

QUICK OPERATING 1/4-TURN FASTENERS

91F SERIES

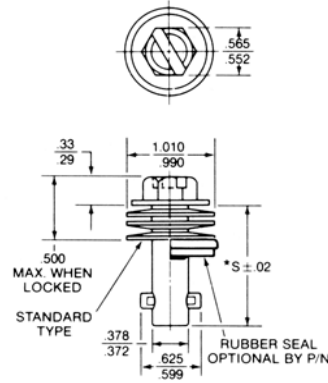
Extra Heavy-Duty Stud Assemblies and Receptacles

Features: Designed for heavy duty service in farm, construction equipment and other applications where high strength and clamping force are required.

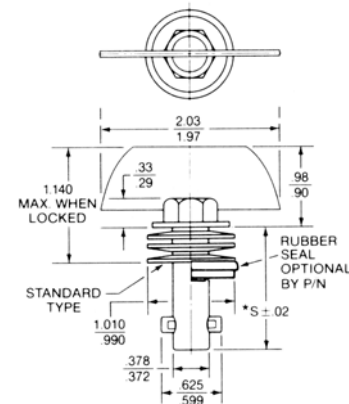
Stud Assemblies

Note: Part numbers shown are basic part numbers only. See ordering information for required dash numbers.

Minimum Preload - 120 LBS



Slotted-Hex Head



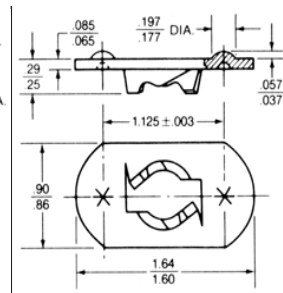
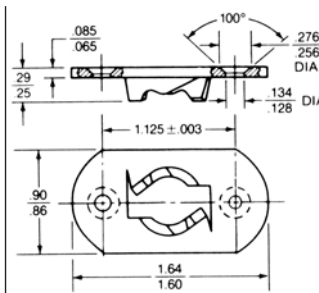
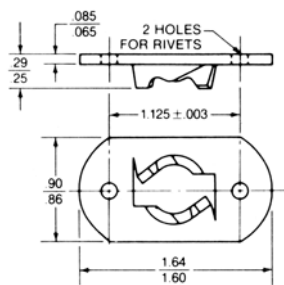
Slotted-Hex Head

Material	Standard Part No.	Self-sealing Part No.	Standard Part No.	Self-sealing Part No.
Steel (Cadmium Plated)	91S2-[]	91S7-[]	91S2-[] JW	91S7-[] JW

*Maximum Service Temperature: Self-Sealing parts have rubber seal and temperature limitation of 225°F
Standard: 450°F; Plastic Knob Version: 140°F.*

$*S = .64 + (.03 \times \text{Dash No.})$

Receptacles



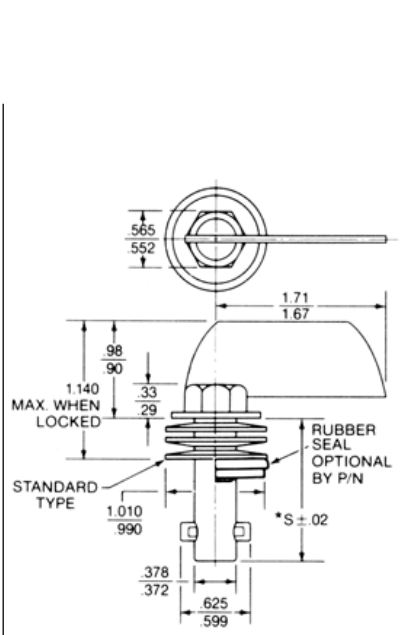
For use with dimpled panels For Spot Weld Attachment

Material	Part No.	Rivet Holes	Rivet Hole Dia.	Part No.	Rivet Holes	Part No.
Steel (Cadmium Plated)	119-18	Plain (for 1/8" rivets)	.134 .128	119-18D	C'Sunk (for 1/8" rivets)	-
	119-18A	Plain (for 5/32" rivets)	.165 .159	-	-	-
Steel (Oil Coated)	-	-	-	-	-	119-18C

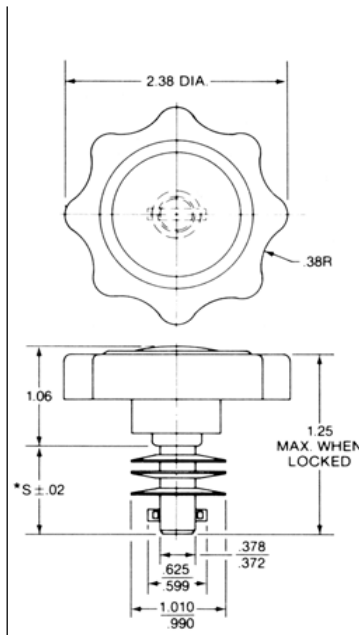
Maximum Service Temperature: 450°F.

QUICK OPERATING 1/4-TURN FASTENERS

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Offset Fixed Wing

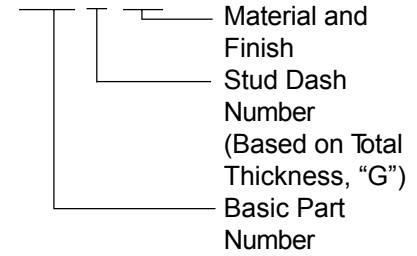


Plastic Knob

Specifications:

Ultimate Tensile Strength: 1800 lbs.
 Working Strength: 1200 lbs.
 Stud Grip Increments: .030 inches.

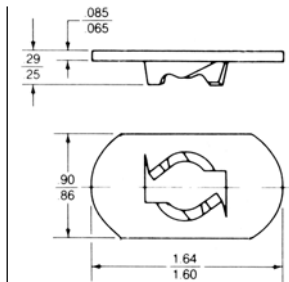
Stud Part Number Structure



A

Standard Part No.	Self-sealing Part No.	Part No.
91S2-[]WO	91S7-[]WO	91S48-[]-1AA

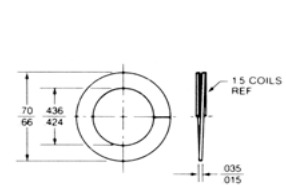
See Stud Dash Number Selection Table on the following page.



For Weld Attachment

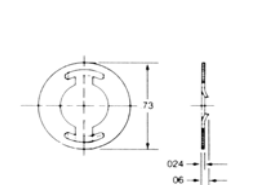
Part No.
-
-
119-18L

Retaining Rings



Spiral Type

Weight per 100 pcs.: 0.24 lbs.



Snap-on Type

Weight per 100 pcs.: 0.15 lbs.

Material	Part No.	Max. Temp.	Part No.	Max. Temp.
Stainless Steel	91S3-1	550°F.	—	—
Steel (Cadmium Plated)	—	—	91S45-1-1AA	450°F.

Spiral Ring offers positive retention. It installs with the use of needle nose pliers.
 Snap-on Type snaps into place over stud cross-pin for faster installation.

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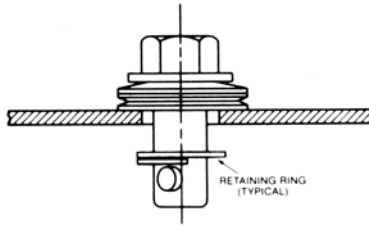
Panel Preparation and Installation Data

Panel Preparation for Stud Installation



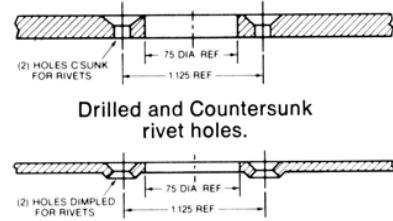
P	X Dia.
Up to .125	.562-.572
.126 & greater	.625-.635

Determine panel thickness "P" and form through hole to corresponding "X" diameter.

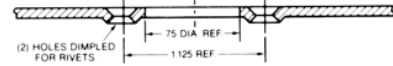


Insert stud through panel and attach retaining ring.

Panel Preparation for Receptacle Installation



Drilled and Countersunk rivet holes.

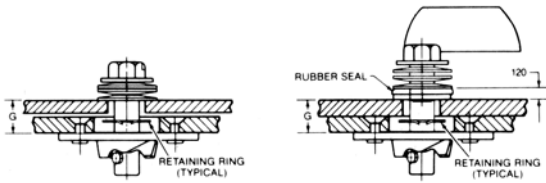


Thin panel dimpled for rivets. (Use receptacle P/N 119-18D.)

Ordering Information/Stud Dash Number Selection

To Select Stud Dash Number:

- Determine "G" total thickness.
Note: Increase "G" to allow for thickness of paint or other finishes and for the compressed thickness of any gasket. If self-sealing stud assemblies are used, add .120 inch to "G" thickness when determining stud dash number.
- Locate total thickness in the Stud Dash Number Selection table.
- Then find the corresponding stud dash number in the column to the right.



Typical Installations

How to Order:

Example 1.

(For standard stud assemblies)
Stud Assembly Used: 91S2-[?]
"G" Total Thickness = 1.125 inch
Stud Dash Number From Table = -37
Complete Part Number: 91S2-37

Example 2.

(For self-sealing stud assemblies)
Stud Assembly Used: 91S7-[?]-WO
"G" Total Thickness = 1.125 inch
Required Calculation: $1.125 + .120 = 1.245$
Stud Dash Number From Table = -41
Complete Part Number: 91S7-41WO

Stud Dash Number Selection			
Total Thickness	Dash Number	Total Thickness	Dash Number
.035-.064	- 1	.785-.814	-26
.065-.094	- 2	.815-.844	-27
.095-.124	- 3	.845-.874	-28
.125-.154	- 4	.875-.904	-29
.155-.184	- 5	.905-.934	-30
.185-.214	- 6	.935-.964	-31
.215-.244	- 7	.965-.994	-32
.245-.274	- 8	.995-1.024	-33
.275-.304	- 9	1.025-1.054	-34
.305-.334	-10	1.055-1.084	-35
.335-.364	-11	1.085-1.114	-36
.365-.394	-12	1.115-1.144	-37
.395-.424	-13	1.145-1.174	-38
.425-.454	-14	1.175-1.204	-39
.455-.484	-15	1.205-1.232	-40
.485-.514	-16	1.235-1.264	-41
.515-.544	-17	1.265-1.294	-42
.545-.574	-18	1.295-1.324	-43
.575-.604	-19	1.325-1.354	-44
.605-.634	-20	1.355-1.384	-45
.635-.664	-21	1.385-1.414	-46
.665-.694	-22	1.415-1.444	-47
.695-.724	-23	1.445-1.474	-48
.725-.754	-24	1.475-1.504	-49
.755-.784	-25	1.505-1.534	-50

Important Note: If total thickness is very near the top of the thickness range, selection of the next greater dash number is recommended. For thicknesses greater than those tabulated, contact the Camloc Products Division.

Stud Part Number Structure

