

Patent no. 7,883,289



SERIES 224 TORQUE-LIMITING CARD LOK

RECOMMENDED GAP WIDTH

PCB + 8.00 (.315)

WEIGHT

1.12 g/cm (.10 oz/in)

MATERIALS AND FINISH

WEDGES

Material: Aluminum Alloy 6061-T6 per ASTM-B221 or AMS-QQ-A-200/8
Finish: See finish table on opposite page

TORQUE LIMITING MECHANISM

Material: Stainless Steel 17-4 PH
Finish: Dry Film Lube per Mil-L-46010 Type 1

SCREW

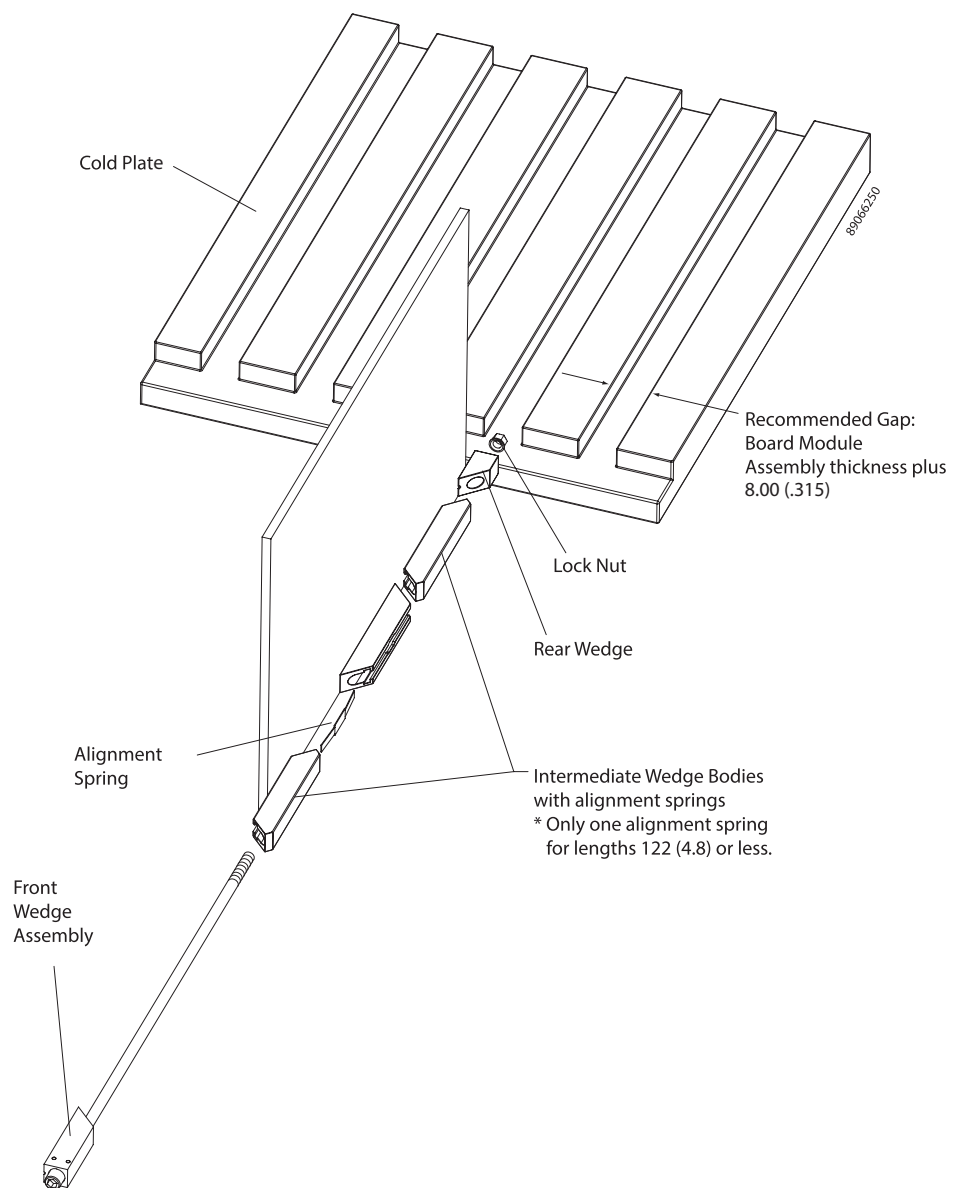
.09-in. or 2.5-mm hex. socket head cap screw, depending on mounting configuration
Material: Stainless steel per ASTM A-582
Finish: Passivated per AMS2700

LOCK NUT

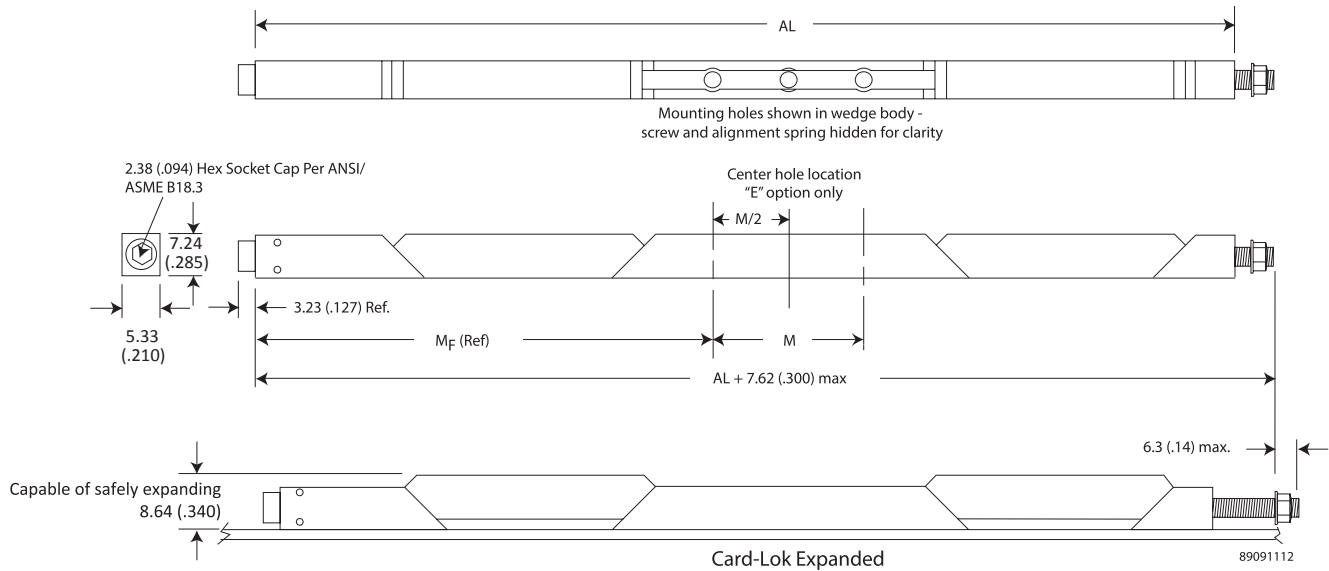
Material: Stainless steel per MS21043-04
Finish: Silver plate per AMS 2410

ALIGNMENT SPRINGS

Material: 301 stainless steel half hard per AMS 5518
Finish: Passivated per AMS2700



SERIES 224 CARD LOK



AL range ± 1.3 (.050)	M ± .13 (.005)	M _F ± .76 (.030)
From 97 (3.8) - 185 (7.3)	22.86 (.90)	AL+12.5 (.500)-M 2
From 198 (7.8) - 211 (8.3)	48.26 (1.90)	
From 224 (8.8) - 325 (12.8)	73.66 (2.90)	

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 224 TL Card-Lok Five Piece

Metric Screw Head M2.5 Hex Drive **M**
 Standard Screw Head 3/32 Hex Drive **[blank]**

Black Anodize **A**
 or choose from Finish Table **see table**

Min length = 97 (3.8), Max length = 325 (12.8), in 13 (0.5) increments **length.xx**

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

Mounting options
 2-56 tapped mounting hole or choose from Mounting Method Table **T2**

M A 224 - 4.80 E T2

Part Number Code Example:

A224- 4.80T2
 Series 224 Card-Lok 121.9 (4.8) long assembly length, black anodized with two 2-56 threaded mounting holes

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
[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

