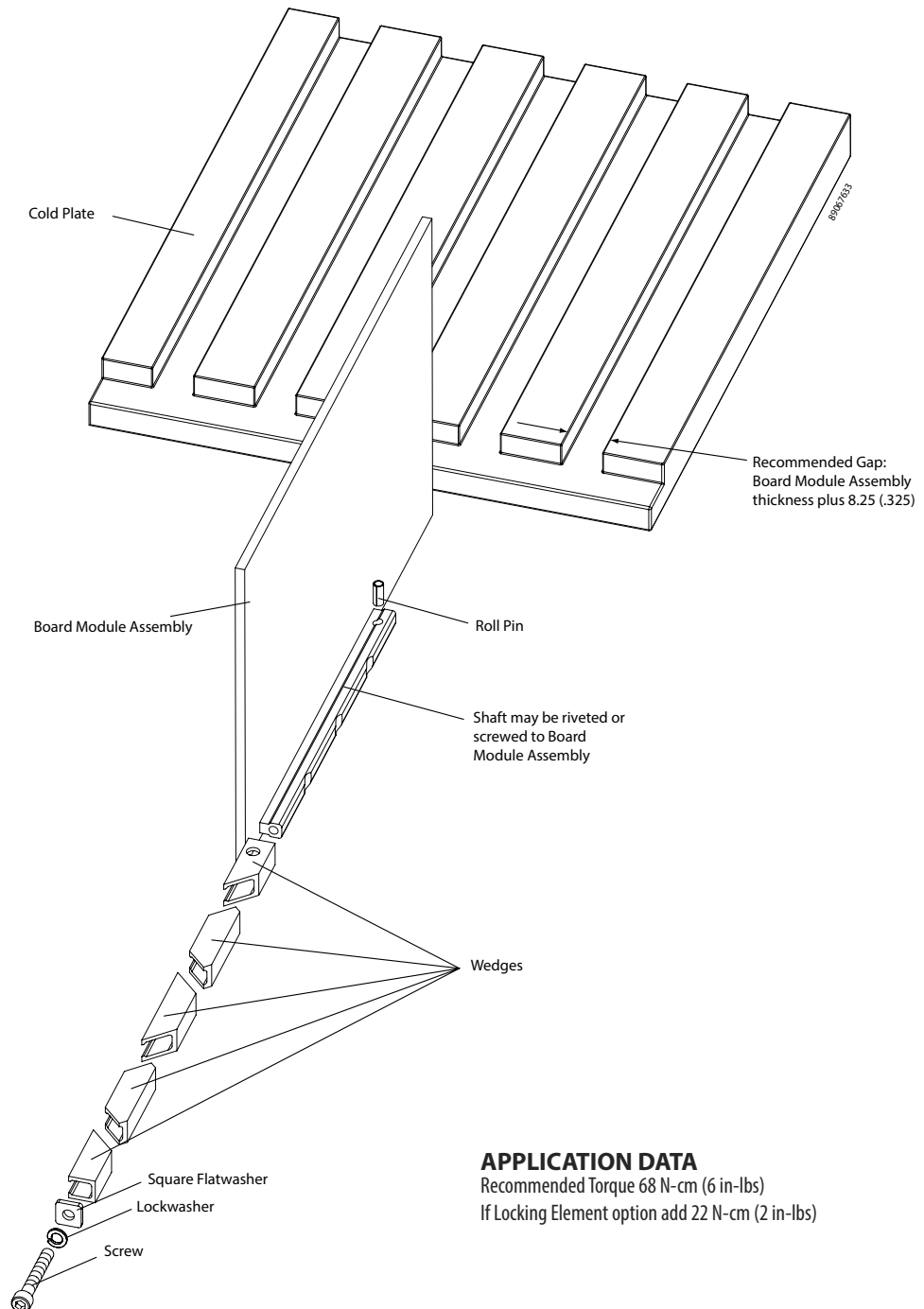
Passivate per Mil-S-5002

### WEIGHT

1.07 g/cm (.096 oz/in)



Series 263 "Card-Lok" Retainer (cold plate)



### APPLICATION DATA

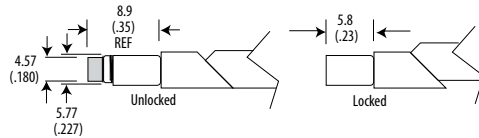
Recommended Torque 68 N-cm (6 in-lbs)

If Locking Element option add 22 N-cm (2 in-lbs)

## OPTION PREFIX

### Detail "V"

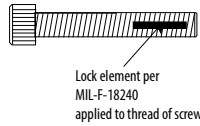
Provides visual lock indication.



## OPTION SUFFIX

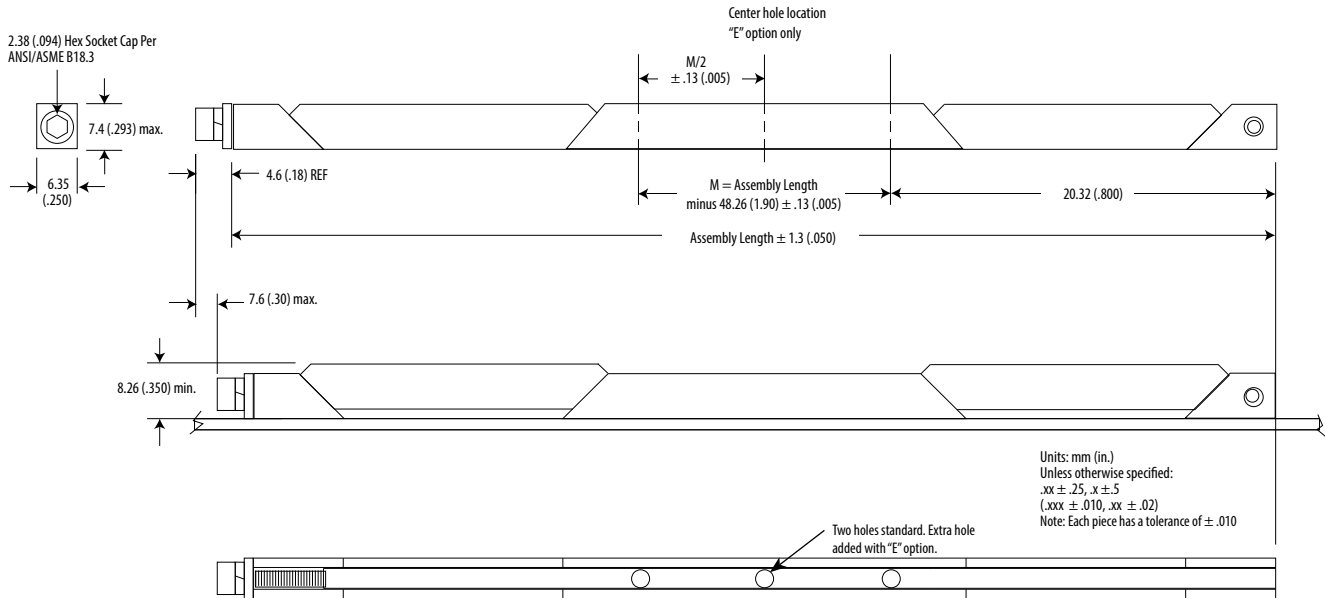
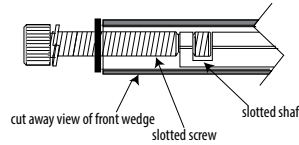
### Detail "L"

Provides prevailing torque for resistance to loosening from shock and vibration. Adds 22 N-cm (2 in-lbs) torque to assembly. See application data on previous sheet.



### Detail "K"

Prevents the unintentional disassembly of screw from front wedge.



Units: mm (in.)  
Unless otherwise specified:  
.xx ± .25, .x ± .5  
(.xxx ± .010, .xx ± .02)  
Note: Each piece has a tolerance of ± .010

## Part Number Code Series 263 Card-Lok Five Piece

### Prefix options

Metric Screw Head M2.5 Hex Drive **M**  
Standard Screw Head 3/32 Hex Drive **[blank]**  
Visual Indicator **V**  
No Visual Indicator **[blank]**  
Black Anodize **A**  
or choose from Finish Table **see table**

### Suffix options

Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80). **length.xx**  
Other lengths available upon request  
Additional Center Mounting Hole **E**  
None **[blank]**  
Mounting Options - through mounting holes **H**  
or choose from Mounting Option Table **see table**  
Lock Element **L**  
None **[blank]**  
Captive Screw **K**  
None **[blank]**

## Part Number Code Example:

V263-3.80ET0K

Series 263 Card-Lok five piece 96.52 (3.80) long with M3 socket head screw, visual indicator, gold chemical finish, 0-80 tapped mounting holes with an additional center mounting hole and a captive screw option

## FINISH TABLE

| Code           | Finish                                                      |
|----------------|-------------------------------------------------------------|
| <b>[blank]</b> | Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold       |
| <b>"R"</b>     | Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear      |
| <b>"A"</b>     | Black Anodize per Mil-A-8625 Type II, Class 2               |
| <b>"HA"</b>    | Hard Black Anodize per Mil-A-8625 Type III, Class 2         |
| <b>"EN"</b>    | Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright |

## MOUNTING METHOD TABLE

| Code           | Method                                                                        |
|----------------|-------------------------------------------------------------------------------|
| <b>"H"</b>     | Ø1.73/1.85 (.068/.073) dia. through holes countersink 100° x 1.50 (.060) deep |
| <b>"T0"</b>    | 0-80 tapped hole                                                              |
| <b>"T2"</b>    | 2-56 tapped hole                                                              |
| <b>"TM2"</b>   | M2 x 0.40 tapped hole                                                         |
| <b>"TM2.5"</b> | M2.5 x 0.45 tapped hole                                                       |

Calmark offers the Series 264 "Card-Lok" Retainer for cold-plate, heat exchanger applications. This "Card-Lok" configuration offers a larger cross sectional profile for increased clamping force and thermal transfer.

### FEATURES

- Maximum uniform clamping force
- Increased thermal transfer
- Maintains wedge and body alignment for easy installation
- Captivated rear wedge
- Choice of screw head style
- Lighter weight
- Lower cost - faster delivery
- Design Flexibility - Special lengths, finishes, or other design options available on request

### WEDGES, BODIES & SHAFT

#### Material:

Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

#### Finish:

See Part Number Code

### SCREW

#### Material:

NAS1352C, Modified NAS1352C04 or 18-8 stainless steel, Stainless steel per ASTM-A582

#### Finish:

Passivate per Mil-S-5002

### LOCK WASHER

#### Material:

MS35338-135

#### Finish:

Passivate per Mil-S-5002

### FLAT WASHER

#### Material:

300 Series Stainless Steel

#### Finish:

Passivate per Mil-S-5002

### ROLL PIN

#### Material:

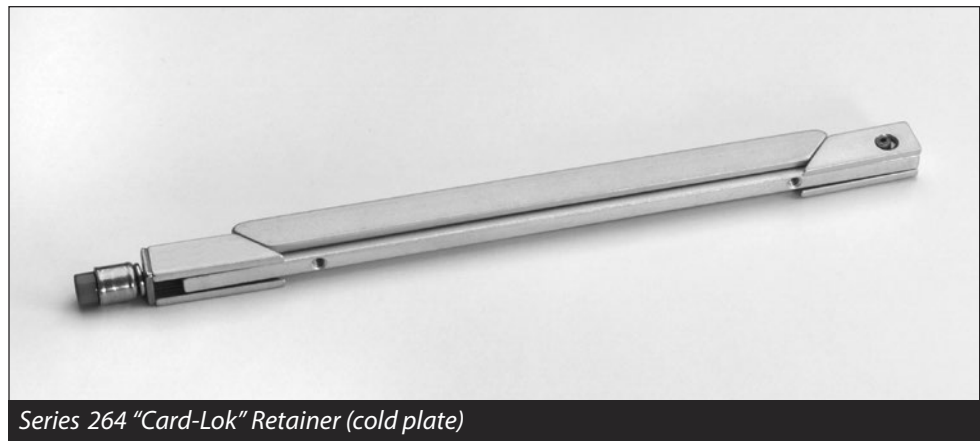
400 Series Stainless Steel

#### Finish:

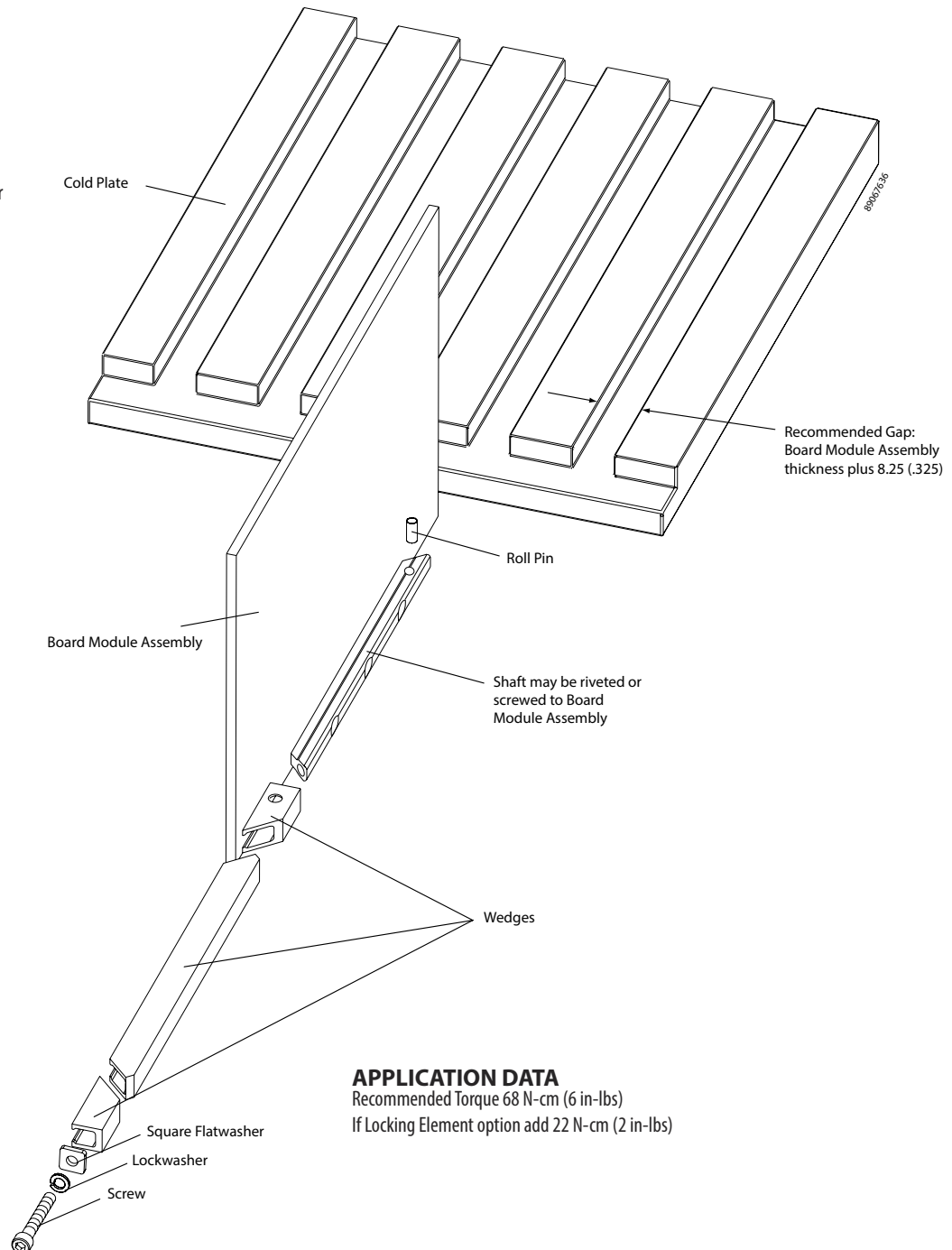
Passivate per Mil-S-5002

### WEIGHT

1.07 g/cm (.096 oz/in)



Series 264 "Card-Lok" Retainer (cold plate)



### APPLICATION DATA

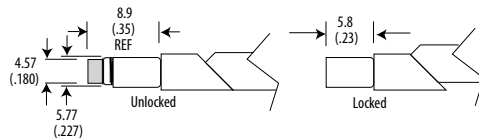
Recommended Torque 68 N-cm (6 in-lbs)

If Locking Element option add 22 N-cm (2 in-lbs)

## OPTION PREFIX

### Detail "V"

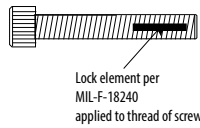
Provides visual lock indication.



## OPTION SUFFIX

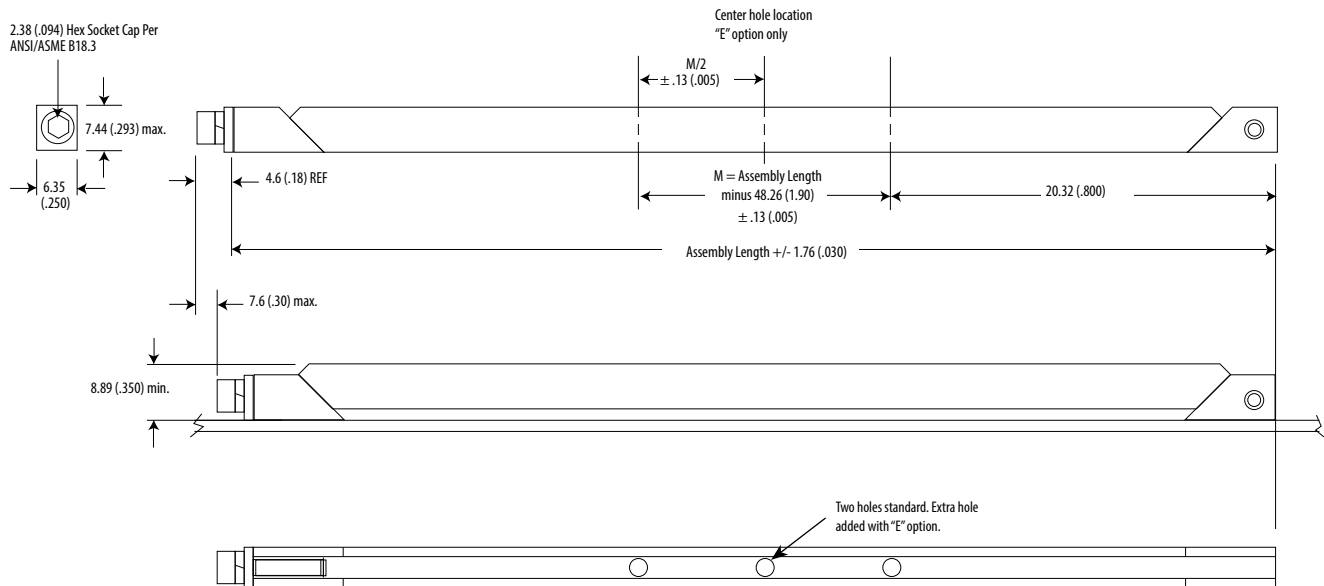
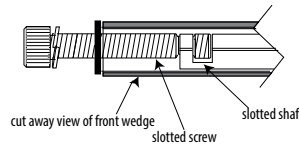
### Detail "L"

Provides prevailing torque for resistance to loosening from shock and vibration. Adds 22 N-cm (2 in-lbs) torque to assembly. See application data on previous sheet.



### Detail "K"

Prevents the unintentional disassembly of screw from front wedge.



Units: mm (in.)  
Unless otherwise specified:  
.xx ± .25, .x ± .5  
(.xxx ± .010, .xx ± .02)  
Note: Each piece has a tolerance of ± .010

## Part Number Code Series 264 Card-Lok Three Piece

### Prefix options

Metric Screw Head M2.5 Hex Drive **M**  
Standard Screw Head 3/32 Hex Drive **[blank]**  
Visual Indicator **V**  
No Visual Indicator **[blank]**  
Black Anodize **A**  
or choose from Finish Table **see table**

### Suffix options

Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80). **length.xx**  
Other lengths available upon request  
Additional Center Mounting Hole **E**  
None **[blank]**  
Mounting Options - holes for rivet mounting **H**  
or choose from Mounting Option Table **see table**  
Lock Element **L**  
None **[blank]**  
Captive Screw **K**  
None **[blank]**

## Part Number Code Example:

M264-2.80T2LK

Series 264 Card-Lok three piece 71.12 (2.80) long with .094-in. hex drive, chemical film finish, 2-56 mounting holes, lock element and captive screw.

Code  
Letter

## FINISH TABLE

| Code    | Letter | Finish                                                      |
|---------|--------|-------------------------------------------------------------|
| [blank] |        | Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold       |
| "R"     |        | Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear      |
| "A"     |        | Black Anodize per Mil-A-8625 Type II, Class 2               |
| "HA"    |        | Hard Black Anodize per Mil-A-8625 Type III, Class 2         |
| "EN"    |        | Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright |

Code  
Letter

## MOUNTING METHOD TABLE

| Code    | Letter | Method                                                                        |
|---------|--------|-------------------------------------------------------------------------------|
| "H"     |        | Ø1.73/1.85 (.068/.073) dia. through holes countersink 100° x 1.52 (.060) deep |
| "T0"    |        | 0-80 tapped hole                                                              |
| "T2"    |        | 2-56 tapped hole                                                              |
| "TM2"   |        | M2 x 0.40 tapped hole                                                         |
| "TM2.5" |        | M2.5 x 0.45 tapped hole                                                       |

Calmark offers the narrow, advance design Series 265 "Card-Lok" retainer for cold plate/heat exchanger applications. This totally unique design incorporates design advancements that provide increased thermal transfer, easy insertion, lighter weight and now closer center to center board spacing.

### FEATURES

- Narrow design permits closer board spacing
- Maximum uniform clamping force
- Increased thermal transfer
- Maintains wedge and body alignment for easy installation
- Captivated rear wedge
- Choice of screw head style
- Lighter weight
- Lower cost - faster delivery
- Design Flexibility - Special lengths, finishes, or other design options available on request

### WEDGES, BODIES & SHAFT

#### Material:

Wedges: Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8

Shaft: Aluminum alloy 7075-T6 per ASTM-B221 or AMS-QQ-A-200/11

#### Finish:

See Finish Table

### SCREW, LOCK & FLAT WASHER

#### Material:

NAS1352C, Modified NAS1352C04 or 18-8 stainless steel, Stainless steel per ASTM-A582

#### Finish:

Passivate per Mil-S-5002

### ROLL PIN

#### Material:

400 Series Stainless Steel

#### Finish:

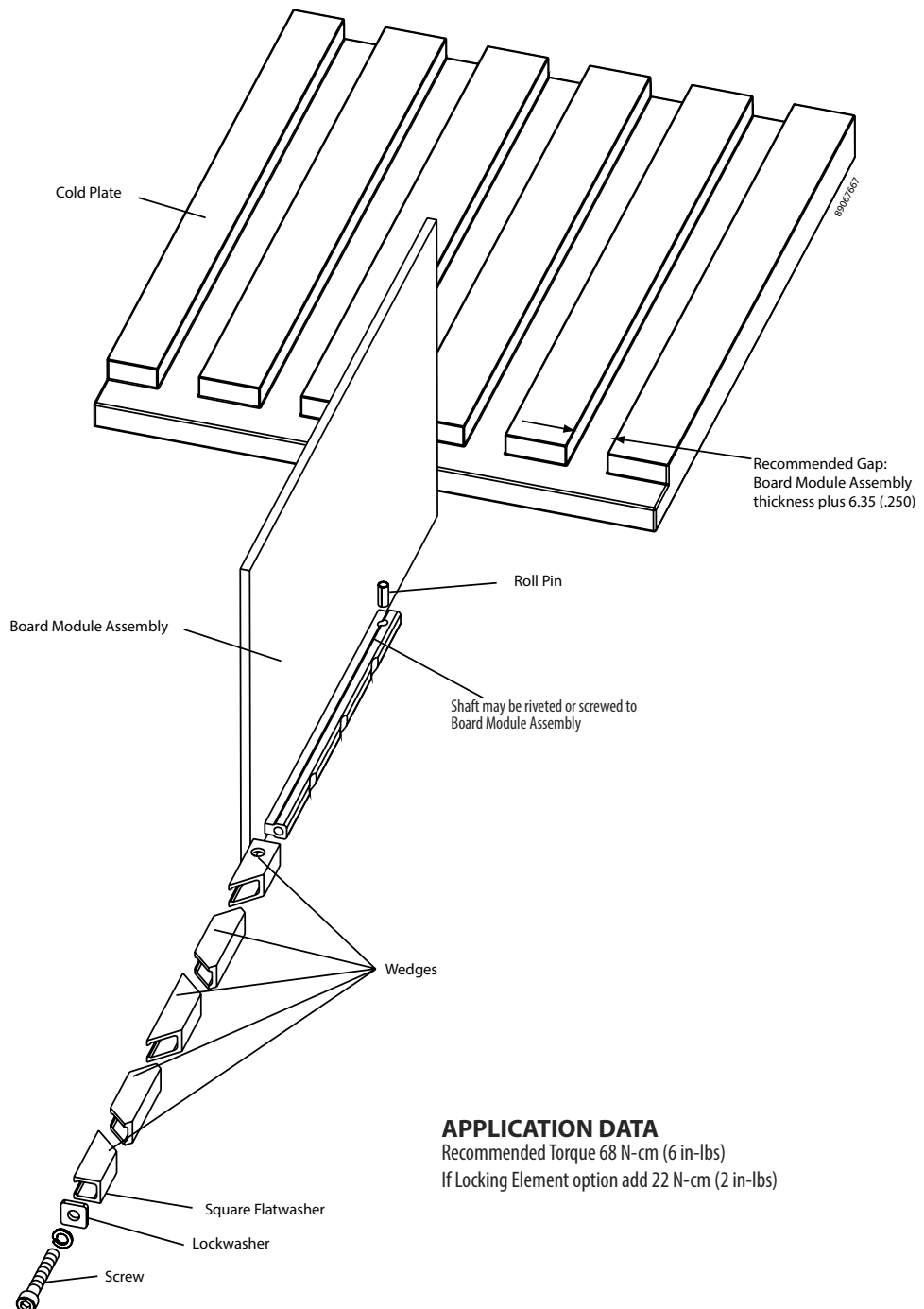
Passivate per Mil-S-5002

### WEIGHT

.89 g/cm (.080 oz/in)



Series 265 "Card-Lok" Retainer (cold plate)



### APPLICATION DATA

Recommended Torque 68 N-cm (6 in-lbs)

If Locking Element option add 22 N-cm (2 in-lbs)



# 50

Calmark offers the narrow, advance design Series 266 "Card-Lok" retainer for cold plate/heat exchanger applications. This totally unique design incorporates design advancements that provide increased thermal transfer, easy insertion, lighter weight and now closer center to center board spacing.

### FEATURES

- Narrow design permits closer board spacing
- Maximum uniform clamping force
- Increased thermal transfer
- Maintains wedge and body alignment for easy insertion
- Captivated rear wedge
- Choice of screw head style
- Lighter weight
- Lower cost - Faster delivery
- Special lengths, finishes, or other design options available on request

### WEDGES, BODIES & SHAFT

#### Material:

Wedges: Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8  
 Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8  
 Shaft: Aluminum alloy 7075-T6 per ASTM-B221 and AMS-QQ-A-200/11

#### Finish:

See Finish Table

### SCREW, LOCK & FLAT WASHER

#### Material:

NAS1352C, Modified NAS1352C04 or 18-8 stainless steel, Stainless steel per ASTM-A582

#### Finish:

Passivate per MIL-S-5002

### ROLL PIN

#### Material:

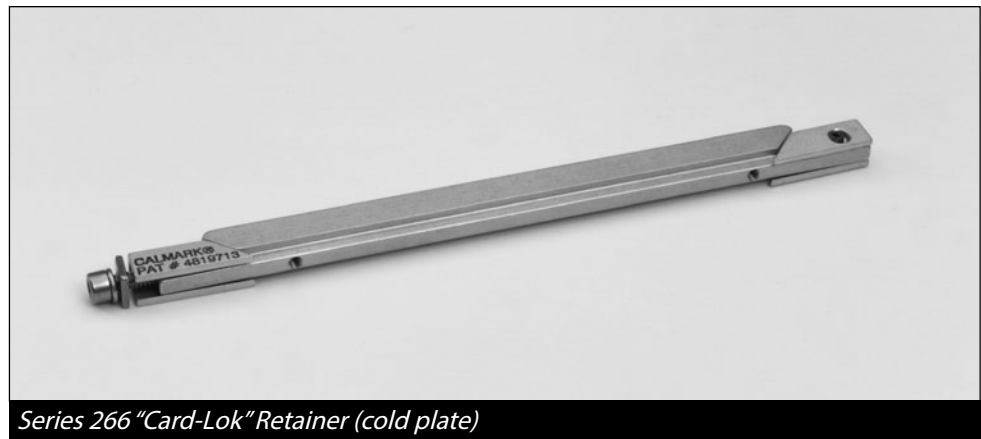
400 Series Stainless Steel

#### Finish:

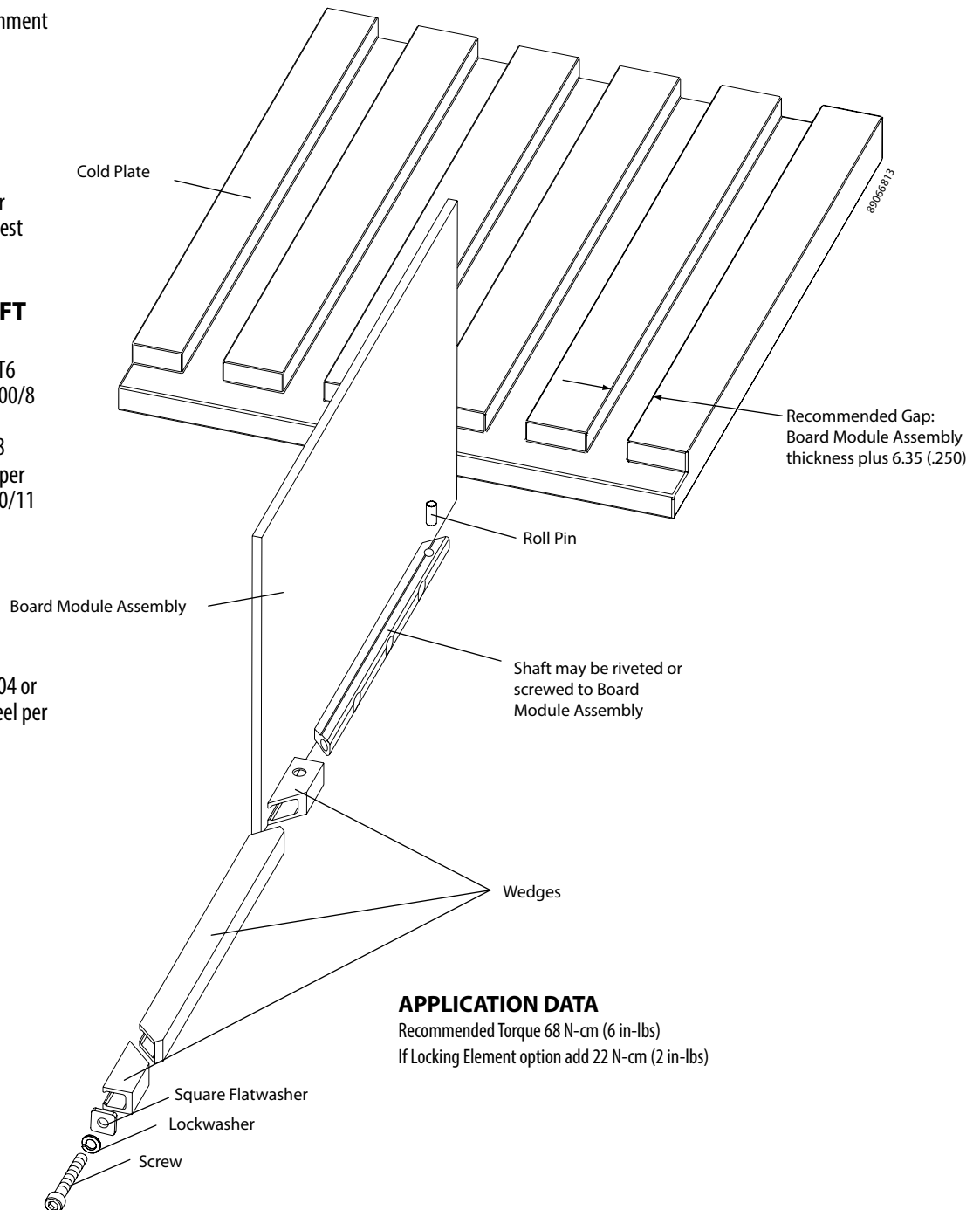
Passivate per Mil-S-5002

### WEIGHT

.89 g/cm (.080 oz/in)



Series 266 "Card-Lok" Retainer (cold plate)



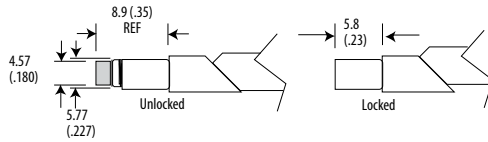
### APPLICATION DATA

Recommended Torque 68 N-cm (6 in-lbs)  
 If Locking Element option add 22 N-cm (2 in-lbs)

## OPTION PREFIX

### Detail "V"

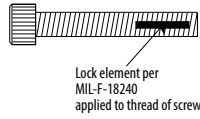
Provides visual lock indication.



## OPTION SUFFIX

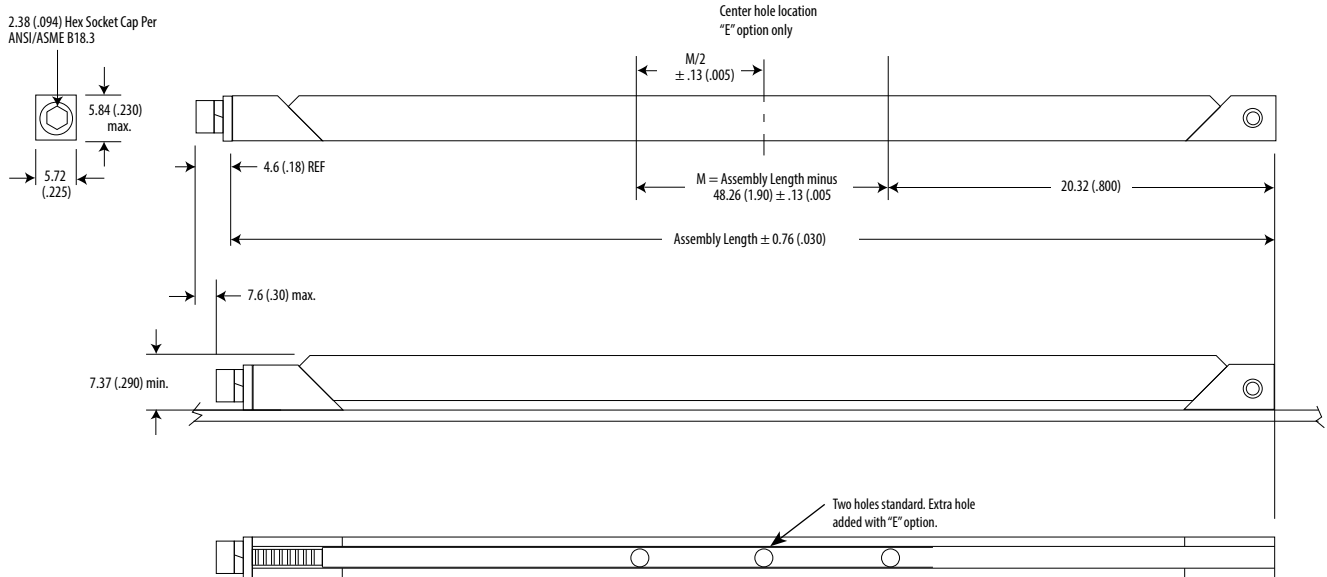
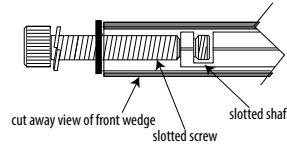
### Detail "L"

Provides prevailing torque for resistance to loosening from shock and vibration. Adds 22 N-cm (2 in-lbs) torque to assembly. See application data on previous sheet.



### Detail "K"

Prevents the unintentional disassembly of screw from front wedge.



Units: mm (in)  
Unless otherwise specified:  
.xx ± .25, .x ± .5  
(.xxx ± .010, .xx ± .02)  
Note: Each piece has a tolerance of ± .25 (.010)

## Part Number Code Series 266 Card-Lok Three Piece

### Prefix options

Metric Screw Head M2.5 Hex Drive **M**  
Standard Screw Head 3/32 Hex Drive **[blank]**  
Visual Indicator **V**  
No Visual Indicator **[blank]**  
Black Anodize **A**  
or choose from Finish Table **see table**

### Suffix options

Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80).  
Other lengths available upon request. **length.xx**  
Additional Center Mounting Hole **E**  
None **[blank]**  
Mounting Options - holes for rivet mounting **H**  
or choose from Mounting Option Table **see table**  
Lock Element **L**  
None **[blank]**  
Captive Screw **K**  
None **[blank]**

## Part Number Code Example:

266-2.80T2K Series 266 three piece Card-Lok gold chemical film finish, 71.12 (2.80) long with 2-56 tapped mounting holes and captive screw feature

Code  
Letter

## FINISH TABLE

**[blank]** Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold  
**"R"** Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear  
**"A"** Black Anodize per Mil-A-8625 Type II, Class 2  
**"HA"** Hard Black Anodize per Mil-A-8625 Type III, Class 2  
**"EN"** Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright

Code  
Letter

## MOUNTING METHOD TABLE

**"H"** Ø1.73/1.85 (.068/.073) dia. through holes countersink 100° x 1.52 (.060) deep  
**"T0"** 0-80 tapped hole  
**"T2"** 2-56 tapped hole  
**"TM2"** M2 x 0.40 tapped hole  
**"TM2.5"** M2.5 x 0.45 tapped hole

Calmark offers the narrow configuration Series 267 "Card-Lok" Retainer for cold-plate, heat exchanger applications. This design features narrowest cross sectional size in addition to optimum thermal transfer, easy insertion, lighter weight and now closer center to center board spacing.

#### FEATURES

- Narrow design permits closer board spacing
- Maximum uniform clamping force
- Increased thermal transfer
- Maintains wedge and body alignment for easy insertion
- Captivated rear wedge
- Choice of screw head style
- Lighter weight
- Lower cost - Faster delivery
- Special lengths, finishes, or other design option available on request

#### WEDGES, BODIES & SHAFT

##### Material:

Wedges: Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8  
 Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8  
 Shaft: Aluminum alloy 7075-T6 per ASTM-B221 and AMS-QQ-A-200/11

##### Finish:

See Finish Table

#### SCREW, LOCK & FLAT WASHER

##### Material:

300 Series Stainless Steel

##### Finish:

Passivate per Mil-S-5002

#### ROLL PIN

##### Material:

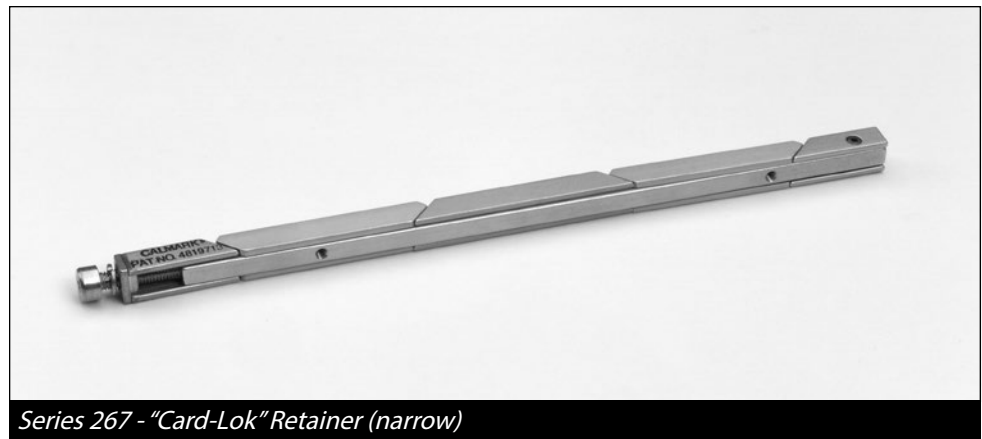
400 Series Stainless Steel

##### Finish:

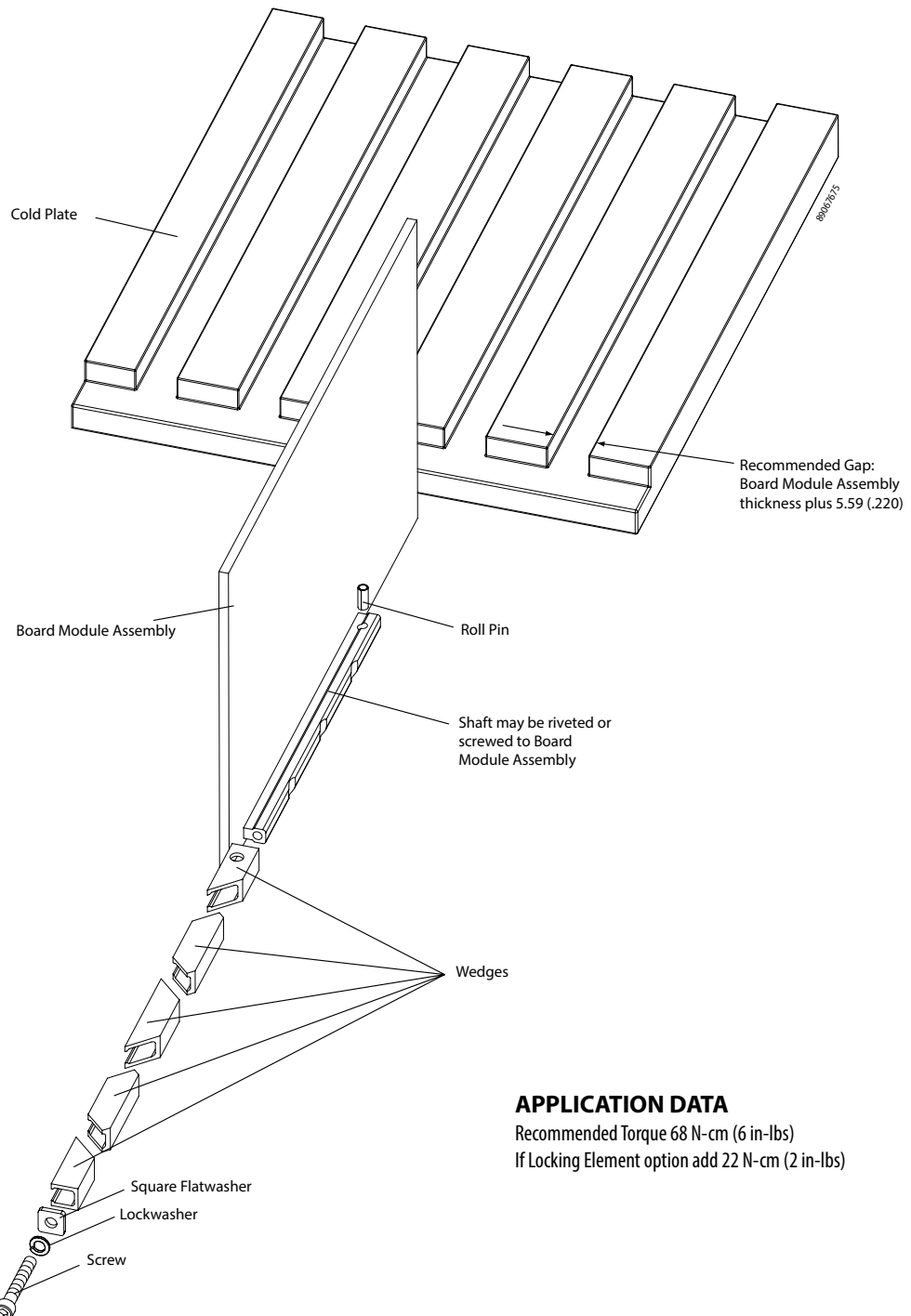
Passivate per Mil-S-5002

#### WEIGHT

.75 g/cm (.067 oz/in)



Series 267 - "Card-Lok" Retainer (narrow)



#### APPLICATION DATA

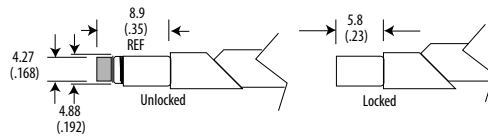
Recommended Torque 68 N-cm (6 in-lbs)

If Locking Element option add 22 N-cm (2 in-lbs)

## OPTION PREFIX

### Detail "V"

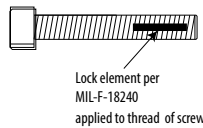
Provides visual lock indication.



## OPTION SUFFIX

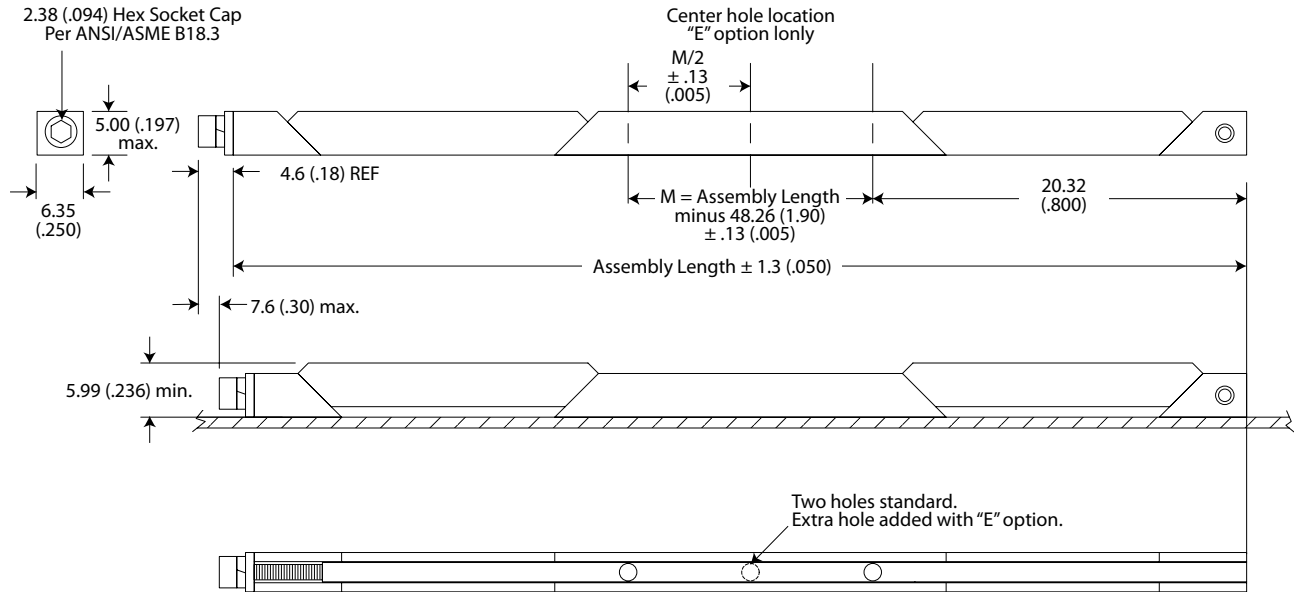
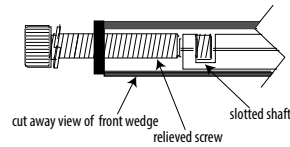
### Detail "L"

Provides prevailing torque for resistance to loosening from shock and vibration. Adds 22 N-cm (2 in-lbs) torque to assembly. See application data on previous sheet.



### Detail "K"

Prevents the unintentional disassembly of screw from shaft



Units: mm (in)  
Unless otherwise specified:  
.xx ± .25, .x ± .5 (.xxx ± .010, .xx ± .02)  
Note: Each piece has a tolerance of ± .010

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## Part Number Code Series 267 Card-Lok Five Piece

### Prefix options

Metric Screw Head M2.5 Hex Drive **M**  
Standard Screw Head 3/32 Hex Drive **[blank]**  
Visual Indicator **V**  
No Visual Indicator **[blank]**  
Black Anodize **A**  
or choose from Finish Table **see table**

### Suffix options

Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80).  
Other lengths available upon request. **length.xx**  
Additional Center Mounting Hole **E**  
None **[blank]**  
Mounting Options - holes for rivet mounting  
or choose from Mounting Option Table **see table**  
Lock Element **L**  
None **[blank]**  
Captive Screw **K**  
None **[blank]**

## Part Number Code Example:

267-2.80T2K Series 267 five piece Card-Lok gold chemical film finish, 71.12 (2.80) long with 2-56 tapped mounting holes and captive screw feature

### FINISH TABLE

| Code Letter    | Finish                                                      |
|----------------|-------------------------------------------------------------|
| <b>[blank]</b> | Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold       |
| <b>"R"</b>     | Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear      |
| <b>"A"</b>     | Black Anodize per Mil-A-8625 Type II, Class 2               |
| <b>"HA"</b>    | Hard Black Anodize per Mil-A-8625 Type III, Class 2         |
| <b>"EN"</b>    | Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright |

### MOUNTING METHOD TABLE

| Code Letter    | Method                                                                        |
|----------------|-------------------------------------------------------------------------------|
| <b>"H"</b>     | Ø1.73/1.85 (.068/.073) dia. through holes countersink 100° x 1.52 (.060) deep |
| <b>"T0"</b>    | 0-80 tapped hole                                                              |
| <b>"T2"</b>    | 2-56 tapped hole                                                              |
| <b>"TM2"</b>   | M2 x 0.40 tapped hole                                                         |
| <b>"TM2.5"</b> | M2.5 x 0.45 tapped hole                                                       |

Calmark offers the advance design Series 280 "Card-Lok" Retainer for cold plate-heat exchanger applications. This totally unique design incorporates design advancements that provide increased thermal transfer, easy insertion, lighter weight and lower cost. The Series 280 specifically provides greater clamping force and load capacity for Board Module Assembly of higher weight and mass.

### FEATURES

- Greater clamping force and load capacity for Board Module Assembly with higher weight and mass
- Maximum uniform clamping force
- Increased thermal transfer
- Maintains wedge and body alignment for easy insertion
- Captive rear wedge
- Choice of screw head style
- Dimensionally compatible with Series 250
- Lighter weight
- Lower cost
- Special lengths, finishes, or other design options available on request

### WEDGES, BODIES & SHAFT

#### Material:

Wedges: Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8  
 Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8  
 Shaft: Aluminum alloy 7075-T6 per ASTM-B221 and AMS-QQ-A-200/11

#### Finish:

See Finish Table

### SCREW, LOCK & FLAT WASHER

#### Material:

300 Series Stainless Steel

#### Finish:

Passivate per Mil-S-5002

### ROLL PIN

#### Material:

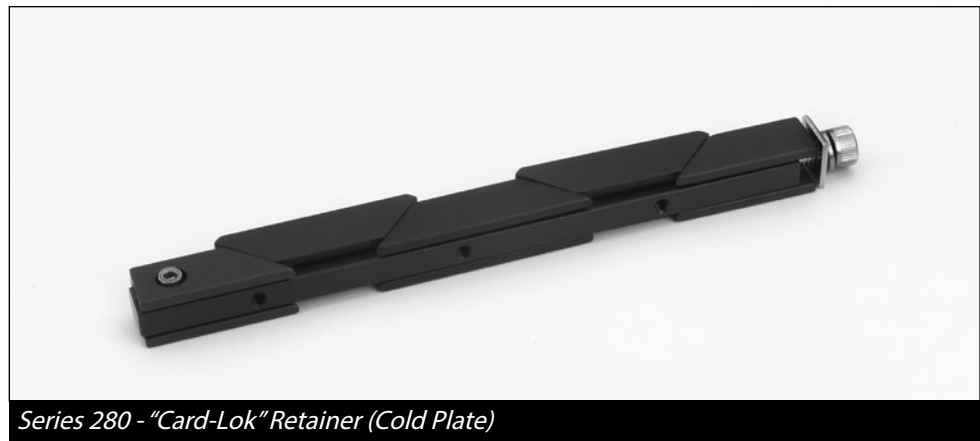
400 Series Stainless Steel

#### Finish:

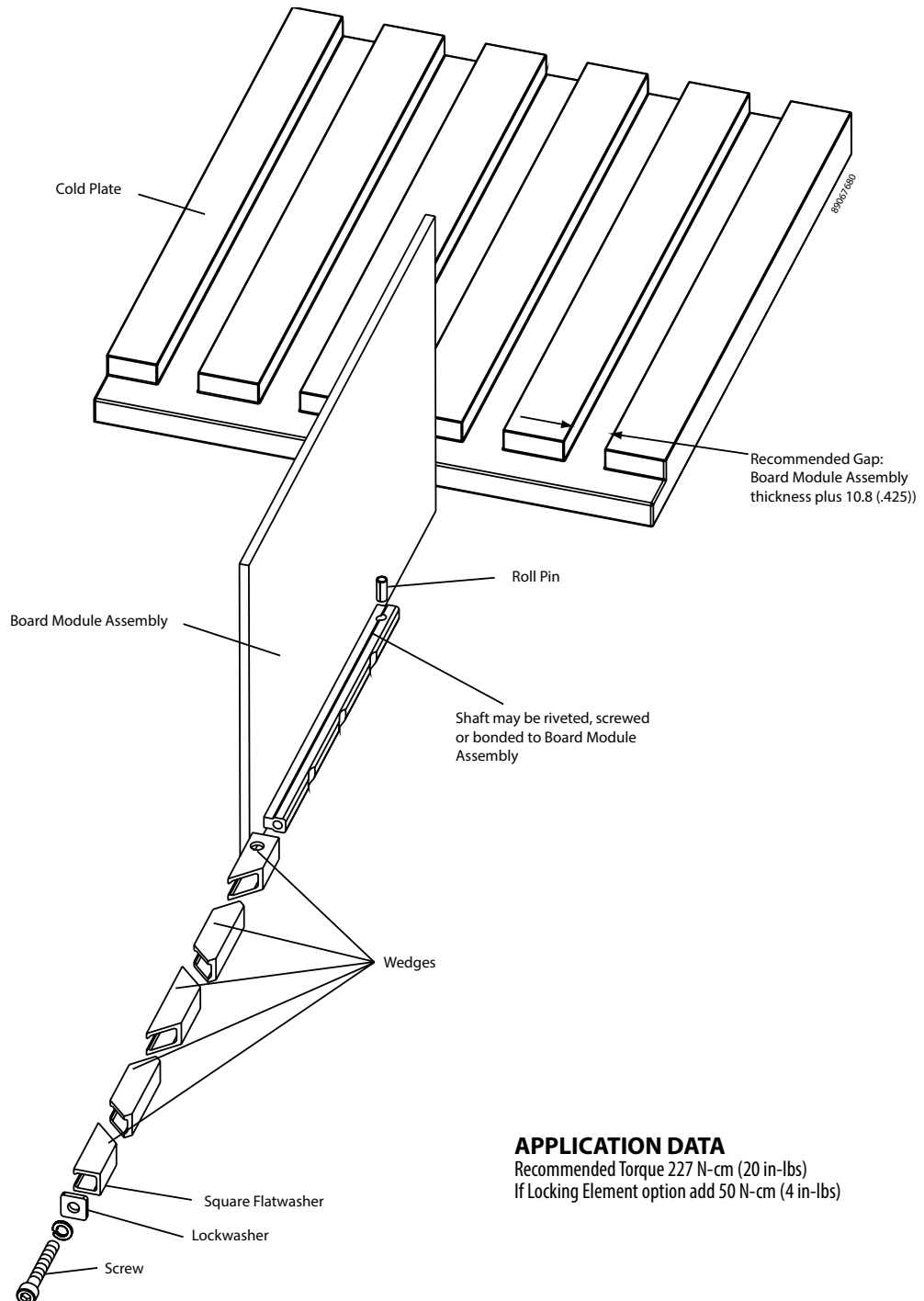
Passivate per Mil-S-5002

### WEIGHT

2.18 g/cm (.195 oz/in)



Series 280 - "Card-Lok" Retainer (Cold Plate)



### APPLICATION DATA

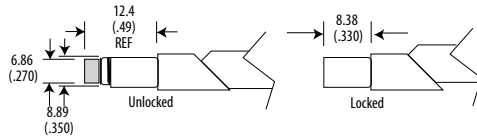
Recommended Torque 227 N-cm (20 in-lbs)  
 If Locking Element option add 50 N-cm (4 in-lbs)



## OPTION PREFIX

### Detail "V"

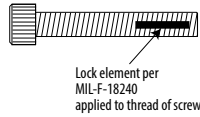
Provides visual lock indication.



## OPTION SUFFIX

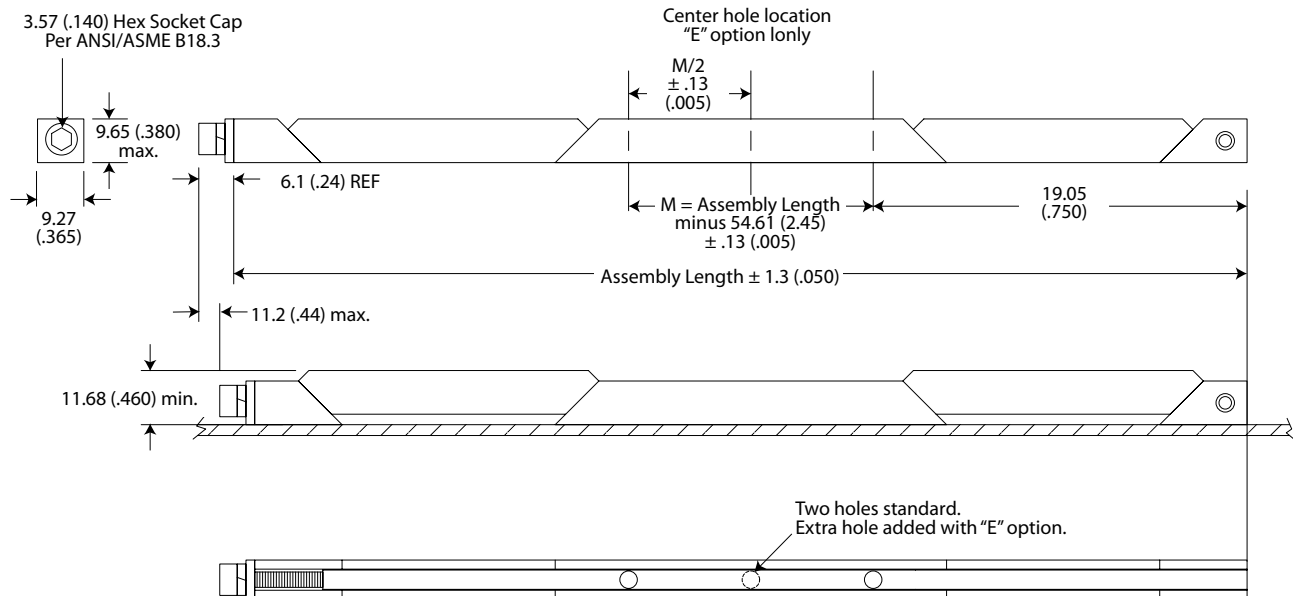
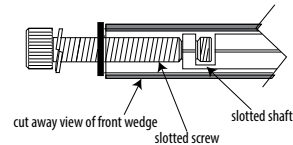
### Detail "L"

Provides prevailing torque for resistance to loosening from shock and vibration. Adds 50 N-cm (4 in-lbs) torque to assembly. See application data on previous sheet.



### Detail "K"

Prevents the unintentional disassembly of screw from shaft



Units: mm (in)  
Unless otherwise specified:  
.xx ± .25, .x ± .5 (.xxx ± .010, .xx ± .02)  
Note: Each piece has a tolerance of ± .010

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## Part Number Code Series 280 Card-Lok Five Piece

### Prefix options

Metric Screw Head M3 Hex Drive **M**  
Standard Screw Head 9/64 Hex Drive **[blank]**  
Visual Indicator **V**  
No Visual Indicator **[blank]**  
Black Anodize **A**  
or choose from Finish Table **see table**

### Suffix options

Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80) **length.xx**  
Other lengths available upon request.  
Additional Center Mounting Hole **E**  
None **[blank]**  
Mounting Options - holes for rivet mounting **H**  
or choose from Mounting Option Table **see table**  
Lock Element **L**  
None **[blank]**  
Captive Screw **K**  
None **[blank]**

## Part Number Code Example:

A280-4.80HK

Series 280 Card-Lok five piece 121.9 (4.80) long with black anodize finish, standard rivet mounting hole and captive screw option

## FINISH TABLE

| Code Letter    | Finish                                                      |
|----------------|-------------------------------------------------------------|
| <b>[blank]</b> | Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold       |
| <b>"R"</b>     | Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear      |
| <b>"A"</b>     | Black Anodize per Mil-A-8625 Type II, Class 2               |
| <b>"HA"</b>    | Hard Black Anodize per Mil-A-8625 Type III, Class 2         |
| <b>"EN"</b>    | Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright |

## MOUNTING METHOD TABLE

| Code Letter  | Method                                                                        |
|--------------|-------------------------------------------------------------------------------|
| <b>"H"</b>   | Ø3.40/3.53 (.0134/.139) dia. through holes countersink 60° x 3.81 (.150) deep |
| <b>"T4"</b>  | 4-40 tapped hole                                                              |
| <b>"TM3"</b> | M3 x 0.50 tapped hole                                                         |

Calmark offers the advance design Series 281 "Card-Lok" Retainer for cold plate-heat exchanger applications. This totally unique design incorporates design advancements that provide increased thermal transfer, easy insertion, lighter weight and lower cost. The Series 281 specifically provides greater clamping force and load capacity for Board Module Assembly of higher weight and mass.

## FEATURES

- Greater clamping force and load capacity for Board Module Assembly with higher weight and mass
- Maximum uniform clamping force
- Increased thermal transfer
- Maintains wedge and body alignment for easy insertion
- Captive rear wedge
- Choice of screw head style
- Dimensionally compatible with Series 250
- Lighter weight
- Lower cost
- Special lengths, finishes, or other design options available on request

## WEDGES, BODIES & SHAFT

### Material:

Wedges: Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8  
 Aluminum alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8  
 Shaft: Aluminum alloy 7075-T6 per ASTM-B221 and AMS-QQ-A-200/11

### Finish:

See Finish Table

## SCREW, LOCK & FLAT WASHER

### Material:

300 Series Stainless Steel

### Finish:

Passivate per Mil-S-5002

## ROLL PIN

### Material:

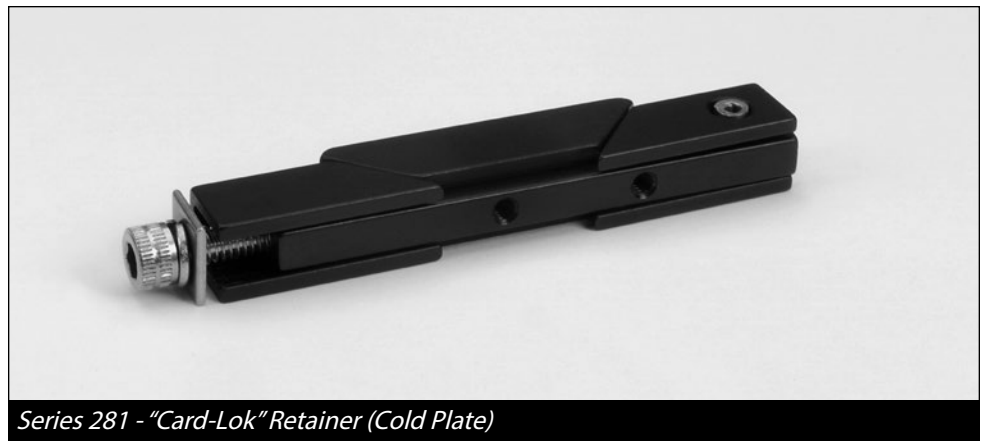
400 Series Stainless Steel

### Finish:

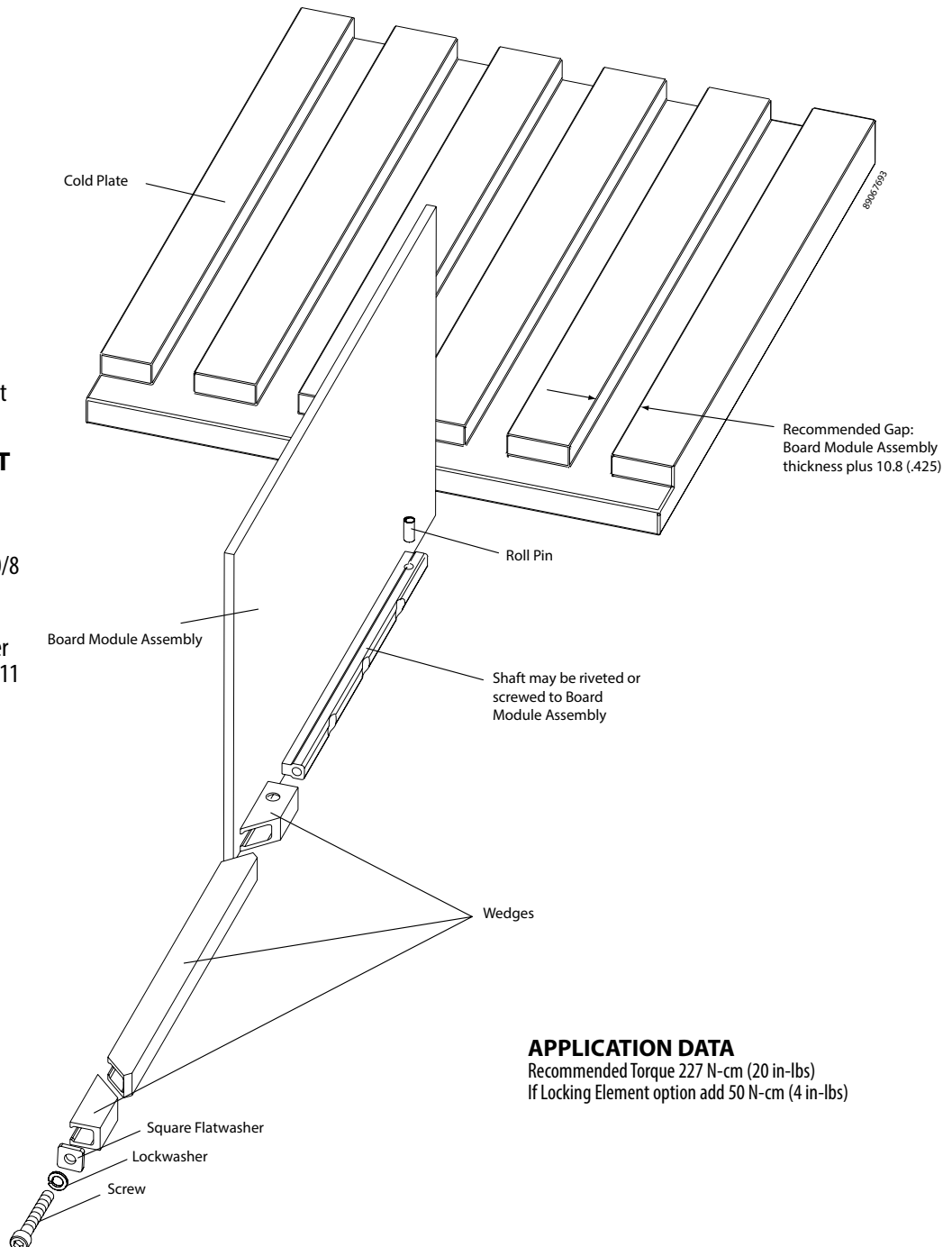
Passivate per Mil-S-5002

## WEIGHT

2.18 g/cm (.195 oz/in)



Series 281 - "Card-Lok" Retainer (Cold Plate)



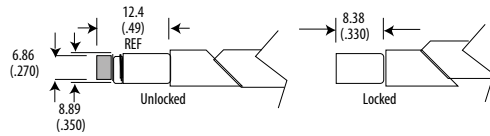
## APPLICATION DATA

Recommended Torque 227 N-cm (20 in-lbs)  
 If Locking Element option add 50 N-cm (4 in-lbs)

## OPTION PREFIX

### Detail "V"

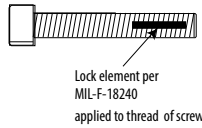
Provides visual lock indication.



## OPTION SUFFIX

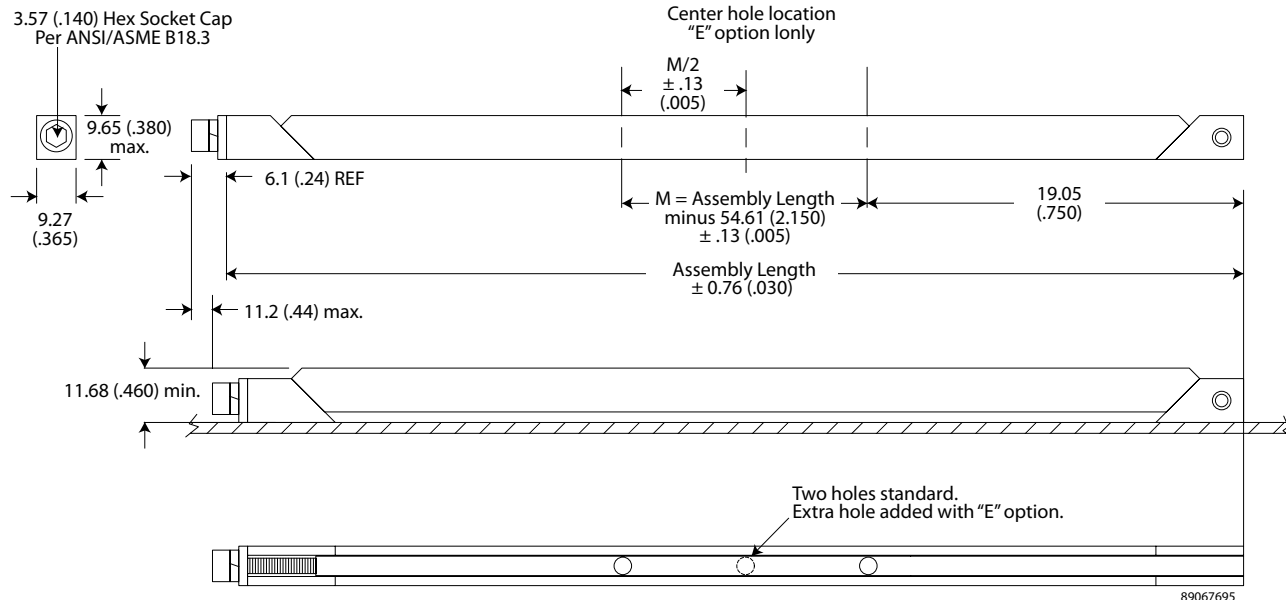
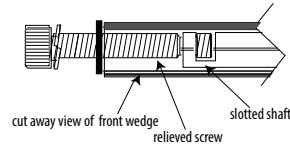
### Detail "L"

Provides prevailing torque for resistance to loosening from shock and vibration. Adds 50 N-cm (4 in-lbs) torque to assembly. See application data on previous sheet.



### Detail "K"

Prevents the unintentional disassembly of screw from shaft.



Units: mm (in)  
Unless otherwise specified:  
.xx ± .25, .x ± .5 (.xxx ± .010, .xx ± .02)  
Note: Each piece has a tolerance of ± .010

## Part Number Code Series 281 Card-Lok Three Piece

### Prefix options

Metric Screw Head M3 Hex Drive M  
Standard Screw Head 9/64 Hex Drive [blank]  
Visual Indicator V  
No Visual Indicator [blank]  
Black Anodize A  
or choose from Finish Table see table

### Suffix options

Assembly length in inches. Standard lengths range from 71.12 (2.80), 96.52 (3.80) and 121.9 (4.80) length.xx  
Other lengths available upon request.  
Additional Center Mounting Hole E  
None [blank]  
Mounting Options - holes for rivet mounting H  
or choose from Mounting Option Table see table  
Lock Element L  
None [blank]  
Captive Screw K  
None [blank]

## Part Number Code Example:

281-2.80H

Series 281 Card-Lok three piece 71.12 (2.80) long with chemical film finish and standard rivet mounting hole

## FINISH TABLE

| Code    | Letter | Finish                                                      |
|---------|--------|-------------------------------------------------------------|
| [blank] |        | Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold       |
| "R"     |        | Chemical Film per Mil-DTL-5541 Class 3, Type II, Clear      |
| "A"     |        | Black Anodize per Mil-A-8625 Type II, Class 2               |
| "HA"    |        | Hard Black Anodize per Mil-A-8625 Type III, Class 2         |
| "EN"    |        | Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright |

## MOUNTING METHOD TABLE

| Code  | Letter | Method                                                                        |
|-------|--------|-------------------------------------------------------------------------------|
| "H"   |        | Ø3.40/3.53 (.0134/.139) dia. through holes countersink 60° x 3.81 (.150) deep |
| "T4"  |        | 4-40 tapped hole                                                              |
| "TM3" |        | M3 x 0.50 tapped hole                                                         |

Calmark offers the Series 227 and 228 Channel Mounted "Card-Lok". This design consists of three or five segment Card-Lok retainer mounted in its own individual chassis mountable heatsink channel.

### FEATURES

- Self contained Card-Lok/Heatsink Channel – Three or five segment Card-Lok mounted in an individually mountable heatsink channel
- Maximum Reliability – Screw-actuated wedge action locks Plug-in Unit in place
- Maximum Thermal Transfer – Wedge action design provides maximum contact between thermal paths on Plug-in Unit and the heat sinking surface
- Maximum Resistance to Shock & Vibration – Wedge action design locks Plug-in Unit in place to provide maximum resistance to shock and vibration
- Zero Insertion & Extraction Forces – Screw actuation provides zero insertion and extraction force on Plug-in Unit
- Design Flexibility – Special lengths, finishes or other design variations available on request

### MATERIALS

#### CHANNEL, BODIES & WEDGES

##### Material:

Aluminum alloy 6061-T6  
per ASTM-B221 or  
AMS-QQ-A-200/8

##### Finish:

See Finish Table

#### SCREW

##### Material:

Stainless Steel per ASTM-  
A582

##### Finish:

Passivated per  
Mil-S-5002

#### FLAT WASHERS, RETAINING RING & SPRING

Passivated Stainless Steel

#### WEIGHT

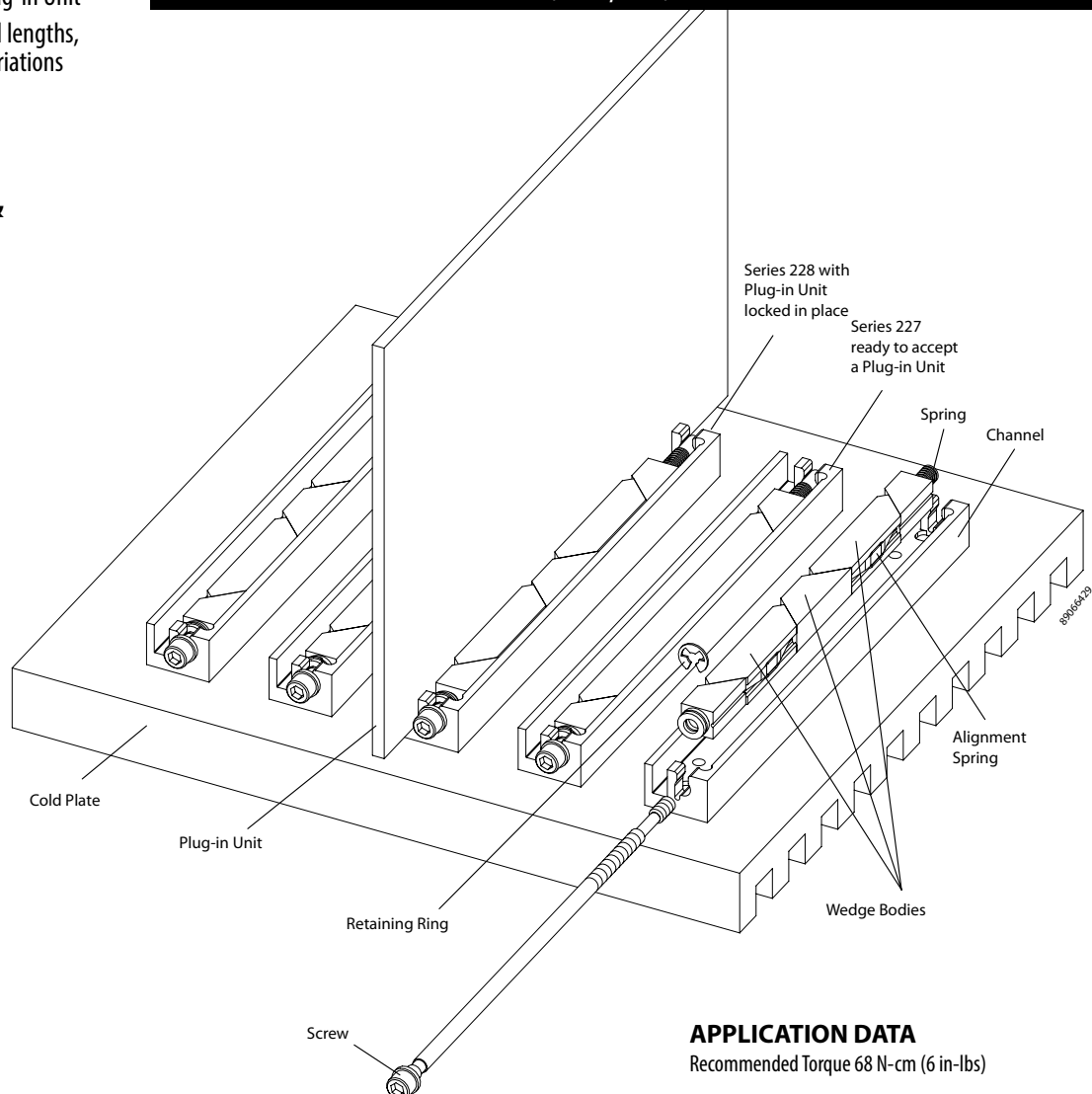
2.44g/cm (0.22 oz/in)



Series 227 - "Channel-Lok" Retainer (cold plate)

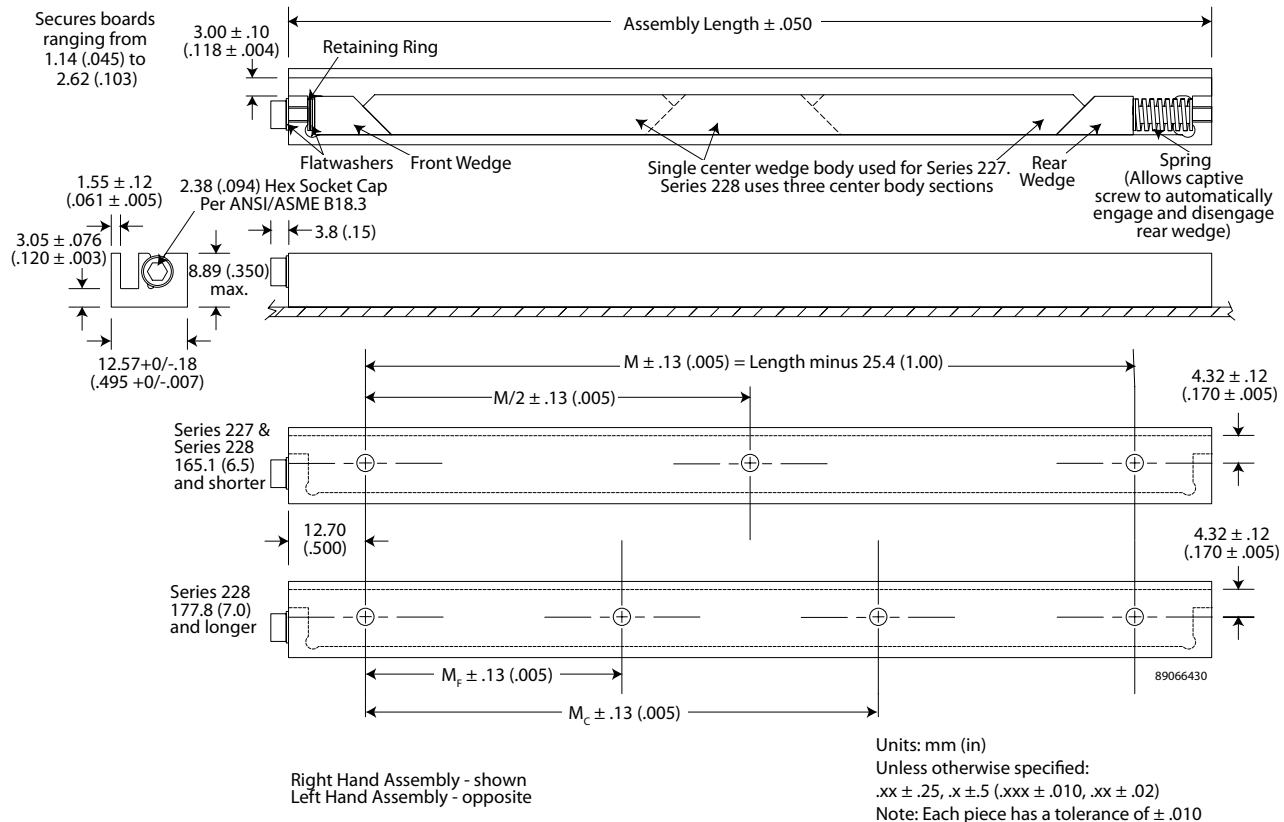


Series 228 - "Channel-Lok" Retainer (cold plate)



### APPLICATION DATA

Recommended Torque 68 N-cm (6 in-lbs)



| Series 227 |               |               |               |                |                |                |                |
|------------|---------------|---------------|---------------|----------------|----------------|----------------|----------------|
| Length     | 76.2 (3.00)   | 88.9 (3.50)   | 101.6 (4.00)  | 114.3 (4.50)   | 127.0 (5.00)   | 139.7 (5.50)   | 152.4 (6.00)   |
| MF         | 25.40 (1.000) | 31.75 (1.250) | 38.10 (1.500) | 127.00 (1.750) | 50.80 (2.000)  | 57.15 (2.250)  | 63.50 (2.500)  |
| MC         | 50.80 (2.000) | 63.50 (2.500) | 76.20 (3.000) | 88.90 (3.500)  | 101.60 (4.000) | 114.30 (4.500) | 127.00 (5.000) |

| Series 228 |                |                |                |                |                |                |                |                |                |                |                |
|------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|
| Length     | 114.3 (4.50)   | 127.0 (5.00)   | 139.7 (5.50)   | 152.4 (6.00)   | 165.1 (6.50)   | 177.8 (7.00)   | 190.5 (7.50)   | 203.2 (8.00)   | 215.9 (8.50)   | 228.6 (9.00)   | 241.3 (9.50)   |
| MF         | 44.45 (1.750)  | 50.80 (2.000)  | 57.15 (2.250)  | 63.50 (2.500)  | 69.85 (2.750)  | 76.20 (3.000)  | 82.55 (3.250)  | 88.90 (3.500)  | 95.25 (3.750)  | 101.60 (4.000) | 107.95 (4.250) |
| MC         | N/A            | N/A            | N/A            | N/A            | N/A            | 101.60 (4.000) | 107.95 (4.250) | 120.65 (4.750) | 127.00 (5.000) | 133.35 (5.250) | 139.70 (5.500) |
| Length     | 266.7 (10.50)  | 279.4 (11.00)  | 304.8 (11.50)  | 317.5 (12.00)  | 330.2 (12.50)  | 342.9 (13.00)  | 355.6 (13.50)  | 368.3 (14.00)  | 381.0 (15.00)  | 393.7 (15.50)  | 406.4 (16.00)  |
| MF         | 82.55 (3.250)  | 88.90 (3.500)  | 95.25 (3.750)  | 101.60 (4.000) | 107.95 (4.250) | 114.30 (4.500) | 120.65 (4.750) | 127.00 (5.000) | 133.35 (5.250) | 139.70 (5.500) | 146.05 (5.750) |
| MC         | 158.75 (6.250) | 165.10 (6.500) | 171.45 (6.750) | 177.80 (7.000) | 184.15 (7.250) | 190.50 (7.500) | 196.85 (7.750) | 203.20 (8.000) | 209.55 (8.250) | 215.90 (8.500) | 222.25 (8.750) |

## Part Number Code Series 227 Card-Lok Three Piece Series 228 Card-Lok Five Piece

### Prefix options

Metric Screw Head M2.5 Hex Drive

Standard Screw Head 3/32 Hex Drive      [blank]

Black Anodize

or choose from Finish Table

### Suffix options

Right or

Left

Series 227

Standard lengths from 76.2 (3.00) to 165.1 (6.50)  
in 12.7 (.500) increments

Series 228

Standard lengths from 101.5 (4.00) to 406.4 (16.00)  
in 12.7 (.500) increments

### Mounting Options

4-40 tapped mounting holes

M3 tapped mounting holes

M A 228 R - 5.00 T4

length.xx

T4

TM3

## Part Number Code Example:

227R-6.50T4

Series 227 Channel-Lok three piece 165.1 (6.50) long with chemical film finish and 4-40 tapped mounting holes; this assembly is for the right side

A228L-9.50TM3

Series 228 Channel-Lok five piece 241.3 (9.50) long with black anodize finish and M3 tapped holes; this assembly is for the left side

## FINISH TABLE

Code

Letter

Finish

[blank]

"R"

"A"

"HA"

"EN"

Chemical Film per Mil-DTL-5541 Class 1A, Type 1, Gold  
Chemical Film per Mil-DTL-5541 Class 3,  
Type II, Clear

Black Anodize per Mil-A-8625 Type II, Class 2  
Hard Black Anodize per Mil-A-8625 Type III, Class 2

Electroless Nickel per Mil-C-26074 Class 4, Grade B, Bright

Calmark offers the Series 125/126 Card Retainer as the economical approach to protecting your Printed Circuit Board in shock and vibration applications. For those applications that require shock and vibration protection and heat sinking and grounding, the Series 165/166 may be the answer to your problem. The Series 125/126 is made from rugged stainless steel while the Series 165/166 is made from Alloy 10 BeCu for exceptional thermal and electrical conductivity. These Retainers conform to DSCC 85034.

## 125/126 Material:

.41 (.016) thick Stainless Steel Type 301, Cond. 1/2 H, ASTM -A240

## Finish:

Passivate per MIL -S-5002

## SPRING RATE

60.4N/cm (34.5lbs/in) of deflection per spring finger

## WEIGHT

.4g/cm (.036oz/inch)

## 165/166 Material:

.41 (.016) thick Alloy 10 Beryllium Copper.  
Cond. "AT" per Mil-C-81021

## Finish:

See Part No. Code

## SPRING RATE

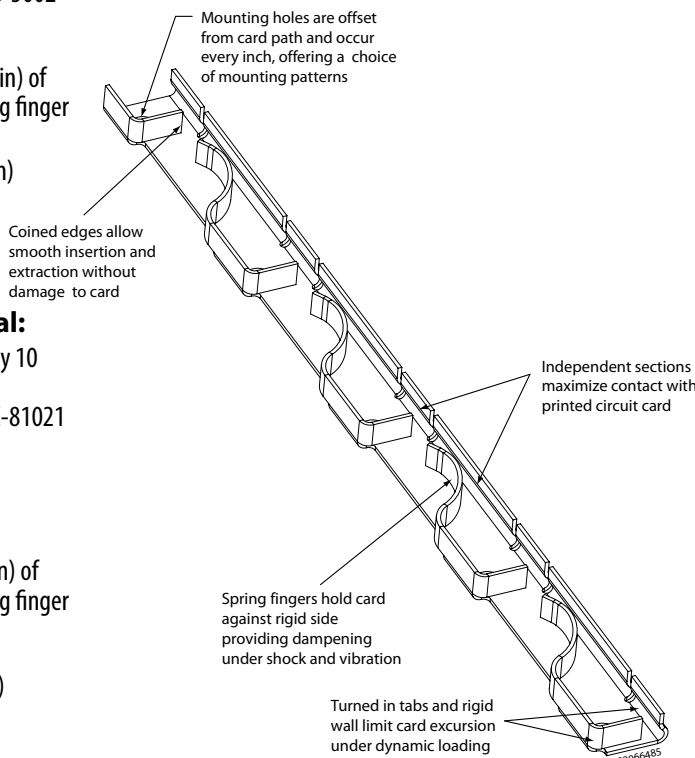
56.0 N/cm (32 lbs/in) of deflection per spring finger

## WEIGHT

.48g/cm (.043oz/in)



Series 125/126/165/166 retainers



## Part Number Code

### Series

125, 126, 165, 166

### PCB Thickness

1.6 (.063)

2.4 (.094)

### Length

31.75 (1.25) to 311.15 (12.25)

in 25.4 (1.00) increments

Other lengths available on request

### Finish (165/166 only)

Nickel plate

or choose from Finish Table

## Part Number Code Example:

125-06-4.25

Series 125 passivated stainless steel, 107.95 (4.25) long designed for 1.6 (.063) thick printed circuit boards

## FINISH TABLE

Code

Letter Finish

[blank] 125/126: passivated  
165/166: no finish

## For 165/166 only

"T"

Bright Tin plate per Mil-T-10727

.005 (.0002) min.

"N"

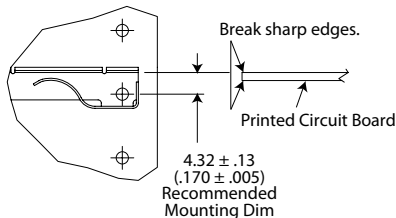
Nickel plate per QQ-N-290 Cl. 1, Gr. F

"ZN"

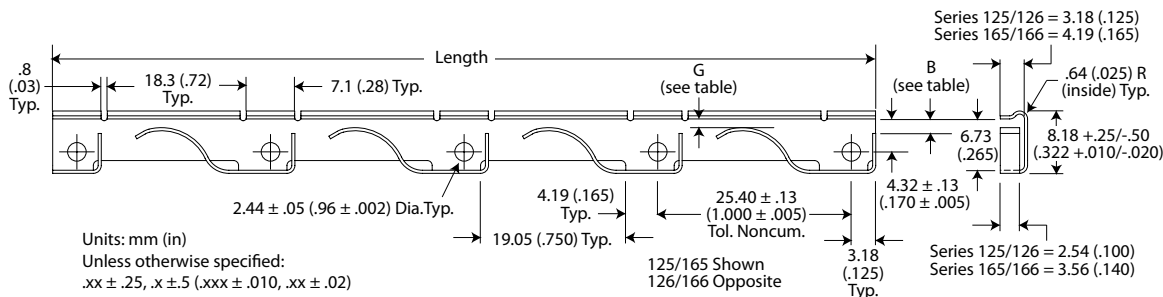
Zinc plate per ASTM-B633 Type III (clear), SC1

"EN"

Electroless nickel plate per Mil-C-26074 Cl. 1 Gr. B



| Dash No. | PCB Thickness | B Dimension<br>+0.38 (.015)<br>-0.0 (.000) | G Dimension<br>+0.0 (.00)<br>-0.80 (.03) |
|----------|---------------|--------------------------------------------|------------------------------------------|
| -06      | 1.6 (1/16)    | 1.91 (.075)                                | 1.14 (.045)                              |
| -09      | 2.4 (3/32)    | 2.67 (.105)                                | 1.91 (.075)                              |



89066486





Series NW125/NW126/NW165/NW166 retainers

## Part Number Code Series

NW125, NW126, NW165, NW166 NW125 -06 -3.25 N

### PCB Thickness

1.6 (.063) 06  
2.4 (.094) 09

### Length

31.75 (1.25) to 311.15 (12.25) length.xx  
in 25.4 (1.00) increments.  
Other lengths available on request

### Finish (NW165/NW166 only)

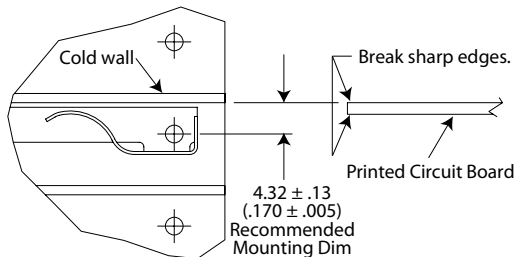
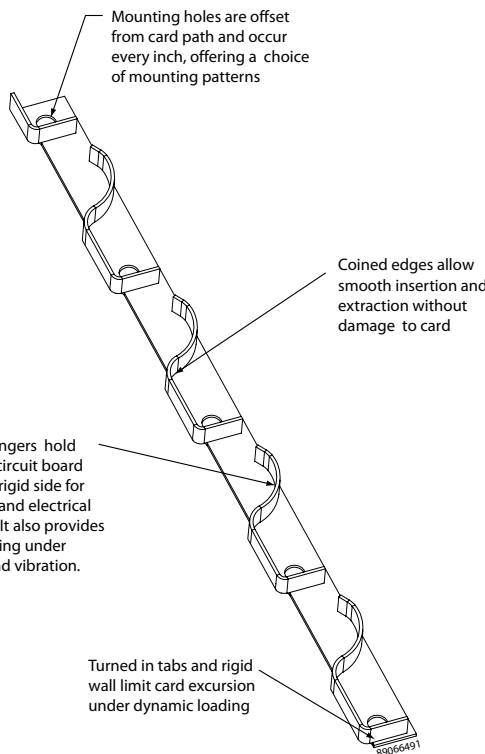
Nickel plate N  
or choose from Finish Table

## FINISH TABLE

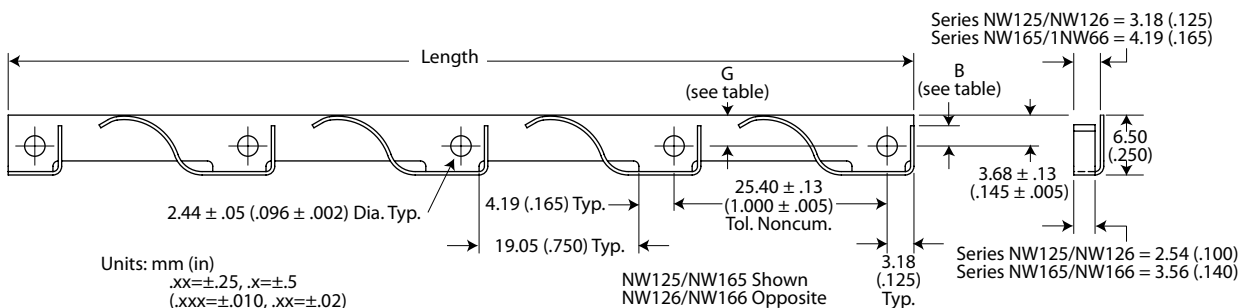
| Code Letter          | Finish                                                |
|----------------------|-------------------------------------------------------|
| [blank]              | NW125/NW126: passivated<br>NW165/NW166: no finish     |
| For NW165/NW166 only |                                                       |
| "T"                  | Bright Tin plate per Mil-T-10727<br>.005 (.0002) min. |
| "N"                  | Nickel plate per QQ-N-290 Cl. 1, Gr. F                |
| "ZN"                 | Zinc plate per ASTM-B633 Type III (clear), SC1        |
| "EN"                 | Electroless nickel plate per Mil-C-26074 Cl. 1 Gr. B  |

Spring fingers hold printed circuit board against rigid side for thermal and electrical contact. It also provides dampening under shock and vibration.

Turned in tabs and rigid wall limit card excursion under dynamic loading



| Dash No. | PCB Thickness | B Dimension<br>+0.38 (.015)<br>-0.0 (.000) | G Dimension<br>+0.0 (.00)<br>-0.80 (.03) |
|----------|---------------|--------------------------------------------|------------------------------------------|
| -06      | 1.6 (1/16)    | 2.41 (.095)                                | 3.94 (.155)                              |
| -09      | 2.4 (3/32)    | 1.65 (.065)                                | 3.18 (.125)                              |



Calmark offers the Series NW125/NW126 and NW165/NW166 Card Retainers for cold plate heat exchanger applications. These Retainers provide the necessary spring pressure to insure positive contact between the thermal path on the Printed Circuit Board and the cold plate surface. The NW165/NW166 provides the additional benefit of improved thermal characteristics. These retainers conform to the DSCC 85034 specification.

## NW125/126

### Material:

0.41 (.016) thick Stainless Steel  
Type 301, Cond. 1/2 H, ASTM -A240

### Finish:

Passivate per MIL -S-5002

### WEIGHT

.32 g/cm (.029 oz/inch)

### SPRING RATE

60.4 N/cm (34.5 lbs/in) of deflection  
per spring finger

## NW165/NW166

### Material:

0.41 (.016) thick Alloy 10 Beryllium  
Copper  
Cond. "AT" per Mil-C-81021

### Finish:

See Part No. Code

### SPRING RATE

56.0 N/cm (32 lbs/in) of deflection per  
spring finger

### WEIGHT

.38 g/cm (.034 oz/in)

## Part Number Code Example:

NW165-09-4.25EN

Series NW165 BeCu with Electroless  
Nickel finish,  
107.95 (4.25) long designed for 2.4  
(.094) thick  
printed circuit boards

Calmark offers the Series 115-287 Card Guide, a most unique design in PC card guides. The Series 115-287 Card Guide allows users of louver or lance type card guides to easily change to an insulated nylon card guide with a minimum modification of strength and air flow.

### FEATURES

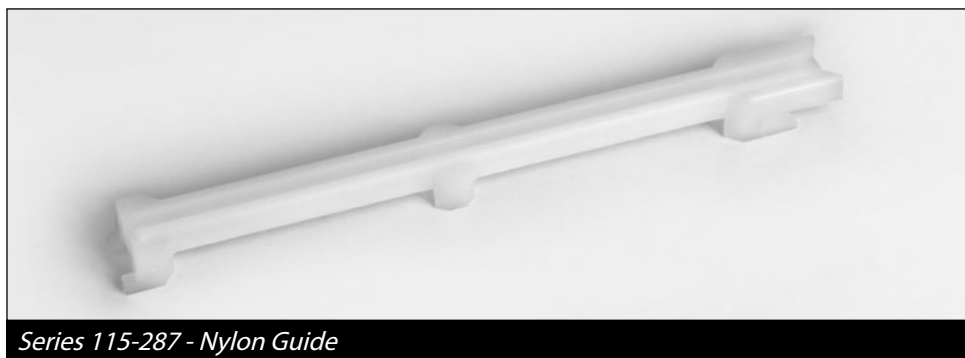
- Available for 1.61 (.063) and 2.43 (.094) thick printed circuit boards
- Unique snap-on design
- Secure and easy installation
- Wide lead-in for easy card entry
- No mounting hardware required
- Metal web support provides strength and rigidity
- Narrow profile for excellent airflow
- No mounting holes required
- Economical

### MATERIAL

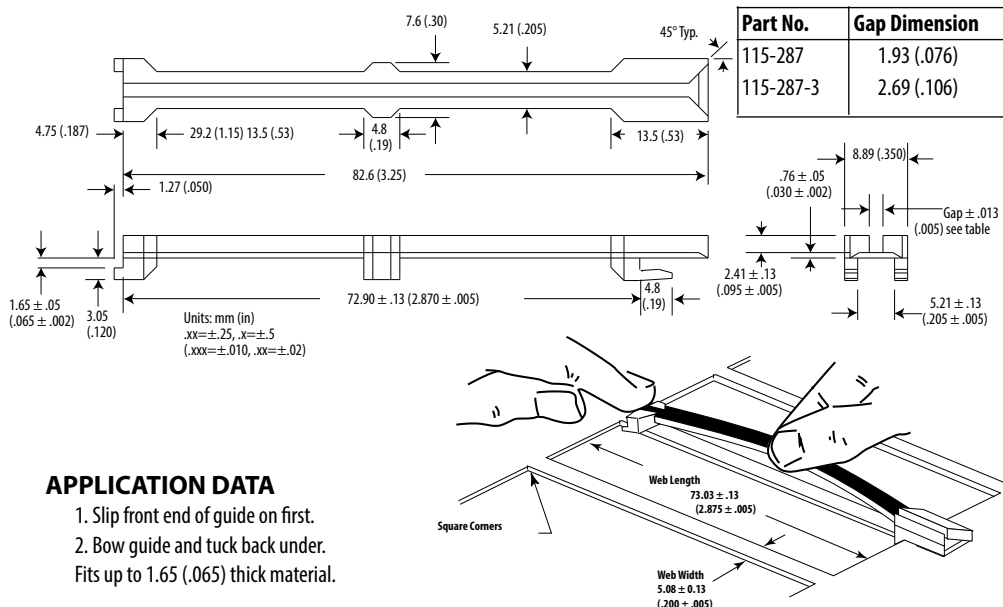
Nylon 6/6. Meets UL 94V-2. Self extinguishing to flame. May be used at 121°C (250°F) continuously. Resistant to alkalis, weak acids, and common solvents.

### COLOR

Standard color is natural (white). Additional colors are special order. Contact factory for availability.



Series 115-287 - Nylon Guide



### APPLICATION DATA

1. Slip front end of guide on first.
  2. Bow guide and tuck back under.
- Fits up to 1.65 (.065) thick material.

### Part Number Code Series 115-287

#### Suffix options

For board thickness 1.5 (.06) \_\_\_\_\_ [blank]  
For board thickness 2.4 (.093) \_\_\_\_\_ -3

For color options other than standard color white, add suffix:

White \_\_\_\_\_ [blank]  
For other colors add BLK, BRN, ORG, YEL, GRN, BLU \_\_\_\_\_ XXX  
(Colors other than White will require special order and part number)



Series 120 - Nylon Guide



Series C120 - Nylon Guide (conductive)

Calmark offers the Series 120 and C120 snap-in PCB Nylon Card Guide.

## 120 FEATURES

- Easy and secure snap-in design
- Extra deep guide
- Wide lead-in for easy card entry
- No mounting hardware required
- Narrow profile for excellent airflow
- Mid-span mounting point option for greater stability
- Available in 1.6 (.063) and 2.4 (.094) board gap widths
- Economical

**Series C120** includes the above features Plus:

- Molded in conductive material
- Provides surface resistivity of  $10^5$  ohms per square

## MATERIAL

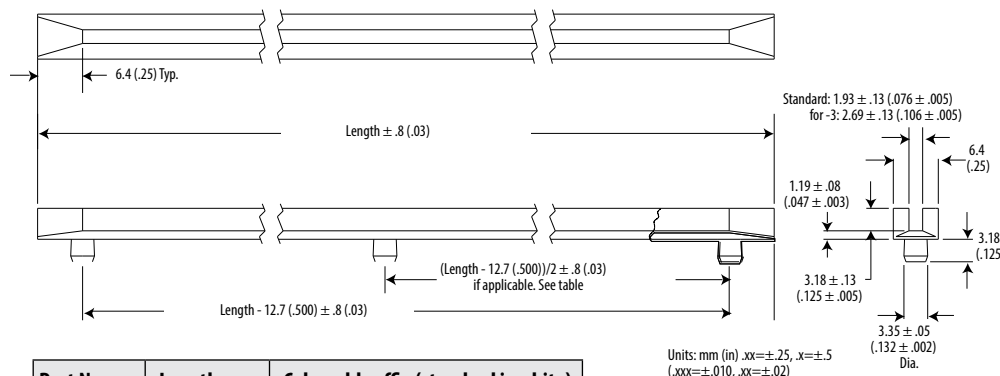
**Series 120:** Nylon 6/6 or 6. Meets UL94V-2 self-extinguishing to flame or UL94V-0 (see part number configuration). May be used at 121°C (250°F) continuously. Resistant to alkalis, weak acids and common solvents.

**Series C120:** 10% Graphite Filled Polycarbonate. Meets UL94V-2.

## COLOR

**Series 120:** Standard color is natural (white). For other colors append BLK, BRN, RED, ORG, YEL, GRN, BLU, VIO or GRV to part number.

**Series C120:** available in black only.

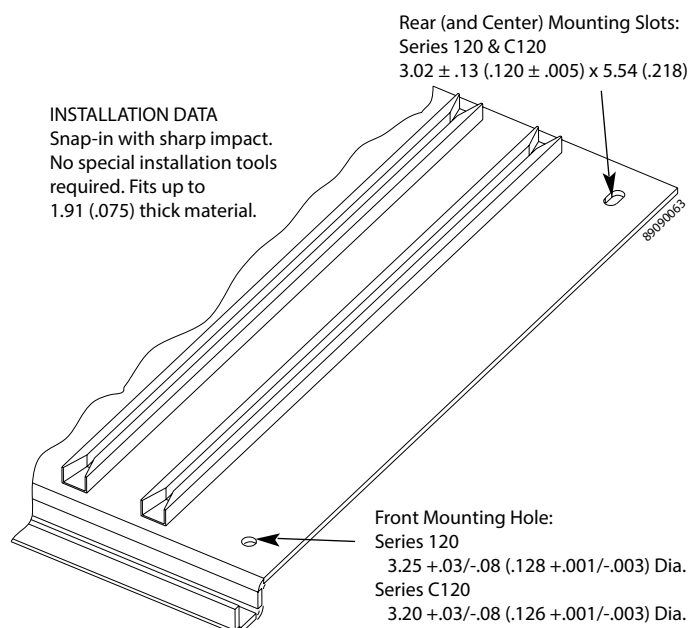


| Part No.  | Length        | Color add suffix (standard is white) |
|-----------|---------------|--------------------------------------|
| 120-400   | 101.6 (4.00)  | BLK, BRN, ORG, YEL, GRN, BLU         |
| 120-600   | 152.4 (6.00)  | BLK, BRN, ORG, YEL, GRN, BLU         |
| 120-700   | 177.8 (7.00)* | BLK, BRN, ORG, YEL, GRN, BLU         |
| 120-700X  | 177.8 (7.00)  | BLK, BRN, ORG, YEL, GRN, BLU         |
| 120-850   | 215.9 (8.50)* | BLK, BRN, ORG, YEL, GRN, BLU         |
| 120-850X  | 215.9 (8.50)  | BLK, BRN, ORG, YEL, GRN, BLU         |
| 120-950   | 215.9 (9.50)* | BLK, BRN, ORG, YEL, GRN, BLU         |
| C120-400  | 102.1 (4.02)  | BLK, BRN, ORG, YEL, GRN, BLU         |
| C120-600  | 153.2 (6.03)  | BLK, BRN, ORG, YEL, GRN, BLU         |
| C120-700  | 178.8 (7.04)* | BLK, BRN, ORG, YEL, GRN, BLU         |
| C120-700X | 178.8 (7.04)  | BLK, BRN, ORG, YEL, GRN, BLU         |
| C120-850  | 216.9 (8.54)* | BLK, BRN, ORG, YEL, GRN, BLU         |
| C120-850X | 216.9 (8.54)  | BLK, BRN, ORG, YEL, GRN, BLU         |
| C120-950  | 242.6 (9.55)  | BLK, BRN, ORG, YEL, GRN, BLU         |

(Colors other than White will require special order and part number)

\*Indicates presence of a mid-mounting post  
For 2.4 (.094) thick pcb, include a "-3" suffix to part number  
For UL94V-0 option add "VO" prefix to part number

**INSTALLATION DATA**  
Snap-in with sharp impact.  
No special installation tools required. Fits up to 1.91 (.075) thick material.



Calmark offers Card Extractors for efficient extraction of Printed Circuit Board from connectors and the Series 107 Card Insert-Extractor for efficient insertion and extraction of Printed Circuit Board in high density connector contact and multiple connector applications.

### FEATURES

- Lever action for safe easy card extraction
- Ample gripping and pushing surfaces for extracting and inserting card
- Available in colors for coding
- Generous area for hot stamp marking
- Exact replacement for other manufacturers

### MATERIALS

All Series 107 nylon extractors are molded in Glass Filled (30%) 6/6 or Type 6 Nylon. See table for flammability ratings. UL94-V0 parts are self extinguishing to flame.

May be used at 121°C (250°F) continuously. Resistant to alkalis, weak acids, and common solvents.

### ROLL PINS

- 2.38 (.094) dia x 6.35 (.250) long  
Series 107, 107-10, 107-20, 107-20-3, 107-70, 107-70-3
- 2.38 (.094) dia x 7.95 (.313) long  
Series 107-3, 107-10-3, 107-70-4

### COLOR

Other colors available; see part number code. Series 107 standard color is black. For standard colors, a color suffix is not necessary.

### HOT STAMPING

Hot stamp marking service is available. Please contact an Application Engineer with your requirements.

### SERIES P - PRE-STARTED ASSEMBLY PIN

Calmark offers any of our extractors and inserter-extractors with the option of Pre-Started Assembly Pin.

### FEATURES

- Faster and easier installation of extractor to PC card
- Eliminates need for special tools or equipment and set-up time
- Eliminates loss of loose assembly pins



Nylon Extractors

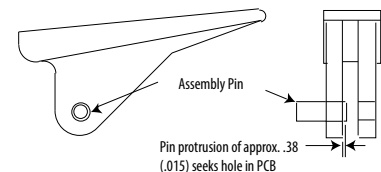
| Series Part Number | Feature | Board Thickness       | Standard Color | UL 94 | Mechanical Advantage | Figures |
|--------------------|---------|-----------------------|----------------|-------|----------------------|---------|
| 103                | ED      | 1.6 (.063)            | natural        | V-2   | 3:1                  | 2/A     |
| V103               | E       | 1.6 (.063)            | natural        | V-0   | 3:1                  | 2/A     |
| 107                | IED     | 1.6 (.063)            | black          | V-0   | 4.5:1                | 1/C     |
| 107-3              | IED     | 2.4 (.093)/3.2 (.125) | black          | V-0   | 4.5:1                | 1/C     |
| 107-10             | IED     | 1.6 (.063)            | black          | V-0   | 3.3:1                | 2/C     |
| 107-10-3           | IED     | 2.4 (.093)            | black          | V-0   | 3.3:1                | 2/C     |
| 107-20             | IEL     | 1.6 (.063)            | black          | V-2   | 4.5:1                | 3/D     |
| V0107-20           | IEL     | 1.6 (.063)            | black          | V-0   | 4.5:1                | 3/D     |
| 107-20-3           | IEL     | 2.4 (.093)            | black          | V-2   | 4.5:1                | 3/D     |
| V0107-20-3         | IEL     | 2.4 (.093)            | black          | V-0   | 4.5:1                | 3/D     |
| 107-70             | IEL     | 1.6 (.063)            | black          | V-0*  | 4.5:1                | 4/D     |
| 107-70-3           | IEL     | 2.4 (.093)            | black          | V-0*  | 4.5:1                | 4/D     |
| 107-70-4           | IEL     | 3.2 (.125)            | black          | V-0*  | 4.5:1                | 4/D     |

Feature: I = Inserter E = Extractor L = Latching D = meets DSCC 83023

For Pre-start pin feature, add "P" prefix to part number

\*Main handle portion is UL-94V0, but latch is UL94-V2

Add suffix WHT for natural color. Standard colors are natural or black. Contact factory for availability of other colors.



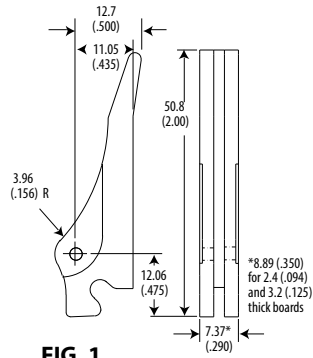


FIG. 1

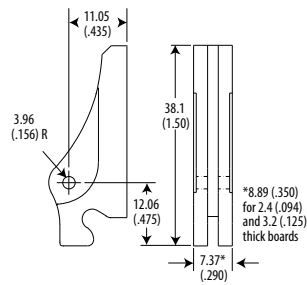


FIG. 2

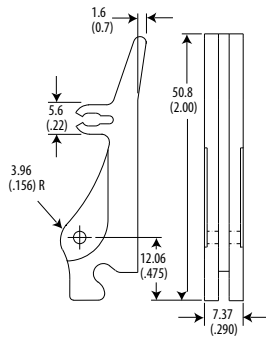


FIG. 3

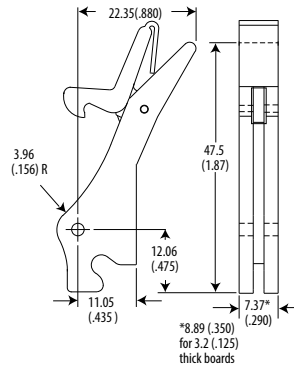


FIG. 4

Units: mm (in)  
Unless otherwise specified:  
.xx ± .25, .x ± .5  
(.xxx ± .010, .xx ± .02)

## APPLICATION DATA

Two inserter or inserter-extractors are recommended per printed circuit board taller than 127 (5) in height.

Units: mm (in)  
Unless otherwise specified:  
.xx ± .25, .x ± .5  
(.xxx ± .010, .xx ± .02)

FIG. A

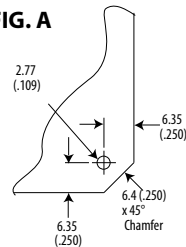
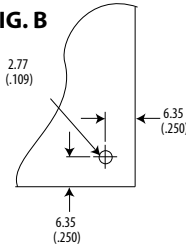
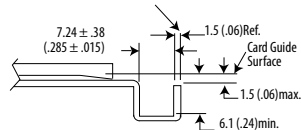


FIG. B



Provides insertion and extraction travel of 8.9 (.35) min.

Nominal position of card edge when seated in connector. The Inserter-Extractor will allow 1.3 (.05) overtravel for tolerance take-up.



Detail of Actuating Surfaces  
Required on Top and Bottom Guide Plates

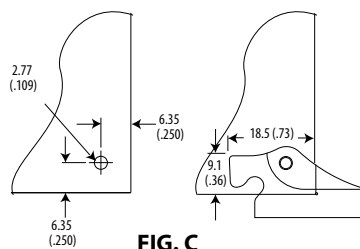


FIG. C

Provides insertion and extraction travel of 8.9 (.35) min.

Nominal position of card edge when seated in connector. The Inserter-Extractor will allow 1.3 (.05) overtravel for tolerance take-up.

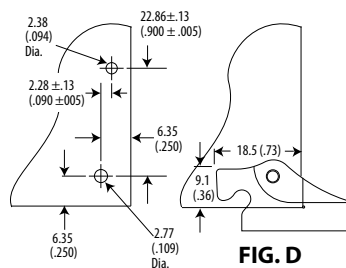
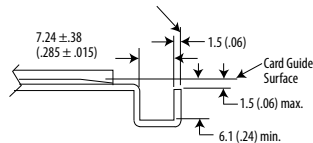


FIG. D

Calmark offers the Series 107 Aluminum Inserter-Extractor for safe and easy insertion and extraction of printed circuit boards in the most severe applications. This product series offer a wide range of inserter-extractor with varying features from mechanical advantage ratios, color, board thickness, etc. If you don't see one here that meets your requirements, please contact our Applications Engineers with your specification.

## FEATURES

- "Ultra strong" lever action design overcomes insertion and extraction forces of highest possible limits
- Widths from 7.37 (.290) to 7.92 (.312) for printed circuit boards ranging from 1.6 (.063) to 3.2 (.125) thick
- Actuates from a simple "U" channel form
- Mounting detail on card retrofits other industry standards
- Available in black anodize or clear chemical film
- Generous area for identification markings
- Strong and Ultra-strong lever action overcome high insertion and extraction forces
- 107-73 and 107-75 offers a positive locking feature

## MATERIALS/FINISH

### EXTRACTOR

Aluminum alloy 6061-T6. Black anodize per Mil-A-8625, Type II Cl. 2. or Clear chemical film per Mil-5541 Cl 3 for a conductive finish. Other anodize colors or a gold chemical film also available. Please contact an Application Engineer with your requirements.

### ROLL PIN

Stainless steel, 2.38 (.094) x 6.35 (.250) [except all Series 107-35 use 7.95 (.313) long]. Roll pins are furnished with each inserter-extractor. [Series 107-73 and 107-75, two roll pins]

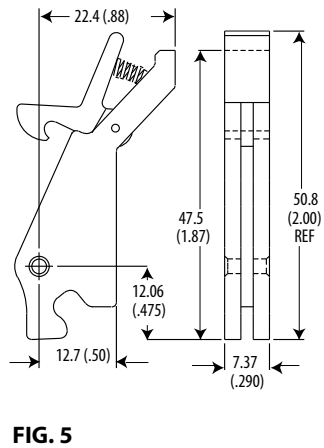
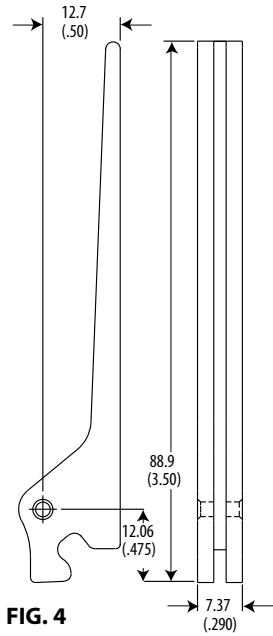
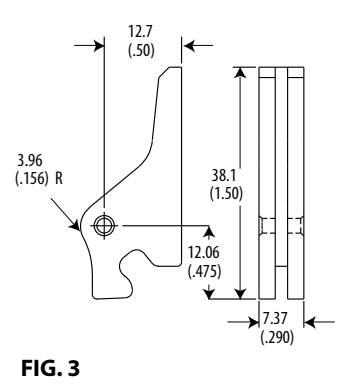
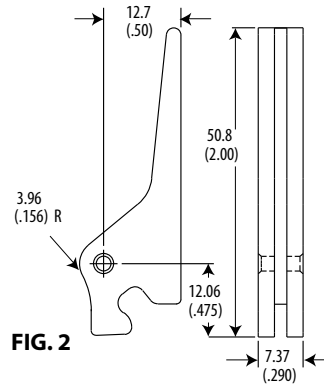
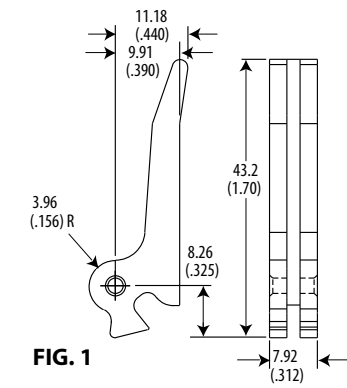


Series 107-50 - Inserter/Extractor (Aluminum)

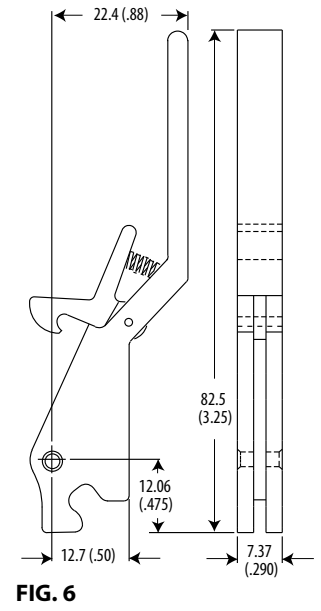
| Series    | Feature | Board Thickness | Standard Color | Mechanical Advantage | Figures |
|-----------|---------|-----------------|----------------|----------------------|---------|
| 107-35    | I E     | 1.6 (.063)      | black          | 5.5:1                | 1/A     |
| C107-35   | I E     | 1.6 (.063)      | clear          | 5.5:1                | 1/A     |
| 107-35-3  | I E     | 2.4 (.093)      | black          | 5.5:1                | 1/A     |
| C107-35-3 | I E     | 2.4 (.093)      | clear          | 5.5:1                | 1/A     |
| 107-35-4  | I E     | 3.2 (.125)      | black          | 5.5:1                | 1/A     |
| C107-35-4 | I E     | 3.2 (.125)      | clear          | 5.5:1                | 1/A     |
| 107-50    | I E     | 1.6 (.063)      | black          | 4.5:1                | 2/B     |
| C107-50   | I E     | 1.6 (.063)      | clear          | 4.5:1                | 2/B     |
| 107-50-3  | I E     | 2.4 (.093)      | black          | 4.5:1                | 2/B     |
| C107-50-3 | I E     | 2.4 (.093)      | clear          | 4.5:1                | 2/B     |
| 107-50-4  | I E     | 3.2 (.125)      | black          | 4.5:1                | 2/B     |
| C107-50-4 | I E     | 3.2 (.125)      | clear          | 4.5:1                | 2/B     |
| 107-51    | I E     | 1.6 (.063)      | black          | 3.3:1                | 3/B     |
| C107-51   | I E     | 1.6 (.063)      | clear          | 3.3:1                | 3/B     |
| 107-51-3  | I E     | 2.4 (.093)      | black          | 3.3:1                | 3/B     |
| C107-51-3 | I E     | 2.4 (.093)      | clear          | 3.3:1                | 3/B     |
| 107-51-4  | I E     | 3.2 (.125)      | black          | 3.3:1                | 3/B     |
| C107-51-4 | I E     | 3.2 (.125)      | clear          | 3.3:1                | 3/B     |
| 107-55    | I E     | 1.6 (.063)      | black          | 8:1                  | 4/B     |
| C107-55   | I E     | 1.6 (.063)      | clear          | 8:1                  | 4/B     |
| 107-55-3  | I E     | 2.4 (.093)      | black          | 8:1                  | 4/B     |
| C107-55-3 | I E     | 2.4 (.093)      | clear          | 8:1                  | 4/B     |
| 107-55-4  | I E     | 3.2 (.125)      | black          | 8:1                  | 4/B     |
| C107-55-4 | I E     | 3.2 (.125)      | clear          | 8:1                  | 4/B     |
| 107-73    | I E L   | 1.6 (.063)      | black          | 4.2:1                | 5/C     |
| C107-73   | I E L   | 1.6 (.063)      | clear          | 4.2:1                | 5/C     |
| 107-73-3  | I E L   | 2.4 (.093)      | black          | 4.2:1                | 5/C     |
| C107-73-3 | I E L   | 2.4 (.093)      | clear          | 4.2:1                | 5/C     |
| 107-73-4  | I E L   | 3.2 (.125)      | black          | 4.2:1                | 5/C     |
| C107-73-4 | I E L   | 3.2 (.125)      | clear          | 4.2:1                | 5/C     |
| 107-75    | I E L   | 1.6 (.063)      | black          | 7:1                  | 6/C     |
| C107-75   | I E L   | 1.6 (.063)      | clear          | 7:1                  | 6/C     |
| 107-75-3  | I E L   | 2.4 (.093)      | black          | 7:1                  | 6/C     |
| C107-75-3 | I E L   | 2.4 (.093)      | clear          | 7:1                  | 6/C     |
| 107-75-4  | I E L   | 3.2 (.125)      | black          | 7:1                  | 6/C     |
| C107-75-4 | I E L   | 3.2 (.125)      | clear          | 7:1                  | 6/C     |

Feature: I = Inserter E = Extractor L = Latching  
For Pre-start pin feature, add "P" prefix to part number



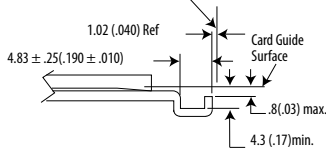


Units: mm (in)  
Unless otherwise specified:  
.xx ± .25, .x ± .5  
(.xxx ± .010, .xx ± .02)

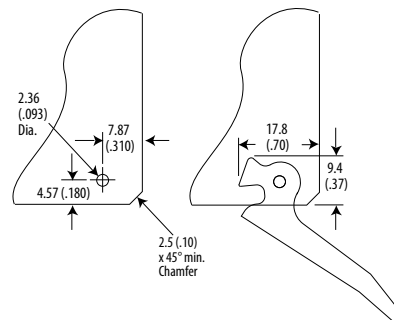


Provides insertion and extraction travel of 7.6 (.30) min.

Nominal position of card edge when seated inconnector. The Inserter-Extractor will allow .76 (.03) overtravel for tolerance take-up.



**Detail of Actuating Surfaces**  
Required on Top and Bottom Guide Plates



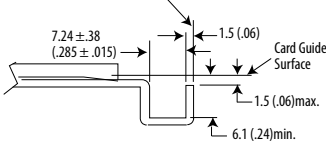
## APPLICATION DATA

Two inserter or inserter-extractors are recommended per printed circuit board taller than 127 (5) in height.

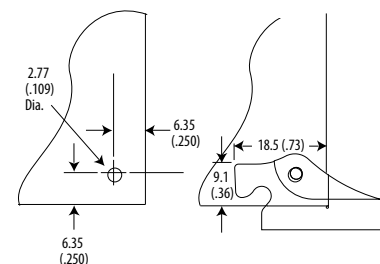
Units: mm (in)  
Unless otherwise specified:  
.xx ± .25, .x ± .5  
(.xxx ± .010, .xx ± .02)

Provides insertion and extraction travel of 8.9 (.35) min.

Nominal position of card edge when seated inconnector. The Inserter-Extractor will allow 1.3 (.05) overtravel for tolerance take-up.

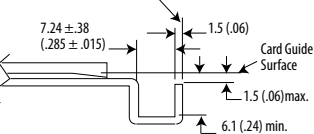


**Detail of Actuating Surfaces**  
Required on Top and Bottom Guide Plates

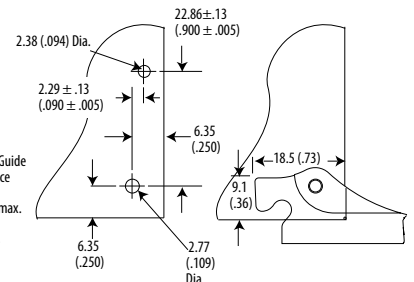


Provides insertion and extraction travel of 8.9 (.35) min.

Nominal position of card edge when seated inconnector. The Inserter-Extractor will allow 1.3 (.05) overtravel for tolerance take-up.



**Detail of Actuating Surfaces**  
Required on Top and Bottom Guide Plates



Calmark offers the Series 109 narrow profile aluminum Card Extractor for safe and efficient extraction of Printed Circuit Board with limited available space. Single-side actuating foot design provides clearance for use on boards with "Card-Lok" clamping retainers. The Series 109 meets the requirements of DSCC 84191.

### FEATURES

- Lever action provides mechanical advantage for efficient insertion and extraction of printed circuit board
- Meets requirements of DSCC 84191
- Narrow profile requires minimum board space
- Single-side actuating foot provides clearance for use with "Card-Lok" clamping retainers
- Strong aluminum or stainless material
- Available in colored finish for coding

### MATERIALS/FINISH

#### EXTRACTOR

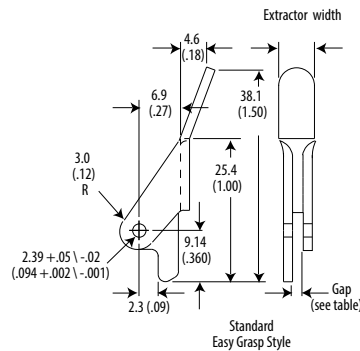
.063 thick Aluminum Alloy, type 5052-H32 per QQ-A-250/8 Chem film or anodize finish (see part number code) or .063 thick Stainless Steel, type 304 per ASTM-A666. Passivated per AMS-QQ-P-35

#### ROLL PIN

Stainless Steel, 2.38 (.093) x 4.75 (.187) long. -3 and -4 versions use 6.35 (.250) long

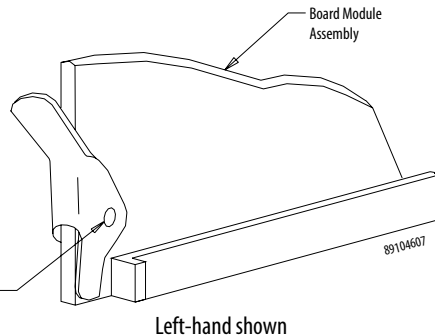
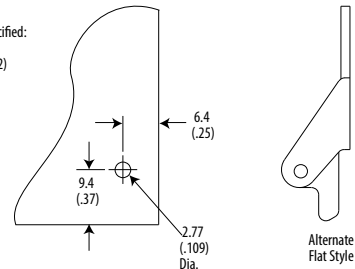


Series 109 - Extractor (Card-Lok Compatible)



| Board Thickness Dash No. | Board Thickness | Gap Dimension± 0.13 (± .005) | Extractor Width Dimension |
|--------------------------|-----------------|------------------------------|---------------------------|
| [blank]                  | 1.6 (.063)      | 1.91 (.075)                  | 6.4 (.25)                 |
| -3                       | 2.3 (.094)      | 2.67 (.105)                  | 6.4 (.25)                 |
| -4                       | 3.2 (.125)      | 3.61 (.142)                  | 7.4 (.29)                 |

Units: mm (in)  
Unless otherwise specified:  
.xx ± .25, .x ± .5  
(.xxx ± .010, .xx ± .02)



Left-hand shown

### APPLICATION DATA

Two (2) extractors are recommended per board. (One "L" and one "R" per printed circuit board). Provides extraction travel of 11.4 (.45) minimum, with a mechanical advantage of 4.5:1

### Part Number Code Series 109 Extractor

#### Prefix options

Prestarted pin option                      **P**  
Pin kitted with extractor                      [blank]  
Flat Style Handle                      **F**  
Easy Grasp Handle                      [blank]

#### Suffix options

Material  
.063" thk. Aluminum Alloy 5052-H2                      [blank]  
.063" thk. Stainless Steel Type 304                      **CR**  
Board Thickness  
.063 (1.6)                      [blank]  
.093 (2.4)                      **-3**  
.125 (3.2)                      **-4**  
Left or Right Orientation  
Left                      **L**  
Right                      **R**  
Finish  
Chem Film Gold                      [blank]  
Or choose from finish table  
ESD silkscreen                      **SED**  
No ESD silkscreen                      [blank]

### Part Number Code Example:

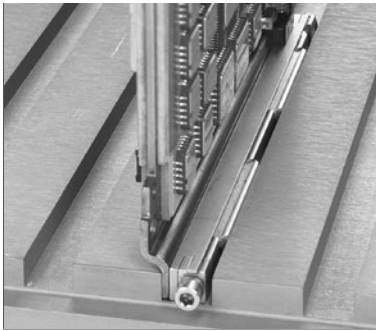
P109CR-4R-BLK-SED

Series 109 Extractor made from stainless steel with pre-start pin, made for .125 thick boards, anodized black with ESD silkscreen for a right handed extraction.

### FINISH TABLE

| Code    | Letter | Finish             |
|---------|--------|--------------------|
| [blank] |        | Chemical Film Gold |
| -BLK    |        | Black Anodize      |
| -BRN    |        | Brown Anodize      |
| -RED    |        | Red Anodize        |
| -ORG    |        | Orange Anodize     |
| -YEL    |        | Yellow Anodize     |
| -BLU    |        | Blue Anodize       |
| -GRN    |        | Green Anodize      |
| -PRP    |        | Purple Anodize     |
| -CLR    |        | Clear Anodize      |

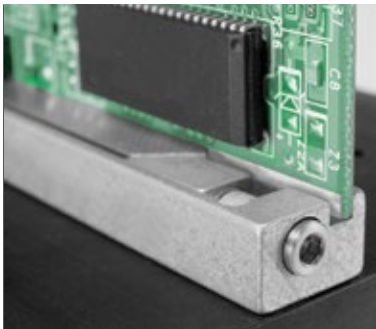
ESD silkscreen will be in a contrasting color.



## CARD-LOK

### For cold wall applications

The Card-Lok series of retainers offer the highest locking force available for cold wall applications. They mount to Printed Circuit Board assemblies using screws, rivets or adhesive bonding and are then inserted into machined channels of cold plates or heat exchangers. The wedge design holds the Printed Circuit Board firmly in place providing high resistance to shock and vibration while producing maximum thermal transfer.



## CHANNEL-LOK

### For sheet metal or non-machined cold wall applications

The Channel-Lok series of locking retainers are designed for heavy shock and vibration, and for effective heat dissipation in sheet metal chassis/heat sink applications. The design combines chassis mounted housing with Card-Lok retainers.



## METAL RETAINERS

### For low cost sheet metal applications or cold wall applications

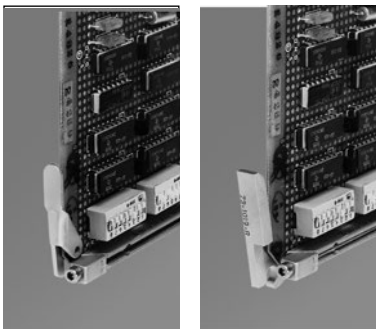
The metal retainers offer a low cost spring action printed circuit board retention design. They attach to the chassis using screws, rivets or adhesives. Retainers provide protection against shock and vibration and offer excellent grounding characteristics.



## NYLON CARD GUIDES

### For low cost sheet metal applications

Patented nylon guide entry, easy tool-less installation and snap guides available to support low cost sheet metal card cages.



## INSERTER & EXTRACTOR

### Metal and nylon designs

Calmark offers a wide selection of Injectors and Extractors for use in both sheet metal and cold wall applications. Available in both metal and nylon designs, these products facilitate the insertion and extraction of printed circuit boards with high density backplane interconnects.

## Technical Applications Discussion

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The clamping outputs indicated in the table below are the results of averaged data. Within each series numerous Card-Loks of various lengths, finishes, and configurations were cycle tested. The accumulated data verified the following:

- Clamping output is not dependent on length
- Clamping output is greatly affected by choice of finish
- Clamping output is greatly improved when washers are used

Customized Card-Lok variations for specific applications are available on request

| Product Series | Screw Size | Torque Setting<br>N-cm (in-lbs) | Clamping Force              |                                          |                          |                                       |
|----------------|------------|---------------------------------|-----------------------------|------------------------------------------|--------------------------|---------------------------------------|
|                |            |                                 | Chem Film Finish<br>N (lbs) | Chem Film Finish<br>With Washers N (lbs) | Black Anodize<br>N (lbs) | Black Anodize<br>With Washers N (lbs) |
| 223            | 4-40       | N/A                             | Consult factory             | Consult factory                          | Consult factory          | Consult factory                       |
| 224            | 4-40       | N/A                             | Consult factory             | Consult factory                          | Consult factory          | Consult factory                       |
| 225            | 4-40       | 68 (6)                          | 445 (100)                   | 778 (175)                                | 1223 (275)               | 1423 (320)                            |
| E225           | 4-40       | 68 (6)                          | 445 (100)                   | 778 (175)                                | 1223 (275)               | 1423 (320)                            |
| L225           | 4-40       | N/A                             | N/A                         | N/A                                      | 533 (120)                | N/A                                   |
| 226            | 4-40       | 68 (6)                          | 801 (180)                   | 1402 (315)                               | 2224 (500)               | 2755 (615)                            |
| 227            | 4-40       | 68 (6)                          | N/A                         | 778 (175)                                | N/A                      | 1423 (320)                            |
| 228            | 4-40       | 68 (6)                          | N/A                         | 1402 (315)                               | N/A                      | 2775 (615)                            |
| 230            | 4-40       | 68 (6)                          | 489 (110)                   | 890 (200)                                | 3334 (300)               | 1512 (340)                            |
| 231            | 4-40       | 68 (6)                          | 801 (180)                   | 1402 (315)                               | 2224 (500)               | 2755 (615)                            |
| 235            | M3         | 68 (6)                          | 445 (100)                   | N/A                                      | 1223 (275)               | N/A                                   |
| 236            | M3         | 68 (6)                          | 801 (150)                   | N/A                                      | 2224 (500)               | N/A                                   |
| 240            | 4-40       | 68 (6)                          | 489 (110)                   | 623 (140)                                | 1446 (325)               | 1490 (335)                            |
| 245            | 6-32       | 110 (10)                        | 623 (140)                   | 1023 (230)                               | 1779 (400)               | 1779 (400)                            |
| 250            | 8-32       | 220 (20)                        | 1112 (250)                  | 1779 (400)                               | 2958 (665)               | 3114 (700)                            |
| 255            | 10-32      | 350 (31)                        | 1779 (400)                  | 2669 (600)                               | 3336 (750)               | 3670 (825)                            |
| 260            | 4-40       | 68 (6)                          | N/A                         | 1779 (400)                               | N/A                      | 2224 (500)                            |
| 261            | 4-40       | 68 (6)                          | N/A                         | 667 (150)                                | N/A                      | 1223 (275)                            |
| L260           | 4-40       | N/A                             | N/A                         | N/A                                      | 556 (125)*               | N/A                                   |
| LE260          | 4-40       | N/A                             | N/A                         | N/A                                      | 556 (125)*               | N/A                                   |
| 263            | 4-40       | 68 (6)                          | N/A                         | 1779 (400)                               | N/A                      | 2224 (500)                            |
| 264            | 4-40       | 68 (6)                          | N/A                         | 667 (150)                                | N/A                      | 1223 (275)                            |
| 265            | 4-40       | 68 (6)                          | N/A                         | 1557 (350)                               | N/A                      | 2113 (475)                            |
| 266            | 4-40       | 68 (6)                          | N/A                         | 600 (135)                                | N/A                      | 801 (180)                             |
| 267            | 4-40       | 68 (6)                          | N/A                         | 1557 (350)                               | N/A                      | 2113 (475)                            |
| 280            | 8-32       | 220 (20)                        | N/A                         | 3336 (750)                               | N/A                      | 4003 (900)                            |
| 281            | 8-32       | 220 (20)                        | N/A                         | 1245 (280)                               | N/A                      | 2224 (500)                            |

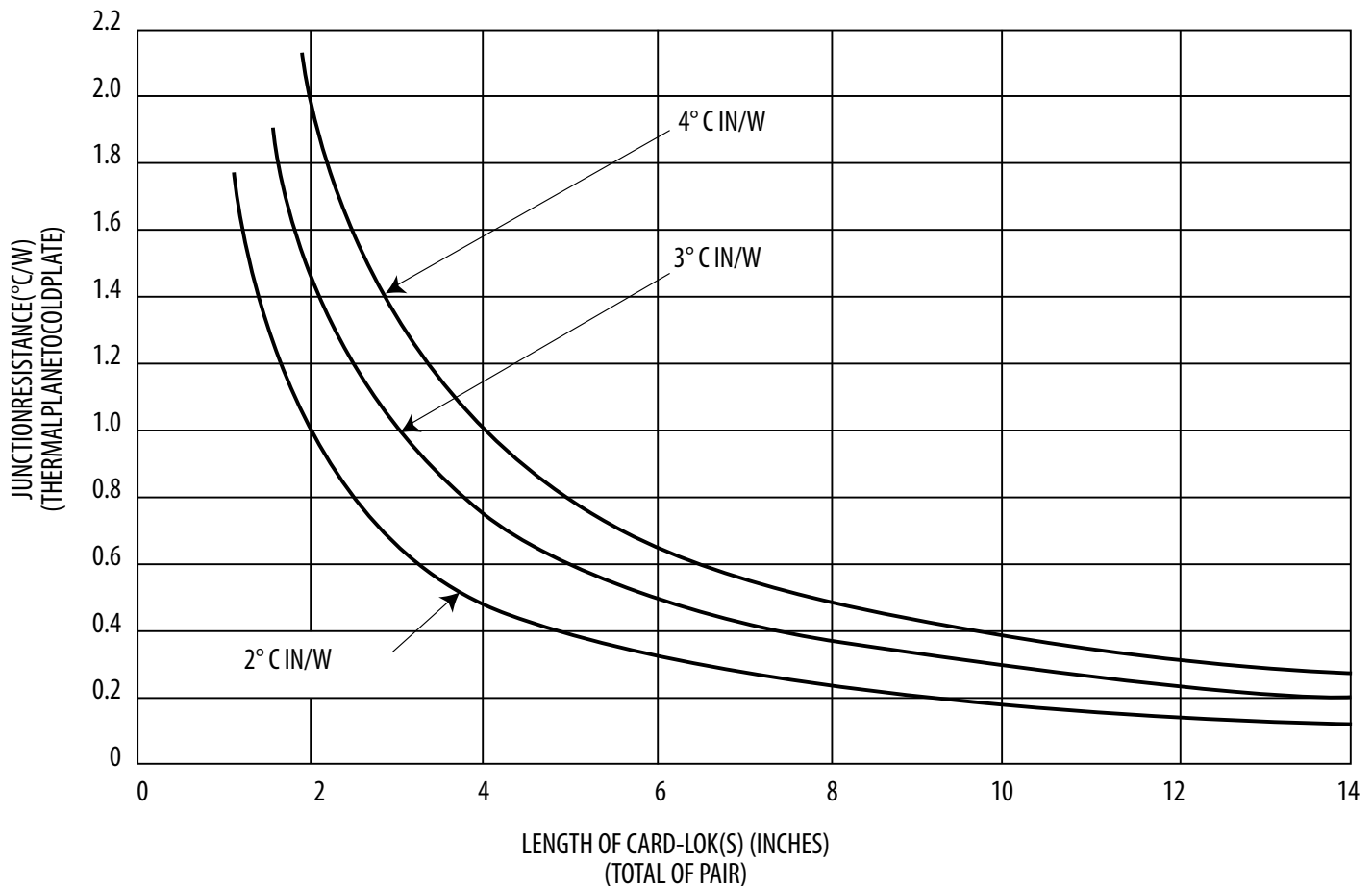
\* Finish is dry film lube over black anodize

Testing performed by numerous users of Calmark's Series 225 and similar size Card-Loks (approx. 6.35 [.25] high) has shown that the thermal resistance across the interface of a card which is clamped to a cold plate will usually fall within the range of 2° to 4°C inch/watt. Three piece Card-Loks of shorter lengths will usually provide results close to the 2, while longer Card-Loks (over 6 inches) may fall closer to the 4.

These thermal resistance numbers apply when testing is performed at or near sea level. When the same testing is performed at high altitude or near vacuum conditions the results can be significantly affected. Increases of from 10 to 40 percent would not be unusual, especially with the longer three piece Card-Loks.

Five piece Card-Loks, such as the Series 260 or 265, with their greater and more evenly distributed clamping force, will greatly reduce these potential gradients.

The following chart provides an easy method of estimating the temperature rise across the interface (junction) of the card and cold plate when thermal conductivity is the only means of heat transfer considered (heat loss due to radiation and convection minimized).



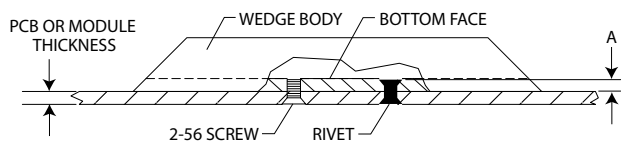
Example: A card using a pair of 127mm (5.00 inch) long Card-Loks is clamped to a pair of cold plates and is dissipating 50 watts of power:

Total length of Card-Loks is 254 (10), [127 (5) x 2]

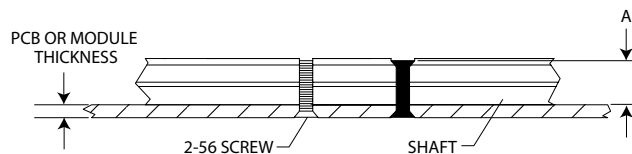
Junction resistance is shown as between 0.2° and 0.4°C/W

Therefore, at their junction, card temperature will rise between 10° and 20°C above the cold plate.  $[0.2^{\circ}\text{C/W} \times 50(\text{W}) = 10^{\circ}\text{C}]$

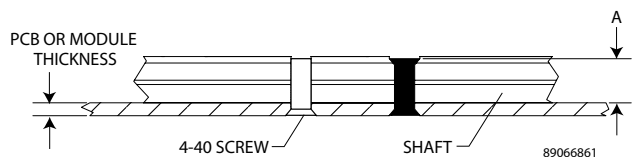
SERIES 223-255



SERIES 260-267



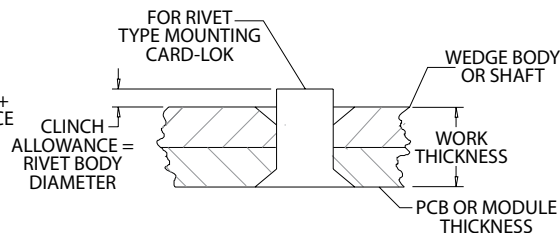
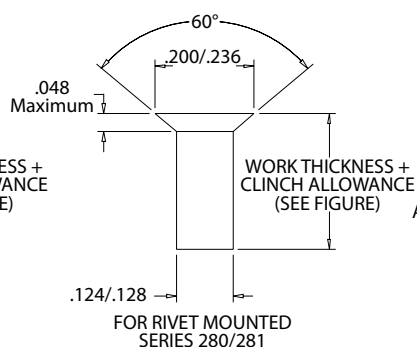
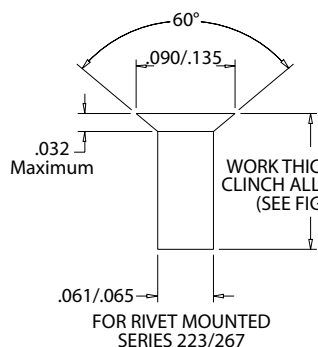
SERIES 280/281



| Series | "A" Recommended |
|--------|-----------------|
| 223    | 1.143 (0.045)   |
| 224    | 1.143 (0.045)   |
| 225    | 1.143 (0.045)   |
| E225   | 1.143 (0.045)   |
| L225   | 1.143 (0.045)   |
| 226    | 1.270 (0.050)   |
| 227    | 2.667 (0.105)   |
| 228    | 2.667 (0.105)   |
| 230    | 0.889 (0.035)   |
| 231    | 0.889 (0.035)   |
| 235    | 1.270 (0.050)   |
| 236    | 1.270 (0.050)   |
| 240    | 0.762 (0.030)   |
| 245    | 1.143 (0.045)   |
| 250    | 1.905 (0.075)   |
| 255    | 1.905 (0.075)   |
| 260    | 4.953 (0.195)   |
| 261    | 4.953 (0.195)   |
| L260   | 4.953 (0.195)   |
| LE260  | 4.953 (0.195)   |
| 263    | 4.953 (0.195)   |
| 264    | 4.953 (0.195)   |
| 265    | 4.953 (0.195)   |
| 266    | 4.953 (0.195)   |
| 267    | 3.810 (0.150)   |
| 280    | 7.366 (0.290)   |
| 281    | 8.382 (0.330)   |

Screw Length and Head Style depend on details of the application. In general, the screw should not extend beyond the bottom face of the wedge body or top edge of the shaft.

SUGGESTED RIVET DIMENSIONS



89066862



Basic theory, knowledge of pertinent forces and understanding of product functionality enables an engineer to select the proper components. The discussion below illustrates the advantage of five or more piece Card-Lok and provides information on how to calculate insertion/extraction forces.

## Inserter - Extractor Theory

Basic theory, knowledge of pertinent forces and understanding of product functionality enables an engineer to select the proper components. The discussion below illustrates the advantage of five or more piece Card-Lok and provides information on how to calculate insertion/extraction forces.

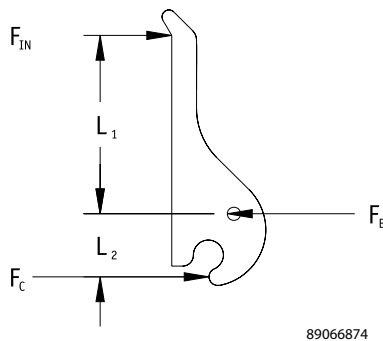
$$M_c = 0 = F_{IN} (L_1 + L_2) - F_B (L_2)$$

$$[F_B \div F_{IN}] = [(L_1 + L_2) \div L_2] = C$$

Example:

Calculate the inserter force exerted on the backplane connector when 8.9N (2lbs) finger force is applied to a pair of Series 107 inserter extractors.

$$F_B = C F_{IN} 2 = 4.21 (8.9N (2 lb.)) (2) = 74.9N (16.84 lb.)$$



89066874

| Series | L <sub>1</sub> | L <sub>2</sub> | F <sub>B</sub> /F <sub>IN</sub> =C |
|--------|----------------|----------------|------------------------------------|
| 101    | 17.475 (.688)  | 9.499 (.374)   | 2.84                               |
| 103    | 17.475 (.688)  | 11.099 (.437)  | 2.57                               |
| 104    | 17.856 (.703)  | 9.906 (.390)   | 2.80                               |
| 105    | 24.003 (.945)  | 7.874 (.310)   | 4.04                               |
| 107    | 38.735 (1.525) | 12.065 (.475)  | 4.21                               |
| 107-10 | 26.035 (1.025) | 12.065 (.475)  | 3.16                               |
| 107-20 | 38.735 (1.525) | 12.065 (.475)  | 4.21                               |
| 107-30 | 34.925 (1.375) | 8.255 (.325)   | 5.23                               |
| 107-40 | 38.735 (1.525) | 12.065 (.475)  | 4.21                               |
| 107-50 | 38.735 (1.525) | 12.065 (.475)  | 4.21                               |
| 107-51 | 26.035 (1.025) | 12.065 (.475)  | 3.16                               |
| 107-55 | 76.825 (3.025) | 12.065 (.475)  | 7.37                               |
| 107-70 | 35.433 (1.395) | 12.065 (.475)  | 3.93                               |
| 107-73 | 35.433 (1.395) | 12.065 (.475)  | 3.93                               |
| 107-75 | 70.485 (2.775) | 12.065 (.475)  | 6.84                               |
| 108    | 38.735 (1.525) | 11.811 (.465)  | 4.28                               |
| 109    | 28.956 (1.140) | 9.114 (.360)   | 4.17                               |

Values represent insertion force ratios. Extraction forces are slightly higher for these products.

## Card-Lok Theory

$$F_{out} = (N-1)F_{in} [(1-\mu_1 \tan(\alpha)) \div (\tan(\alpha) + \mu_1 + \mu_2(1-\mu_1 \tan(\mu)))]$$

Where N = number of wedge segments

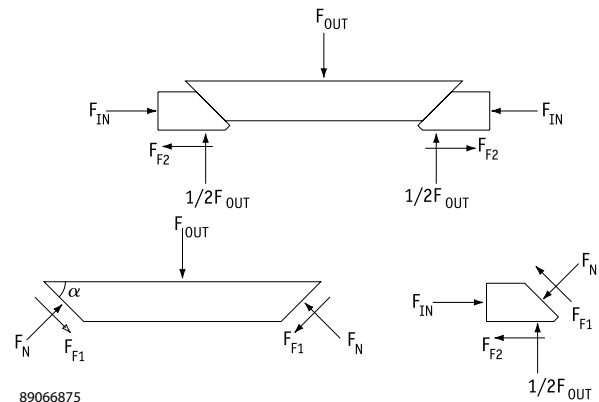
$\alpha$  = angle of interface

$\mu_1$  = friction coefficient of 45° wedge face

$\mu_2$  = friction coefficient of wedge surface in contact with cold wall

If  $\mu_1 = \mu_2 = \mu$  and  $\alpha = 45^\circ$  then

$$F_{out} = (N-1)F_{in} [(1-\mu) \div (1+2-\mu^2)]$$



89066875

| $\mu$ | Three-piece<br>F <sub>out</sub> | Five-piece<br>F <sub>out</sub> | Seven-piece<br>F <sub>out</sub> |
|-------|---------------------------------|--------------------------------|---------------------------------|
| 0     | 2.00•F <sub>in</sub>            | 4.00•F <sub>in</sub>           | 6.00•F <sub>in</sub>            |
| .05   | 1.73•F <sub>in</sub>            | 3.40•F <sub>in</sub>           | 5.19•F <sub>in</sub>            |
| .10   | 1.51•F <sub>in</sub>            | 3.03•F <sub>in</sub>           | 4.54•F <sub>in</sub>            |
| .15   | 1.33•F <sub>in</sub>            | 2.66•F <sub>in</sub>           | 3.99•F <sub>in</sub>            |
| .20   | 1.18•F <sub>in</sub>            | 2.35•F <sub>in</sub>           | 3.53•F <sub>in</sub>            |
| .25   | 1.04•F <sub>in</sub>            | 2.09•F <sub>in</sub>           | 3.13•F <sub>in</sub>            |
| .30   | .93•F <sub>in</sub>             | 1.85•F <sub>in</sub>           | 2.78•F <sub>in</sub>            |
| .40   | .73•F <sub>in</sub>             | 1.46•F <sub>in</sub>           | 2.20•F <sub>in</sub>            |

$F_{in} = T \div kd$  where  $k \approx .25$  (friction coefficient of screw)

$d$  = diameter of screw and  $T$ =Torque

## Guide to Materials and Finishes

### Galvanic Corrosion

Galvanic corrosion occurs when dissimilar metals are in contact in the presence of an electrolyte (conductive medium). Galvanic compatibility therefore is important if the application is in an environment where an electrolyte is present. For most office environments this is of little concern. However, if the application is in a marine environment or has contact with outside air then galvanic compatibility is necessary.

The table below shows a typical galvanic series. In general, the farther apart two metals appear on the chart the greater the tendency for corrosion.

| ANODIC (Least Noble) End Material                |
|--------------------------------------------------|
| Magnesium                                        |
| Magnesium Alloys                                 |
| Zinc                                             |
| Aluminum                                         |
| Cadmium                                          |
| Aluminum 17ST                                    |
| Steel or iron                                    |
| Cast iron                                        |
| Chromium-iron (active)                           |
| Ni-Resist                                        |
| 18-8 Chromium-nickel-iron (active)               |
| 18-8-3 Chromium-nickel-molybdenum-iron (active)  |
| Lead-tin solders                                 |
| Lead                                             |
| Tin                                              |
| Nickel (active)                                  |
| Inconel (active)                                 |
| Hastelloy C (active)                             |
| Brasses                                          |
| Copper                                           |
| Bronzes                                          |
| Copper-nickel alloys                             |
| Monel                                            |
| Silver Solder                                    |
| Nickel (passive)                                 |
| Inconel (passive)                                |
| Chromium-iron (passive)                          |
| 18-8 Chromium-nickel iron (passive)              |
| 18-8-3 Chromium-nickel-molybdenum-iron (passive) |
| Hastelloy C (passive)                            |
| Silver                                           |
| Carbon and graphite                              |
| Platinum                                         |
| Gold                                             |
| CATHODIC (Most Noble)                            |

## Finish Options

### Beryllium Copper Finish Options (see product pages for ordering information)

- Tin Plate per Mil-T-10727 .0002 min.
  - Good corrosion resistance but will tarnish over time.
- Nickel Plate per QQ-N-290 Class 1, Grade F
  - Excellent corrosion protection along with high hardness for wear and low friction.
- Electroless Nickel Plate per Mil-C-26074 Class 1, Grade B
  - Excellent corrosion protection along with good electrical conductivity and low friction.

### Aluminum Finish Options (see product pages for ordering information)

- Chemical Film (Gold) per MIL-C-5541, Class 1A or Class 3 Chemical Film (Clear) per MIL-DTL-5541, Class 3, Type II
  - Other commonly used trade names associated with this process include: Alodine, Alochrom, Iridite.
- Anodize ("Soft"), per MIL-8625, Class 2, Type II (.00005" - .0003")
  - Good corrosion resistance with medium abrasion resistance.
  - Unless specified otherwise color will be black.
- Anodize ("Hard"), per MIL-8625, Class 2, Type III (.002")
  - Excellent corrosion and abrasion resistance.
  - Unless specified otherwise color will be black.
- Electroless Nickel Plate per Mil-C-26074 Class 1, Grade B
  - Excellent corrosion protection along with good electrical conductivity and low friction.

### Stainless Steel Finish

- Passivation per MIL-S-5002
  - Passivation is not a plating or a coating. It is a cleaning process that removes residue from manufacturing operations and enhances the natural corrosion resistance of stainless steels.

### Material Properties

| Material               | BeCu        | BeCu HT  | Stainless Steel | Steel     |
|------------------------|-------------|----------|-----------------|-----------|
| Type                   | C17200 1/4H | C17200 H | 304             | ASTM A366 |
| Yield Strength (Mpa)   | 410-550     | 710      | 329             | 280       |
| Tensile Strength (Mpa) | 520-610     | 780      | 673             | 330       |
| Elastic Modulus (Gpa)  | 125-130     | 125-130  | 190             | 207       |

**Table 1. American National Standard Hexagon and Spline Socket Head Cap Screws**

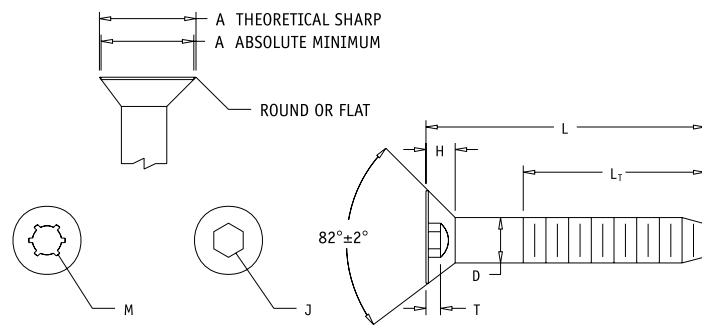
**1960 Series ANSI B18.3-1982**

| Nominal Size | Body Diameter |        | Head Diameter |       | Head Height |       | Spline Socket Size | Hex. Socket Size | Fillet Ext. | Key Engagement* |
|--------------|---------------|--------|---------------|-------|-------------|-------|--------------------|------------------|-------------|-----------------|
|              | Max           | Min    | Max           | Min   | Max         | Min   | Nom                | Nom              | Max         |                 |
|              | <i>D</i>      |        | <i>A</i>      |       | <i>H</i>    |       | <i>M</i>           | <i>J</i>         | <i>F</i>    | <i>T</i>        |
| 0            | 0.0600        | 0.0568 | 0.096         | 0.091 | 0.060       | 0.057 | 0.060              | - 0.050          | 0.007       | 0.025           |
| 1            | 0.0730        | 0.0695 | 0.118         | 0.112 | 0.073       | 0.070 | 0.072              | 1/16 0.062       | 0.007       | 0.031           |
| 2            | 0.0860        | 0.0822 | 0.140         | 0.134 | 0.086       | 0.083 | 0.096              | 5/64 0.078       | 0.008       | 0.038           |
| 3            | 0.0990        | 0.0949 | 0.161         | 0.154 | 0.099       | 0.095 | 0.096              | 5/64 0.078       | 0.008       | 0.044           |
| 4            | 0.1120        | 0.1075 | 0.183         | 0.176 | 0.112       | 0.108 | 0.111              | 3/32 0.094       | 0.009       | 0.051           |
| 5            | 0.2250        | 0.1202 | 0.205         | 0.198 | 0.125       | 0.121 | 0.111              | 3/32 0.094       | 0.010       | 0.057           |
| 6            | 0.1380        | 0.1329 | 0.226         | 0.218 | 0.138       | 0.234 | 0.133              | 7/64 0.109       | 0.010       | 0.064           |
| 8            | 0.1640        | 0.2585 | 0.270         | 0.262 | 0.164       | 0.159 | 0.168              | 9/64 0.141       | 0.012       | 0.077           |
| 10           | 0.1900        | 0.1840 | 0.312         | 0.303 | 0.190       | 0.185 | 0.183              | 5/32 0.156       | 0.014       | 0.090           |
| 1 1/4        | 0.2500        | 0.2435 | 0.375         | 0.365 | 0.250       | 0.244 | 0.216              | 3/16 0.188       | 0.014       | 0.120           |
| 5/16         | 0.3125        | 0.3053 | 0.469         | 0.457 | 0.312       | 0.306 | 0.291              | 1/4 0.250        | 0.017       | 0.151           |
| 3/8          | 0.3750        | 0.3678 | 0.562         | 0.550 | 0.375       | 0.368 | 0.372              | 5/16 0.312       | 0.020       | 0.182           |
| 7/16         | 0.4375        | 0.4294 | 0.656         | 0.642 | 0.438       | 0.430 | 0.454              | 3/8 0.375        | 0.023       | 0.213           |
| 1/2          | 0.5000        | 0.4919 | 0.750         | 0.735 | 0.500       | 0.492 | 0.454              | 3/8 0.375        | 0.026       | 0.245           |
| 5/8          | 0.6250        | 0.6163 | 0.938         | 0.921 | 0.625       | 0.616 | 0.595              | 1/2 0.500        | 0.032       | 0.307           |
| 3/4          | 0.7500        | 0.7406 | 1.125         | 1.107 | 0.750       | 0.740 | 0.620              | 5/8 0.625        | 0.039       | 0.370           |
| 7/8          | 0.8750        | 0.8647 | 1.312         | 1.293 | 0.875       | 0.864 | 0.698              | 3/4 0.750        | 0.044       | 0.432           |
| 1            | 1.0000        | 0.9886 | 1.500         | 1.479 | 1.000       | 0.988 | 0.790              | 3/4 0.750        | 0.050       | 0.495           |
| 1 1/8        | 1.1250        | 1.1086 | 1.688         | 1.665 | 1.125       | 1.111 | ...                | 7/8 0.875        | 0.055       | 0.557           |
| 1 1/4        | 1.2500        | 1.2336 | 1.875         | 1.852 | 1.250       | 1.236 | ...                | 7/8 0.875        | 0.060       | 0.620           |
| 1 3/8        | 1.3750        | 1.3568 | 2.062         | 2.038 | 1.375       | 1.360 | ...                | 1 1.000          | 0.065       | 0.682           |
| 1 1/2        | 1.5000        | 1.4828 | 2.250         | 2.224 | 1.500       | 1.485 | ...                | 1 1.000          | 0.070       | 0.745           |
| 1 3/4        | 1.7500        | 1.7295 | 2.625         | 2.597 | 1.750       | 1.734 | ...                | 1 1/4 1.250      | 0.080       | 0.870           |
| 2            | 2.0000        | 1.9780 | 3.000         | 2.970 | 2.000       | 1.983 | ...                | 1 1/2 1.500      | 0.090       | 0.995           |
| 2 1/4        | 2.2500        | 2.2280 | 3.375         | 3.344 | 2.250       | 2.232 | ...                | 1 3/4 1.750      | 0.100       | 1.120           |
| 2 1/2        | 2.5000        | 2.4762 | 3.750         | 3.717 | 2.500       | 2.481 | ...                | 1 3/4 1.750      | 0.110       | 1.245           |
| 2 3/4        | 2.7500        | 2.7262 | 4.125         | 4.090 | 2.750       | 2.730 | ...                | 2 2.000          | 0.120       | 1.370           |
| 3            | 3.0000        | 2.9762 | 4.500         | 4.464 | 3.000       | 2.979 | ...                | 2 1/4 2.250      | 0.130       | 1.495           |
| 3 1/4        | 3.2500        | 3.2262 | 4.875         | 4.837 | 3.250       | 3.228 | ...                | 2 1/4 2.250      | 0.140       | 1.620           |
| 3 1/2        | 3.5000        | 3.4762 | 5.250         | 5.211 | 3.500       | 3.478 | ...                | 2 3/4 2.750      | 0.150       | 1.745           |
| 3 3/4        | 3.7500        | 3.7262 | 5.625         | 5.584 | 3.750       | 3.727 | ...                | 2 3/4 2.750      | 0.160       | 1.870           |
| 4            | 4.0000        | 3.9762 | 6.000         | 5.958 | 4.000       | 3.976 | ...                | 3 3.000          | 0.170,      | 1.995           |

\* Key engagement depths are minimum.

All dimensions in inches. The body length  $L_b$  of the screw is the length of the unthreaded cylindrical portion of the shank. The length of thread,  $L_t$ , is the distance from the extreme point to the last complete (full form) thread. Standard length increments for screw diameters up to 1 inch are 1/16 inch for lengths 1/8 through 1/4 inch, 1/8 inch for lengths 1/4 through 1 inch, 1/4 inch for lengths 1 through 3 1/2 inches, 1/2 inch for lengths 3 1/2 through 7 inches, 1 inch for lengths 7 through 10 inches and for diameters over 1 inch are 1/2 inch for lengths 1 through 7 inches, 1 inch for lengths 7 through 10 inches and 2 inches for lengths over 10 inches. Heads may be plain or knurled, and chamfered to an angle  $E$  of 30 to 45 degrees with the surface of the flat. The thread conforms to the Unified Standard with radius root, Class 3A, UNRC and UNRF for screw sizes No. 0 through 1 inch inclusive, Class 2A, UNRC and UNRF for over 1 inch through 1 1/2 inches inclusive, and Class 2A UNRC for sizes larger than 1 1/2 inches. For manufacturing details not shown, including materials, see American National Standard ANSI B18.3-1982.

**Table 2. American National Standard Hexagon and Spline Socket Flat Countersunk Head Cap Screws (ANSI B 18.3-1982)**

|  |            |        |                   |           |             |                    |                     |                |
|------------------------------------------------------------------------------------|------------|--------|-------------------|-----------|-------------|--------------------|---------------------|----------------|
| Nominal Size                                                                       | Body Diam. |        | Head Diameter     |           | Head Height | Spline Socket Size | Hexagon Socket Size | Key Engagement |
|                                                                                    |            |        | Theoretical Sharp | Abs. Min. | Reference   |                    |                     | Nom.           |
|                                                                                    | Max.       | Min.   | Max.              |           |             |                    |                     |                |
|                                                                                    | <i>D</i>   |        | <i>A</i>          |           |             | <i>H</i>           | <i>M</i>            |                |
| 0                                                                                  | 0.0600     | 0.0568 | 0.138             | 0.117     | 0.044       | 0.048              | 0.035               | 0.025          |
| 1                                                                                  | 0.0730     | 0.0695 | 0.168             | 0.143     | 0.054       | 0.060              | 0.050               | 0.031          |
| 2                                                                                  | 0.0860     | 0.0822 | 0.197             | 0.168     | 0.064       | 0.060              | 0.050               | 0.038          |
| 3                                                                                  | 0.0990     | 0.0949 | 0.226             | 0.193     | 0.073       | 0.072              | 1/16                | 0.044          |
| 4                                                                                  | 0.1120     | 0.1075 | 0.255             | 0.218     | 0.083       | 0.072              | 1/16                | 0.055          |
| 5                                                                                  | 0.1250     | 0.1202 | 0.281             | 0.240     | 0.090       | 0.096              | 5/64                | 0.061          |
| 6                                                                                  | 0.1380     | 0.1329 | 0.307             | 0.263     | 0.097       | 0.096              | 5/64                | 0.066          |
| 8                                                                                  | 0.1640     | 0.1585 | 0.359             | 0.311     | 0.112       | 0.111              | 3/32                | 0.076          |
| 10                                                                                 | 0.1900     | 0.1840 | 0.411             | 0.359     | 0.127       | 0.145              | 1/8                 | 0.087          |
| 1/4                                                                                | 0.2500     | 0.2435 | 0.531             | 0.480     | 0.161       | 0.183              | 5/32                | 0.111          |
| 5/16                                                                               | 0.3125     | 0.3053 | 0.656             | 0.600     | 0.198       | 0.216              | 3/16                | 0.135          |
| 3/8                                                                                | 0.3750     | 0.3678 | 0.781             | 0.720     | 0.234       | 0.251              | 7/32                | 0.159          |
| 7/16                                                                               | 0.4375     | 0.4294 | 0.844             | 0.781     | 0.234       | 0.291              | 1/4                 | 0.159          |
| 1/2                                                                                | 0.5000     | 0.4919 | 0.938             | 0.872     | 0.251       | 0.372              | 5/16                | 0.172          |
| 5/8                                                                                | 0.6250     | 0.6163 | 1.188             | 1.112     | 0.324       | 0.454              | 3/8                 | 0.220          |
| 3/4                                                                                | 0.7500     | 0.7406 | 1.438             | 1.355     | 0.396       | 0.454              | 1/2                 | 0.220          |
| 7/8                                                                                | 0.8750     | 0.8647 | 1.688             | 1.604     | 0.468       | ...                | 9/16                | 0.248          |
| 1                                                                                  | 1.0000     | 0.9886 | 1.938             | 1.841     | 0.540       | ...                | 5/8                 | 0.297          |
| 1 1/8                                                                              | 1.1250     | 1.1086 | 2.188             | 2.079     | 0.611       | ...                | 3/4                 | 0.325          |
| 1 1/4                                                                              | 1.2500     | 1.2336 | 2.438             | 2.316     | 0.683       | ...                | 7/8                 | 0.358          |
| 1 3/8                                                                              | 1.3750     | 1.3568 | 2.688             | 2.553     | 0.755       | ...                | 7/8                 | 0.402          |
| 1 1/2                                                                              | 1.5000     | 1.4818 | 2.938             | 2.791     | 0.827       | ...                | 1                   | 0.435          |

All dimensions in inches.

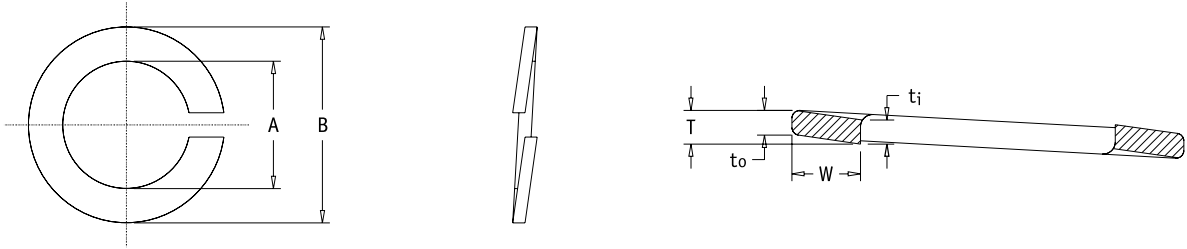
The body of the screw is the unthreaded cylindrical portion of the shank where not threaded to the head; the shank being the portion of the screw from the point of juncture of the conical bearing surface and the body to the flat of the point. The length of thread  $L_1$  is the distance measured from the extreme point to the last complete (full form) thread.

Standard length increments of No. 0 through 1-inch sizes are as follows: 1/16 inch for nominal screw lengths of 1/8 through 1/4 inch; 1/8 inch for lengths of 1/4 through 1 inch; 1/4 inch for lengths of 1 inch through 3 1/2 inches; 1/2 inch for lengths of 3 1/2 through 7 inches; and 1 inch for lengths of 7 through 10 inches, incl. For screw sizes over 1 inch, length increments are: 1/2 inch for nominal screw lengths of 1 inch through 7 inches; 1 inch for lengths of 7 through 10 inches; and 2 inches for lengths over 10 inches.

Threads shall be Unified external threads with radius root; Class 3A UNRC and UNRF series for sizes No. 0 through 1 inch and Class 2A UNRC and UNRF series for sizes over 1 inch to 1 1/2 inches, incl.

For manufacturing details not shown, including materials, see American National Standard ANSI B18 3-1982.

**Table 3. American National Standard Helical Spring Lock Washers**  
ANSI B18.21.1-1972



| Nominal Washer Size |       | Inside Diameter, A |       | Regular*             |                  |                       | Heavy†               |                  |                       | Extra Duty‡          |                  |                       |
|---------------------|-------|--------------------|-------|----------------------|------------------|-----------------------|----------------------|------------------|-----------------------|----------------------|------------------|-----------------------|
|                     |       | Max                | Min   | O.D., B<br>Max:<br>¶ | Section Width, W | Section Thickness, T§ | O.D., B<br>Max:<br>¶ | Section Width, W | Section Thickness, T§ | O.D., B<br>Max:<br>¶ | Section Width, W | Section Thickness, T§ |
|                     |       |                    |       |                      |                  |                       |                      |                  |                       |                      |                  |                       |
| No. 2               | 0.086 | 0.094              | 0.088 | 0.172                | 0.035            | 0.020                 | 0.182                | 0.040            | 0.025                 | 0.208                | 0.053            | 0.027                 |
| No. 3               | 0.099 | 0.107              | 0.101 | 0.195                | 0.040            | 0.025                 | 0.209                | 0.047            | 0.031                 | 0.239                | 0.062            | 0.034                 |
| No. 4               | 0.112 | 0.120              | 0.114 | 0.209                | 0.040            | 0.025                 | 0.223                | 0.047            | 0.031                 | 0.253                | 0.062            | 0.034                 |
| No. 5               | 0.125 | 0.133              | 0.127 | 0.236                | 0.047            | 0.031                 | 0.252                | 0.055            | 0.040                 | 0.300                | 0.079            | 0.045                 |
| No. 6               | 0.138 | 0.148              | 0.141 | 0.250                | 0.047            | 0.031                 | 0.266                | 0.055            | 0.040                 | 0.314                | 0.079            | 0.045                 |
| No. 8               | 0.164 | 0.174              | 0.167 | 0.293                | 0.055            | 0.040                 | 0.307                | 0.062            | 0.047                 | 0.375                | 0.096            | 0.057                 |
| No. 10              | 0.190 | 0.200              | 0.193 | 0.334                | 0.062            | 0.047                 | 0.350                | 0.070            | 0.056                 | 0.434                | 0.112            | 0.068                 |
| No. 12              | 0.216 | 0.227              | 0.220 | 0.377                | 0.070            | 0.056                 | 0.391                | 0.077            | 0.063                 | 0.497                | 0.130            | 0.080                 |
| 1/4                 | 0.250 | 0.262              | 0.254 | 0.489                | 0.109            | 0.062                 | 0.491                | 0.110            | 0.077                 | 0.535                | 0.132            | 0.084                 |
| 5/16                | 0.311 | 0.326              | 0.317 | 0.586                | 0.125            | 0.078                 | 0.596                | 0.130            | 0.097                 | 0.622                | 0.143            | 0.108                 |
| 3/8                 | 0.375 | 0.390              | 0.380 | 0.683                | 0.141            | 0.094                 | 0.691                | 0.145            | 0.115                 | 0.741                | 0.170            | 0.123                 |
| 7/16                | 0.438 | 0.455              | 0.443 | 0.779                | 0.156            | 0.109                 | 0.787                | 0.160            | 0.133                 | 0.839                | 0.186            | 0.143                 |
| 1/2                 | 0.500 | 0.518              | 0.506 | 0.873                | 0.171            | 0.125                 | 0.883                | 0.176            | 0.151                 | 0.939                | 0.204            | 0.162                 |
| 9/16                | 0.518 | 0.582              | 0.570 | 0.971                | 0.188            | 0.141                 | 0.981                | 0.193            | 0.170                 | 1.041                | 0.223            | 0.182                 |
| 0.562               | 0.625 | 0.650              | 0.635 | 1.079                | 0.203            | 0.156                 | 1.093                | 0.210            | 0.189                 | 1.157                | 0.242            | 0.202                 |
| 11/16               | 0.688 | 0.713              | 0.698 | 1.176                | 0.219            | 0.172                 | 1.192                | 0.227            | 0.207                 | 1.258                | 0.260            | 0.221                 |
| 3/4                 | 0.750 | 0.775              | 0.760 | 1.271                | 0.234            | 0.188                 | 1.291                | 0.244            | 0.226                 | 1.361                | 0.279            | 0.241                 |
| 3/16                | 0.812 | 0.843              | 0.824 | 1.367                | 0.250            | 0.203                 | 1.391                | 0.262            | 0.246                 | 1.463                | 0.298            | 0.261                 |
| 7/8                 | 0.875 | 0.905              | 0.887 | 1.464                | 0.266            | 0.219                 | 1.494                | 0.281            | 0.266                 | 1.576                | 0.322            | 0.285                 |
| 15/16               | 0.938 | 0.970              | 0.950 | 1.560                | 0.281            | 0.234                 | 1.594                | 0.298            | 0.284                 | 1.688                | 0.345            | 0.308                 |
| 1                   | 1.000 | 1.042              | 1.017 | 1.661                | 0.297            | 0.250                 | 1.705                | 0.319            | 0.306                 | 1.799                | 0.366            | 0.330                 |
| 1 1/16              | 1.062 | 1.107              | 1.080 | 1.756                | 0.312            | 0.266                 | 1.808                | 0.338            | 0.326                 | 1.910                | 0.389            | 0.352                 |
| 1 1/8               | 1.125 | 1.172              | 1.144 | 1.853                | 0.328            | 0.281                 | 1.909                | 0.356            | 0.345                 | 2.019                | 0.411            | 0.375                 |
| 1 13/16             | 1.188 | 1.237              | 1.208 | 1.950                | 0.344            | 0.297                 | 2.008                | 0.373            | 0.364                 | 2.124                | 0.431            | 0.396                 |
| 1 1/4               | 1.250 | 1.302              | 1.271 | 2.045                | 0.359            | 0.312                 | 2.113                | 0.393            | 0.384                 | 2.231                | 0.452            | 0.417                 |
| 1 5/16              | 1.312 | 1.366              | 1.334 | 2.141                | 0.375            | 0.328                 | 2.211                | 0.410            | 0.403                 | 2.335                | 0.472            | 0.438                 |
| 1 3/8               | 1.375 | 1.432              | 1.398 | 2.239                | 0.391            | 0.344                 | 2.311                | 0.427            | 0.422                 | 2.439                | 0.491            | 0.458                 |
| 1 7/16              | 1.438 | 1.497              | 1.462 | 2.334                | 0.406            | 0.359                 | 2.406                | 0.442            | 0.440                 | 2.540                | 0.509            | 0.478                 |
| 1 1/2               | 1.500 | 1.561              | 1.525 | 2.430                | 0.422            | 0.375                 | 2.502                | 0.458            | 0.458                 | 2.638                | 0.526            | 0.496                 |

All dimensions are given in inches.

\* Formerly designated Medium Helical Spring Lock Washers.

† Not recommended for new applications.

‡ Formerly designated Extra Heavy Helical Spring Lock Washers.

¶ The maximum outside diameters specified allow for the commercial tolerances on cold-drawn wire.

T § = mean section thickness =  $(t_i + t_o) \div 2$

**Table 4. American National Standard Type A Plain Washers****Preferred Sizes\*\* ANSI B18.22.1-1965, R1975**

| Nominal Washer Size*** |       | Series | Inside Diameter |           |       | Outside Diameter |           |       | Thickness |       |       |
|------------------------|-------|--------|-----------------|-----------|-------|------------------|-----------|-------|-----------|-------|-------|
|                        |       |        | Basic           | Tolerance |       | Basic            | Tolerance |       | Basic     | Max.  | Min.  |
|                        |       |        |                 | Plus      | Minus |                  | Plus      | Minus |           |       |       |
| -                      | -     |        | 0.078           | 0.000     | 0.005 | 0.188            | 0.000     | 0.005 | 0.020     | 0.025 | 0.016 |
| -                      | -     |        | 0.094           | 0.000     | 0.005 | 0.250            | 0.000     | 0.005 | 0.020     | 0.025 | 0.016 |
| -                      | -     |        | 0.125           | 0.008     | 0.005 | 0.312            | 0.008     | 0.005 | 0.032     | 0.040 | 0.025 |
| No. 6                  | 0.138 |        | 0.156           | 0.008     | 0.005 | 0.375            | 0.015     | 0.005 | 0.049     | 0.065 | 0.036 |
| No. 8                  | 0.164 |        | 0.188           | 0.008     | 0.005 | 0.438            | 0.015     | 0.005 | 0.049     | 0.065 | 0.036 |
| No. 10                 | 0.190 |        | 0.219           | 0.008     | 0.005 | 0.500            | 0.015     | 0.005 | 0.049     | 0.065 | 0.036 |
| 3/16                   | 0.188 |        | 0.250           | 0.015     | 0.005 | 0.562            | 0.015     | 0.005 | 0.049     | 0.065 | 0.036 |
| No. 12                 | 0.216 |        | 0.250           | 0.015     | 0.005 | 0.562            | 0.015     | 0.005 | 0.065     | 0.080 | 0.051 |
| 1/4                    | 0.250 | N      | 0.281           | 0.015     | 0.005 | 0.625            | 0.015     | 0.005 | 0.065     | 0.080 | 0.051 |
| 1/4                    | 0.250 | W      | 0.312           | 0.015     | 0.005 | 0.734*           | 0.015     | 0.007 | 0.065     | 0.080 | 0.051 |
| 5/16                   | 0.312 | N      | 0.344           | 0.015     | 0.005 | 0.688            | 0.015     | 0.007 | 0.065     | 0.080 | 0.051 |
| 5/16                   | 0.312 | W      | 0.375           | 0.015     | 0.005 | 0.875            | 0.030     | 0.007 | 0.083     | 0.104 | 0.064 |
| 3/8                    | 0.375 | N      | 0.406           | 0.015     | 0.005 | 0.812            | 0.015     | 0.007 | 0.065     | 0.080 | 0.051 |
| 3/8                    | 0.375 | W      | 0.438           | 0.015     | 0.005 | 1.000            | 0.030     | 0.007 | 0.083     | 0.104 | 0.064 |
| 7/16                   | 0.438 | N      | 0.469           | 0.015     | 0.005 | 0.922            | 0.015     | 0.007 | 0.065     | 0.080 | 0.051 |
| 7/16                   | 0.438 | W      | 0.500           | 0.015     | 0.005 | 1.250            | 0.030     | 0.007 | 0.083     | 0.104 | 0.064 |
| 1/2                    | 0.500 | N      | 0.531           | 0.015     | 0.005 | 1.062            | 0.030     | 0.007 | 0.095     | 0.121 | 0.074 |
| 1/2                    | 0.500 | W      | 0.562           | 0.015     | 0.005 | 1.375            | 0.030     | 0.007 | 0.109     | 0.132 | 0.086 |
| 9/16                   | 0.562 | N      | 0.594           | 0.015     | 0.005 | 1.156*           | 0.030     | 0.007 | 0.095     | 0.121 | 0.074 |
| 9/16                   | 0.562 | W      | 0.625           | 0.015     | 0.005 | 1.469*           | 0.030     | 0.007 | 0.109     | 0.132 | 0.086 |
| 5/8                    | 0.625 | N      | 0.656           | 0.030     | 0.007 | 1.312            | 0.030     | 0.007 | 0.095     | 0.121 | 0.074 |
| 5/8                    | 0.625 | W      | 0.688           | 0.030     | 0.007 | 1.750            | 0.030     | 0.007 | 0.134     | 0.160 | 0.108 |
| 3/4                    | 0.750 | N      | 0.812           | 0.030     | 0.007 | 1.469            | 0.030     | 0.007 | 0.134     | 0.160 | 0.108 |
| 3/4                    | 0.750 | W      | 0.812           | 0.030     | 0.007 | 2.000            | 0.030     | 0.007 | 0.148     | 0.177 | 0.122 |
| 7/8                    | 0.875 | N      | 0.938           | 0.030     | 0.007 | 1.750            | 0.030     | 0.007 | 0.134     | 0.160 | 0.108 |
| 7/8                    | 0.875 | W      | 0.938           | 0.030     | 0.007 | 2.250            | 0.030     | 0.007 | 0.165     | 0.192 | 0.136 |
| 1                      | 1.000 | N      | 1.062           | 0.030     | 0.007 | 2.000            | 0.030     | 0.007 | 0.134     | 0.160 | 0.108 |
| 1                      | 1.000 | W      | 1.062           | 0.030     | 0.007 | 2.500            | 0.030     | 0.007 | 0.165     | 0.192 | 0.136 |
| 1 1/8                  | 1.125 | N      | 1.250           | 0.030     | 0.007 | 2.250            | 0.030     | 0.007 | 0.134     | 0.160 | 0.108 |
| 1 1/8                  | 1.125 | W      | 1.250           | 0.030     | 0.007 | 2.750            | 0.030     | 0.007 | 0.165     | 0.192 | 0.136 |
| 1 1/4                  | 1.250 | N      | 1.375           | 0.030     | 0.007 | 2.500            | 0.030     | 0.007 | 0.165     | 0.192 | 0.136 |
| 1 1/4                  | 1.250 | W      | 1.375           | 0.030     | 0.007 | 3.000            | 0.030     | 0.007 | 0.165     | 0.192 | 0.136 |
| 1 3/8                  | 1.375 | N      | 1.500           | 0.030     | 0.007 | 2.750            | 0.030     | 0.007 | 0.165     | 0.192 | 0.136 |
| 1 3/8                  | 1.375 | W      | 1.500           | 0.045     | 0.010 | 3.250            | 0.045     | 0.010 | 0.180     | 0.213 | 0.153 |
| 1 1/2                  | 1.500 | N      | 1.625           | 0.030     | 0.007 | 3.000            | 0.030     | 0.007 | 0.165     | 0.192 | 0.136 |
| 1 1/2                  | 1.500 | W      | 1.625           | 0.045     | 0.010 | 3.500            | 0.045     | 0.010 | 0.180     | 0.213 | 0.153 |
| 1 5/8                  | 1.625 |        | 1.750           | 0.045     | 0.010 | 3.750            | 0.045     | 0.010 | 0.180     | 0.213 | 0.153 |
| 1 3/4                  | 1.750 |        | 1.875           | 0.045     | 0.010 | 4.000            | 0.045     | 0.010 | 0.180     | 0.213 | 0.153 |
| 1 7/8                  | 1.875 |        | 2.000           | 0.045     | 0.010 | 4.250            | 0.045     | 0.010 | 0.180     | 0.213 | 0.153 |
| 2                      | 2.000 |        | 2.125           | 0.045     | 0.010 | 4.500            | 0.045     | 0.010 | 0.180     | 0.213 | 0.153 |
| 2 1/4                  | 2.250 |        | 2.375           | 0.045     | 0.010 | 4.750            | 0.045     | 0.010 | 0.220     | 0.248 | 0.193 |
| 2 1/2                  | 2.500 |        | 2.625           | 0.045     | 0.010 | 5.000            | 0.045     | 0.010 | 0.238     | 0.280 | 0.210 |
| 2 3/4                  | 2.750 |        | 2.875           | 0.065     | 0.010 | 5.250            | 0.065     | 0.010 | 0.259     | 0.310 | 0.228 |
| 3                      | 3.000 |        | 3.125           | 0.065     | 0.010 | 5.500            | 0.065     | 0.010 | 0.284     | 0.327 | 0.249 |

All dimensions are in inches.

\* The 0.734-inch, 1.156-inch, and 1.469-inch outside diameters avoid washers which could be used in coin operated devices.

\*\* Preferred sizes are for the most part from series previously designated "Standard Plate" and "SAE." Where common sizes existed in the two series, the SAE size is designated "N" (narrow) and the Standard Plate "W" (wide). These sizes as well as all other sizes of Type A Plain Washers are to be ordered by ID, OD, and thickness dimensions.

\*\*\* Nominal washer sizes are intended for use with comparable nominal screw or bolt sizes.



**Table 5. Machinability**  
**Surface Cutting Speeds**

Surface cutting speeds given below are approximate and are intended as a guide in calculating the proper speed for the part in hand. The figures are average for the general run of parts and are based on the use of high speed cutting tools. Any extraordinary features in the part to be made should be taken into consideration and speeds altered accordingly.

For the carbon and alloy grades listed, the figures are based on cold drawn bars in the as-drawn condition, except when it is noted that the grade is annealed.

Surface cutting speeds for hot rolled as-rolled bars and hot rolled heat treated bars are not available, since the machining qualities of these bars vary according to hardness, microstructure, condition of the surface, etc.

For the stainless steels and super alloys listed, all grades are annealed or solution annealed except where otherwise indicated.

| CARBON STEELS            |                         |         | ALLOY STEELS               |                         |         |
|--------------------------|-------------------------|---------|----------------------------|-------------------------|---------|
| Grade                    | Surface Feet per Minute | Rating* | Grade                      | Surface Feet per Minute | Rating* |
| 1015                     | 120                     | 72%     | 2355 Ann.                  | 115                     | 70%     |
| 1018                     | 130                     | 78%     | 4130 Ann.                  | 120                     | 72%     |
| 1020                     | 120                     | 72%     | 4140 Ann.                  | 110                     | 66%     |
| 1022                     | 130                     | 78%     | 4142 Ann.                  | 110                     | 66%     |
| 1030                     | 115                     | 70%     | 41L42 Ann.                 | 127                     | 77%     |
| 1040                     | 105                     | 64%     | 4150 Ann.                  | 100                     | 60%     |
| 1042                     | 105                     | 64%     | 4150 Resul. Heat Treat     | 65                      | 40%     |
| 1050                     | 90                      | 54%     | 4330 Mod. Ann.             | 95                      | 59%     |
| 1095                     | 70                      | 42%     | 4340 Ann.                  | 95                      | 57%     |
| 1117                     | 150                     | 91%     | 4340 Mod. (300M) Ann.      | 95                      | 57%     |
| 1137                     | 120                     | 72%     | 4620                       | 110                     | 66%     |
| 1141                     | 115                     | 70%     | 4820 Ann.                  | 80                      | 49%     |
| 1141 Ann.                | 135                     | 81%     | 52100 Ann.                 | 65                      | 40%     |
| 1144                     | 125                     | 76%     | 6150 Ann.                  | 100                     | 60%     |
| 1144 Ann.                | 140                     | 85%     | 8620                       | 110                     | 66%     |
| 1212                     | 165                     | 100%    | 86L20                      | 127                     | 77%     |
| 1213                     | 225                     | 136%    | 9310 Ann.                  | 85                      | 51%     |
| 12L14                    | 280                     | 170%    | D6AC Ann.                  | 50                      | 30%     |
| 1215                     | 225                     | 136%    | "e.t.d." 150               | 125                     | 75%     |
| 1144 Hi Stress           | 130                     | 79%     | H-11 Ann.                  | 49                      | 29%     |
| Stressproof              | 140                     | 83%     | HS 220-18 Ann.             | 85                      | 51%     |
| Fatigue-proof            | 134                     | 80%     | Nitriding #3 135 Mod. Ann. | 76                      | 45%     |
| Leaded Grade A           | 325                     | 193%    |                            |                         |         |
| Ledloy A, La-Led         | 325                     | 193%    |                            |                         |         |
| Leaded Grade AX,AY,AZ    | 420                     | 250%    |                            |                         |         |
| Ledloy AZ, La-Led X      | 420                     | 250%    |                            |                         |         |
| STAINLESS & SUPER ALLOYS |                         |         |                            |                         |         |
| Grade                    | Surface Feet per Minute | Rating" | Grade                      | Surface Feet per Minute | Rating" |
| 302                      | 75                      | 45%     | 431                        | 75                      | 45%     |
| 303                      | 130                     | 78%     | 440A                       | 75                      | 45%     |
| 303MA                    | 135                     | 82%     | 440B&C                     | 65                      | 40%     |
| 304                      | 75                      | 45%     | 15-5 Condition A           | 80                      | 48%     |
| 304L                     | 75                      | 45%     | Condition H1150            | 90                      | 55%     |
| 316                      | 75                      | 45%     | Condition H1150M           | 125                     | 76%     |
| 321                      | 60                      | 36%     | 17-4 Condition A           | 80                      | 48%     |
| 347                      | 60                      | 36%     | Nitronic 50 (22-13-5)      | 50                      | 21%     |
| 410                      | 90                      | 54%     | A286 Aged                  | 55                      | 33%     |
| 416                      | 180                     | 110%    | Hastelloy X                | 32                      | 19%     |
| 420                      | 75                      | 45%     | Maraging 18 Ni 250         | 50                      | 30%     |
| 430                      | 90                      | 54%     |                            |                         |         |
| 430F                     | 150                     | 91%     |                            |                         |         |

\*"Rating" refers to relative speed, base on 1212 as 100%.

Table 6. Hardness Conversion Numbers for Steel

| BRINELL<br>3000 kg. Load<br>10 mm. Ball |                    | ROCKWELL   |            |            |               | SHORE<br>SCLERO-<br>SCOPE | TENSILE<br>STRENGTH<br>psi<br>(Approx.) |
|-----------------------------------------|--------------------|------------|------------|------------|---------------|---------------------------|-----------------------------------------|
| Diameter<br>Milli-<br>meters            | Hardness<br>Number | A<br>Scale | B<br>Scale | C<br>Scale | 15-N<br>Scale |                           |                                         |
| 2.25                                    | 745                | 84.1       | -          | 65.3       | 92.3          | 91                        | -                                       |
| 2.30                                    | 712                | -          | -          | -          | -             | -                         | -                                       |
| 2.35                                    | 682                | 82.2       | -          | 61.7       | 91.0          | 84                        | -                                       |
| 2.40                                    | 653                | 81.2       | -          | 60.0       | 90.2          | 81                        | -                                       |
| 2.45                                    | 627                | 80.5       | -          | 58.7       | 89.6          | 79                        | -                                       |
| 2.50                                    | 601                | 79.8       | -          | 57.3       | 89.0          | 77                        | -                                       |
| 2.55                                    | 578                | 79.1       | -          | 56.0       | 88.4          | 75                        | -                                       |
| 2.60                                    | 555                | 78.4       | -          | 54.7       | 87.8          | 73                        | 298000                                  |
| 2.65                                    | 534                | 77.8       | -          | 53.5       | 87.2          | 71                        | 288000                                  |
| 2.70                                    | 514                | 76.9       | -          | 52.1       | 86.5          | 70                        | 274000                                  |
| 2.75                                    | 495                | 76.3       | -          | 51.0       | 85.9          | 68                        | 264000                                  |
| 2.80                                    | 477                | 75.6       | -          | 49.6       | 85.3          | 66                        | 252000                                  |
| 2.85                                    | 461                | 74.9       | -          | 48.5       | 84.7          | 65                        | 242000                                  |
| 2.90                                    | 444                | 74.2       | -          | 47.1       | 84.0          | 63                        | 230000                                  |
| 2.95                                    | 429                | 73.4       | -          | 45.7       | 83.4          | 61                        | 219000                                  |
| 3.00                                    | 415                | 72.8       | -          | 44.5       | 82.8          | 59                        | 212000                                  |
| 3.05                                    | 401                | 72.0       | -          | 43.1       | 82.0          | 58                        | 202000                                  |
| 3.10                                    | 388                | 71.4       | -          | 41.8       | 81.4          | 56                        | 193000                                  |
| 3.15                                    | 375                | 70.6       | -          | 40.4       | 80.6          | 54                        | 184000                                  |
| 3.20                                    | 363                | 70.0       | -          | 39.1       | 80.0          | 52                        | 177000                                  |
| 3.25                                    | 352                | 69.3       | 110.0      | 37.9       | 79.3          | 51                        | 170000                                  |
| 3.30                                    | 341                | 68.7       | 109.0      | 36.6       | 78.6          | 50                        | 163000                                  |
| 3.35                                    | 331                | 68.1       | 108.5      | 35.5       | 78.0          | 48                        | 158000                                  |
| 3.40                                    | 321                | 67.5       | 108.0      | 34.3       | 77.3          | 47                        | 152000                                  |
| 3.45                                    | 311                | 66.9       | 107.5      | 33.1       | 76.7          | 46                        | 147000                                  |
| 3.50                                    | 302                | 66.3       | 107.0      | 32.1       | 76.1          | 45                        | 143000                                  |
| 3.55                                    | 293                | 65.7       | 106.0      | 30.9       | 75.5          | 43                        | 139000                                  |
| 3.60                                    | 285                | 65.3       | 105.5      | 29.9       | 75.0          | -                         | 136000                                  |
| 3.65                                    | 277                | 64.6       | 104.5      | 28.8       | 74.4          | 41                        | 131000                                  |
| 3.70                                    | 269                | 64.1       | 104.0      | 27.6       | 73.7          | 40                        | 128000                                  |
| 3.75                                    | 262                | 63.6       | 103.0      | 26.6       | 73.1          | 39                        | 125000                                  |
| 3.80                                    | 255                | 63.0       | 102.0      | 25.4       | 72.5          | 38                        | 121000                                  |
| 3.85                                    | 248                | 62.5       | 101.0      | 24.2       | 71.7          | 37                        | 118000                                  |
| 3.90                                    | 241                | 61.8       | 100.0      | 22.8       | 70.9          | 36                        | 114000                                  |
| 3.95                                    | 235                | 61.4       | 99.0       | 21.7       | 70.3          | 35                        | 111000                                  |
| 4.00                                    | 229                | 60.8       | 98.2       | 20.5       | 69.7          | 34                        | 109000                                  |
| 4.05                                    | 223                | -          | 97.3       | 18.8       | -             | -                         | 104000                                  |
| 4.10                                    | 217                | -          | 96.4       | 17.5       | -             | 33                        | 103000                                  |
| 4.15                                    | 212                | -          | 95.5       | 16.0       | -             | -                         | 100000                                  |
| 4.20                                    | 207                | -          | 94.6       | 15.2       | -             | 32                        | 99000                                   |
| 4.25                                    | 201                | -          | 93.8       | 13.8       | -             | 31                        | 97000                                   |
| 4.30                                    | 197                | -          | 92.8       | 12.7       | -             | 30                        | 94000                                   |
| 4.35                                    | 192                | -          | 91.9       | 11.5       | -             | 29                        | 92000                                   |
| 4.40                                    | 187                | -          | 90.7       | 10.0       | -             | -                         | 90000                                   |
| 4.45                                    | 183                | -          | 90.0       | 9.0        | -             | 28                        | 89000                                   |
| 4.50                                    | 179                | -          | 89.0       | 8.0        | -             | 27                        | 88000                                   |
| 4.55                                    | 174                | -          | 87.8       | 6.4        | -             | -                         | 86000                                   |
| 4.60                                    | 170                | -          | 86.8       | 5.4        | -             | 26                        | 84000                                   |
| 4.65                                    | 167                | -          | 86.0       | 4.4        | -             | -                         | 83000                                   |
| 4.70                                    | 163                | -          | 85.0       | 3.3        | -             | 25                        | 82000                                   |
| 4.80                                    | 156                | -          | 82.9       | 0.9        | -             | -                         | 80000                                   |
| 4.90                                    | 149                | -          | 80.8       | -          | -             | 23                        | -                                       |
| 5.00                                    | 143                | -          | 78.7       | -          | -             | 22                        | -                                       |
| 5.10                                    | 137                | -          | 76.4       | -          | -             | 21                        | -                                       |
| 5.20                                    | 131                | -          | 74.0       | -          | -             | -                         | -                                       |
| 5.30                                    | 126                | -          | 72.0       | -          | -             | 20                        | -                                       |
| 5.40                                    | 121                | -          | 69.8       | -          | -             | 19                        | -                                       |
| 5.50                                    | 116                | -          | 67.6       | -          | -             | 18                        | -                                       |
| 5.60                                    | 111                | -          | 65.7       | -          | -             | 15                        | -                                       |

| ROCKWELL         |            |               |               |            |            |            | BRINELL<br>500 kg. Load<br>10 mm.<br>Ball |
|------------------|------------|---------------|---------------|------------|------------|------------|-------------------------------------------|
| B Scale<br>Scale | F<br>Scale | 15-T<br>Scale | 30-T<br>Scale | E<br>Scale | H<br>Scale | A<br>Scale |                                           |
| 74               | 99.0       | -             | 66.0          | -          | -          | 46.0       | 118                                       |
| 72               | 98.0       | 84.0          | 65.0          | -          | -          | 45.0       | 114                                       |
| 70               | 97.0       | 83.5          | 63.5          | 99.5       | -          | 44.0       | 110                                       |
| 68               | 95.5       | -             | 62.0          | 98.0       | -          | 43.0       | 107                                       |
| 66               | 94.5       | 82.0          | 60.5          | 97.0       | -          | 42.0       | 104                                       |
| 64               | 93.5       | 81.5          | 59.5          | 95.5       | -          | 41.5       | 101                                       |
| 62               | 92.0       | -             | 58.0          | 94.5       | -          | 40.5       | 98                                        |
| 60               | 91.0       | -             | 56.5          | 93.0       | -          | 39.5       | 95                                        |
| 58               | 90.0       | 79.5          | 55.0          | 92.0       | -          | 38.5       | 92                                        |
| 56               | 89.0       | 79.0          | 54.0          | 90.5       | -          | -          | 90                                        |
| 54               | 87.5       | -             | 52.5          | 89.5       | -          | 37.0       | 87                                        |
| 52               | 86.5       | 77.5          | 51.0          | 88.0       | -          | 36.0       | 85                                        |
| 50               | 85.5       | 77.0          | 49.5          | 87.0       | -          | 35.0       | 83                                        |
| 48               | 84.5       | -             | 48.5          | 85.5       | -          | 34.5       | 81                                        |
| 46               | 83.0       | 75.5          | 47.0          | 84.5       | -          | 33.5       | -                                         |
| 44               | 82.0       | 75.0          | 45.5          | 83.5       | -          | 32.5       | 78                                        |
| 42               | 81.0       | -             | 44.0          | 82.0       | -          | 31.5       | 76                                        |
| 40               | 79.5       | 73.5          | 43.0          | 81.0       | -          | -          | -                                         |
| 38               | 78.5       | 73.0          | 41.5          | 79.5       | -          | 30.0       | 73                                        |
| 36               | 77.5       | -             | 40.0          | 78.5       | 100.0      | 29.0       | -                                         |
| 34               | 76.5       | 71.5          | 38.5          | 77.0       | 99.0       | 28.0       | 70                                        |
| 32               | 75.0       | 71.0          | 37.5          | 76.0       | 98.5       | 27.5       | -                                         |
| 30               | 74.0       | 70.5          | 36.0          | 75.0       | -          | 26.5       | 67                                        |
| 28               | 73.0       | -             | 34.5          | 73.5       | 97.0       | 25.5       | 66                                        |
| 26               | 72.0       | 69.0          | 33.0          | 72.5       | -          | 24.5       | 65                                        |
| 24               | 70.5       | 68.5          | 32.0          | 71.0       | 95.5       | 24.0       | -                                         |
| 22               | 69.5       | -             | 30.5          | 70.0       | 95.0       | 23.0       | -                                         |
| 20               | 68.5       | -             | 29.0          | 68.5       | -          | 22.0       | -                                         |
| 18               | 67.0       | 66.5          | 27.5          | 67.5       | 93.5       | -          | -                                         |
| 16               | 66.0       | 66.0          | 26.0          | 66.5       | -          | 20.5       | -                                         |
| 14               | 65.0       | -             | 25.0          | 65.0       | 92.0       | -          | -                                         |
| 12               | 64.0       | 64.5          | 23.5          | 64.0       | 91.5       | -          | -                                         |
| 10               | 63.0       | 64.0          | 22.0          | 62.5       | 90.5       | -          | 57                                        |
| 8                | 61.5       | 63.5          | 20.5          | 61.5       | 90.0       | -          | -                                         |
| 6                | 60.5       | -             | 19.5          | 60.5       | -          | -          | -                                         |
| 4                | 59.5       | 62.0          | 18.0          | 59.0       | 88.5       | -          | -                                         |
| 2                | 58.0       | 61.5          | 16.5          | 58.0       | -          | -          | 54                                        |
| 0                | 57.0       | -             | 15.0          | 57.0       | 87.0       | -          | 53                                        |

## ROCKWELL HARDNESS SCALES

| Scale | Major<br>Load,<br>Kg. | Indenter     | Use of Scale                                                                                     |
|-------|-----------------------|--------------|--------------------------------------------------------------------------------------------------|
| A     | 60                    | Diamond cone | Extremely hard material such as tungsten carbide or hard sheet material too thin for heavy load. |
| B     | 100                   | 1/16" ball   | Materials of B 0 to B 100 hardness.                                                              |
| C     | 150                   | Diamond cone | Materials of C 20 to C 70 hardness.                                                              |
| E     | 100                   | 1/8" ball    | Very soft materials such as bearing metals.                                                      |
| F     | 60                    | 1/16" ball   | Very soft materials such as bearing metals.                                                      |
| H     | 60                    | 1/8" ball    | Very soft materials such as bearing metals.                                                      |

## ROCKWELL SUPERFICIAL HARDNESS SCALES

|      |    |              |                                                   |
|------|----|--------------|---------------------------------------------------|
| 15-N | 15 | Diamond cone | Materials comparable in hardness of C 20 to C 70. |
| 15-T | 15 | 1/16" ball   | Materials comparable in hardness of B 0 to B 100. |
| 30-T | 30 | 1/16" ball   | Materials comparable in hardness of B 0 to B 100. |

**Table 7. Sheet Gauges**

| Gauge No. | STEEL SHEETS                |                     | GALVANIZED SHEETS           |                     | STAINLESS STEEL SHEETS         |                              |                             | ALUMINUM SHEETS                |                     |
|-----------|-----------------------------|---------------------|-----------------------------|---------------------|--------------------------------|------------------------------|-----------------------------|--------------------------------|---------------------|
|           | Weight Lbs. Per Square Foot | Thickness in Inches | Weight Lbs. per Square Foot | Thickness in Inches | Wt., Lbs. per Sq. Ft.          |                              | Approx. Thickness in lathes | Weight Lbs. per Sq. Ft. (1100) | Thickness in Inches |
|           |                             |                     |                             |                     | Straight Chromium (400 Series) | Chromium Nickel (300 Series) |                             |                                |                     |
| 38        | .25000                      | .0060               |                             |                     |                                |                              |                             | .0558                          | .0039               |
| 37        | .26562                      | .0064               |                             |                     |                                |                              |                             | .0627                          | .0044               |
| 36        | .28125                      | .0067               |                             |                     |                                |                              |                             | .0705                          | .00500              |
| 35        | .31250                      | .0075               |                             |                     |                                |                              |                             | .0791                          | .0056               |
| 34        | .34375                      | .0082               |                             |                     |                                |                              |                             | .0888                          | .00630              |
| 33        | .37500                      | .0090               |                             |                     |                                |                              |                             | .0998                          | .00701              |
| 32        | .40625                      | .0097               | .56250                      | .0134               | .3708                          | .3780                        | .010                        | .1121                          | .00795              |
| 31        | .43750                      | .0105               | .59375                      | .0142               | .4506                          | .4594                        | .011                        | .1259                          | .00893              |
| 30        | .50000                      | .0120               | .65625                      | .0157               | .5150                          | .5250                        | .013                        | .1410                          | .0100               |
| 29        | .56250                      | .0135               | .71875                      | .0172               | .5794                          | .5906                        | .014                        | .1593                          | .0113               |
| 28        | .62500                      | .0149               | .78125                      | .0187               | .6438                          | .6562                        | .016                        | .1777                          | .0126               |
| 27        | .68750                      | .0164               | .84375                      | .0202               | .7081                          | .7218                        | .017                        | .2002                          | .0142               |
| 26        | .75000                      | .0179               | .90625                      | .0217               | .7725                          | .7875                        | .019                        | .2242                          | .0159               |
| 25        | .87500                      | .0209               | 1.03125                     | .0247               | .9013                          | .9187                        | .022                        | .2524                          | .0179               |
| 24        | 1.0000                      | .0239               | 1.15625                     | .0276               | 1.0300                         | 1.0500                       | .025                        | .2834                          | .0201               |
| 23        | 1.1250                      | .0269               | 1.28125                     | .0306               | 1.1587                         | 1.1813                       | .028                        | .3187                          | .0226               |
| 22        | 1.2500                      | .0299               | 1.40625                     | .0336               | 1.2875                         | 1.3125                       | .031                        | .3567                          | .0253               |
| 21        | 1.3750                      | .0329               | 1.53125                     | .0366               | 1.4160                         | 1.4437                       | .034                        | .4019                          | .0285               |
| 20        | 1.5000                      | .0359               | 1.65625                     | .0396               | 1.5450                         | 1.5750                       | .038                        | .4512                          | .0320               |
| 19        | 1.7500                      | .0418               | 1.90625                     | .0456               | 1.8025                         | 1.8375                       | .044                        | .5062                          | .0359               |
| 18        | 2.0000                      | .0478               | 2.15625                     | .0516               | 2.0600                         | 2.1000                       | .050                        | .5682                          | .0403               |
| 17        | 2.2500                      | .0538               | 2.40625                     | .0575               | 2.3175                         | 2.3625                       | .056                        | .6387                          | .0453               |
| 16        | 2.5000                      | .0598               | 2.65625                     | .0635               | 2.5750                         | 2.6250                       | .063                        | .7163                          | .0508               |
| 15        | 2.8125                      | .0673               | 2.96875                     | .0710               | 2.8968                         | 2.9531                       | .070                        | .8051                          | .0571               |
| 14        | 3.1250                      | .0747               | 3.28125                     | .0785               | 3.2187                         | 3.2812                       | .078                        | .9038                          | .0641               |
| 13        | 3.7500                      | .0897               | 3.90625                     | .0934               | 3.8625                         | 3.9375                       | .094                        | 1.015                          | .0720               |
| 12        | 4.3750                      | .1046               | 4.53125                     | .1084               | 4.5063                         | 4.5937                       | .109                        | 1.139                          | .0808               |
| 11        | 5.0000                      | .1196               | 5.15625                     | .1233               | 5.1500                         | 5.2500                       | .125                        | 1.279                          | .0907               |
| 10        | 5.6250                      | .1345               | 5.78125                     | .1382               | 5.7937                         | 5.9062                       | .141                        | 1.437                          | .1019               |
| 9         | 6.2500                      | .1495               | 6.40625                     | .1532               | 6.4375                         | 6.5625                       | .156                        | 1.613                          | .1144               |
| 8         | 6.8750                      | .1644               | 7.03125                     | .1681               | 7.0813                         | 7.2187                       | .172                        | 1.812                          | .1285               |
| 7         | 7.5000                      | .1793               |                             |                     |                                |                              |                             | 2.035                          | .1443               |
| 6         | 8.1250                      | .1943               |                             |                     |                                |                              |                             | 2.284                          | .1620               |
| 5         | 8.7500                      | .2092               |                             |                     |                                |                              |                             | 2.565                          | .1819               |
| 4         | 9.3750                      | .2242               |                             |                     |                                |                              |                             | 2.881                          | .2043               |
| 3         | 10.000                      | .2391               |                             |                     |                                |                              |                             | 3.235                          | .2294               |

**Table 8. Millimeters Converted to Decimal and Fractional Inches**

| Milli-<br>meters | Fractional<br>Decimal<br>Inches | Inches<br>(to nearest<br>64th) | Milli-<br>Meters | Fractional<br>Decimal.<br>Inches | Inches<br>(to nearest<br>64th) | Milli-<br>meters | Fractional<br>Decimal<br>Inches | Inches<br>(to nearest<br>64th) |
|------------------|---------------------------------|--------------------------------|------------------|----------------------------------|--------------------------------|------------------|---------------------------------|--------------------------------|
| 1                | .0394                           | 3/64                           | 34               | 1.339                            | 1 11/32                        | 67               | 2.638                           | 2 41/64                        |
| 2                | .0787                           | 5/64                           | 35               | 1.378                            | 1 3/8                          | 68               | 2.677                           | 2 43/64                        |
| 3                | .1181                           | 1/6                            | 36               | 1.417                            | 1 27/64                        | 69               | 2.717                           | 2 23/32                        |
| 4                | .1575                           | 5/32                           | 37               | 1.457                            | 1 29/64                        | 70               | 2.756                           | 2 3/4                          |
| 5                | .1969                           | 13/64                          | 38               | 1.496                            | 1 1/2                          | 71               | 2.795                           | 2 51/64                        |
| 6                | .2362                           | 15/64                          | 39               | 1.535                            | 1 17/32                        | 72               | 2.835                           | 2 53/64                        |
| 7                | .2756                           | 9/32                           | 40               | 1.575                            | 1 37/64                        | 73               | 2.874                           | 2 7/8                          |
| 8                | .3150                           | 5/16                           | 41               | 1.614                            | 1 39/64                        | 74               | 2.913                           | 2 29/32                        |
| 9                | .3543                           | 23/64                          | 42               | 1.654                            | 1 21/32                        | 75               | 2.953                           | 2 61/64                        |
| 10               | .3937                           | 26/64                          | 43               | 1.693                            | 1 11/16                        | 76               | 2.992                           | 2 63/64                        |
| 11               | .4331                           | 7/16                           | 44               | 1.732                            | 1 47/64                        | 77               | 3.031                           | 3 1/32                         |
| 12               | .4724                           | 15/32                          | 45               | 1.772                            | 1 49/64                        | 78               | 3.071                           | 3 5/64                         |
| 13               | .5118                           | 33/64                          | 46               | 1.811                            | 1 13/16                        | 79               | 3.110                           | 3 7/64                         |
| 14               | .5512                           | 35/64                          | 47               | 1.850                            | 1 27/32                        | 80               | 3.150                           | 3 5/32                         |
| 15               | .5906                           | 19/32                          | 48               | 1.890                            | 1 57/64                        | 81               | 3.189                           | 3 3/16                         |
| 16               | .6299                           | 5/8                            | 49               | 1.929                            | 1 59/64                        | 82               | 3.228                           | 3 15/64                        |
| 17               | .6693                           | 43/64                          | 50               | 1.969                            | 1 31/32                        | 83               | 3.268                           | 3 17/64                        |
| 18               | .7087                           | 45/64                          | 51               | 2.008                            | 2 1/64                         | 84               | 3.307                           | 3 5/16                         |
| 19               | .7480                           | 3/4                            | 52               | 2.047                            | 2 3/64                         | 85               | 3.346                           | 3 11/32                        |
| 20               | .7874                           | 25/32                          | 53               | 2.087                            | 2 3/32                         | 86               | 3.386                           | 3 25/64                        |
| 21               | .8268                           | 53/64                          | 54               | 2.126                            | 2 1/8                          | 87               | 3.425                           | 3 27/64                        |
| 22               | .8661                           | 55/64                          | 55               | 2.165                            | 2 11/64                        | 88               | 3.465                           | 3 15/32                        |
| 23               | .9055                           | 29/32                          | 56               | 2.205                            | 2 13/64                        | 89               | 3.504                           | 3 1/2                          |
| 24               | .9449                           | 15/16                          | 57               | 2.244                            | 2 1/4                          | 90               | 3.543                           | 3 35/64                        |
| 25               | .9843                           | 63/64                          | 58               | 2.283                            | 2 9/32                         | 91               | 3.583                           | 3 37/64                        |
| 26               | 1.024                           | 1 1/32                         | 59               | 2.323                            | 2 21/64                        | 92               | 3.622                           | 3 5/8                          |
| 27               | 1.063                           | 1 1/16                         | 60               | 2.362                            | 2 23/64                        | 93               | 3.661                           | 3 21/32                        |
| 28               | 1.102                           | 1 7/64                         | 61               | 2.402                            | 2 13/32                        | 94               | 3.701                           | 3 45/64                        |
| 29               | 1.142                           | 1 9/64                         | 62               | 2.441                            | 2 7/16                         | 95               | 3.740                           | 3 47/64                        |
| 30               | 1.181                           | 1 3/16                         | 63               | 2.480                            | 2 31/64                        | 96               | 3.780                           | 3 25/32                        |
| 31               | 1.220                           | 1 7/32                         | 64               | 2.520                            | 2 33/64                        | 97               | 3.819                           | 3 13/16                        |
| 32               | 1.260                           | 1 17/64                        | 65               | 2.559                            | 2 9/16                         | 98               | 3.858                           | 3 55/64                        |
| 33               | 1.299                           | 1 19/64                        | 66               | 2.598                            | 2 19/32                        | 99               | 3.898                           | 3 57/64                        |
|                  |                                 |                                |                  |                                  |                                | 100              | 3.937                           | 3 15/16                        |

**Table 9. Conversion Factors**

|                           |                                           |                                                 |
|---------------------------|-------------------------------------------|-------------------------------------------------|
| Acceleration              | 1 m/s <sup>2</sup>                        | = 4.252 x 10 <sup>7</sup> ft/h <sup>2</sup>     |
| Area                      | 1 m <sup>2</sup>                          | = 1550.0 in <sup>2</sup>                        |
|                           |                                           | = 10.764 ft <sup>2</sup>                        |
| Degree (angle)            | 1 radian                                  | = 57.471 degree                                 |
| Energy                    | 1 J                                       | = 9.4787 x 10 <sup>-4</sup> Btu                 |
|                           | 1 kcal                                    | = 3.968 Btu                                     |
| Force                     | 1 N                                       | = .22481 lbf                                    |
| Heat Flux                 | 1 W/m <sup>2</sup>                        | = .3171 Btu/h•ft <sup>2</sup>                   |
| Heat Transfer Coefficient | 1 W/m <sup>2</sup> •K                     | = 0.17612 Btu/h•ft <sup>2</sup> •°F             |
| Heat Transfer Rate        | 1 W                                       | = 3.4123 Btu/h                                  |
| Length                    | 1 m                                       | = 39.370 in                                     |
|                           |                                           | = 3.2808 ft                                     |
| Mass                      | 1 kg                                      | = 2.2046 lbm                                    |
|                           | 1 lbm                                     | = 16 oz                                         |
| Mass Density              | 1 kg/m <sup>3</sup>                       | = .062428 lbm/ft <sup>3</sup>                   |
| Pressure and Stress       | 1 N/m <sup>2</sup>                        | = .020886 lbf/ft <sup>2</sup>                   |
|                           |                                           | = 1.4504 x 10 <sup>-4</sup> lbf/in <sup>2</sup> |
|                           |                                           | = 4.015 x 10 <sup>-3</sup> inH <sub>2</sub> O   |
|                           |                                           | = 2.953 x 10 <sup>-4</sup> inHg                 |
|                           |                                           | = 1 standard atmosphere                         |
| Temperature               | 1.1033 x 10 <sup>5</sup> N/m <sup>2</sup> | = 1 bar                                         |
|                           | 1 x 10 <sup>5</sup> N/m <sup>2</sup>      | = 1 °R                                          |
|                           | 1 K                                       | = (5/9) °F                                      |
|                           |                                           | = (5/9)(°F + 459.67)                            |
|                           |                                           | = °C + 273.15                                   |
| Temperature Difference    | 1 K                                       | = 1 °C                                          |
|                           |                                           | = (9/5) °R = (9/5) °F                           |
| Thermal Conductivity      | 1 W/m•K                                   | = .57782 Btu/h•ft•°F                            |
| Thermal Resistance        | 1 K/W                                     | = .52750 °F/h•Btu                               |
| Volume                    | 1 m <sup>3</sup>                          | = 6.1023 x 10 <sup>4</sup> in <sup>3</sup>      |
|                           |                                           | = 35.314 ft <sup>3</sup>                        |
|                           |                                           | = 264.17 gal                                    |
| Volume Flow Rate          | 1 m <sup>3</sup> /s                       | = 1.2713 x 10 <sup>5</sup> ft <sup>3</sup> /h   |
|                           |                                           | = 2.1189 x 10 <sup>3</sup> ft <sup>3</sup> /min |
|                           |                                           | = 1.5850 x 10 <sup>4</sup> gal/min              |

| <b>DSCC Specification</b> | <b>Calmark Series</b>                             |
|---------------------------|---------------------------------------------------|
| 83023                     | Series 103, 104, 105 and 107 (plastic)            |
| 84103                     | Series 225, 230, 240                              |
| 84191                     | Series 109                                        |
| 85034                     | Series 125/126, 165/166, NW125/NW126, NW165/NW166 |
| 89024                     | Series 260                                        |
| 89064                     | Series 226, 231                                   |
| AA59590/18                | Series 245                                        |
| AA59590/1                 | Series L225                                       |
| AA59590/2                 | Series E225                                       |
| AA59590/3                 | Series V225                                       |
| AA59590/4                 | Series 225                                        |
| AA59590/5                 | Series 225                                        |
| AA59590/6                 | Series V225                                       |
| AA59590/7                 | Series 230                                        |
| AA59590/10                | Series V230                                       |
| AA59590/11                | Series V240                                       |
| AA59590/12                | Series 240                                        |
| AA59590/13                | Series 250                                        |
| AA59590/14                | Series V250                                       |
| AA59590/15                | Series 250                                        |
| AA59590/16                | Series V250                                       |
| AA59590/17                | Series 245                                        |
| AA59590/18                | Series V245                                       |
| AA59590/19                | Series 245                                        |
| AA59590/20                | Series V245                                       |
| AA59590/21                | Series 255                                        |
| AA59590/22                | Series V255                                       |
| AA59590/23                | Series 255                                        |
| AA59590/24                | Series V255                                       |
| AA59590/25                | Series VE225                                      |
| AA59789/1                 | Series 226                                        |
| AA59789/2                 | Series V226                                       |
| AA59789/3                 | Series 231                                        |
| AA59789/4                 | Series V231                                       |
| AA59789/5                 | Series L260                                       |
| AA59789/6                 | Series LE260                                      |
| AA59789/7                 | Series 267                                        |
| AA59789/8                 | Series V267                                       |
| AA59789/9                 | Series 265                                        |
| AA59789/10                | Series V265                                       |



**Beryllium Copper** - A metal alloy consisting principally of copper with a small amount of Beryllium (usually 1%-2%)

**Board Module Assembly** - A mechanical structure that supports a plug-in unit, like a power supply, radio or CCA, etc.

**Board Mount** - Where the device is mounted onto the PC board

**Card-Lok** - PC board retainer using wedge configuration to provide a locking force

**Card Retainer** - A device that securely holds a PCB or Board Module Assembly in a chassis

**CCA** - A Conduction Cooled Assembly consisting of a conduction frame, extractors, wedge clamps and backing plate or strip that is mounted to a Plug-In Unit for structural and thermal performance enhancement

**Chassis Mount** - Where the device is mounted directly onto the chassis or cold wall

**Cold Wall or Cold Plate** - The portion of the chassis that sinks heat away from the card to the environment

**Conduction** - A mode of heat transfer in a stationary medium

**Contact Intimacy** - Direct PCB or Board Module Assembly contact with the cold wall for maximum heat dissipation

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**Datum** - The starting point (zero) for dimensioning a part

**Extractor** - Hardware used to disengage PCB or Board Module Assembly from backplate interconnects

**Insertor** - Hardware to assist insertion of PC board into backplane interconnects

**Lever Actuated** - A means to activate a Card-Lok without tools required

**Normal Force** - Force acting perpendicular to the long axis of a PCB retainer such as a Wedge-Lok™

**Plug-in Unit** - A generic description of an assembly usually consisting of a PCB with connectors and may optionally have extractors and covers

**PCB** - Printed Circuit Board

**PC** - Printed Circuit

**Retention Force** - The force required to move a locked PC board that is not connected to a backplane; unit: lbs. or oz.

**Shock** - A violent impact

**Thermal Grease** - A compound that reduces thermal resistance at interfaces

**Thermal Resistance** - Resistance to the flow of heat usually measured as a temperature drop across an interface; units: °C per Watt per inch

**Thermal Transfer** - The passage of heat from PC board to chassis or heat sink

**Thermocouple** - A sensor that measures temperature

**Torque** - A measure of rotational force; Units: Newton-meters, Newton-centimeters, inch-lbs or inch-oz.

**Vibration** - Quick motion to and fro; oscillatory

**Zero Entry Force** - No force is required to insert or extract a board into or out of a card guide or channel









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Вы можете разместить у нас заказ для любого Вашего проекта, будь то серийное производство или разработка единичного прибора.

В нашем ассортименте представлены ведущие мировые производители активных и пассивных электронных компонентов.

Нашей специализацией является поставка электронной компонентной базы двойного назначения, продукции таких производителей как XILINX, Intel (ex.ALTERA), Vicor, Microchip, Texas Instruments, Analog Devices, Mini-Circuits, Amphenol, Glenair.

Сотрудничество с глобальными дистрибьюторами электронных компонентов, предоставляет возможность заказывать и получать с международных складов практически любой перечень компонентов в оптимальные для Вас сроки.

На всех этапах разработки и производства наши партнеры могут получить квалифицированную поддержку опытных инженеров.

Система менеджмента качества компании отвечает требованиям в соответствии с ГОСТ Р ИСО 9001, ГОСТ РВ 0015-002 и ЭС РД 009

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