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Monogram Aerospace Fasteners
3423 South Garfield Avenue
Los Angeles, California 90040

ENGINEERING
STANDARD

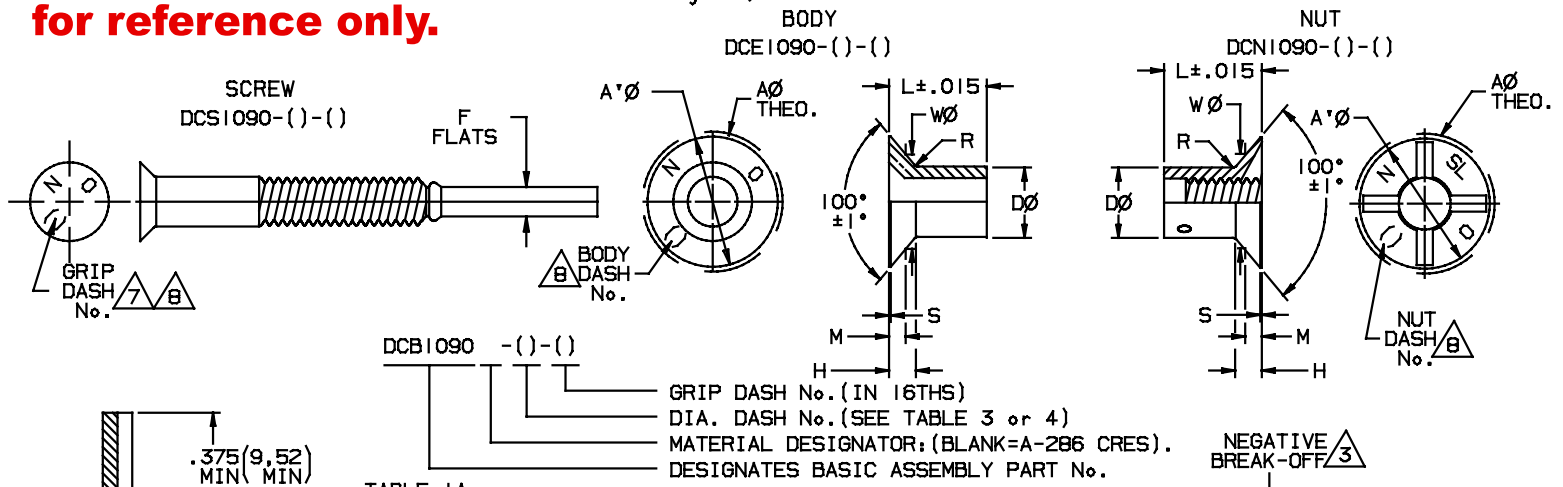


TABLE 1A.

ASSEMBLY	COMPONENTS		
	SCREW	BODY	NUT
DCB1090-()-()-()	DCS1090-()-()-()	DCE1090-()-()-()	DCN1090-()-()-()

TABLE 1B.

SUB-ASSEMBLY	COMPONENTS		
	SCREW	BODY	NUT
DCB1094-()-()-()	DCS1090-()-()-()	DCE1090-()-()-()	—
DCB1095-()-()-()	—	—	DCN1090-()-()-()

TABLE 2.

COMPONENTS	MATERIAL AND STRENGTH LEVEL	FINISH	LUBRICATION Δ
SCREW DCS1090-()-()-()	A-286 CRES PER AMS 5732 STRENGTH: AS REQ'D FOR PERFORMANCE	PASSIVATE PER QQ-P-35	DRY FILM LUBE PER MIL-L-46010, PARAFIN WAX, AND/OR CETYL ALCOHOL PER MIL-L-87132 AS REQ'D FOR PERFORMANCE.
BODY DCE1090-()-()-()			
NUT DCN1090-()-()-()			

TABLE 3. (DIMENSIONS IN INCHES)

DIA DASH No.	NOM. SIZE	AØ THEO.	A*Ø MIN	DØ	F FLATS	H REF	M GAGE PROT.	R rad.	S MAX	WØ GAGE DIA	BREAK-OFF LIMITS	PREVAILING TORQUE MIN. (in-lb)	DOUBLE SHEAR STRENGTH MIN. (lb)	TENSILE STRENGTH MIN. (lb)	CLAMP-UP PRELOAD MIN. (lb)	SHORTEST AVAILABLE GRIP DASH No.
-06	.1980	.385 .378	.342	.1990 .1970	.086 .081	.077	.0299 .0259	.030 .015	.015	.3147 .3143	+0.015 -.073	1.5	5240	1400	280	-10
-08	.2590	.507 .499	.463	.2600 .2580	.104 .099	.102	.0353 .0307	.030 .015	.015	.4245 .4241	+0.010 -.078	2.5	9000	2100	420	-10
-10	.3105	.635 .626	.577	.3115 .3095	.135 .130	.134	.0409 .0357	.040 .020	.020	.5389 .5385	+0.010 -.083	3.5	12000	3600	720	-14
-12	.3735	.762 .752	.696	.3745 .3725	.152 .147	.160	.0466 .0407	.040 .020	.023	.6532 .6528	+0.010 -.093	4.0	19500	5600	1120	-16

TABLE 4. (DIMENSIONS IN MILLIMETERS)

DIA DASH No.	NOM. SIZE	AØ THEO.	A*Ø MIN	DØ DIA.	F FLATS	H REF	M GAGE PROT.	R rad.	S MAX	WØ GAGE DIA	BREAK-OFF LIMITS	PREVAILING TORQUE MIN. (N-m)	DOUBLE SHEAR STRENGTH MIN. (N)	TENSILE STRENGTH MIN. (N)	CLAMP-UP PRELOAD MIN. (N)	SHORTEST AVAILABLE GRIP DASH No.
-06	4,8	9,78 9,60	8,69	5,055 5,004	2,18 2,06	1,95	0,759 0,658	0,76 0,38	0,38	7,993 7,983	+0,38 -1,85	0,170	23300	6200	1240	-10
-08	6,4	12,88 12,67	11,76	6,604 6,553	2,64 2,51	2,59	0,897 0,780	0,76 0,38	0,38	10,782 10,772	+0,25 -1,98	0,282	40000	9300	1870	-10
-10	8,0	16,13 15,90	14,66	7,912 7,861	3,43 3,30	3,40	1,039 0,907	1,02 0,51	0,51	13,688 13,678	+0,25 -2,11	0,395	53300	16000	3200	-14
-12	9,5	19,35 19,10	17,68	9,512 9,462	3,86 3,73	4,06	1,184 1,034	1,02 0,51	0,58	16,591 16,581	+0,25 -2,36	0,452	86700	24900	5000	-16

Monogram

CODE IDENT. NO.
98524

US PATENT No. 3643544. OTHER PATENTS PENDING

TITLE

BOLT, DOUBLE FLUSH, INTERNALLY THREADED, SELF-LOCKING
100° FLUSH HEAD PIN INSTALLED WITH 100° FLUSH NUT
A-286 CRES

(CONSTANT BODY & NUT LENGTH WITHIN A GRIP)

A DWG: DCB1090, DCB1094,
DCB1095

DCB1090-()-()-() DCB1094-()-()-()
DCS1090-()-()-() DCB1095-()-()-()
DCE1090-()-()-()
DCN1090-()-()-() SHEET 1 OF 2

APPROVED DATE
05-16-85 ECN #4139

REVISION LETTER & DATE
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TABLE 5.

GRIP DASH No.	GRIP RANGE (in)		L ± .015 (in)
	MIN.	MAX.	
-10	.595	.656	.281
-11	.657	.719	.312
-12	.720	.781	.344
-13	.782	.844	.375
-14	.845	.906	.406
-15	.907	.969	.437
-16	.970	1.031	.469
-17	1.032	1.094	.500
-18	1.095	1.156	.531
-19	1.157	1.218	.562
-20	1.219	1.281	.594
-21	1.282	1.344	.625
-22	1.345	1.406	.656
-23	1.407	1.469	.687
-24	1.470	1.531	.718
-25	1.532	1.594	.750
-26	1.595	1.656	.781
-27	1.657	1.719	.812
-28	1.720	1.781	.844
-29	1.782	1.844	.875
-30	1.845	1.906	.906
-31	1.907	1.969	.937
-32	1.970	2.031	.968
-33	2.032	2.094	1.000
-34	2.095	2.156	1.031
-35	2.157	2.219	1.062
-36	2.220	2.281	1.094
-37	2.282	2.344	1.125
-38	2.345	2.406	1.156
-39	2.407	2.469	1.187
-40	2.470	2.531	1.218

TABLE 6.

GRIP DASH No.	GRIP RANGE (mm)		L ± 0,38 (mm)
	MIN.	MAX.	
-10	15,11	16,66	7,14
-11	16,69	18,26	7,92
-12	18,29	19,84	8,74
-13	19,86	21,44	9,52
-14	21,46	23,01	10,31
-15	23,04	24,61	11,10
-16	24,64	26,19	11,91
-17	26,21	27,79	12,70
-18	27,81	29,36	13,49
-19	29,39	30,94	14,27
-20	30,96	32,54	15,09
-21	32,56	34,14	15,88
-22	34,16	35,71	16,66
-23	35,74	37,31	17,45
-24	37,34	38,89	18,24
-25	38,91	40,49	19,05
-26	40,51	42,06	19,84
-27	42,09	43,66	20,62
-28	43,69	45,24	21,44
-29	45,26	46,84	22,22
-30	46,86	48,41	23,01
-31	48,44	50,01	23,80
-32	50,04	51,59	24,59
-33	51,61	53,19	25,40
-34	53,21	54,76	26,19
-35	54,79	56,36	26,97
-36	56,39	57,94	27,79
-37	57,96	59,54	28,58
-38	59,56	61,11	29,36
-39	61,14	62,71	30,15
-40	62,74	64,29	30,94

TABLE 7. (INSTALLATION TOOLS)

DIA DASH No.	PNEUMATIC PISTOL	NOSE ADAPTER	WRENCH ADAPTER
-06	MP550BF	MPF-06	MP-05
-08		MPF-08	MP-06
-10		MPF-10	MP-08
-12		MPTFBF-12	MPTBF-10

NOTES:

1. PROCUREMENT SPECIFICATION: DCB1000.
2. DIMENSIONS EXCLUSIVE OF LUBRICATION. LUBRICATION IS OPTIONAL ON ALL COMPONENTS.
3. BREAK-OFF LIMITS MEASURED FROM TOP SURFACE OF THE NUT.
4. LOCKING FEATURE CONSISTS OF THREE INDENTATIONS 120° APART. DISTORTION OF THE NUT DIAMETER IN THE AREA OF LOCKING FEATURE IS PERMISSIBLE. LOCKING FEATURE SHALL BE LOCATED SUCH THAT THE NUT WILL THREAD ONTO SCREW BY HAND UNTIL PINTAIL OF SCREW PROTRUDES .375"(9,52) MIN. ABOVE THE NUT HEAD BEFORE OCCURANCE OF THE PREVAILING LOCKING TORQUE.
5. TEMPERATURE LIMITATIONS: 1200 °F MAX.
6. SCREW IS ADAPTED TO ROTATE IN THE BODY AND THE NUT DURING INSTALLATION.
7. HEAD MARKINGS DEPRESSED .010"(3,25) MAX. ARRANGEMENT OPTIONAL.
8. "BODY DASH No." AND "NUT DASH No." ARE THE SAME AS "GRIP DASH No." FOR "CONSTANT BODY & NUT LENGTH WITHIN A GRIP" APPLICATION.

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A DWG: DCB1090, DCB1094,
DCB1095
DCB1090-{}-{} DCB1094-{}-{}
DCS1090-{}-{} DCB1095-{}-{}
DCE1090-{}-{}
DCN1090-{}-{} SHEET 2 OF 2