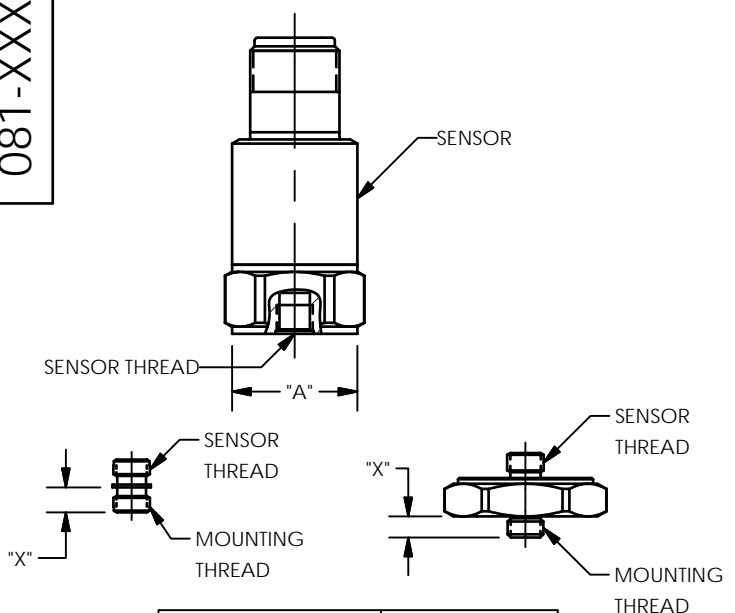


081-XXXX-90

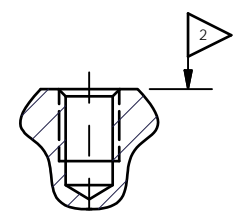
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STANDARD STUD MOUNT



MOUNTING THREAD	SEE DRAWING
5-40	A
M3 X 0.50	B
10-32	C
M5 X 0.80	D
1/4-28	E
M6 X 1.00	F

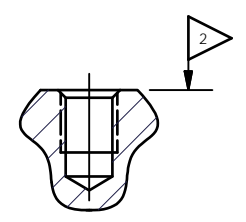
"A"
5-40
MOUNTING INSTRUCTIONS
(METRIC DIMENSIONS IN BRACKETS)



MOUNTING HOLE PREPARATION:
 1) $\phi .101[\phi 2.57]$
 X .20[5.1] ∇ MIN.
 5-40 UNC-2B
 X .15[3.8] ∇ MIN.

4.) RECOMMENDED MOUNTING TORQUE,
 4-5 INCH POUNDS
 [45-55 NEWTON CENTIMETERS].

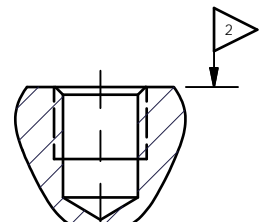
"B"
M3 X 0.50
MOUNTING INSTRUCTIONS
(ENGLISH DIMENSIONS IN BRACKETS)



MOUNTING HOLE PREPARATION:
 1) $\phi 2.5[\phi .099]$
 X 4.6 [1.8] ∇ MIN.
 M3 X 0.50-6H
 X 3.3[.13] ∇ MIN.

4.) RECOMMENDED MOUNTING TORQUE,
 45-55 NEWTON CENTIMETERS
 [4-5 INCH POUNDS].

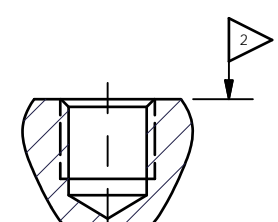
"C"
10-32
MOUNTING INSTRUCTIONS
(METRIC DIMENSIONS IN BRACKETS)



MOUNTING HOLE PREPARATION:
 1) $\phi .159[\phi 4.04]$
 X .23[5.8] ∇ MIN.
 10-32 UNF-2B
 X .15[3.8] ∇ MIN.

4.) RECOMMENDED MOUNTING TORQUE,
 10-20 INCH POUNDS
 [113-225 NEWTON CENTIMETERS].

"D"
M5 X 0.80
MOUNTING INSTRUCTIONS
(ENGLISH DIMENSIONS IN BRACKETS)

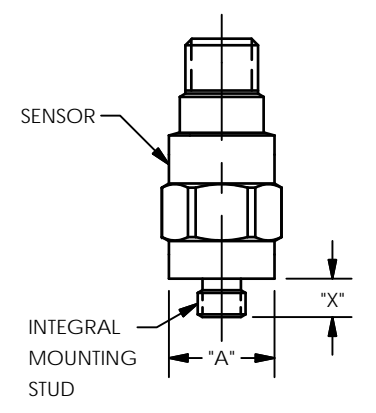


MOUNTING HOLE PREPARATION:
 1) $\phi 4.22[\phi .166]$
 X 7.62 [.300] ∇ MIN.
 M5 X 0.8-6H
 X 5.08[.200] ∇ MIN.

4.) RECOMMENDED MOUNTING TORQUE,
 113-225 NEWTON CENTIMETERS
 [10-20 INCH POUNDS].

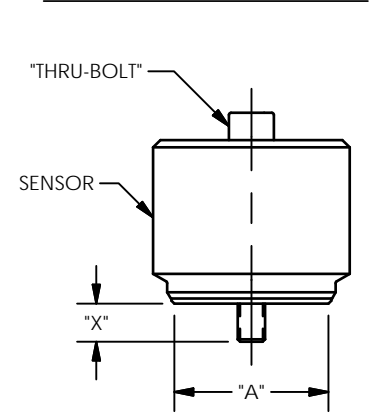
REVISIONS		
REV	DESCRIPTION	DIN
P	UPDATE DRAWING	25686

INTEGRAL STUD MOUNT



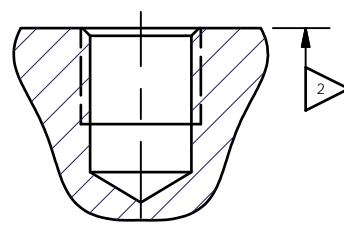
MOUNTING THREAD	SEE DRAWING
5-40	A
M3 X 0.50	B
10-32	C
M5 X 0.80	D
1/4-28	E
M6 X 1.00	F

"THRU-BOLT" STUD MOUNT



BOLT THREAD	SEE DRAWING
10-32	C
M5 X 0.80	D
1/4-28	E
M6 X 1.00	F
M8 X 1.25	F

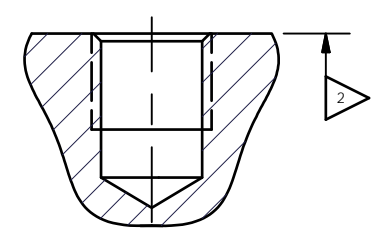
"E"
1/4-28
MOUNTING INSTRUCTIONS
(METRIC DIMENSIONS IN BRACKETS)



MOUNTING HOLE PREPARATION:
 1) $\phi .218[\phi 5.54]$
 X .300[7.62] ∇ MIN.
 1/4-28 UNF-2B
 X .200[5.08] ∇ MIN.

4.) RECOMMENDED MOUNTING TORQUE,
 2-5 FOOT POUNDS
 [3-7 NEWTON METERS].

"F"
M6 X 0.75, M6 X 1.00, M8 X 1.25
MOUNTING INSTRUCTIONS
(ENGLISH DIMENSIONS IN BRACKETS)



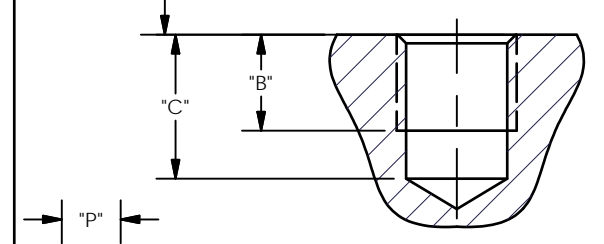
M6 X 0.75 MOUNTING HOLE PREPARATION:
 1) $\phi 5.31[\phi .209]$
 X 7.62 [.300] ∇ MIN.
 M6 X 0.75-6H
 X 5.08[.200] ∇ MIN.

M6 X 1.0 MOUNTING HOLE PREPARATION:
 1) $\phi 5.05[\phi .199]$
 X 8.10 [.320] ∇ MIN.
 M6X 1.0-6H
 X 6.35[.250] ∇ MIN.

M8 X 1.25 MOUNTING HOLE PREPARATION:
 1) $\phi 6.75[\phi .266]$
 X 8.64 [.340] ∇ MIN.
 M8 X 1.25-6H
 X 5.00[.197] ∇ MIN.

4.) RECOMMENDED MOUNTING TORQUE,
 3-7 NEWTON METERS [2-5 FT POUNDS].

"G"
MOUNTING INSTRUCTIONS
FOR SPECIAL THREAD LENGTHS
(METRIC DIMENSIONS IN BRACKETS)



MOUNTING HOLE PREPARATION:
 1) ϕ DRILL DIA.
 X "C" ∇ MIN.
 TAP
 X "B" ∇ MIN.

THREAD DEPTH : B = X + 1 THREAD PITCH
 DRILL DEPTH : C = B + 3 THREAD PITCH
 SEE A-F FOR APPROPRIATE DRILL AND TAP
 THREAD PITCH = 1/TPI [P]

- 3.) FOR BEST RESULTS, PLACE A THIN LAYER OF SILICONE GREASE (OR EQUIVALENT) ON INTERFACE PRIOR TO MOUNTING.
- 2) MOUNTING SURFACE SHOULD BE FLAT TO WITHIN .001(0.03) TIR OVER DIM 'A' WITH A $\frac{63[1.61]}{\sqrt{\quad}}$ OR BETTER FINISH FOR BEST RESULTS.
- 1) DRILL PERPENDICULAR TO MOUNTING SURFACE TO WITHIN $\pm 1^\circ$.

UNLESS OTHERWISE SPECIFIED TOLERANCES ARE:		DRAWN		CHECKED		ENGINEER	
DIMENSIONS IN INCHES	DIMENSIONS IN MILLIMETERS [IN BRACKETS]	JDM	3/9/07	ECB	3/9/07	JJD	3/9/07
DECIMALS XX $\pm .01$ XXX $\pm .005$	DECIMALS X $\pm .03$ XX ± 0.13	TITLE					
ANGLES ± 2 DEGREES	ANGLES ± 2 DEGREES	INSTALLATION DRAWING FOR STANDARD 081 SERIES MOUNTING					
FILLETS AND RADII .003 - .005	FILLETS AND RADII 0.07 - 0.13	CODE IDENT. NO. 52681		DWG. NO. 081-XXXX-90		SCALE: N.T.S. SHEET 1 OF 1	

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