



INCREMENTAL CHANGE

Release Notification Date: 09/22/2022

SPM 70-48-18 REPLACEMENT OF KELOX STUDS

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### HIGHLIGHTS

<u>HIGHLIGHT REFERENCE</u>	<u>DESCRIPTION OF CHANGE</u>
sk70-48-18-350-291	Technical Change: Added part numbers J1131P04, J1131P07, 5031T71P03, and 5031T71P08 throughout the procedure. Also, changed Vendor name from ALCOA to HOWMET in the Table 1. Part and Tool Information.

TASK 70-48-18-350-029

1. General.

The following procedure must be used to replace Kelox studs which are damaged or loose.

2. Equipment.

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- A. Refer to Table 1 for Part and Tool Information and Table 2 for Kelox Studs and Sizes, required to replace studs.

Table 1. Part and Tool Information

GE Stud Part Number	VENDOR INFORMATION			
	Vendor Name	Part Identification Number	Installation Tool Type	Tool Vendor Number
3012T34P01	HOWMET	878CW-6SG-10	Setting Tool	324-6
			Flush Tool	325-6
3020T29P01	HOWMET	KLSS-10376-4-1	Setting Tool	323-4
			Flush Tool	325-4
	SHUR-LOK CORP	SL9302-4P01	Installation Tool	M256-4
3020T29P02	HOWMET	KLSS-10376-4-2	Setting Tool	323-4
			Flush Tool	325-4
	SHUR-LOK CORP	SL9302-4P02	Installation Tool	M256-4
3020T29P07	HOWMET	KLSS-10376-3-7	Setting Tool	323-3

			Flush Tool	325-3
	SHUR-LOK CORP	SL9302-3P07	Installation Tool	M256-3
3020T29P08	HOWMET	KLSS-10376-3-8	Setting Tool	323-3
			Flush Tool	325-3
	SHUR-LOK CORP	SL9302-3P08	Installation Tool	M256-3
3020T29P09	HOWMET	KLSS-10376-3-9	Setting Tool	323-3
			Flush Tool	325-3
	SHUR-LOK CORP	SL9302-3P09	Installation Tool	M256-3
4031T42P06	HOWMET	KLSS10153-4-6	Setting Tool	323-4
			Flush Tool	325-4
	SHUR-LOK CORP	SL9312-4P06	Installation Tool	M256-4
5031T71P03	HOWMET	KLSS10154-4-3	Setting Tool	323-4
			Flush Tool	325-4
	SHUR-LOK CORP	SL9314-4P03	Installation Tool	M256-4
5031T71P08	HOWMET	KLSS10154-4-8	Setting Tool	323-4
			Flush Tool	325-4
	SHUR-LOK CORP	SL9314-4P08	Installation Tool	M256-4
J1130P03	HOWMET	KLSS10152-3-3	Setting Tool	323-3
			Flush Tool	325-3
	SHUR-LOK CORP	SL9301-3P03	Installation Tool	M256-3
J1130P05	HOWMET	KLSS10152-3-5	Setting Tool	323-3
			Flush Tool	325-3
	SHUR-LOK CORP	SL9301-3P05	Installation Tool	M256-3
J1131P04	HOWMET	KLSS-10151-3-4	Setting Tool	323-4
			Flush Tool	325-4
	SHUR-LOK CORP	SL9303-4P04	Installation Tool	M256-4
J1131P05	HOWMET	KLSS-10151-3-5	Setting Tool	323-4
			Flush Tool	325-4
	SHUR-LOK CORP	SL9303-4P05	Installation Tool	M256-4
J1131P07	HOWMET	KLSS-10151-3-7	Setting Tool	323-4
			Flush Tool	325-4
	SHUR-LOK CORP	SL9303-4P07	Installation Tool	M256-4
J1172P05	HOWMET	KLSS-10155-6-5	Setting Tool	323-6
			Flush Tool	325-6
	SHUR-LOK CORP	SL9308-6P05	Installation Tool	M256-5
J1172P07	HOWMET	KLSS-10155-6-7	Setting Tool	323-6
			Flush Tool	325-6
	SHUR-LOK CORP	SL9308-6P07	Installation Tool	M256-5

Table 2. Kelox Studs and Sizes

GE Stud Part Number	STUD END THREAD	NUT END THREAD (UNJF-3A)	DRILL DIAMETER (inches)	DRILL DEPTH (inches)
3012T34P01	0.500-20 UNJF-3A	0.3750-24 UNJF-3A	0.404	0.234
3020T29P01	0.3125-18 UNJC-3A	0.2500-28 UNJF-3A	0.250	0.145
3020T29P02	0.3125-18 UNJC-3A	0.2500-28 UNJF-3A	0.250	0.145
3020T29P07	0.2500-28 UNJF-3A	0.1900-32 UNJF-3A	0.190	0.127
3020T29P08	0.2500-20 UNJC-3A	0.1900-32 UNJF-3A	0.190	0.127
3020T29P09	0.2500-20 UNJC-3A	0.1900-32 UNJF-3A	0.190	0.127
4031T42P06	0.3125-24 UNJF-3A	0.2500-28 UNJF-3A	0.250	0.145
5031T71P03	0.3125-24 UNJF-3A	0.2500-28	0.250	0.145

		UNJF-3A		
5031T71P08	0.3125-24 UNJF-3A	0.2500-28 UNJF-3A	0.250	0.145
J1130P03	0.2500-28 UNJF-3A	0.1900-32 UNJF-3A	0.190	0.127
J1130P05	0.2500-28 UNJF-3A	0.1900-32 UNJF-3A	0.190	0.127
J1131P04	0.3125-24 UNJF-3A	0.2500-28 UNJF-3A	0.250	0.145
J1131P05	0.3125-24 UNJF-3A	0.250-28 UNJF-3A	0.250	0.145
J1131P07	0.3125-24 UNJF-3A	0.2500-28 UNJF-3A	0.250	0.145
J1172P05	0.4375-20 UNJF-3A	0.375-24 UNJF-3A	0.375	0.203
J1172P07	0.4375-20 UNJF-3A	0.375-24 UNJF-3A	0.375	0.203

**NOTE:** ALL DIMENSIONS ARE IN INCHES.

**NOTE:** BOTH FLUSH AND SETTING TOOLS ARE USED TO INSTALL THE KELOX STUD. USE FLUSH TOOL WHEN DRIVING INTO HARD MATERIALS.

3. Materials.

Subtask 70-48-18-350-292

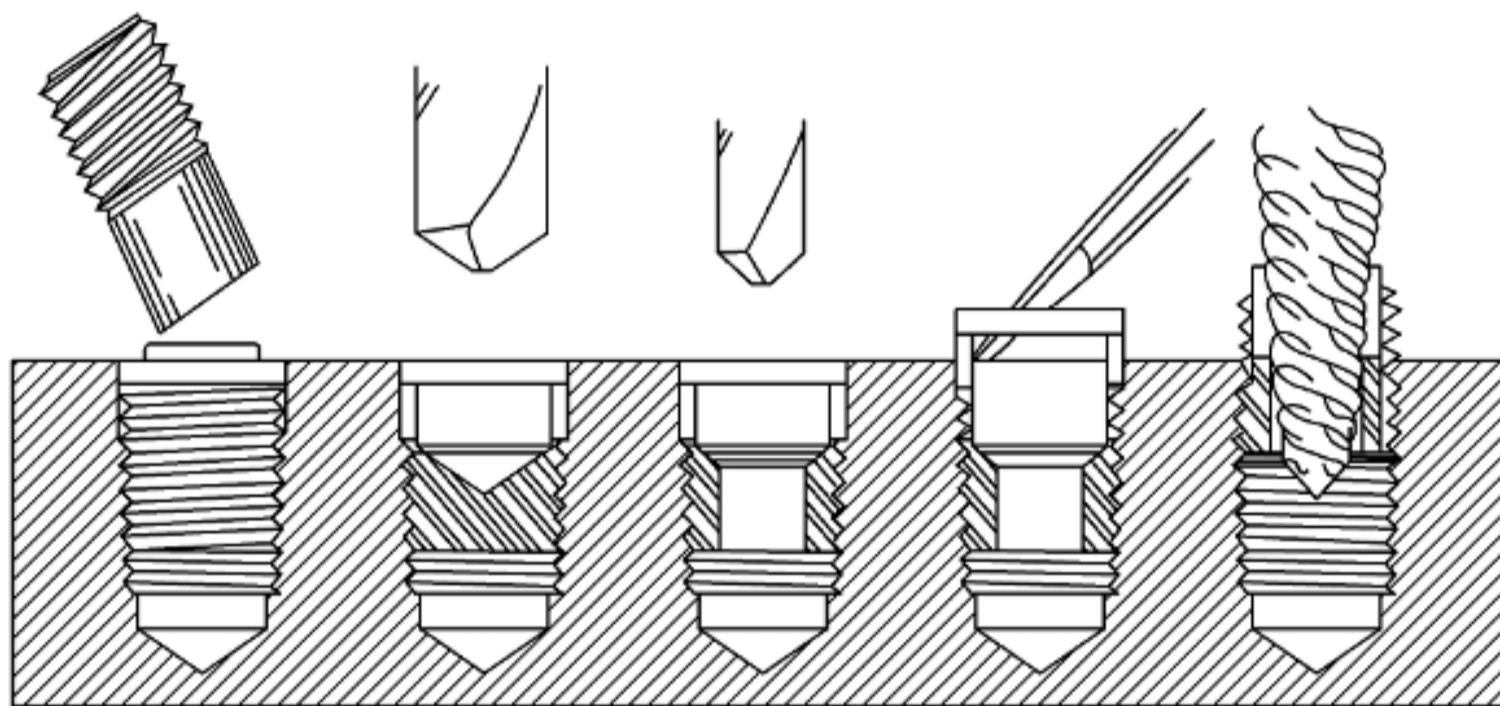
Consumable Product	No.
Zinc chromate primer	C03-001
Chromated conversion coating	C03-081 , C03-082 , C03-084 , or C03-092

4. Procedure.

Subtask 70-48-18-350-293

- A. Remove the defective stud. Refer to Figure 1 and as follows:
  - (1) Cut off the flush of stud with surface of the part.
  - (2) Remove defective part and drill out top of the stud. Refer to Table 2 for drill diameter and depth. Use second drill bit of approximately half the diameter of the first to finish drill through. The hardened ring will act as a drill bushing to guide drill.
  - (3) Use a sharp pointed tool, remove the key ring.
  - (4) Use the screw extractor to remove stud.
- B. Install the stud. Refer to Figure 2 and as follows:
  - (1) The threaded hole must be clear and not damaged. Up to one full thread can be missing.
  - (2) Refinish the threaded hole with chromated conversion coating. Refer to TASK 70-43-07-380-007 (70-43-07, Chemical Touch-Up Surface Refinishing Process for Aluminum).
  - (3) Coat the external threads with zinc chromate primer C03-001 .
  - (4) Install the replacement stud before primer dries.
  - (5) Screw assembly into tapped hole until keys contact first thread of stud.
  - (6) Drive key ring to or slightly below the surface.

\* \* \* FOR ALL

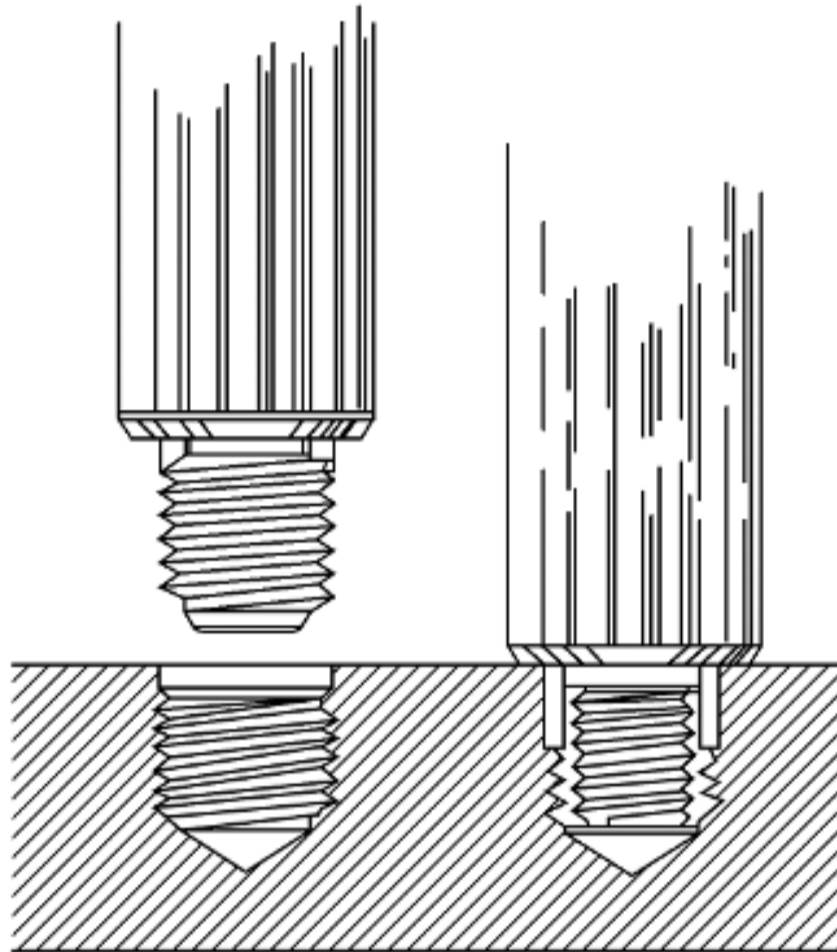


REMOVAL

5038723-00

Figure 1 Removal of Stud

\* \* \* FOR ALL



**INSTALLATION**

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Figure 2 Installation of Kelox Stud

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