

TECHNICAL MANUAL



HEXSTIX® Drive Systems

Includes comprehensive engineering Head Standards, Driver Bit Standards, Gage Standards, Quality Standards and Punch Standards.



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HEXSTIX®

Drive System Technical Manual



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Bellingham, MA 02019

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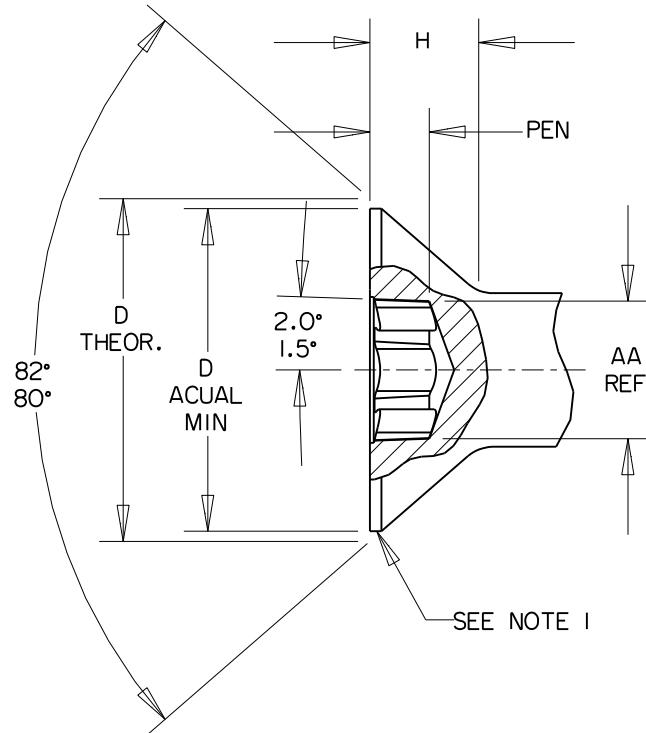
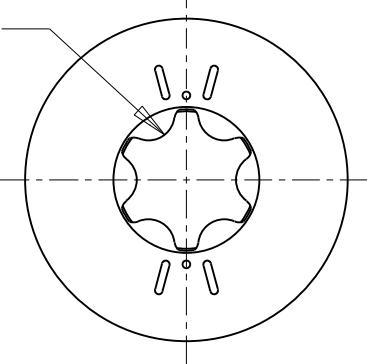
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HEXSTIX® ENGINEERING MANUAL
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DRIVE
SIZE



SCREW SIZE	PUNCH PIN NO.	HEAD DIMENSIONS			RECESS DIMENSIONS			DRIVE SIZE
		ϕD THEO.	ϕD ACUAL MIN.	H REF.	ϕAA REF.	PENETRATION MAX.	MIN.	
8	HS15-533	.332	.292	.100	.1325	.054	.045	HS15
10	HS20-533	.385	.340	.116	.1555	.064	.053	HS20
12	HS25-533	.438	.389	.132	.1790	.073	.061	HS25
1/4	HS27-533	.507	.452	.153	.2010	.082	.068	HS27
5/16	HS40-533	.635	.568	.191	.2675	.109	.090	HS40
3/8	HS45-533	.762	.685	.230	.3125	.128	.106	HS45
7/16	HS50-533	.812	.723	.223	.3525	.144	.120	HS50

NOTES:

1. EDGE OF HEAD MAY BE ROUNDED OR FLAT.
2. DIMENSIONS ARE IN INCHES.
3. DRAWING NOT TO SCALE.

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TITLE:

HEXSTIX® 82° FLAT C'SUNK HEAD (INCH)

DRAWN

CHECKED:

DATE

DATE

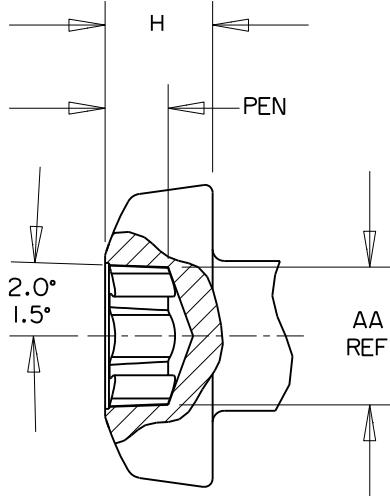
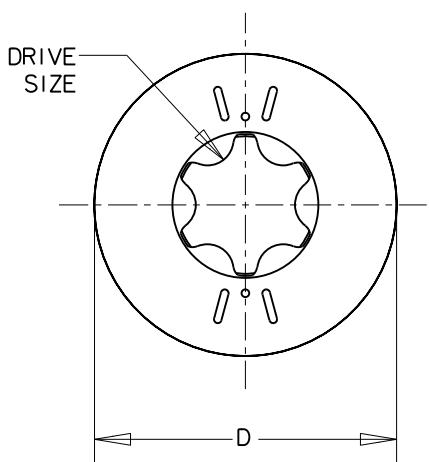
DRAWING NUMBER

PSC-H-100

SHEET 1 OF 1

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SCREW SIZE	PUNCH PIN NO.	HEAD DIMENSIONS				RECESS DIMENSIONS		DRIVE SIZE	
		D		H		ØAA REF.	PENETRATION		
		MAX.	MIN.	MAX.	MIN.		MAX.	MIN.	
6	HS15-532	.270	.256	.097	.087	.1325	.061	.051	HS15
8	HS20-532	.322	.306	.115	.105	.1555	.071	.060	HS20
10	HS25-532	.373	.357	.133	.122	.1790	.082	.069	HS25
12	HS27-532	.425	.407	.151	.139	.2010	.092	.078	HS27
1/4	HS30-532	.492	.473	.175	.162	.2220	.102	.086	HS30
5/16	HS40-532	.615	.594	.218	.203	.2675	.122	.104	HS40
3/8	HS45-532	.740	.716	.261	.244	.3125	.144	.122	HS45
7/16	HS50-532	.862	.836	.305	.284	.3525	.162	.137	HS50

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. DRAWING NOT TO SCALE.

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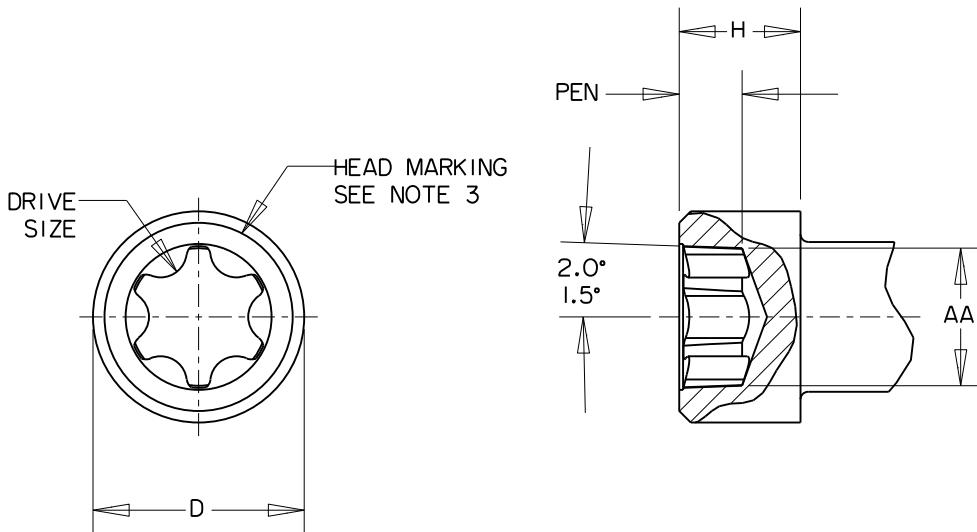
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TITLE:
**HEXSTIX®
PAN HEAD (INCH)**

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CHECKED: G.DILLING	DATE 9/09/10	PSC-H-101

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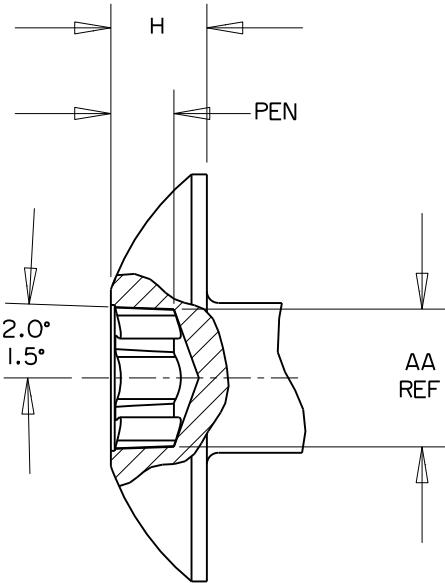
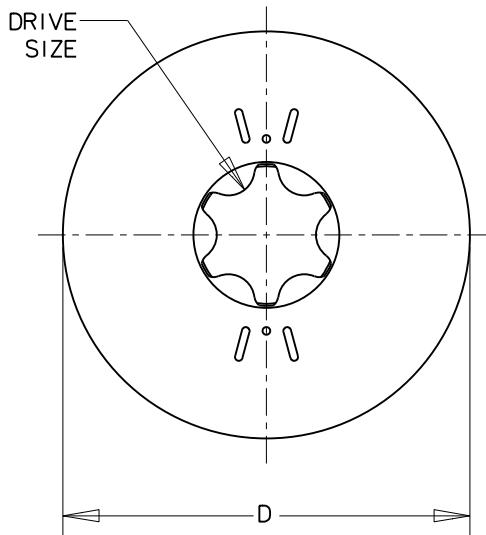
SCREW SIZE	PUNCH PIN NO.	HEAD DIMENSIONS				RECESS DIMENSIONS			DRIVE SIZE	
		D		H		ØAA REF.	PENETRATION			
		MAX.	MIN.	MAX.	MIN.		MAX.	MIN.		
6	HS15-53I	.226	.218	.138	.134	.1325	.067	.058	HS15	
8	HS25-53I	.270	.262	.164	.159	.1790	.091	.078	HS25	
10	HS27-53I	.312	.303	.190	.185	.2010	.102	.088	HS27	
1/4	HS30-53I	.375	.365	.250	.244	.2220	.113	.097	HS30	
5/16	HS45-53I	.469	.457	.312	.306	.3125	.159	.137	HS45	
3/8	HS50-53I	.562	.550	.375	.368	.3525	.180	.155	HS50	

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. DRAWING NOT TO SCALE.
3. HEAD MARKING NOT REQUIRED FOR SOCKET HEAD CAP SCREWS.

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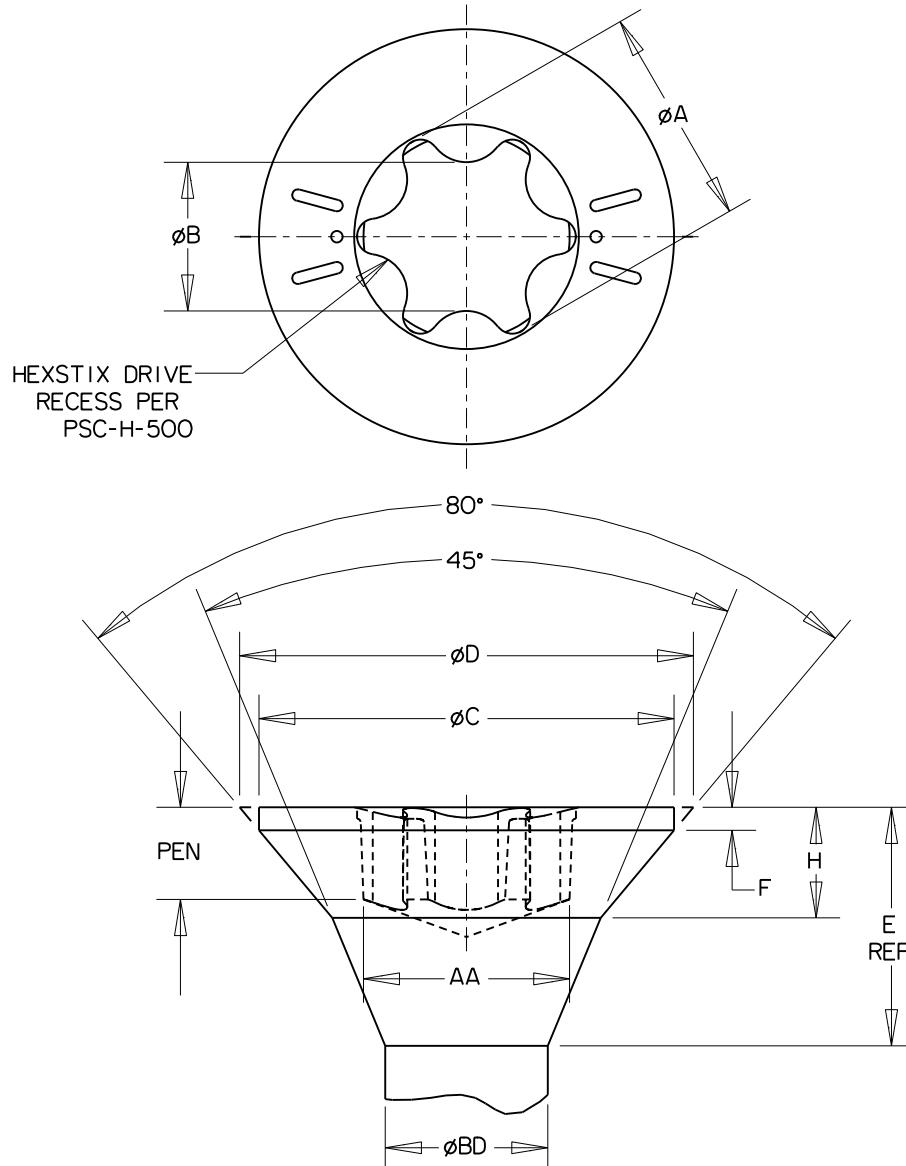
SCREW SIZE	PUNCH PIN NO.	HEAD DIMENSIONS				RECESS DIMENSIONS		DRIVE SIZE	
		D		H		ØAA REF.	PENETRATION MAX.		
		MAX.	MIN.	MAX.	MIN.				
8	HS15-533	.384	.364	.102	.088	.1325	.054	.045 HS15	
10	HS20-533	.448	.425	.118	.103	.1555	.064	.053 HS20	
12	HS25-533	.511	.487	.134	.118	.1790	.073	.061 HS25	
1/4	HS27-533	.573	.546	.150	.133	.2010	.082	.068 HS27	
5/16	HS40-533	.698	.666	.183	.162	.2675	.109	.090 HS40	
3/8	HS45-533	.823	.787	.215	.191	.3125	.128	.106 HS45	
7/16	HS45-533	.948	.907	.248	.221	.3125	.128	.106 HS45	
1/2	HS50-533	1.073	1.028	.280	.250	.3525	.144	.120 HS50	

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. DRAWING NOT TO SCALE.

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© COPYRIGHT 2011 PHILLIPS SCREW COMPANY. ALL RIGHTS RESERVED.		TITLE: HEXSTIX® TRUSS HEAD (INCH)		
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SCREW SIZE	DRIVE SIZE	PUNCH PIN NO. SEE NOTE I	A REF	AA REF	B REF	ØC ACTUAL	ØD THEOR. MAX.	+0.00 -0.25 PEN	E REF	F REF	ØBD	H
M3.5	HS15	HS15-528-M3.5	3.57	3.36	2.44	6.99	7.5	1.50	4.19	0.30	2.50-2.33	1.80
M4.0	HS20	HS20-528-M4	4.19	3.95	2.86	7.56	8.2	1.50	4.45	0.38	2.86-2.69	1.95
M4.5	HS20	HS20-528-M4.5	4.19	3.95	2.86	8.36	9.0	1.90	4.72	0.38	3.22-3.05	2.20
M5.0	HS25	HS25-528-M5	4.83	4.55	3.28	9.14	10.0	2.00	5.25	0.51	3.58-3.41	2.44
M6.0	HS25	HS25-528-M6	4.83	4.55	3.28	10.93	12.0	2.50	6.30	0.64	4.29-4.12	2.93

NOTES:

I. REFER TO DRAWING "PSC-H-525" FOR PUNCH NUMBER.

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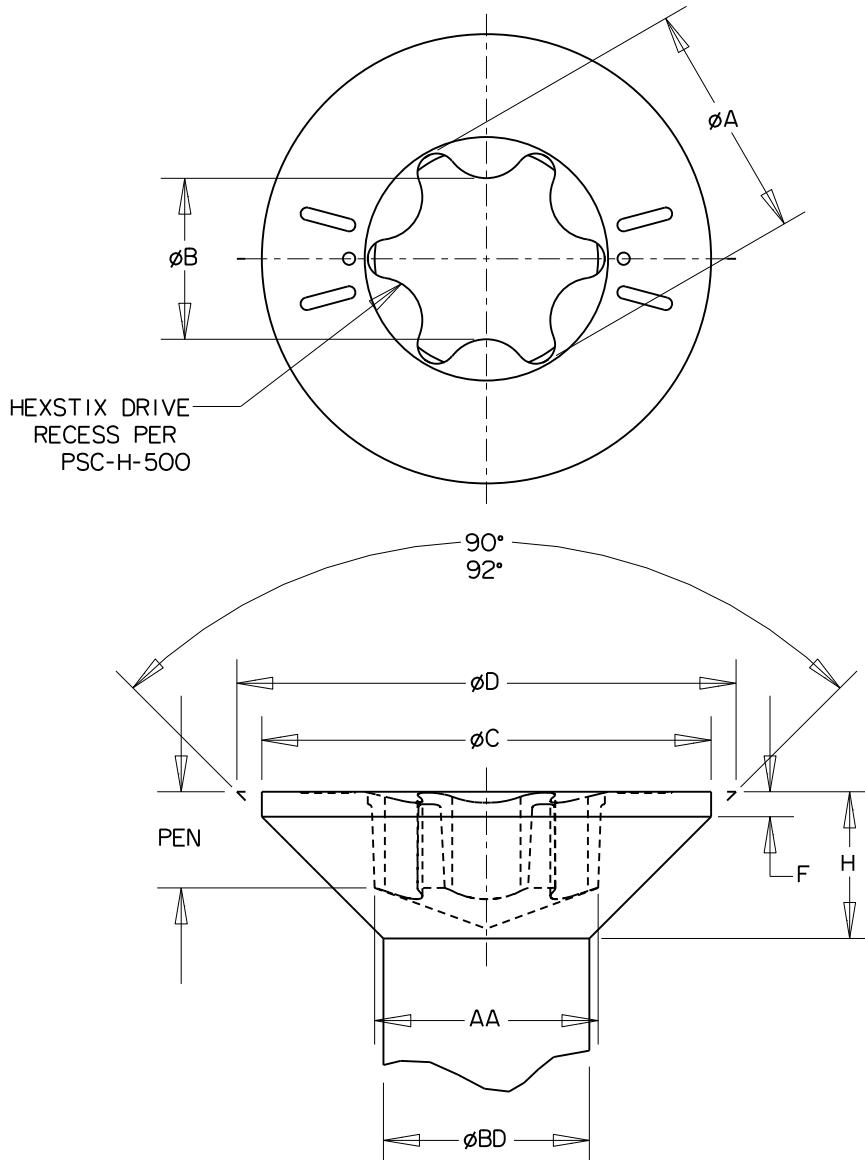
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TITLE: HEXSTIX® DOUBLE ANGLE
FLAT HEAD LOW ENERGY "LE" SCREW

DRAWN G.DILLING	DATE 6/24/10	DRAWING NUMBER PSC-H-125
CHECKED: G.DILLING	DATE 9/28/10	SHEET 1 OF 1

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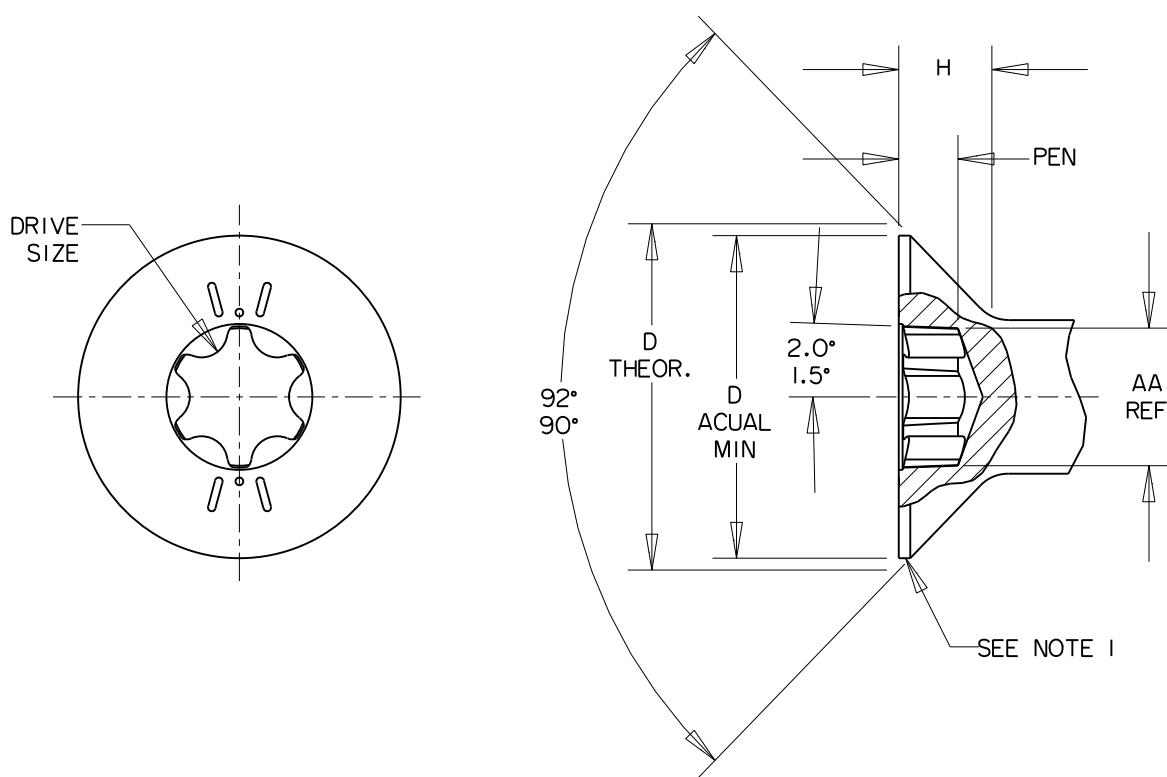
SCREW SIZE	DRIVE SIZE	PUNCH PIN NO. SEE NOTE 1	A REF	AA REF	B REF	C ACTUAL	ØD THEOR.	F REF	+0.00 -0.25 PEN	ØBD	H
M3.5	HS15	HS15-528-M3.5	3.57	3.36	2.44	6.90	7.5	0.30	1.50	2.94	2.28
M4.0	HS20	HS20-528-M4	4.19	3.95	2.86	7.74	8.5	0.38	1.50	3.35	2.58
M4.5	HS20	HS20-528-M4	4.19	3.95	2.86	7.74	8.5	0.38	1.50	3.77	2.37
M5.0	HS25	HS25-528-M5	4.83	4.55	3.28	8.98	10.0	0.51	2.00	4.19	2.91
M6.0	HS25	HS25-528-M6	4.83	4.55	3.28	12.00	13.26	0.64	2.50	4.32	4.47

NOTES:

I. REFER TO DRAWING "PSC-H-526" FOR PUNCH NUMBER.

© COPYRIGHT 2011 PHILLIPS SCREW COMPANY. ALL RIGHTS RESERVED.	TITLE: HEXSTIX® 90° FLAT HEAD LOW ENERGY "LE" SCREW		
DRAWN G.DILLING		DATE 3/25/10	DRAWING NUMBER PSC-H-126
CHECKED: G.DILLING		DATE 9/29/10	SHEET 1 OF 1
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SCREW SIZE	PUNCH PIN NO.	HEAD DIMENSIONS			RECESS DIMENSIONS			DRIVE SIZE
		ØD THEO.	ØD ACUAL MIN.	H REF.	ØAA REF.	PENETRATION MAX.	MIN.	
M3.5	HS15-533	8.2	6.9	2.3	3.36	1.37	1.14	HS15
M4	HS20-533	9.4	8.0	2.7	3.95	1.62	1.34	HS20
M5	HS25-533	10.4	8.9	2.9	4.55	1.85	1.54	HS25
M6	HS30-533	12.6	10.9	3.3	5.64	2.30	1.91	HS30
M8	HS40-533	17.3	15.4	4.6	6.79	2.77	2.30	HS40
M10	HS50-533	20.0	17.8	5.0	8.95	3.67	3.04	HS50

NOTES:

1. EDGE OF HEAD MAY BE ROUNDED OR FLAT.
2. DIMENSIONS ARE IN METRIC.
3. DRAWING NOT TO SCALE.

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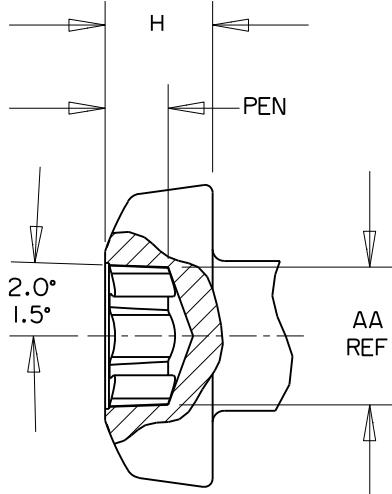
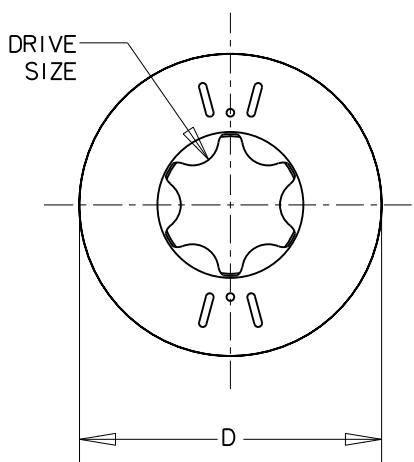
TITLE:

HEXSTIX® 90° FLAT C'SUNK HEAD (METRIC)

DRAWN G.DILLING	DATE 7/02/10	DRAWING NUMBER PSC-H-127
CHECKED: G.DILLING	DATE 9/10/10	SHEET 1 OF 1

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SCREW SIZE	PUNCH PIN NO.	HEAD DIMENSIONS				RECESS DIMENSIONS			DRIVE SIZE	
		D		H		ØAA REF.	PENETRATION			
		MAX.	MIN.	MAX.	MIN.		MAX.	MIN.		
M3.5	HS15-532	7.0	6.6	2.6	2.3	3.36	1.54	1.31	HS15	
M4	HS20-532	8.0	7.6	3.1	2.8	3.95	1.81	1.54	HS20	
M5	HS25-532	9.5	9.1	3.7	3.4	4.55	2.08	1.76	HS25	
M5.5	HS25-532	11.0	10.5	4.0	3.7	4.55	2.08	1.76	HS25	
M6	HS30-532	12.0	11.5	4.6	4.3	5.64	2.58	2.19	HS30	
M8	HS40-532	16.0	15.5	6.0	5.6	6.79	3.11	2.64	HS40	
M10	HS50-532	20.0	19.4	7.5	7.1	8.95	4.11	3.49	HS50	

NOTES:

1. DIMENSIONS ARE IN METRIC.
2. DRAWING NOT TO SCALE.

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TITLE:

HEXSTIX®
PAN HEAD (METRIC)

DRAWN
G.DILLING

DATE
7/02/10

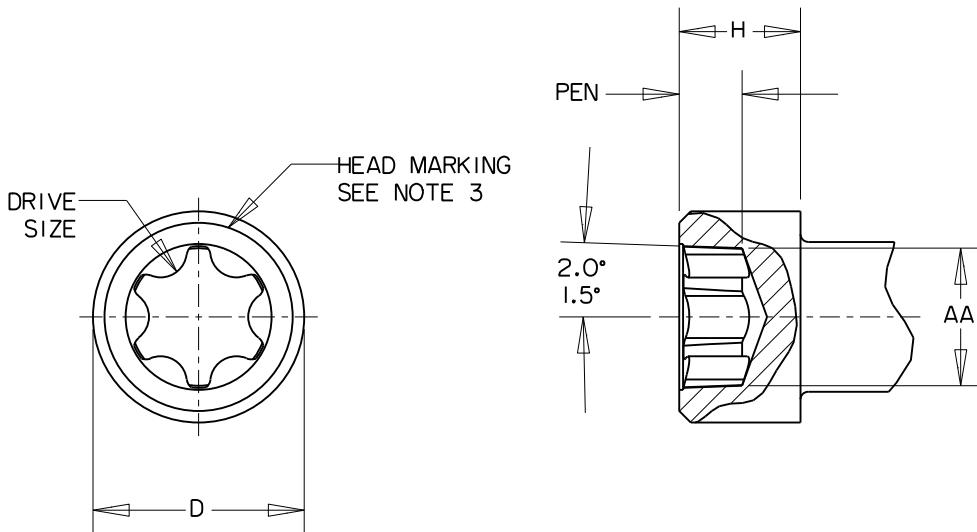
DRAWING NUMBER

PSC-H-128

SHEET 1 OF 1

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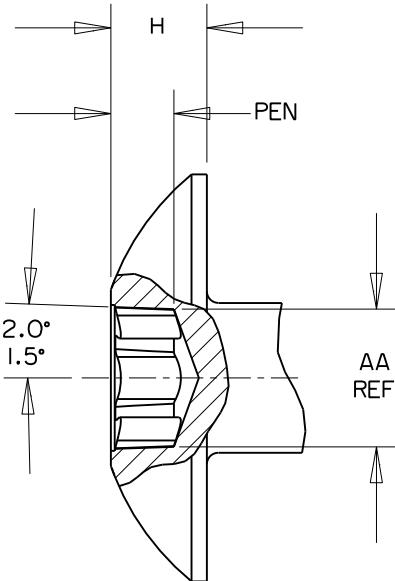
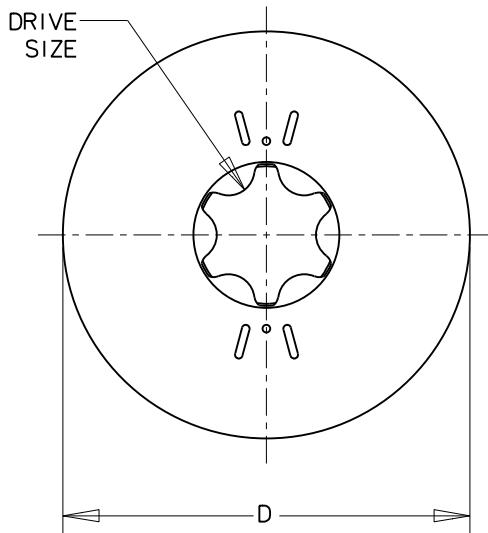
SCREW SIZE	PUNCH PIN NO.	HEAD DIMENSIONS				RECESS DIMENSIONS		DRIVE SIZE	
		D		H		ØAA REF.	PENETRATION		
		MAX.	MIN.	MAX.	MIN.		MAX.		
M3.5	HS15-53I	6.25	6.05	3.50	3.38	3.36	1.71	1.47	HS15
M4	HS25-532	7.00	6.80	4.00	3.88	4.55	2.08	1.76	HS25
M4.5	HS27-532	7.75	7.52	4.50	4.37	5.11	2.34	1.98	HS27
M5	HS27-53I	8.50	8.27	5.00	4.86	5.11	2.59	2.24	HS27
M6	HS30-53I	10.0	9.74	6.00	5.85	5.64	2.86	2.47	HS30
M7	HS40-53I	11.50	11.22	7.00	6.84	6.79	3.45	2.97	HS40
M8	HS45-53I	13.00	12.70	8.00	7.83	7.94	4.04	3.48	HS45
M10	HS50-53I	16.00	15.67	10.00	9.81	8.95	4.56	3.93	HS50

NOTES:

1. DIMENSIONS ARE IN METRIC.
2. DRAWING NOT TO SCALE.
3. HEAD MARKING NOT REQUIRED FOR SOCKET HEAD CAP SCREWS.

REVISION

© COPYRIGHT 2011 PHILLIPS SCREW COMPANY. ALL RIGHTS RESERVED.		TITLE: HEXSTIX® SOCKET HEAD CAP SCREW (METRIC)		
DRAWN	G.DILLING	DATE	7/02/10	DRAWING NUMBER
CHECKED:	G.DILLING	DATE	9/10/10	PSC-H-129
PHILLIPS SCREW CO., 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326				SHEET 1 OF 1
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SCREW SIZE	PUNCH PIN NO.	HEAD DIMENSIONS				RECESS DIMENSIONS		DRIVE SIZE	
		D		H		ØAA REF.	PENETRATION		
		MAX.	MIN.	MAX.	MIN.		MAX.		
M4	HS15-533	9.76	9.24	3.15	2.65	3.36	1.37	1.14	HS15
M5	HS20-533	11.38	10.78	3.70	3.10	3.95	1.62	1.34	HS20
M6	HS30-533	14.56	13.86	4.65	4.00	5.64	2.30	1.91	HS30
M8	HS40-533	17.73	16.92	5.50	4.95	6.79	2.77	2.30	HS40
M10	HS50-533	20.91	19.98	7.20	6.30	8.95	3.67	3.04	HS50

NOTES:

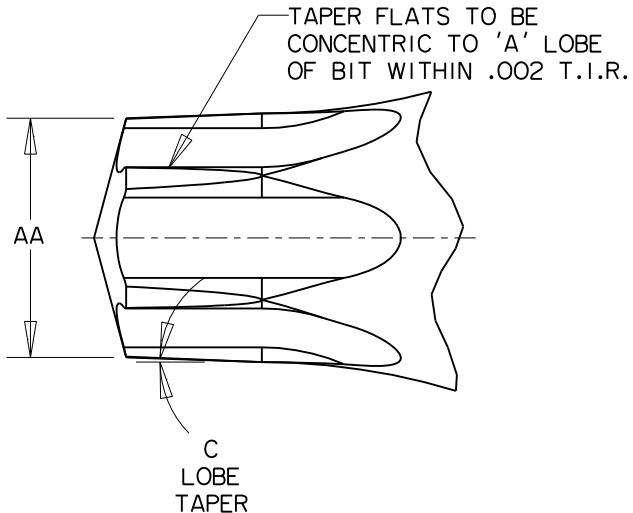
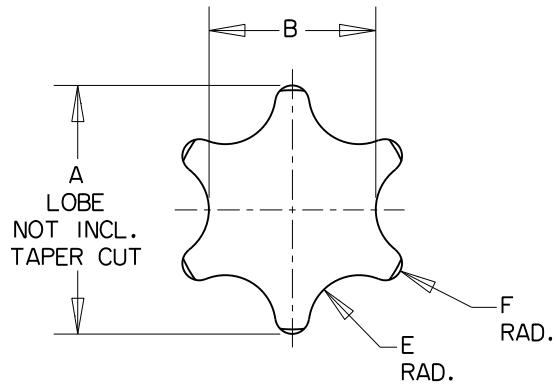
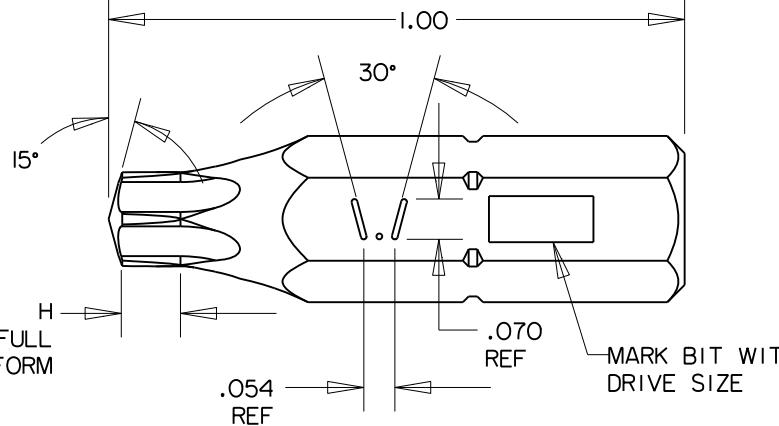
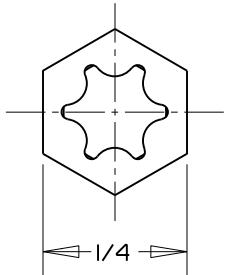
1. DIMENSIONS ARE IN METRIC.
2. DRAWING NOT TO SCALE.

REVISION

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CHECKED: G.DILLING		DATE 9/10/10	SHEET 1 OF 1	
PHILLIPS SCREW CO., 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326				
PHILLIPS II® PHILLIPS® POZIDRIV® ACR® POZISQUARE® PHILLIPS SQUARE-DRIV® TORQ-SET® TRI-WING® MORTORQ® HEXSTIX® AND POZILOCK® ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY				

HEXSTIX® ENGINEERING MANUAL
INDEX
DRIVER BIT STANDARDS

PSC-H-200	HEXSTIX INSERT DRIVER BIT	3/15/II
PSC-H-20I	TAMPER RESISTANT INSERT DRIVER BIT	10/31/II



DRIVE SIZE	+.0000 -.0030 A	+.0000 -.0030 B	E REF	F REF	AA	+0.0° -0.5° C	H MIN
HS15	.1367	.0920	.0290	.0089	.1335 .1325	1.50°	.085
HS20	.1610	.1085	.0344	.0104	.1565 .1555	1.50°	.090
HS25	.1850	.1240	.0376	.0126	.1805 .1790	1.50°	.100
HS27	.2085	.1396	.0450	.0130	.2025 .2010	1.50°	.110
HS30	.2305	.1550	.0482	.0153	.2240 .2225	1.50°	.125
HS40	.2780	.1865	.0580	.0183	.2695 .2680	1.50°	.130
HS45	.3265	.2180	.0722	.0193	.3145 .3130	1.50°	.150
HS50	.3690	.2420	.0730	.0243	.3545 .3530	1.50°	.180

REVISION REV A: 3/15/11

MATERIAL: S2 OR EQUIVALENT
HT: R/c 58-62

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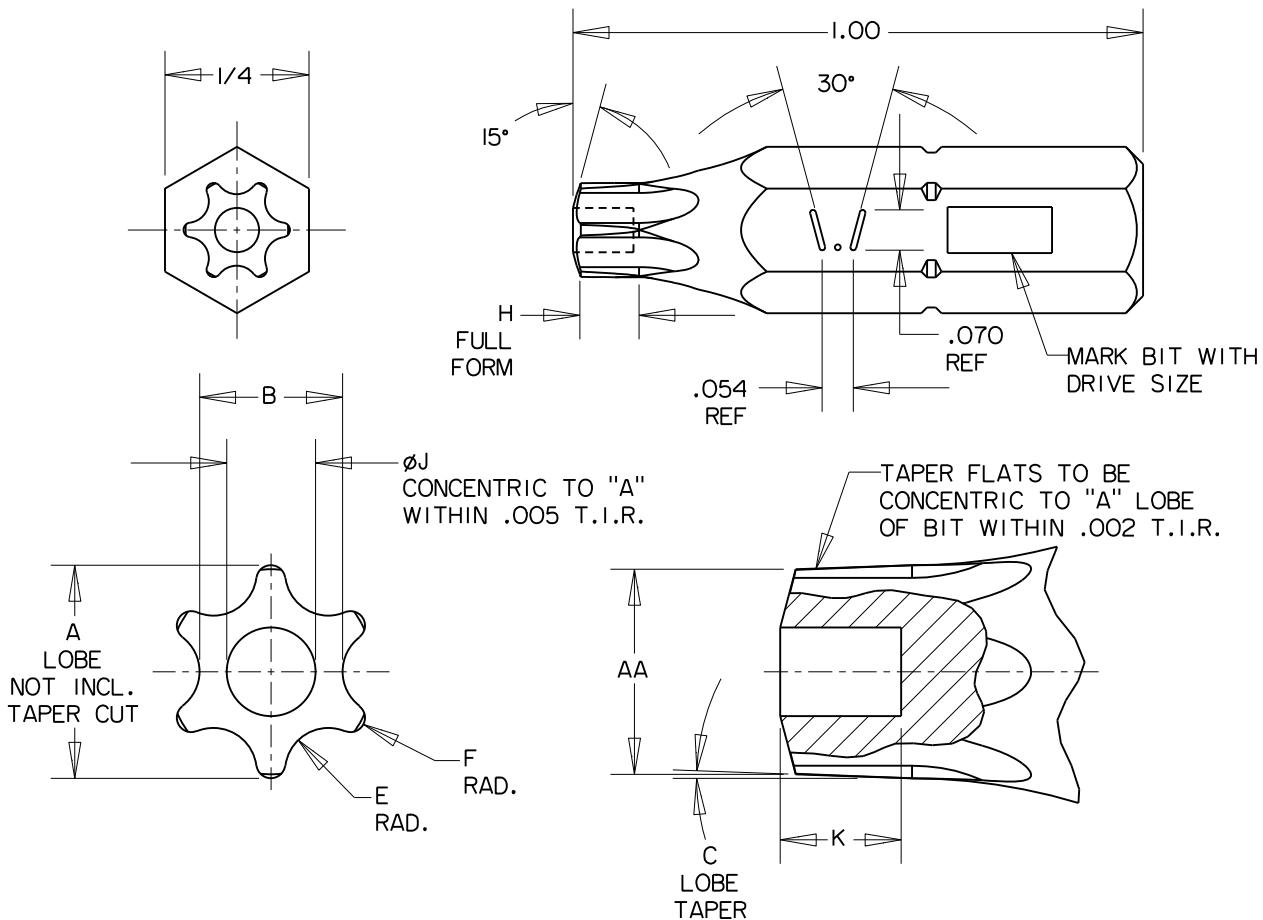
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TITLE: HEXSTIX®
1" INSERT DRIVER BIT DIMENSIONS

DRAWN G.DILLING	DATE 3/17/10	DRAWING NUMBER PSC-H-200
CHECKED: G.DILLING	DATE 8/31/10	SHEET 1 OF 1

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DRIVE SIZE	+.0000 -.0030 A	+.0000 -.0030 B	E REF	F REF	AA	+0.0° -0.5° C	H MIN	J MIN	K MIN
HS15	.1367	.0920	.0290	.0089	.1335 .1325	1.50°	.085	.046	.080
HS20	.1610	.1085	.0344	.0104	.1565 .1555	1.50°	.090	.061	.090
HS25	.1850	.1240	.0376	.0126	.1805 .1790	1.50°	.100	.076	.100
HS27	.2085	.1396	.0450	.0130	.2025 .2010	1.50°	.110	.086	.115
HS30	.2305	.1550	.0482	.0153	.2240 .2225	1.50°	.125	.101	.125
HS40	.2780	.1865	.0580	.0183	.2695 .2680	1.50°	.130	.115	.145
HS45	.3265	.2180	.0722	.0193	.3145 .3130	1.50°	.150	.136	.170
HS50	.3690	.2420	.0730	.0243	.3545 .3530	1.50°	.180	.151	.190

MATERIAL: S2 OR EQUIVALENT
HT: R/c 58-62

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TITLE: HEXSTIX® TAMPER RESISTANT
1" INSERT DRIVER BIT DIMENSIONS

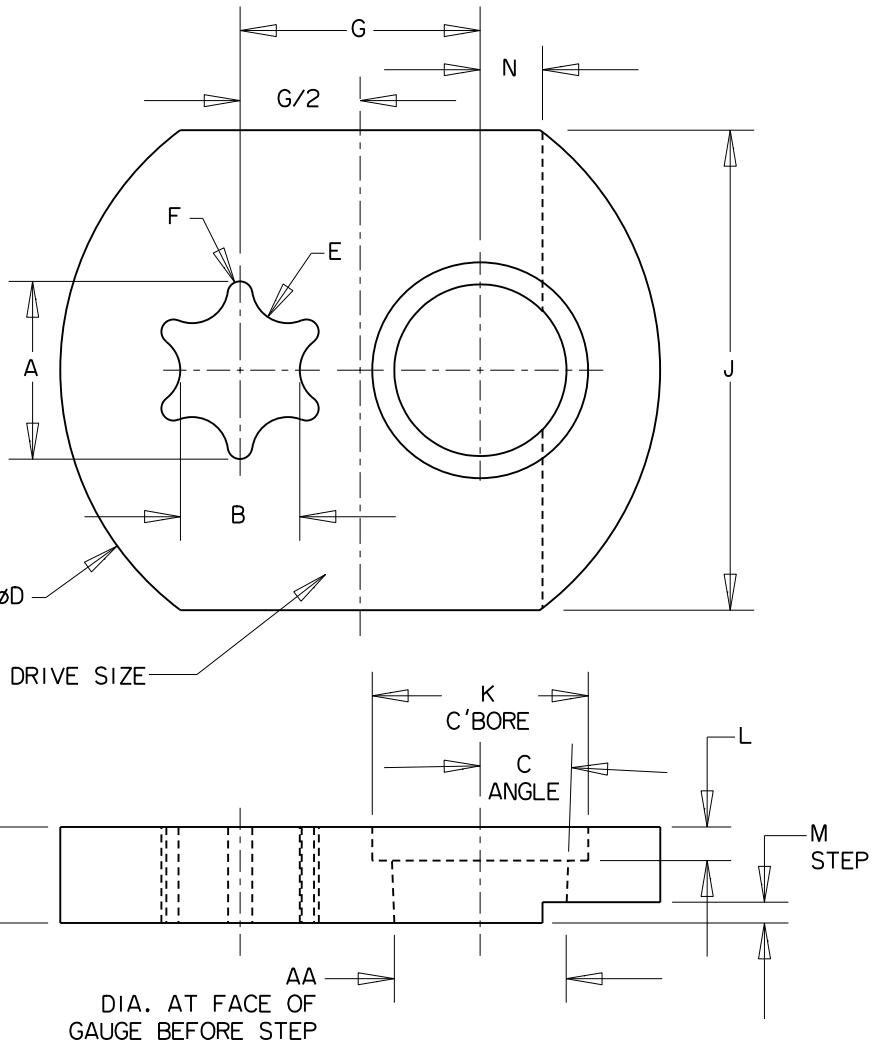
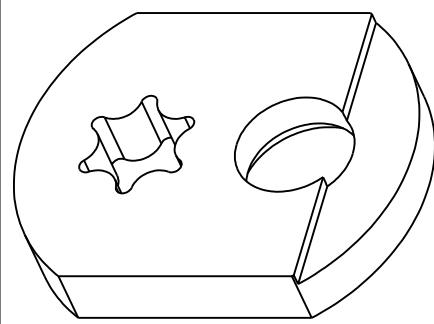
DRAWN G.DILLING	DATE 10/31/11	DRAWING NUMBER PSC-H-201
CHECKED: G.DILLING	DATE 10/31/11	SHEET 1 OF 1

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PHONE: 774-396-6190 FAX: 508-966-2326

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HEXSTIX® ENGINEERING MANUAL
INDEX
GAUGING STANDARDS

PSC-H-400	DRIVER BIT RING GAUGE	3/16/II
PSC-H-401	RECESS PLUG GO/NO-GO GAUGE	2/1/12
PSC-H-402	RECESS PENETRATION DEPTH GAUGE	2/1/12
PSC-H-403	DRIVER BIT TORQUE TEST BLOCK	3/16/II
PSC-H-406	PUNCH GO/NO-GO FORK PLUG GAUGE	4/8/II
PSC-H-407	O.S. PUNCH GO, NO-GO FORK PLUG GAUGE	1/13/12
PSC-H-408	O.S. RECESS PLUG GO/NO-GO GAUGE	1/13/12



DRIVE SIZE	$\pm .0001$ A	$\pm .0001$ B	E REF	F REF	$\pm .0001$ AA	$+0.00^\circ$ -0.25° C	$\pm .002$ D	G	$\pm .005$ H	$\pm .002$ J	$.010$ $-.000$ K	$\pm .005$ L	$\pm .0005$ M	$\pm .002$ N
HS15	.1370	.0923	.0289	.0091	.1325	2.00°	1.250	.500	.150	1.125	.185	.095	.0143	.050
HS20	.1613	.1088	.0343	.0106	.1555	2.00°	1.250	.500	.150	1.125	.205	.090	.0143	.065
HS25	.1853	.1243	.0375	.0128	.1790	2.00°	1.250	.500	.150	1.125	.225	.085	.0215	.065
HS27	.2088	.1399	.0449	.0131	.2010	2.00°	1.250	.500	.150	1.125	.250	.085	.0215	.065
HS30	.2308	.1553	.0481	.0154	.2225	2.00°	1.250	.500	.150	1.125	.250	.080	.0215	.075
HS40	.2783	.1868	.0579	.0185	.2680	2.00°	1.250	.500	.150	1.125	.400	.080	.0215	.090
HS45	.3268	.2183	.0721	.0195	.3130	2.00°	1.250	.500	.150	1.125	.400	.080	.0215	.120
HS50	.3693	.2423	.0729	.0245	.3530	2.00°	1.250	.500	.150	1.125	.400	.080	.0215	.150

MATERIAL: CARBIDE

REVISION REV A:3/6/II

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TITLE:

HEXSTIX® DRIVER BIT RING GAUGE

DRAWN

G.DILLING

DATE

4/04/10

DRAWING NUMBER

PSC-H-400

CHECKED:

G.DILLING

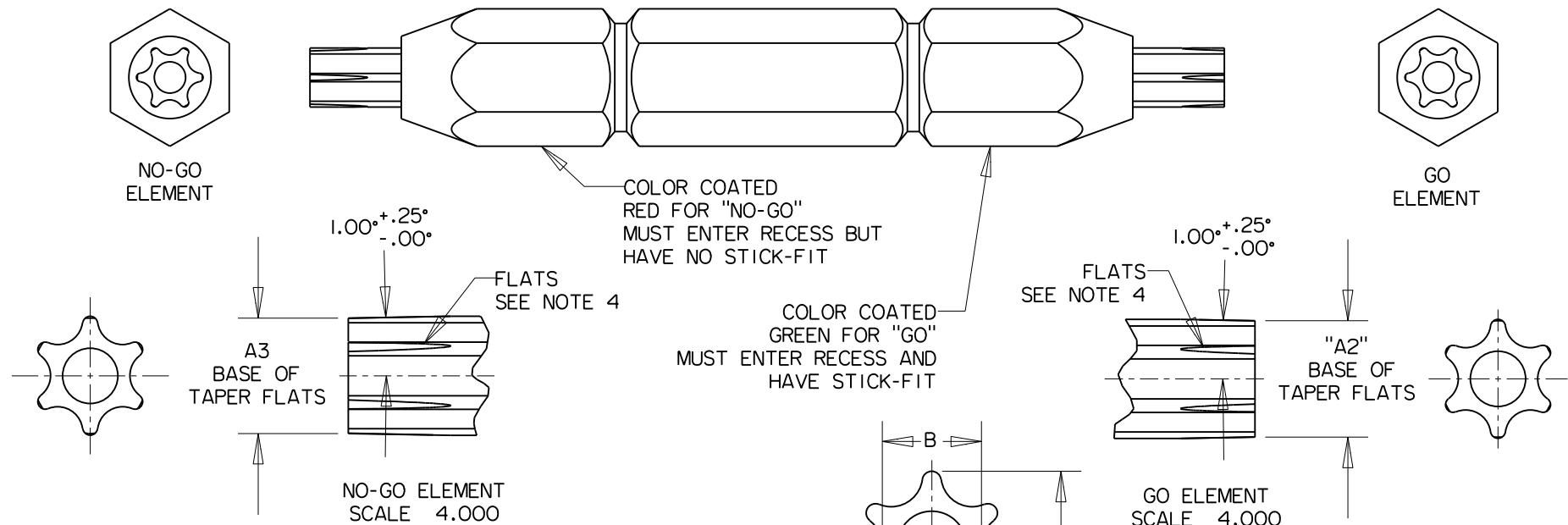
DATE

9/7/10

SHEET 1 OF 1

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DRIVE SIZE	$+.0000$ $-.0005$	$+.0000$ $-.0005$	E	F REF	$+.0002$ $-.0000$	$+.0000$ $-.0005$	$.005$ $-.000$
HS15	.1347	.0900	.0300	.0079	.1325	.1315	.055
HS20	.1590	.1065	.0354	.0094	.1555	.1540	.070
HS25	.1830	.1220	.0386	.0116	.1790	.1775	.085
HS27	.2065	.1376	.0460	.0120	.2010	.1995	.095
HS30	.2285	.1530	.0492	.0143	.2225	.2205	.115
HS40	.2760	.1845	.0590	.0173	.2680	.2660	.132
HS45	.3245	.2160	.0732	.0183	.3130	.3110	.140
HS50	.3670	.2400	.0740	.0233	.3530	.3510	.155

NOTE:

1. MARK PART NUMBER AND DRIVE SIZE ON EACH GAGE.
2. GO, NO-GO ELEMENT MATERIAL: CARBIDE.
3. LENGTH OF GO, NO-GO ELEMENTS: 5/8 MINIMUM.
4. TAPER FLATS TO BE CONCENTRIC TO OUTSIDE "A" DIA. WITHIN .0005 T.I.R.
5. ALL DIMENSIONS ARE IN INCHES.
6. HOLE DIA. TO BE CONCENTRIC TO OUTSIDE "A" DIA. WITHIN .002 T.I.R.

REVISION REV A:3/16/II REV B:4/8/II REV C: 2/1/12

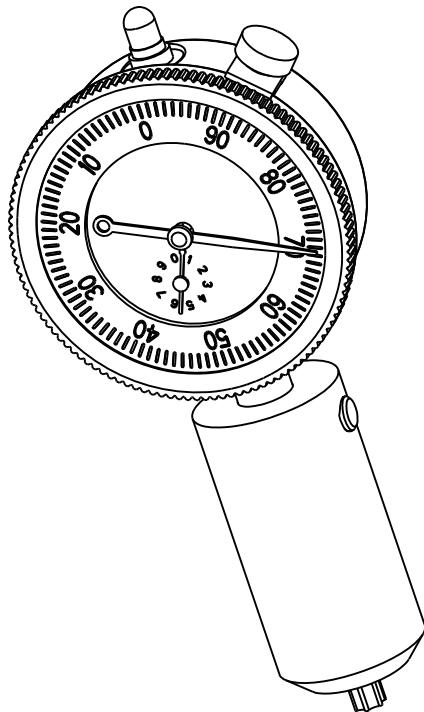
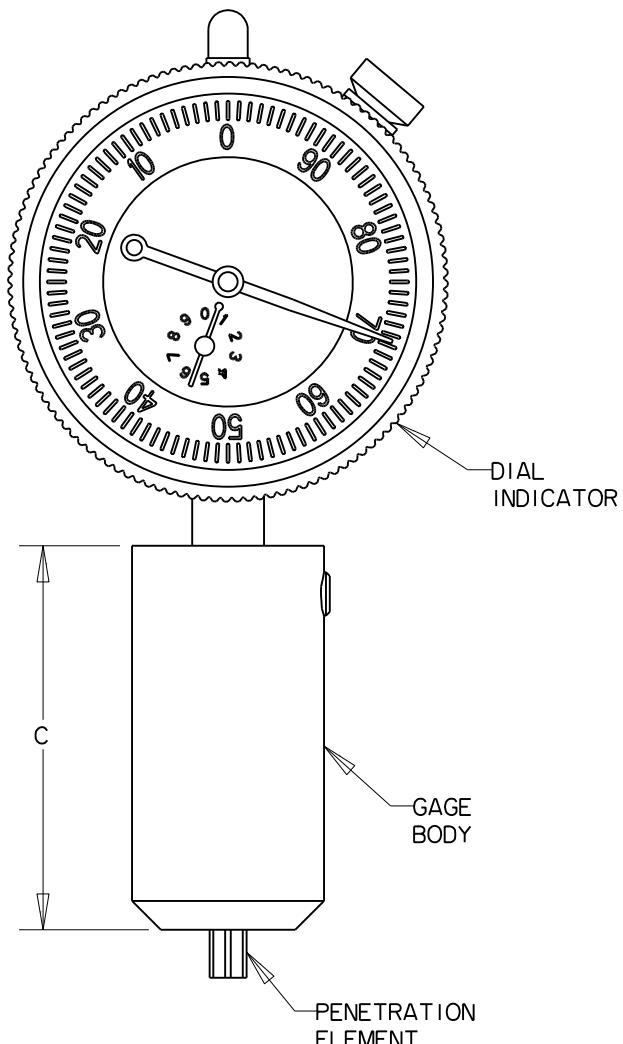
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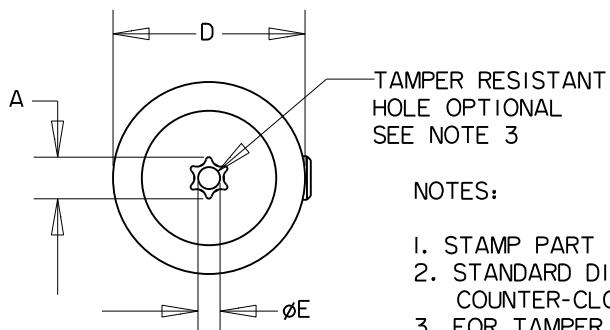
HEXSTIX®
RECESS PLUG GO, NO-GO GAGE

DRAWN	G.DILLING	DATE	DRAWING NUMBER
CHECKED:		5/19/10	PSC-H-40I
	G.DILLING	9/7/10	SHEET 1 OF 1
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DRIVE SIZE	MAX A REF	C REF	D REF	+.005 -.000 E
HS15	.1310	1.657	.875	.055
HS20	.1540	1.688	.875	.070
HS25	.1765	1.688	.875	.085
HS27	.1985	1.688	.875	.095
HS30	.2195	1.688	.875	.115
HS40	.2640	1.688	.875	.132
HS45	.3100	1.688	.875	.140
HS50	.3500	1.688	.875	.155



NOTES:

1. STAMP PART NUMBER AND POINT SIZE ON BODY OF GAGE.
2. STANDARD DIAL GAGE WITH NUMERAL READING COUNTER-CLOCKWISE IN THOUSANDS.
3. FOR TAMPER RESISTANT PENETRATION GAGE PLACE A "T" AT THE END OF PART NUMBER. "EXAMPLE: PSC-H-402-HS25-T"

REVISION REV A:3/16/11 REV B:2/11/12

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TITLE:

HEXSTIX®
PENETRATION GAUGE

DRAWN

G.DILLING

DATE

7/23/10

DRAWING NUMBER

PSC-H-402

CHECKED:

G.DILLING

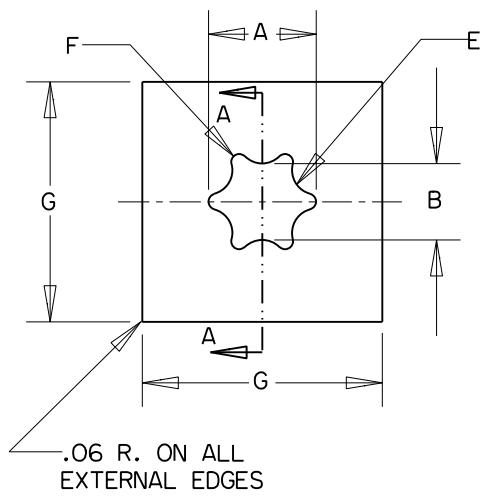
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9/09/10

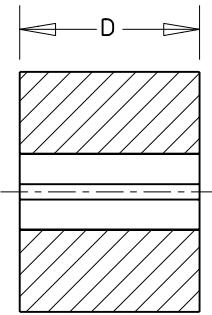
SHEET 1 OF 1

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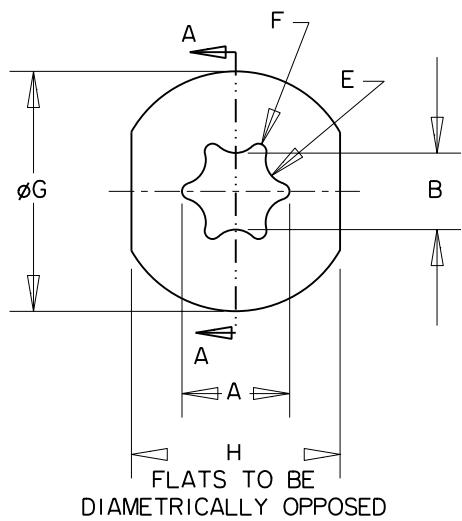
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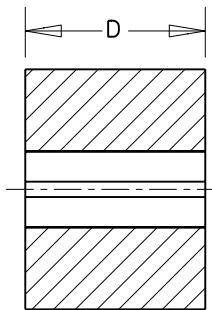
TEST BLOCK
STYLE I



SECTION A-A



TEST BLOCK
STYLE II



SECTION A-A

DRIVE SIZE	A +.0000 -.0010	B +.0000 -.0010	D REF	E REF	F REF	G +.000 -.031	H REF
HS15	.1405	.0960	.500	.0265	.0113	1.000	.870
HS20	.1650	.1125	.500	.0319	.0127	1.000	.870
HS25	.1900	.1290	.500	.0342	.0155	1.000	.870
HS27	.2140	.1446	.500	.0416	.0158	1.000	.870
HS30	.2350	.1600	.500	.0450	.0181	1.000	.870
HS40	.2840	.1925	.500	.0540	.0218	1.000	.870
HS45	.3315	.2240	.500	.0682	.0229	1.000	.870
HS50	.3740	.2560	.500	.0690	.0305	1.000	.870

NOTES:

1. MATERIAL: MI OR EQUIV., HEAT TREAT: Rc 61-63.
2. MARKING: IDENTIFY WITH THIS DWG NO. AND APPLICABLE RECESS SIZE NO., LOCATED ON TOP OR SIDE SURFACE.

REVISION REV A:3/6/11

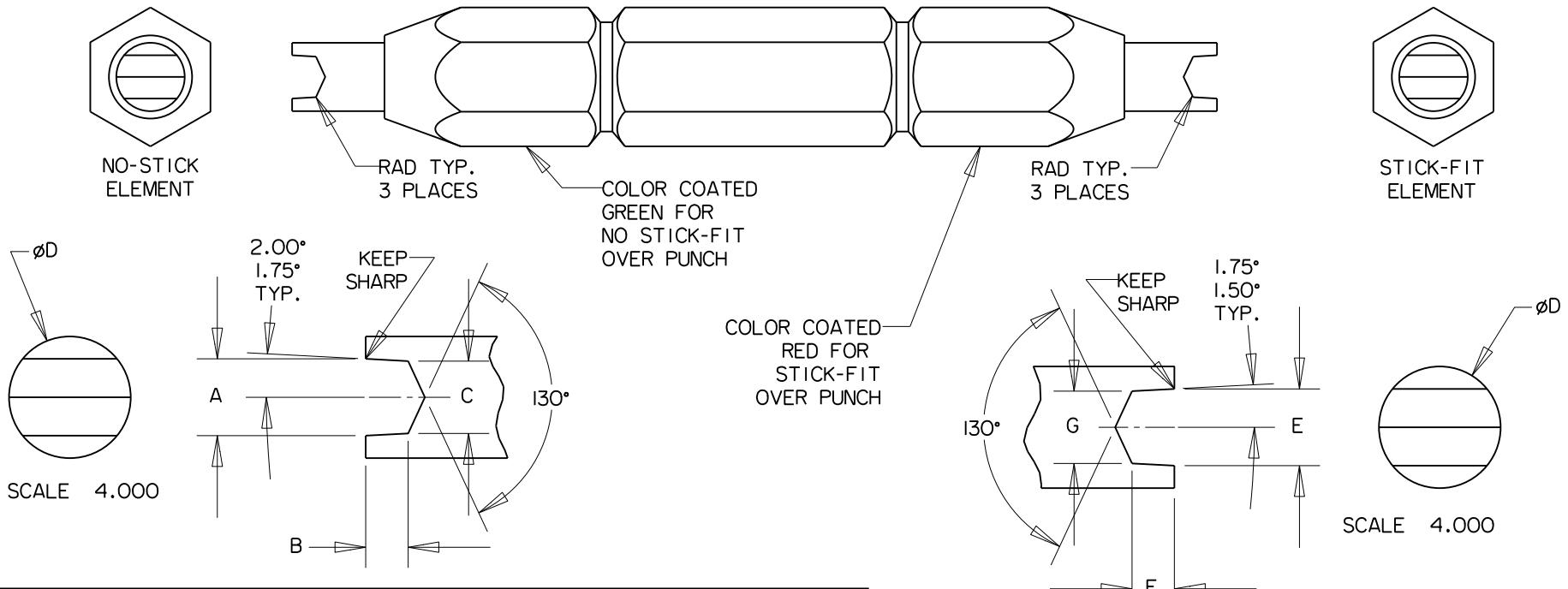
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TITLE:
HEXSTIX®
TORQUE TEST BLOCKS

DRAWN G.DILLING	DATE 7/23/10	DRAWING NUMBER PSC-H-403
CHECKED: G.DILLING	DATE 9/7/10	SHEET 1 OF 1

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DRIVE SIZE	NO-STICK			+.002 -.002 ϕD	STICK-FIT			MAX RAD
	REF A	+.002 -.002 B	+.0002 -.0002 C		REF E	+.002 -.002 F	+.0002 -.0002 G	
HS15	.1349	.033	.1327	.250	.1339	.033	.1320	.005
HS20	.1582	.038	.1557	.312	.1567	.038	.1545	.005
HS25	.1818	.040	.1792	.312	.1803	.040	.1780	.005
HS27	.2043	.048	.2012	.375	.2027	.048	.2000	.005
HS30	.2265	.058	.2227	.375	.2248	.058	.2215	.005
HS40	.2728	.070	.2682	.438	.2710	.070	.2670	.005
HS45	.3183	.086	.3132	.500	.3164	.086	.3120	.005
HS50	.3583	.086	.3532	.500	.3564	.086	.3520	.005

REVISION REV A.3/16/II REV B:4/8/II

NOTE:

1. MARK PART NUMBER AND DRIVE SIZE ON EACH GAGE.
2. GO, NO-GO ELEMENT MATERIAL: CARBIDE.
3. LENGTH OF GO, NO-GO ELEMENTS: 5/8 MINIMUM.
4. ALL DIMENSIONS ARE IN INCHES.

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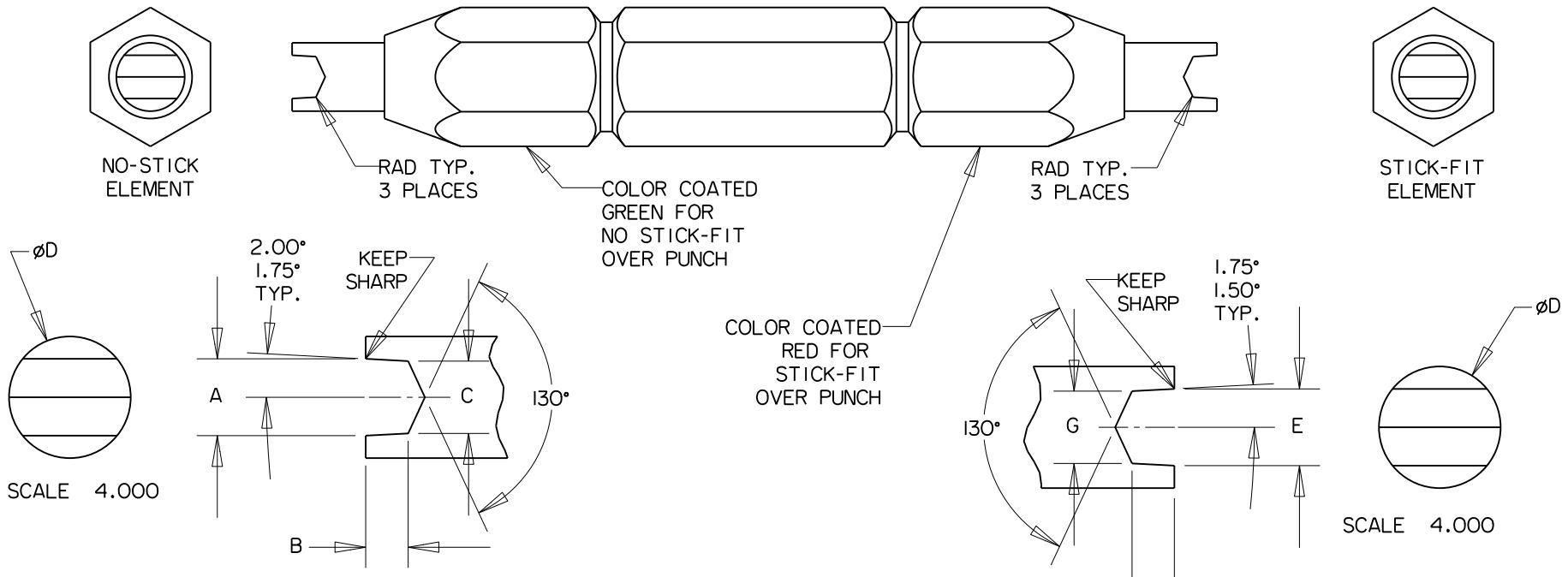
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HEXSTIX®
PUNCH PLUG GO, NO-GO GAGE

DRAWN G.DILLING	DATE 12/14/10	DRAWING NUMBER PSC-H-406
CHECKED: G.DILLING	DATE 12/14/10	SHEET 1 OF 1

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DRIVE SIZE	NO-STICK			+.002 -.002 ϕD	STICK-FIT			MAX RAD
	REF A	+.002 -.002 B	+.0002 -.0002 C		REF E	+.002 -.002 F	+.0002 -.0002 G	
HS15-OS	.1359	.033	.1337	.250	.1349	.033	.1330	.005
HS20-OS	.1597	.038	.1572	.312	.1587	.038	.1565	.005
HS25-OS	.1833	.040	.1807	.312	.1823	.040	.1800	.005
HS27-OS	.2058	.048	.2027	.375	.2047	.048	.2020	.005
HS30-OS	.2280	.058	.2242	.375	.2268	.058	.2235	.005
HS40-OS	.2743	.070	.2697	.438	.2730	.070	.2690	.005
HS45-OS	.3203	.086	.3147	.500	.3189	.086	.3140	.005
HS50-OS	.3603	.086	.3547	.500	.3589	.086	.3540	.005

NOTE:

1. MARK PART NUMBER AND DRIVE SIZE ON EACH GAGE.
2. GO, NO-GO ELEMENT MATERIAL: CARBIDE.
3. LENGTH OF GO, NO-GO ELEMENTS: 5/8 MINIMUM.
4. ALL DIMENSIONS ARE IN INCHES.
5. PLUG GAGE TO BE USED ON OVERSIZE PUNCH GEOMETRY.
SEE O.S. PUNCH POINT DRAWING PSC-H-50I FOR REFERENCE.

REVISION

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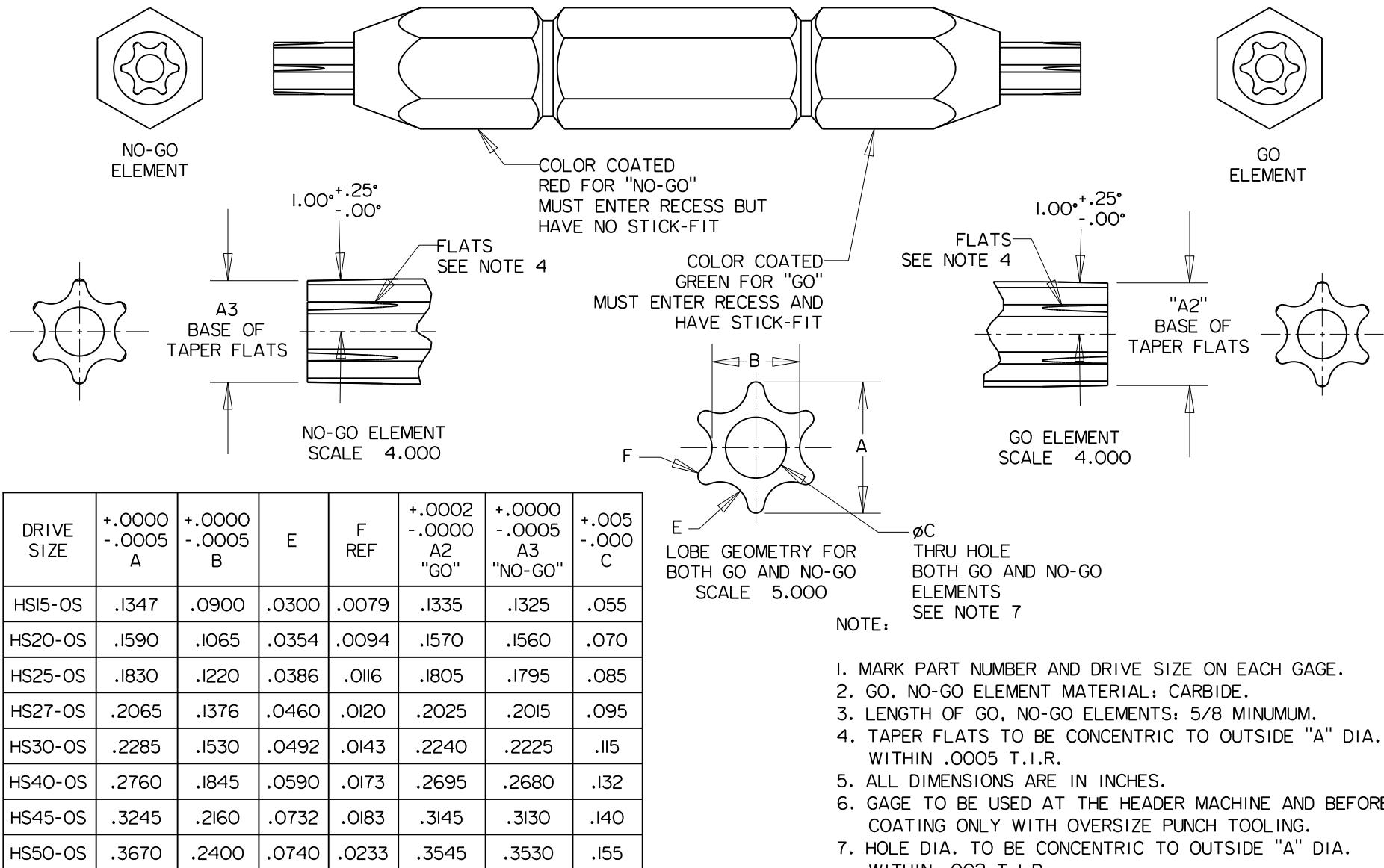
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HEXSTIX®
O.S. PUNCH PLUG GO, NO-GO GAGE

DRAWN G.DILLING	DATE 1/13/12	DRAWING NUMBER PSC-H-407
CHECKED: G.DILLING	DATE 1/13/12	SHEET 1 OF 1

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HEXSTIX® O.S. RECESS PLUG GO, NO-GO GAGE

DRAWN G.DILLING	DATE 1/13/12	DRAWING NUMBER PSC-H-408
CHECKED: G.DILLING	DATE 1/13/12	SHEET 1 OF 1

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HEXSTIX® ENGINEERING MANUAL
INDEX
QUALITY STANDARDS

PSC-H-300	INSPECTION REF SHEET FOR BIT AND RING GAUGE	9/14/IO
PSC-H-301	INSPECTION REF SHEET FOR SCREW AND PLUG GAUGE	8/26/IO
PSC-H-302	INSPECTION REF SHEET FOR SCREW AND PEN GAUGE	8/26/IO
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PSC-H-306	PUNCH INSPECTION PROCEDURES	IO/8/IO
PSC-H-307	INSPECTION REF SHEET FOR PUNCH FORK PLUG GAUGE	I/07/II

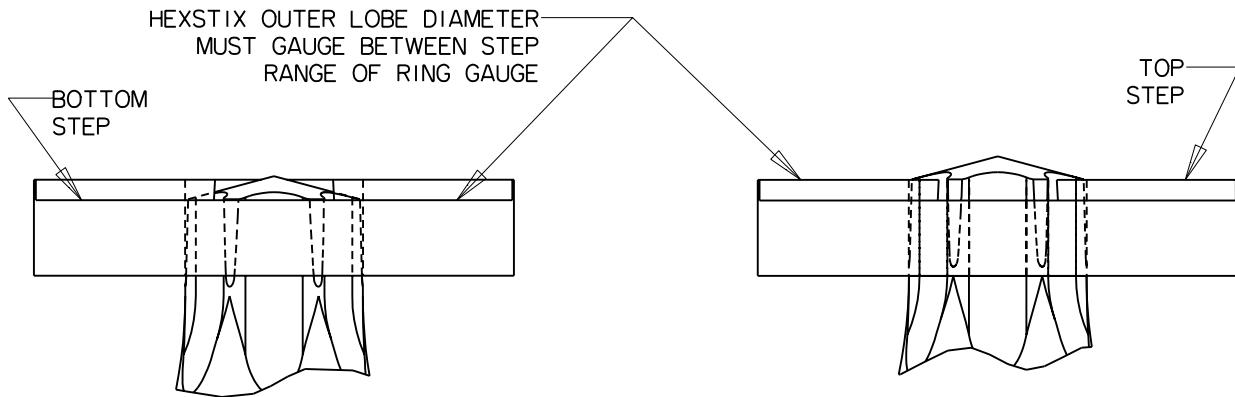


FIG 1: PASS
BIT MUST MEET BOTTOM STEP

FIG 2: PASS
BIT MUST MEET BUT NOT GO THRU TOP STEP

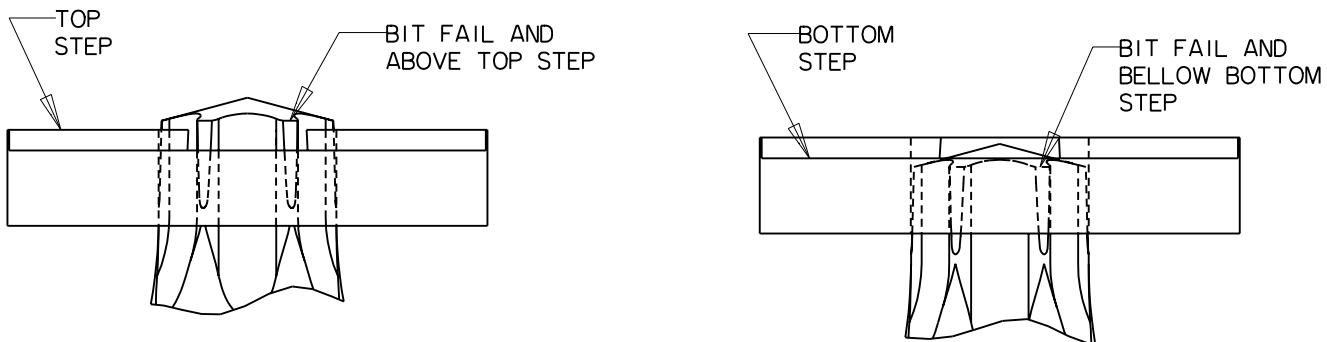


FIG 3: FAIL
BIT MUST NOT GO THRU TOP STEP

FIG 4: FAIL
BIT MUST NOT BE BELOW LOWER STEP

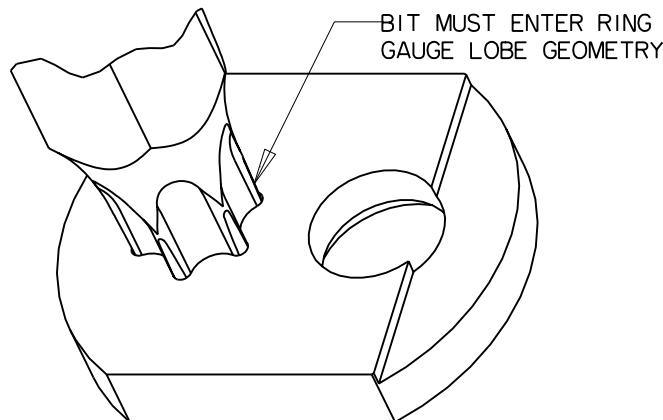


FIG 5: GO - PROFILE CHECK
BIT MUST GO AND ENTER LOBE GEOMETRY

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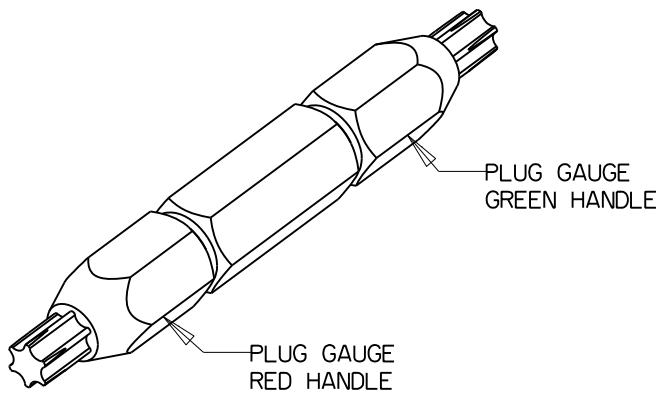
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TITLE: HEXSTIX® INSPECTION REF SHEET
FOR DRIVER BIT WITH RING GAUGE

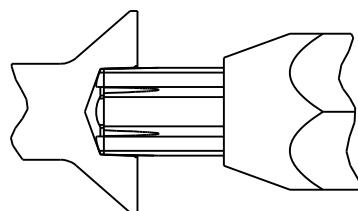
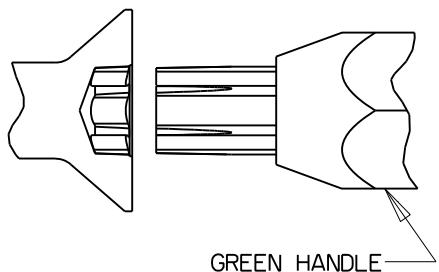
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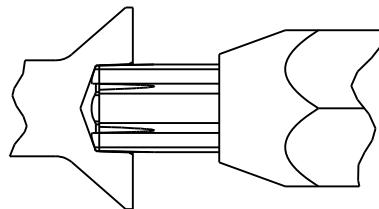
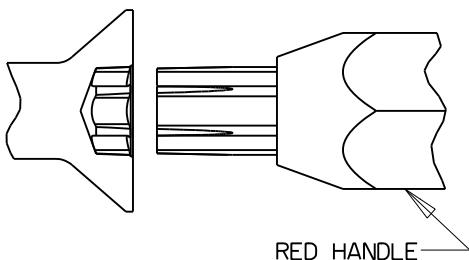
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I. GREEN HANDLE: PLUG GAUGE SHOULD ENTER INTO THE SCREW RECESS AND ACHIEVE STICK FIT.



2. RED HANDLE: PLUG GAUGE SHOULD BOTTOM INTO RECESS AND HAVE NO STICK FIT.



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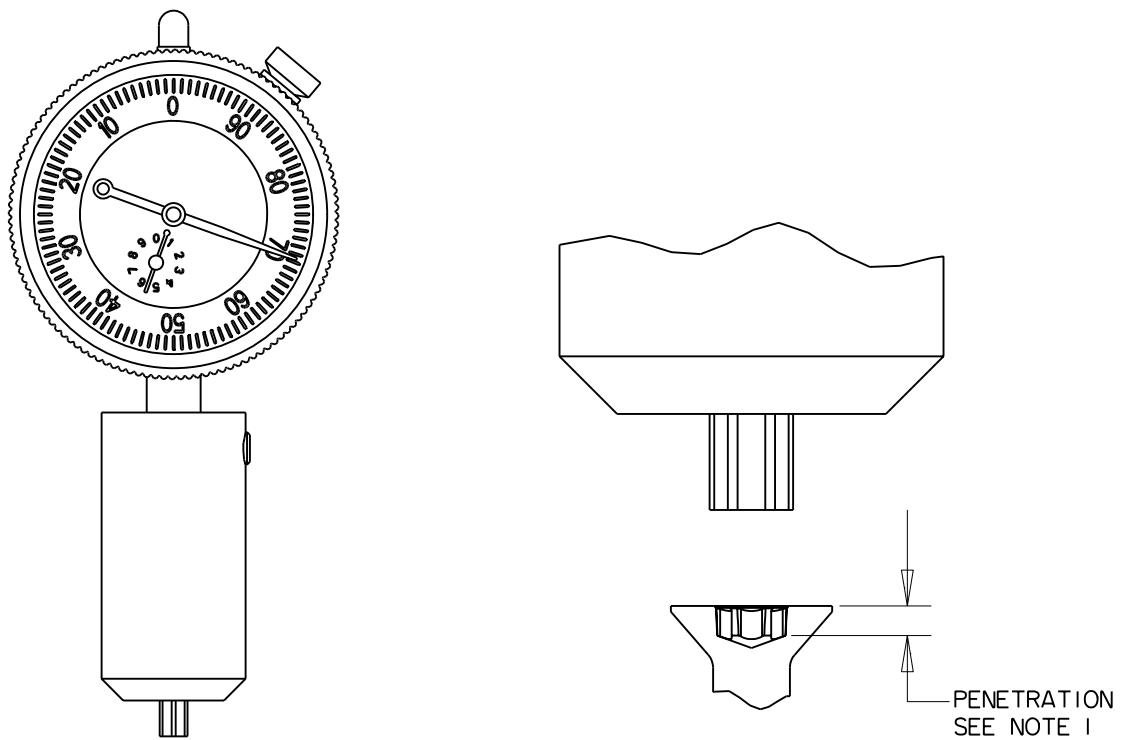
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TITLE: HEXSTIX® INSPECTION REF SHEET
FOR SCREW RECESS STICK-FIT PLUG GAUGE

DRAWN	DATE	DRAWING NUMBER
G.DILLING	8/26/10	PSC-H-301
CHECKED:	DATE	SHEET 1 OF 1
G.DILLING	8/26/10	PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326

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NOTES:

1. RECESS PENETRATION IS MEASURED FROM FACE OF SCREW RECESS TO THE BOTTOM CORNER OF THE RECESS.
2. HEXSTIX RECESS IS COMPATIBLE WITH ANY HEXLOBE OR SIXLOBE PENETRATION GAUGE.

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TITLE: HEXSTIX® INSPECTION REF SHEET
FOR SCREW RECESS PENETRATION GAUGE

DRAWN	DATE	DRAWING NUMBER
G.DILLING	8/26/10	PSC-H-302
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HEXSTIX® STABLE DRIVE SYSTEM QUALITY SPECIFICATIONS

1.0 SCOPE:

This quality specification defines inspection plans and procedures for initial inspection requirements, first article inspection, and final conformance inspection of HEXSTIX stable drive system driver bits, punches and recesses.

Inspection practice in accordance with procedures, sampling plans and specified gages set forth herein will guarantee product uniformity for dimension, appearance and function.

2.0 INSPECTION PLANS:

2.1 Initial Qualification:

Phillips Screw Company shall perform the initial qualification inspection for all new products as required under the license agreement.

A minimum of 50 pieces of each HEXSTIX drive system drive size and head style are to be qualified. Phillips Screw Company shall retain 25 pieces for reference material.

2.2 Periodic Inspection:

Every (4) months a letter is sent requesting a minimum of 5 pieces of each HEXSTIX drive system size and head style, as required by the license agreement.

2.3 First Article Inspection:

A first article inspection is required. Any defects found by visual inspection or gage readings beyond the stated limits, is reason for rejection and corrective action is required.

2.4 Final Quality Conformance Inspection:

Typical industry standards for sampling shall be used for each lot size. These samples will be inspected for visual and dimensional characteristics.

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	CHECKED: G.DILLING	DATE 10/8/10	SHEET 1 OF 1
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HEXSTIX® STABLE DRIVE SYSTEM QUALITY SPECIFICATIONS

BIT AND DRIVER INSPECTION PROCEDURES AND SPECIFICATIONS:

1.0 SCOPE:

The following document covers the equipment, procedures, test values and inspection criteria for HEXSTIX drive system screwdrivers, insert bits and power bits.

2.0 APPLICABLE DRAWINGS:

2.1 Insert driver bits:

PSC-H-200

2.3 Driver bit and screw driver manufacturing gages:

PSC-H-400

2.4 Torque test blocks:

PSC-H-403

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3.0 : REQUIREMENTS

3.1 Dimensions:

All bit and driver points shall conform to Phillips Screw Company's drawings PSC-H-200.

3.2 Quality:

The workmanship shall be of the highest quality throughout. Bits and screwdrivers shall be free from rust, fins, burrs, sharp or rough edges, corners or surfaces and defects that may impair their serviceability or durability.

3.3 Materials:

Screwdrivers and bits shall be made from the following recommended, equivalent or superior material:

3.3.1 Hand Screwdrivers - These drivers shall be made from AISI S2 steel or equivalent, and heat-treated to a hardness of HRC 58-62.

3.3.2 Insert and Power bits - These bits shall be made from AISI S2 steel or equivalent and heat-treated to a hardness of HRC 58-62.

3.3.3 Steel AISI S2 Type Analysis

Carbon	.50 - .55
Manganese	.45 - .55
Silicon	.90 - 1.10
Molybdenum	.45 - .55
Vanadium	.15 - .25

3.4 Markings:

3.4.1 HEXSTIX bit shall be marked "\. /" followed by the letters "HS" and the point size (e.g. \. / HS25). Manufactures may also include company names, trademark, trade names, part numbers etc. if they so desire.

3.4.2 In the case of hand screwdrivers, the handle and ferrule may be utilized for the above marking.

3.4.3 In the case of insert bits, if insufficient space is available for marking, the package or shipping container shall include the required identification.

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3.5 Bit Torsional Strength:

3.5.1	Minimal Torsional Strength:	Fatigue Torque Limit:
Drive size	Torque (Lb ins)	(Lb ins) ±10 %
HS15	70	42
HS20	115	69
HS25	170	102
HS27	240	144
HS30	335	201
HS40	575	345
HS45	910	546
HS50	1400	840

3.5.2 Test blocks:

Screwdrivers and bits shall be tested in the test blocks having the same form and size of the recess as the bit being tested. Screwdriver and bit test blocks shall be in accordance with drawing PSC-H-403.

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3.5.3 Test procedures:

The torsional loads shall be applied either with suitable torque wrenches or by means of a suitable lever system with dead weights. The driver or bit must be inserted fully into the test block and restrained in a hold down device to provide firm engagement with no axial movement.

The torsional load at failure shall be taken as the strength of the driver bit.

The failure load must exceed the minimum torsional strength as shown in paragraph 3.5.1

3.6 Gaging:

3.6.1 Driver Bit Ring Gauge:

The HEXSTIX[®] drive system driver bit must enter the appropriate six lobe form (PSC-H-400) and extend into the gage for the minimum "full form" length (H) dimension as shown on the appropriate driver point drawing (PSC - H-200). See Drawing Number PSC-H-300; Figure 5.

The bit must also enter the circular step gage, so that when fully inserted, the outer edge of the lobes lie between the bottom and top steps of the gage. (See Drawing Number PSC-H-300; Figures #1,2,3 and 4).

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4.0 PHYSICAL PROPERTIES

4.1 Discontinuities:

Driver bits shall be free from discontinuities such as laps, seams or inclusions greater in depth than 2 percent of the thickness at the discontinuity location.

4.2 Cracks:

Driver bits shall be free from cracks in any location or direction. A crack is defined as a clean crystalline break through the grain or grain boundary without inclusion of foreign elements.

5.0 QUALITY ASSURANCE PROVISIONS:

5.1 Responsibility for Inspection:

Unless otherwise specified in the contract or order, the manufacturer is responsible for the performance of all quality conformance inspection requirements as specified herein.

5.2 Change of Product:

After initial approval, any change of product as regards to materials, design, construction, or methods of manufacture shall require review and approval of Phillips Screw Company and may require qualification testing prior to incorporation into production lots.

5.3 Qualification Testing:

Qualification testing shall be performed per section 3.0 of this drawing.

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HEXSTIX® STABLE DRIVE SYSTEM QUALITY SPECIFICATIONS

RECESS INSPECTION PROCEDURES AND SPECIFICATIONS:

1.0 SCOPE:

The following document covers the equipment, procedures, test values and inspection criteria for HEXSTIX drive system recesses.

2.0 APPLICABLE DRAWINGS:

**2.1 Screw Recess
Go, No-Go gages:**

**HS15 thru HS50
HS15-O.S. thru HS50-O.S.**

**PSC-H-401
PSC-H-408**

2.2 Recess Penetration Gage Assy:

**HS15 thru HS50
HS15-O.S. thru HS50-O.S.**

PSC-H-402

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DRAWN L.DOUGAN	DATE 9/30/10	DRAWING NUMBER PSC-H-305													
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3.0 REQUIREMENTS:

3.1 Dimensions:

All HEXSTIX® drive system recesses shall conform to the appropriate Phillips Screw Company head standards.

3.2 Quality:

The workmanship shall be of the highest quality throughout. Recesses shall be free from rust, fins, burrs, sharp or rough edges, corners or surfaces and defects that may impair their serviceability or durability.

3.3 Markings:

3.3.1 Head marking must be to Phillips Screw Company drawing PSC-H-503

3.4 Gaging:

3.4.1 Go Plug Gage:

Using finger pressure only, place the appropriate GO gage (PSC-H-401, PSC-H-408) into the recess until resistance is felt. The fastener must "stick-fit" to the plug gage when the gage is held in a vertical position. (Ref. Drawing No. PSC-H-301)

3.4.2 NO-GO Plug Gage:

Using finger pressure only, place the appropriate NO-GO gage (PSC-H-401, PSC-H-408) into the recess. The gage should enter the recess but provide no stick fit with the recess. (Ref. Drawing No. PSC-H-301)

3.4.3 Penetration Gage:

Using the appropriate size penetration gage (PSC-H-402) check the zero adjustment against a known flat piece of steel stock.

Insert the penetration element into the hexstix recess and firmly push the top of the recess against the bottom of the gage body.

Measure and record the gage penetration. The reading must be within the acceptable limits per the application part standard.

Gage readings outside the stated limits are cause for rejection. (Ref. Drawing No. PSC-H-302)

REVISION

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DRAWN L.DUGAN	DATE 9/30/10	DRAWING NUMBER PSC-H-305													
CHECKED G.DILLING	DATE 10/8/10	SHEET 2 OF 4													
PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326															
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4.0 PHYSICAL PROPERTIES:

4.1 Head Discontinuities:

See PSC-H-305 sheet 4 of 4 for examples of head discontinuities that shall be considered "ACCEPTABLE". Screws will be rejected if they exhibit imperfections as shown as "NOT ACCEPTABLE".

5.0 RECESS TO SHANK ECCENTRICITY:

5.1 The recesses in screw heads shall not be eccentric with the screw bodies by more than 6% of the nominal (basic) body diameter or .015", whichever is greater.

5.2 Generally, this inspection will be most readily accomplished by a simple visual examination.

6.0 QUALITY ASSURANCE PROVISIONS:

6.1 Responsibility for Inspection:

Unless otherwise specified in the contract or order, the manufacturer is responsible for the performance of all quality conformance inspection requirements as specified herein.

6.2 Qualification Testing:

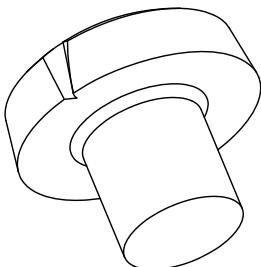
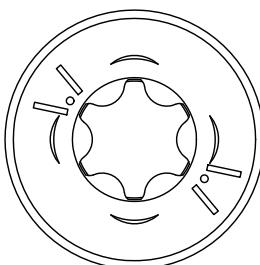
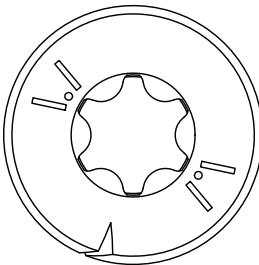
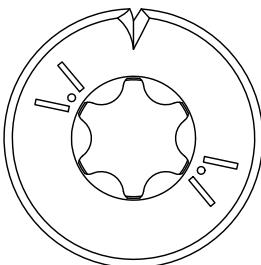
Qualification testing shall be performed per sections 3.0, 4.0 and 5.0 of this drawing.

REVISION

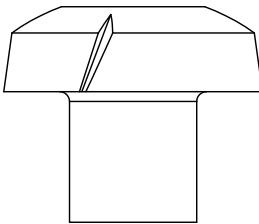
© COPYRIGHT 2011 PHILLIPS SCREW COMPANY. ALL RIGHTS RESERVED.		TITLE: HEXSTIX® DRIVE SYSTEM RECESS INSPECTION		
DRAWN	L.DUGAN	DATE	9/30/10	DRAWING NUMBER
CHECKED:	G.DILLING	DATE	10/8/10	PSC-H-305 SHEET 3 OF 4
PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326				
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FIGURE #1

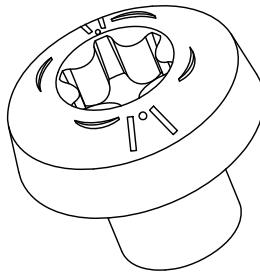
NOT ACCEPTABLE



(1)



(2)



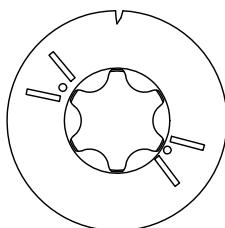
(3)

LARGE IMPERFECTIONS
EXTENDING OVER 1/2 WAY
TO RECESS

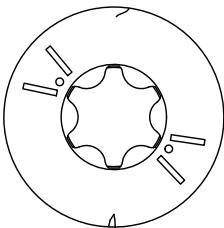
OPEN ANGULAR
IMPERFECTIONS
ON EDGE OF HEAD

SLIVERS OR LOOSE
FLAKES ON TOP
OF HEAD

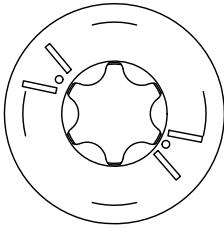
ACCEPTABLE



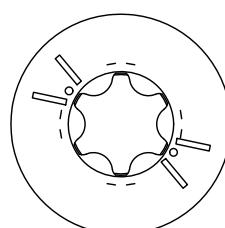
(4)



(5)



(6)



(7)

MULTIPLE IMPERFECTIONS
NOT EXTENDING 1/2 WAY
TO RECESS AND NOT
AFFECTING USABILITY

SLIGHT HAIR
LINES

SLIGHT RECESS
FLOW LINES

SLIGHT TOOL MARKS
SLIGHT PIN MARKS

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TITLE:

HEXSTIX® DRIVE SYSTEM
RECESS INSPECTION

DRAWN

L. DOUGAN

DATE

9/30/10

DRAWING NUMBER

PSC-H-305

CHECKED:

G. DILLING

DATE

10/8/10

PHILLIPS SCREW CO.

155 FARM STREET, BELLINGHAM, MA 02019 U.S.A.

PHONE: 774-396-6188 FAX: 508-966-2326

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HEXSTIX® STABLE DRIVE SYSTEM QUALITY SPECIFICATIONS

PUNCH INSPECTION PROCEDURES AND SPECIFICATIONS:

1.0 SCOPE:

The following document covers the equipment, procedures, test values and inspection criteria for HEXSTIX drive system punches.

2.0 APPLICABLE DRAWINGS:

2.1 Punch Point Dimensions	HS15 thru HS50 HS15-O.S. thru HS50-O.S.	PSC-H-500 PSC-H-501
2.2 Punch PLUG Go, No-Go gages:	HS15 thru HS50 HS15-O.S. thru HS50-O.S.	PSC-H-406 PSC-H-407

2.3 Punch Penetration Gage Assy:

HS15 thru HS50 HS15-O.S. thru HS50-O.S.	PSC-H-402
--	-----------

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	DRAWN L.DOUGAN DATE 9/30/10 CHECKED G.DILLING DATE 10/8/10
DRAWING NUMBER PSC-H-306 SHEET 1 OF 3	
PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326	
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3.0 REQUIREMENTS:

3.1 Dimensions:

All HEXSTIX® stable drive system punches shall conform to the appropriate Phillips Screw Company's punch standards and punch point dimensions as shown in section 2.1.

3.2 Quality:

The workmanship shall be of the highest quality throughout. Punches shall be free from rust, fins, burrs, sharp or rough edges, corners or surfaces and defects that may impair their serviceability or durability.

3.3 Markings:

3.3.1 HEXSTIX punches shall be marked with the appropriate punch number as shown on the punch drawings each of which begins with the letters "HS" and the drive size number (e.g. HS15-525-M3.5) and the manufacturer's symbol. Punches with OverSize recesses will have a suffix of "O.S.". Tamper Resistant punches will also have a "T" designation at the very end. Manufactures may also include company names, trademark, trade names, part numbers etc., if they so desired.

3.4 Gaging:

3.4.1 Punches may be inspected using casts, plug and penetration gages. Casts must be made of a good quality casting material. (Buehler Ultra-mount™ or equivalent)

3.4.2 Red Stick Fit Plug Gage:

Using light finger pressure only, place the appropriate Stick Fit gage (PSC-H-406, PSC-H-407) onto the punch point until resistance is felt. The punch must "stick-fit" to the plug gage when the gage is held in a vertical position. (Ref. Drawing Number PSC-H-307 Figure #1)

3.4.3 Green No-Stick Plug Gage:

Using finger pressure only, place the appropriate No-Stick gage (PSC-H-406, PSC-H-407) onto the punch point.

The gage should bottom on the point but provide no stick fit. (Ref. Drawing Number PSC-H-307 Figure #2)

3.4.4 Special Gages:

Special Stick and No-Stick Gages will be required for any non-standard punch recesses.

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DRAWN L.DOUGAN	DATE 9/30/10	DRAWING NUMBER PSC-H-306													
CHECKED: G.DILLING	DATE 10/8/10	SHEET 2 OF 3													
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PHILLIPS II PHILLIPS® POZIDRIV® ACR® POZISQUARE® PHILLIPS SQUARE-DRIV® TORQ-SET® TRI-WING® MORTORQ® AND HEXSTIX® ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY															

3.4.5 Penetration Gage:

Using the appropriate size penetration gage (section 2.3), check the zero adjustment against a known flat piece of steel stock.

Insert the penetration element into the HEXSTIX drive system recess, formed in the cast and firmly push the top of the recess against the bottom of the gage body.

Measure and record the gage penetration. The reading must be within acceptable limits per the application part standard.

Gage readings outside the stated limits are cause for rejection.

4.0 QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

Unless otherwise specified in the contract or order, the manufacturer is responsible for the performance of all quality conformance inspection requirements as specified herein.

4.2 Change of Product:

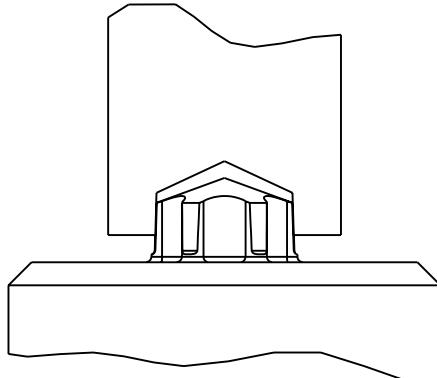
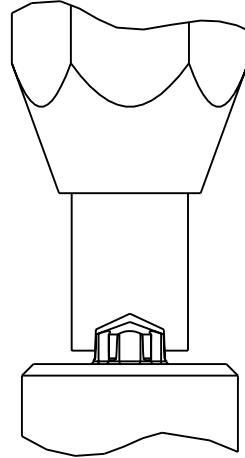
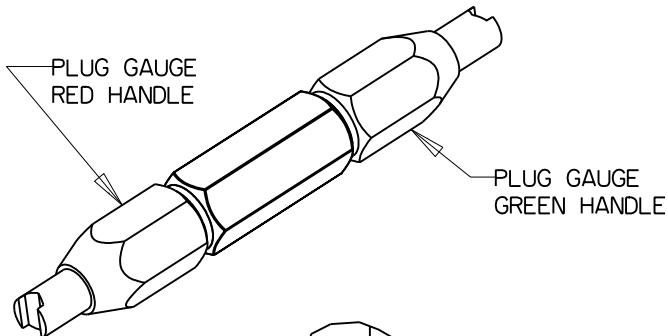
After initial approval, any change of product as regards to materials, design, construction, or methods of manufacture shall require review and approval of Phillips Screw Company and may require qualification testing prior to incorporation into production lots.

4.3 Qualification Testing:

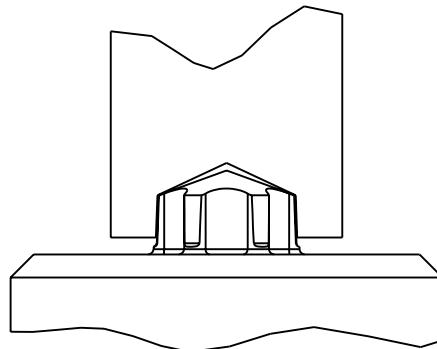
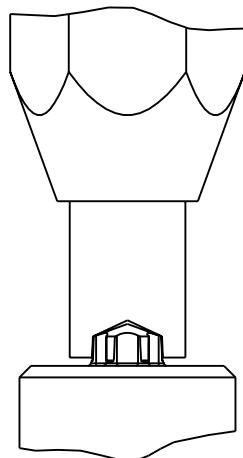
Qualification testing shall be performed per section 3.0 of this drawing.

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CHECKED: G.DILLING		DATE 10/8/10	SHEET 3 OF 3	
PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. 1880 FAX: 508-966-2326				
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1. RED HANDLE: FORK PLUG GAUGE SHOULD STICK-FIT OVER RECESS LOBES AND NOT BE ABLE TO ROTATE THE RECESS WITHIN THE FORK PLUG GAUGE ELEMENT.



2. GREEN HANDLE: FORK PLUG GAUGE SHOULD "NOT" STICK-FIT OVER RECESS LOBES AND BE ABLE TO ROTATE THE RECESS WITHIN THE FORK PLUG GAUGE ELEMENT.

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TITLE: HEXSTIX® INSPECTION REF SHEET
FOR PUNCH RECESS FORK PLUG GAUGE

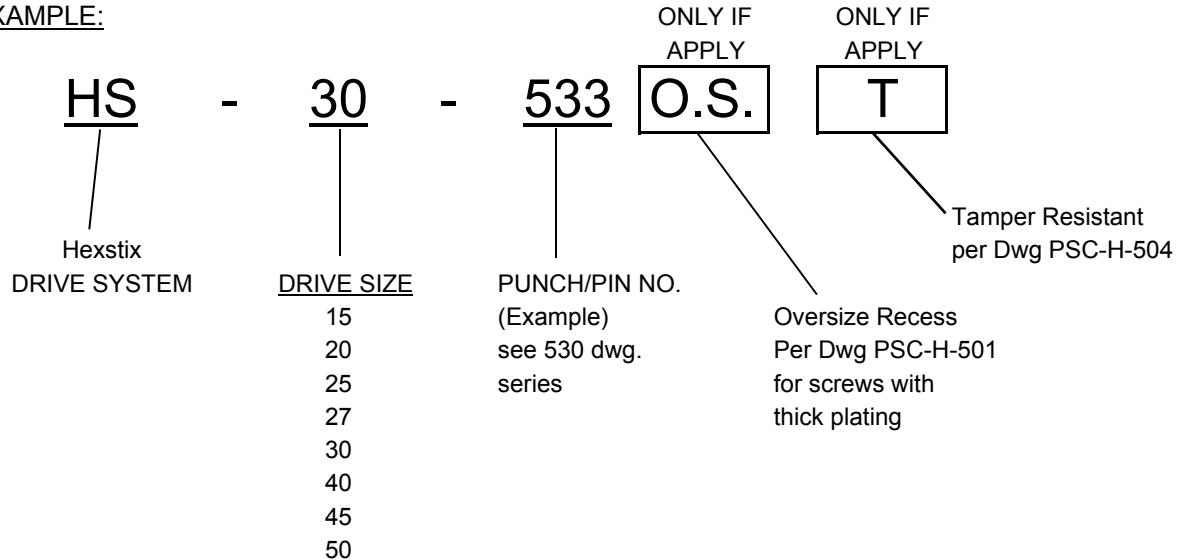
DRAWN G.DILLING	DATE 1/7/11	DRAWING NUMBER PSC-H-307
CHECKED: G.DILLING	DATE 1/7/11	

PHILLIPS SCREW CO., 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A.
PHONE: 774-396-6188 FAX: 508-966-2326

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Hexstix® Stable Drive System

EXAMPLE:



PUNCH EXAMPLE:

HS30-533 PIN PART NUMBER
DRAWING # : PSC-HS30-530

PUNCH/PIN DIMENSIONS:

HEXSTIX STANDARD PIN TOOLING UNDER
"530 SERIES" DRAWING

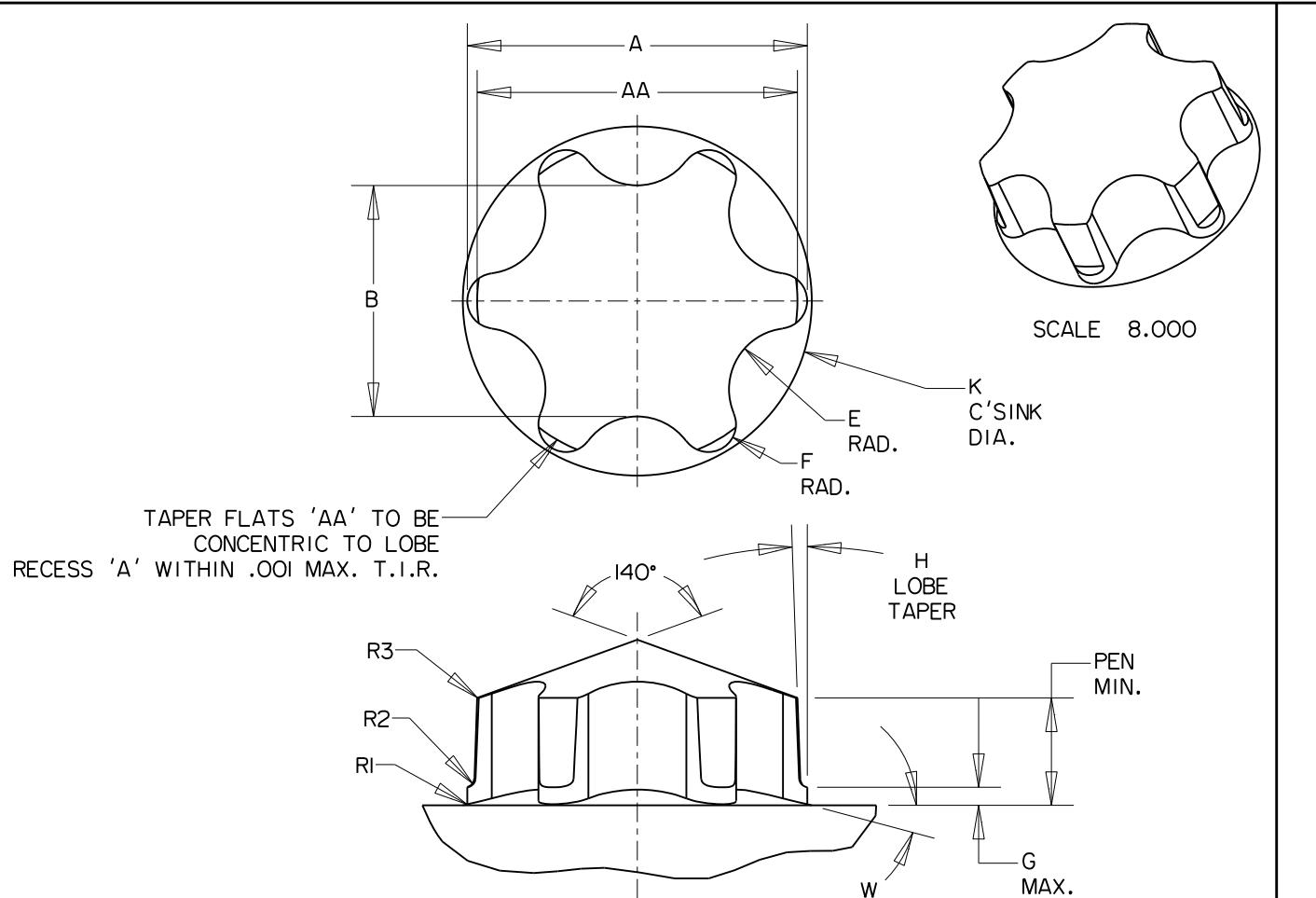
HEXSTIX "250" SERIES" PIN TOOLING
IS ALSO AVAILABLE

NOTES:

1. PIN/PUNCH PART NUMBER FOLLOWED BY O.S. REFERES TO OVERSIZE RECESS.
SEE DRAWING PSC-H-501 FOR OVERSIZE RECESS DIMENSIONS
2. PIN/PUNCH PART NUMBER ENDING WITH "T" REFERES TO TAMPER RESISTANT.
SEE DRAWING PSC-H-504 FOR TAMPER RESISTANT DETAIL DIMENSIONS.

HEXSTIX® ENGINEERING MANUAL
INDEX
PUNCH STANDARDS

PSC-H-500	PUNCH POINT DIMENSIONS	3/16/II
PSC-H-501	OVERSIZE RECESS PUNCH POINT DIMENSIONS	1/27/I2
PSC-H-502	PUNCH PIN RECESS BLANK	3/16/II
PSC-H-503	HEXSTIX HEAD MARKING	3/16/II
PSC-H-504	TAMPER RESISTANT RECESS PUNCH PIN DIMENSIONS	10/31/II
PSC-H-525	DOUBLE ANGLE FLAT HEAD PUNCH FOR LE SCREW	10/25/II
PSC-H-526	90° FLAT HEAD PUNCH FOR LE SCREW	10/25/II
PSC-H-527	HOLDER FOR PIN TOOLING	2/24/I4
PSC-H-528	PUNCH PIN RECESS FOR LE SCREW	2/24/I4
PSC-H-529	PAN HEAD HOLDER (INCH)	2/24/I4
PSC-H-530	PAN HEAD HOLDER (METRIC)	2/24/I4
PSC-H-531	TRUSS HEAD HOLDER (INCH)	2/24/I4
PSC-H-532	TRUSS HEAD HOLDER (METRIC)	2/24/I4
PSC-HS15-250	PUNCH PIN RECESS HSI5, 250 SERIES	2/24/I4
PSC-HS20-250	PUNCH PIN RECESS HS20, 250 SERIES	2/24/I4
PSC-HS25-250	PUNCH PIN RECESS HS25, 250 SERIES	2/24/I4
PSC-HS27-250	PUNCH PIN RECESS HS27, 250 SERIES	2/24/I4
PSC-HS30-250	PUNCH PIN RECESS HS30, 250 SERIES	2/24/I4
PSC-HS40-250	PUNCH PIN RECESS HS40, 250 SERIES	2/24/I4
PSC-HS45-250	PUNCH PIN RECESS HS45, 250 SERIES	2/24/I4
PSC-HS50-250	PUNCH PIN RECESS HS50, 250 SERIES	2/24/I4
PSC-HS15-530	PUNCH PIN RECESS HSI5, 530 SERIES	2/24/I4
PSC-HS20-530	PUNCH PIN RECESS HS20, 530 SERIES	2/24/I4
PSC-HS25-530	PUNCH PIN RECESS HS25, 530 SERIES	2/24/I4
PSC-HS27-530	PUNCH PIN RECESS HS27, 530 SERIES	2/24/I4
PSC-HS30-530	PUNCH PIN RECESS HS30, 530 SERIES	2/24/I4
PSC-HS40-530	PUNCH PIN RECESS HS40, 530 SERIES	2/24/I4
PSC-HS45-530	PUNCH PIN RECESS HS45, 530 SERIES	2/24/I4
PSC-HS50-530	PUNCH PIN RECESS HS50, 530 SERIES	2/24/I4



DRIVE SIZE	A	B	E MAX REF	F REF	+.0000 -.0010 AA	R1	R2	R3	PEN MIN	G MAX	+0.0° -.5° H	.005 -.005 K	W
HS15	.1405 .1395	.0960 .0950	.0265	.0113	.1325 .1320	.003 .005	.002 .006	.001 .003	.046	.006	2.00°	.145	15°
HS20	.1650 .1640	.1125 .1115	.0319	.0127	.1555	.003 .005	.002 .006	.002 .004	.054	.008	2.00°	.170	15°
HS25	.1900 .1890	.1290 .1280	.0342	.0155	.1790	.004 .007	.003 .007	.002 .004	.060	.010	2.00°	.195	15°
HS27	.2140 .2130	.1446 .1436	.0416	.0158	.2010	.004 .007	.003 .007	.002 .004	.068	.010	2.00°	.219	15°
HS30	.2350 .2340	.1600 .1590	.0450	.0181	.2225	.004 .007	.003 .007	.002 .004	.078	.010	2.00°	.240	15°
HS40	.2840 .2825	.1925 .1910	.0540	.0218	.2680	.004 .007	.003 .007	.002 .004	.090	.010	2.00°	.289	30°
HS45	.3315 .3300	.2240 .2225	.0682	.0229	.3130	.005 .008	.003 .007	.003 .006	.106	.010	2.00°	.337	30°
HS50	.3740 .3725	.2560 .2545	.0690	.0305	.3530	.005 .008	.003 .007	.003 .006	.120	.010	2.00°	.379	30°

REVISION REV A: 11/9/10 REV B: 3/16/11

NOTES:

I. ALL DIMENSIONS ARE IN INCH.

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TITLE: HEXSTIX®
PUNCH POINT DIMENSIONS

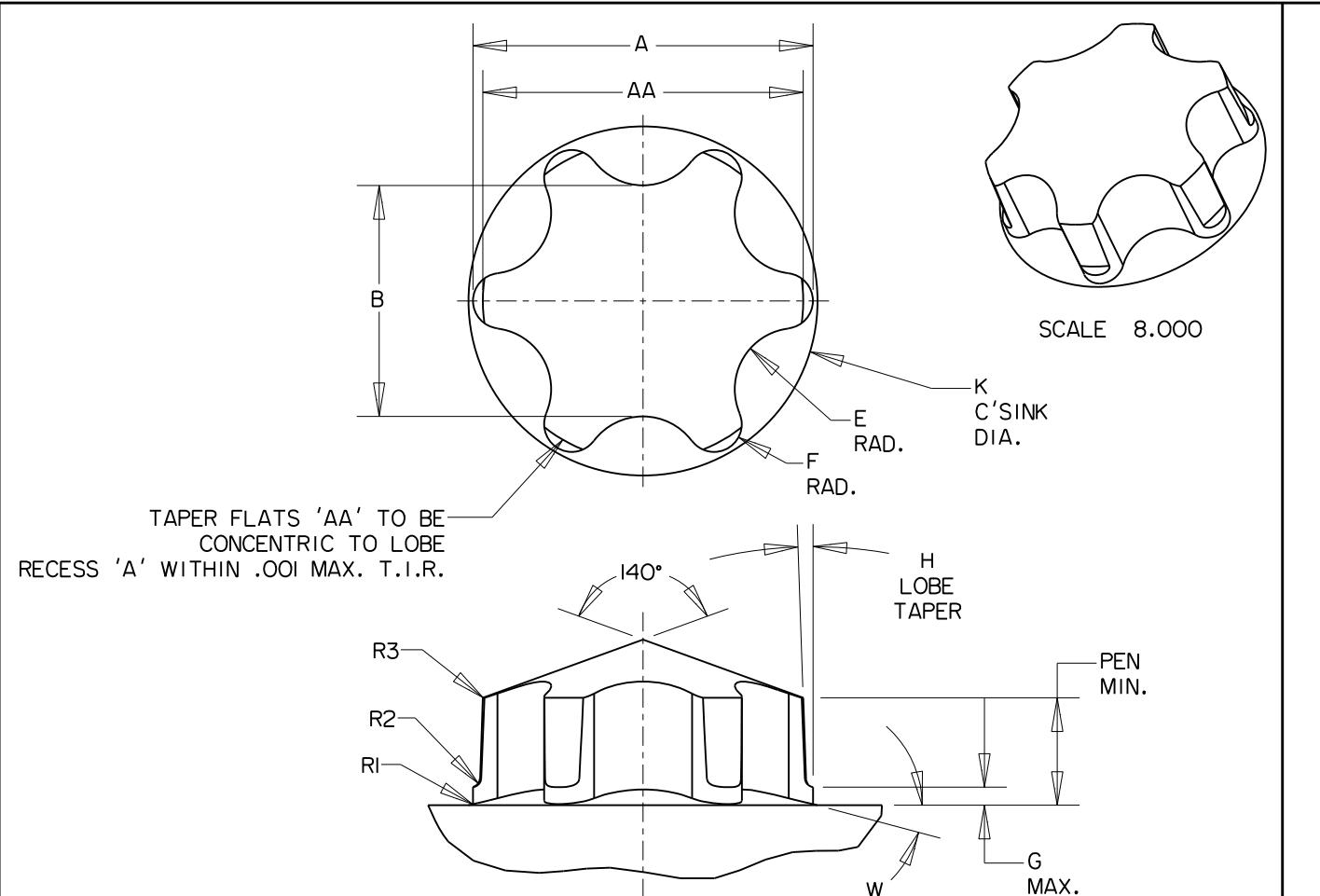
DRAWN G.DILLING	DATE 3/17/10	DRAWING NUMBER
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PSC-H-500

SHEET 1 OF 1

PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A.
PHONE: 774-396-6190 FAX: 508-966-2326

PHILLIPS II® PHILLIPS® POZIDRIV® ACR® POZISQUARE® PHILLIPS SQUARE-DRIV® TORQ-SET® TRI-WING® MORTORQ® HEXSTIX®
AND POZILOCK® ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY



DRIVE SIZE	A	B	E MAX REF	F REF	$+.0000$ $-.0005$	AA	R1	R2	R3	PEN MIN	G MAX	$+0.0^\circ$ -0.5°	$+.005$ $-.005$	K	W
HS15	.1405 .1395	.0960 .0950	.0265	.0113	.1335	.003 .005	.002 .006	.001 .003	.046	.006	2.00°	.145	.15°		
HS20	.1650 .1640	.1125 .1115	.0319	.0127	.1570	.003 .005	.002 .006	.002 .004	.054	.008	2.00°	.170	.15°		
HS25	.1900 .1890	.1290 .1280	.0342	.0155	.1805	.004 .007	.003 .007	.002 .004	.060	.010	2.00°	.195	.15°		
HS27	.2140 .2130	.1446 .1436	.0416	.0158	.2025	.004 .007	.003 .007	.002 .004	.068	.010	2.00°	.219	.15°		
HS30	.2350 .2340	.1600 .1590	.0450	.0181	.2240	.004 .007	.003 .007	.002 .004	.078	.010	2.00°	.240	.15°		
HS40	.2840 .2825	.1925 .1910	.0540	.0218	.2695	.004 .007	.003 .007	.002 .004	.090	.010	2.00°	.289	30°		
HS45	.3315 .3300	.2240 .2225	.0682	.0229	.3145	.005 .008	.003 .007	.003 .006	.106	.010	2.00°	.337	30°		
HS50	.3740 .3725	.2560 .2545	.0690	.0305	.3545	.005 .008	.003 .007	.003 .006	.120	.010	2.00°	.379	30°		

REVISION REV A: 11/9/10 REV B: 3/16/11 REV C: 1/27/12

NOTES:

- I. ALL DIMENSIONS ARE IN INCH.

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TITLE: HEXSTIX® "OVERSIZE"
PUNCH POINT DIMENSIONS

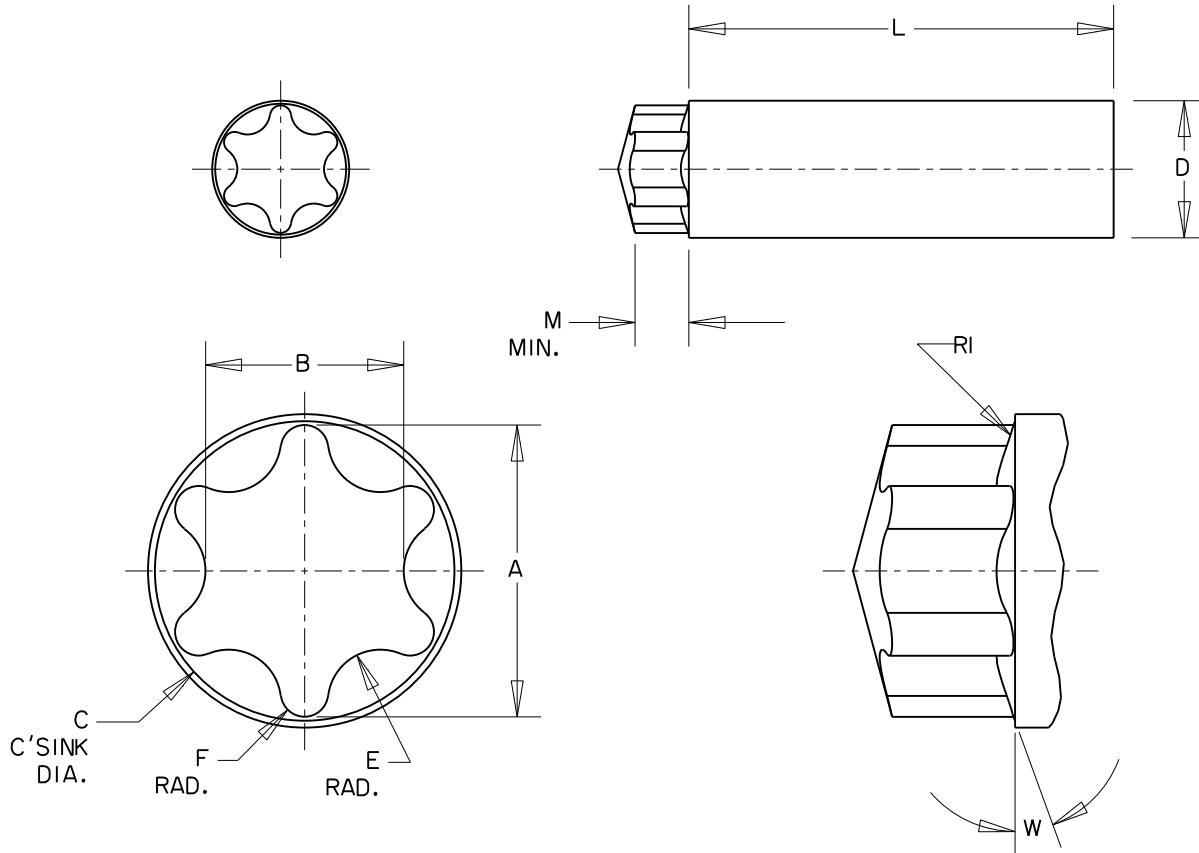
DRAWN G.DILLING DATE 10/15/10 DRAWING NUMBER

PSC-H-501

CHECKED: G.DILLING DATE 10/27/10 SHEET 1 OF 1

PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A.
PHONE: 774-396-6190 FAX: 508-966-2326

PHILLIPS II® PHILLIPS® POZIDRIV® ACR® POZISQUARE® PHILLIPS SQUARE-DRIV® TORQ-SET® TRI-WING® MORTORQ® HEXSTIX®
AND POZILOCK® ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY



DRIVE SIZE	PIN NO.	A	B	+.005 -.005	+.001 -.003	E REF	F REF	L	M MIN.	RI	W
HS15	HS15-BLK	.1405 .1395	.0960 .0950	.145	.149	.0265	.0113	.631 .629	.110	.003 .005	15°
HS20	HS20-BLK	.1650 .1640	.1125 .1115	.170	.183	.0319	.0127	.631 .629	.130	.003 .005	15°
HS25	HS25-BLK	.1900 .1890	.1290 .1280	.195	.204	.0342	.0155	.636 .632	.165	.004 .007	15°
HS27	HS27-BLK	.2140 .2130	.1446 .1436	.219	.225	.0416	.0158	.636 .632	.175	.004 .007	15°
HS30	HS30-BLK	.2350 .2340	.1600 .1590	.240	.254	.0450	.0181	.636 .632	.185	.004 .007	15°
HS40	HS40-BLK	.2840 .2825	.1925 .1910	.289	.300	.0540	.0218	.764 .760	.220	.004 .007	30°
HS45	HS45-BLK	.3315 .3300	.2240 .2225	.337	.374	.0682	.0229	1.014 1.010	.240	.005 .008	30°
HS50	HS50-BLK	.3740 .3725	.2560 .2545	.379	.417	.0690	.0305	1.014 1.010	.250	.005 .008	30°

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. MATERIAL: MI.
3. RECESS "A" TO BE CONCENTRIC TO "D" WITHIN .001 MAX. T.I.R.

REVISION REV A: 11/9/10 REV B: 3/16/11

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TITLE:

HEXSTIX® RECESS PUNCH PIN BLANK

DRAWN

G.DILLING

DATE

10/26/10

DRAWING NUMBER

PSC-H-502

CHECKED:

G.DILLING

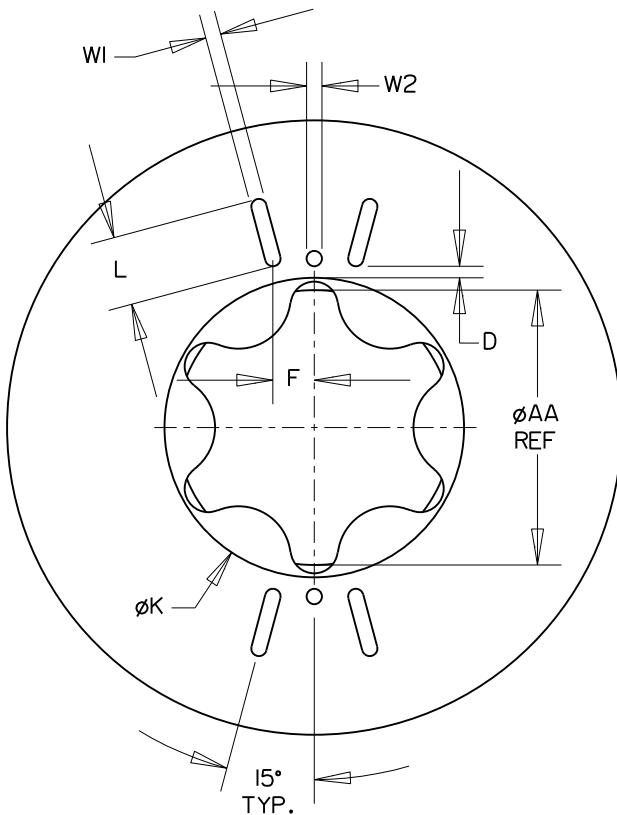
DATE

10/27/10

SHEET 1 OF 1

PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A.
PHONE: 774-396-6190 FAX: 508-966-2326

PHILLIPS II® PHILLIPS® POZIDRIV® ACR® POZISQUARE® PHILLIPS SQUARE-DRIV® TORQ-SET® TRI-WING® MORTORQ® HEXSTIX®
AND POZILOCK® ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY



DRIVE SIZE	AA	D MIN	F	K	L	WI	W2	MARKING NOTE 2
HS15	.1325	.005	.020	.145	.025 .035	.008	.008	.002 .004
HS20	.1555	.010	.020	.170	.025 .035	.008	.008	.002 .004
HS25	.1790	.010	.027	.195	.035 .045	.010	.010	.002 .004
HS27	.2010	.015	.027	.219	.035 .045	.010	.010	.002 .004
HS30	.2225	.020	.027	.240	.050 .060	.010	.010	.002 .004
HS40	.2680	.025	.027	.289	.050 .060	.010	.010	.002 .004
HS45	.3130	.025	.027	.337	.060 .070	.010	.010	.004 .006
HS50	.3530	.025	.027	.379	.060 .070	.010	.010	.004 .006

NOTES:

1. ALL DIMENSIONS ARE IN INCH.
2. THIS DIMENSION WOULD BE THE HEIGHT OR DEPTH OF MARKING ON A PUNCH OR PIN-HOLDER FACE.

REVISION

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TITLE: HEXSTIX®
HEAD MARKINGS

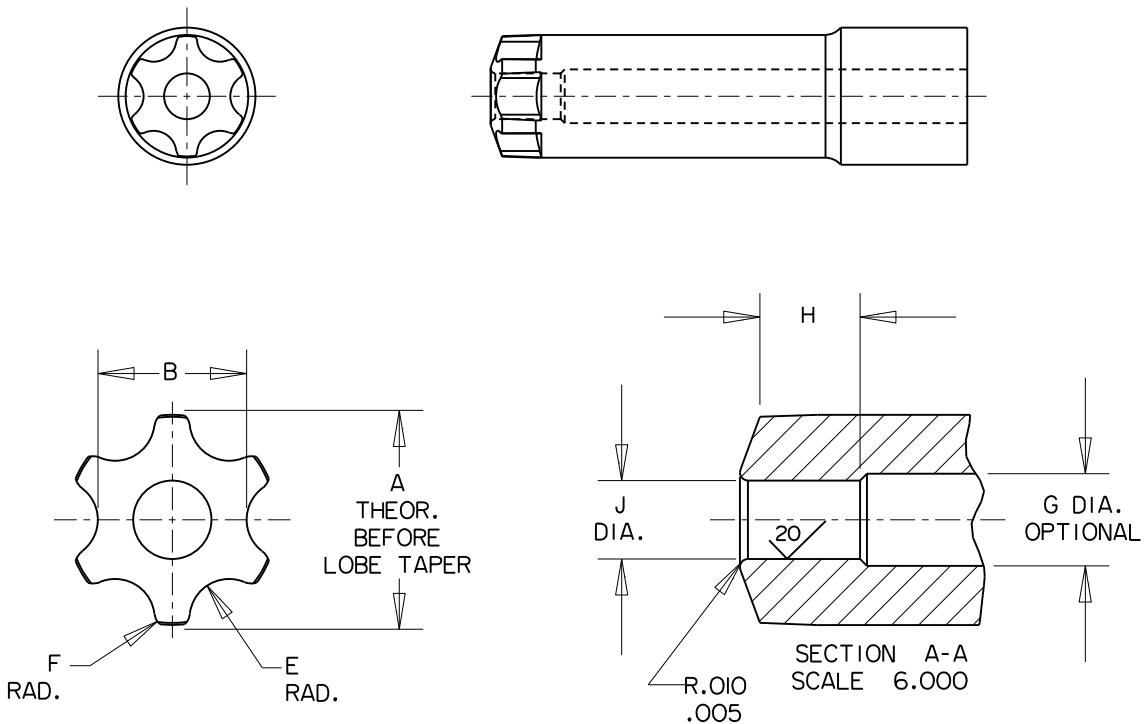
DRAWN G.DILLING DATE 3/15/11 DRAWING NUMBER

PSC-H-503

CHECKED: G.DILLING DATE 3/16/11 SHEET 1 OF 1

PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A.
PHONE: 774-396-6190 FAX: 508-966-2326

PHILLIPS II PHILLIPS POZIDRIV ACR POZISQUARE PHILLIPS SQUARE-DRIV TORQ-SET TRI-WING MORTORQ HEXSTIX AND POZILOCK ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY



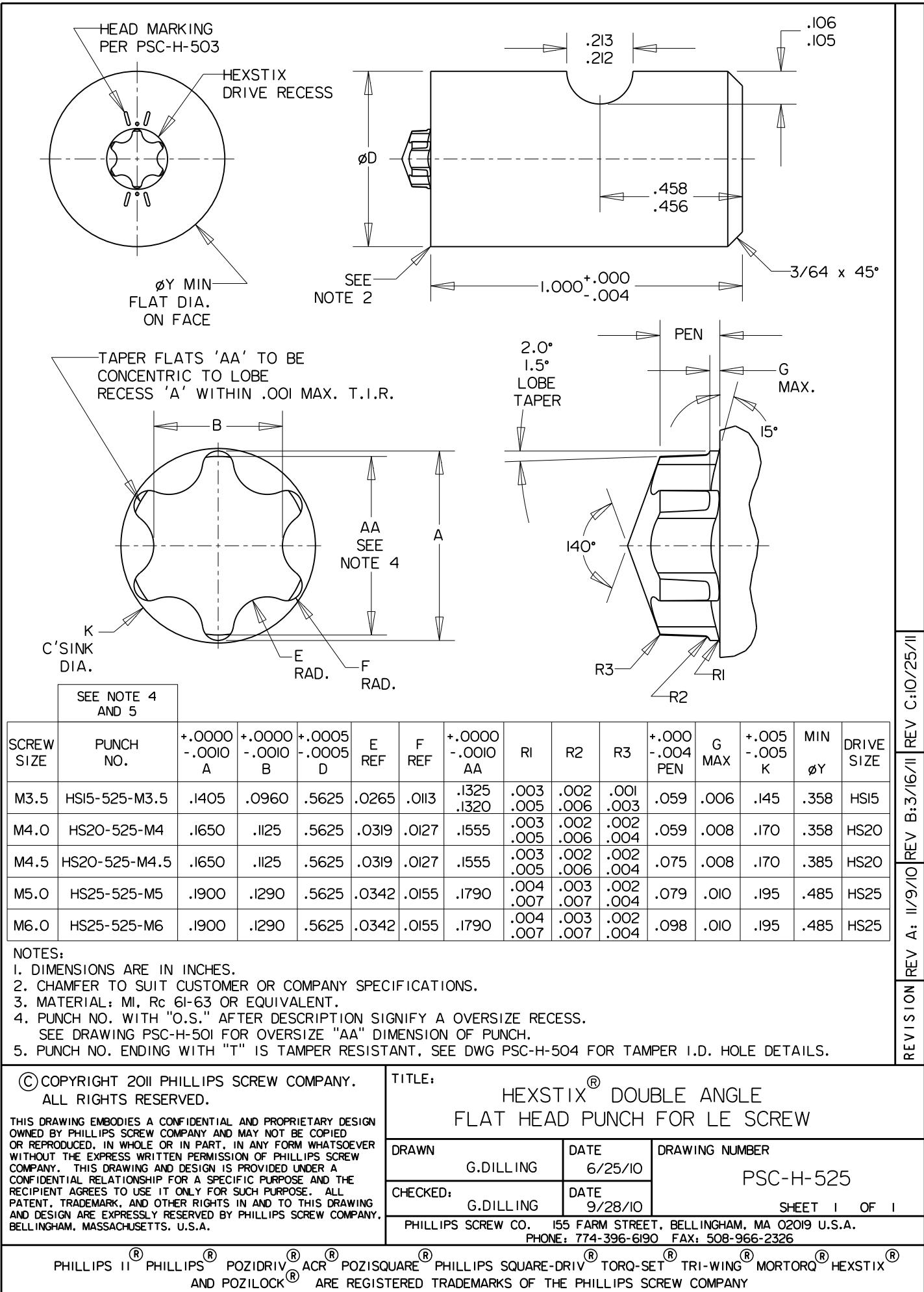
DRIVE SIZE	A	B	E REF	F REF	.+.002 -.000 J	.+.002 -.002 G	.+.015 -.000 H
HS15	.1405 .1395	.0960 .0950	.0265	.0113	.038	.050	.065
HS20	.1650 .1640	.1125 .1115	.0319	.0127	.053	.070	.075
HS25	.1900 .1890	.1290 .1280	.0342	.0155	.068	.080	.090
HS27	.2140 .2130	.1446 .1436	.0416	.0158	.078	.090	.100
HS30	.2350 .2340	.1600 .1590	.0450	.0181	.088	.100	.110
HS40	.2840 .2825	.1925 .1910	.0540	.0218	.102	.130	.130
HS45	.3315 .3300	.2240 .2225	.0682	.0229	.123	.140	.150
HS50	.3740 .3725	.2560 .2545	.0690	.0305	.138	.150	.170

NOTES:

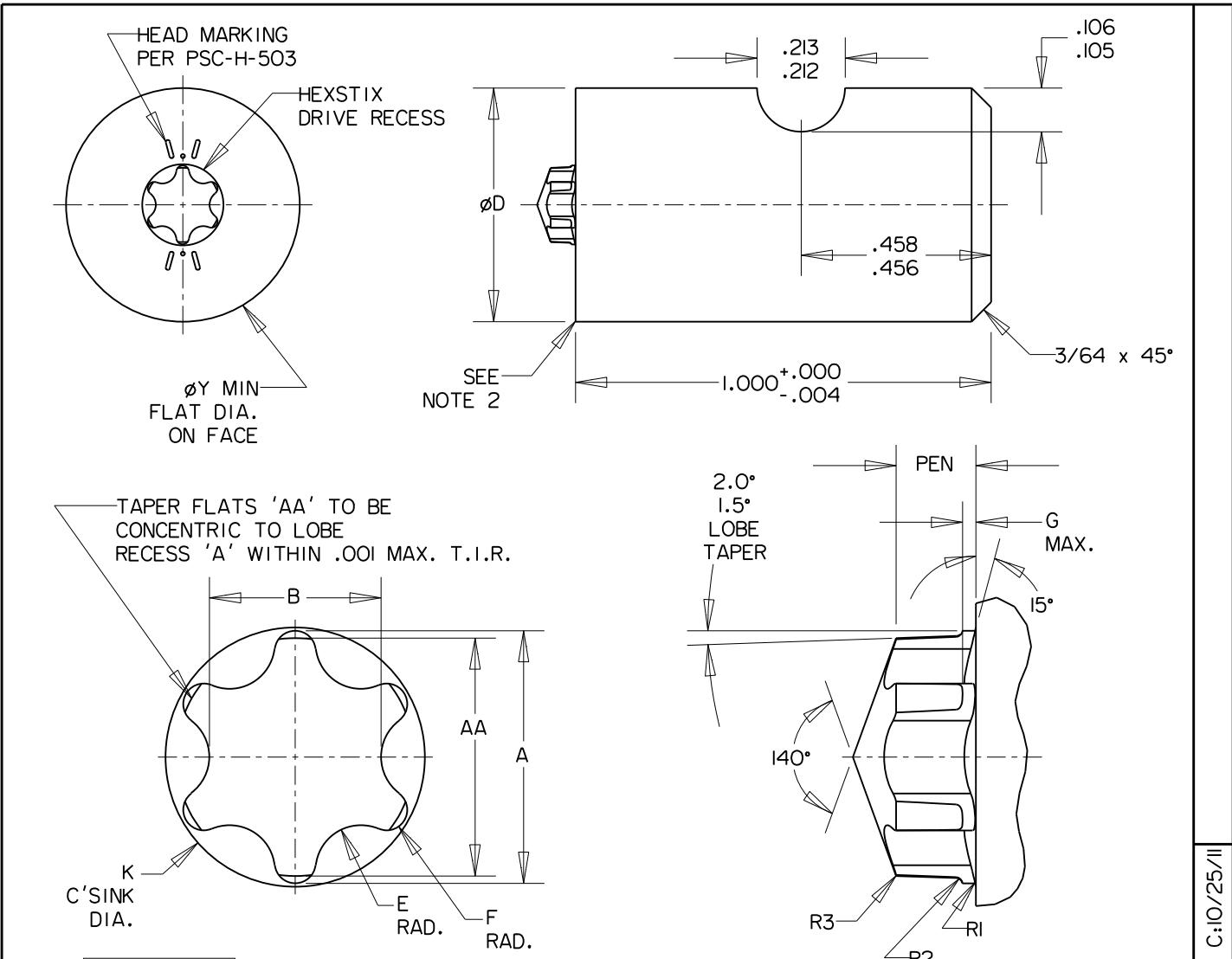
1. DIMENSIONS ARE IN INCHES.
2. "J" TO BE CONCENTRIC TO "A" WITHIN .003 T.I.R.
3. MATERIAL: MI, Rc 61-63 OR EQUIVALENT.

REVISION

© COPYRIGHT 2011 PHILLIPS SCREW COMPANY. ALL RIGHTS RESERVED.		TITLE: HEXSTIX® TAMPER RESISTANT RECESS PUNCH PIN		
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CHECKED: G.DILLING		DATE 10/31/11	SHEET 1 OF 1	
PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326				
PHILLIPS II® PHILLIPS® POZIDRIV® ACR® POZISQUARE® PHILLIPS SQUARE-DRIV® TORQ-SET® TRI-WING® MORTORQ® HEXSTIX® AND POZILOCK® ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY				



S ARE IN INCHES.



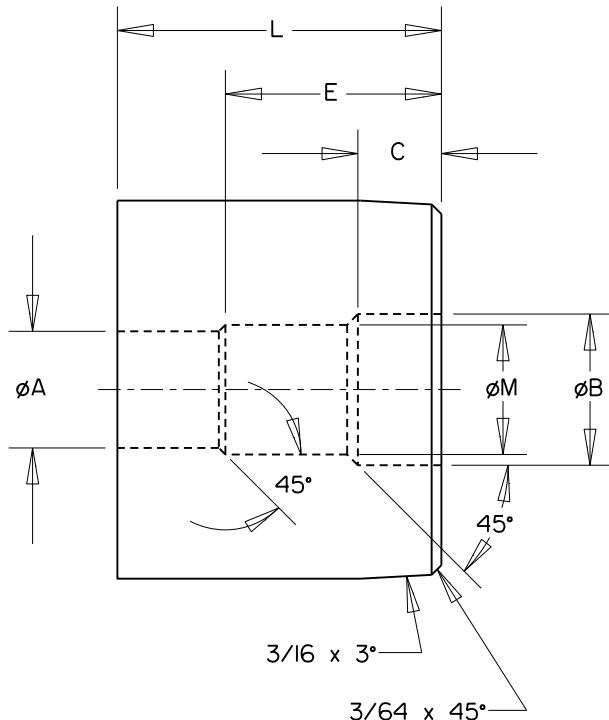
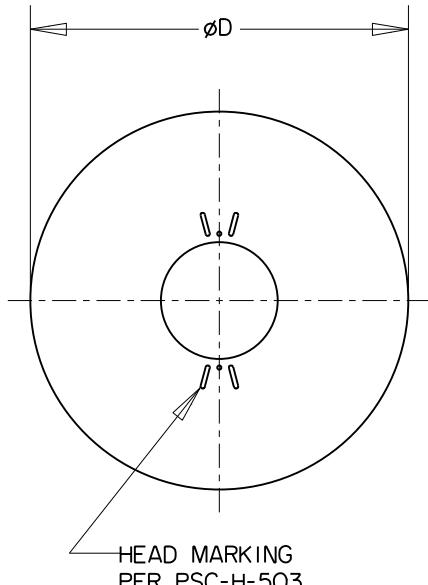
SEE NOTE 4 AND 5		SCREW SIZE	PUNCH NO.	+.0000 -.0010		+.0000 -.0010		+.0005 -.0005		E REF	F REF	+.0000 -.0010		RI	R2	R3	+.000 -.004		G MAX	+.005 -.005		MIN ØY	DRIVE SIZE
A	B			D	C	E	F	AA	AA			PEN	G	MAX	K								
M3.5	HS15-526-M3.5	.1405	.0960	.5625	.0265	.0113	.1325 .1320	.003 .005	.002 .006	.001 .003	.059	.006	.145	.358	HS15								
M4.0 M4.5	HS20-526-M4	.1650	.1125	.5625	.0319	.0127	.1555	.003 .005	.002 .006	.002 .004	.059	.008	.170	.358	HS20								
M5.0	HS25-526-M5	.1900	.1290	.5625	.0342	.0155	.1790	.004 .007	.003 .007	.002 .004	.079	.010	.195	.485	HS25								
M6.0	HS25-526-M6	.1900	.1290	.5625	.0342	.0155	.1790	.004 .007	.003 .007	.002 .004	.098	.010	.195	.530	HS25								

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. CHAMFER TO SUIT CUSTOMER OR COMPANY SPECIFICATIONS.
3. MATERIAL: MI, RC 61-63 OR EQUIVALENT.
4. PUNCH NO. WITH "O.S." AFTER DESCRIPTION SIGNIFY A OVERSIZE RECESS.
SEE DRAWING PSC-H-501 FOR OVERSIZE "AA" DIMENSION OF PUNCH.
5. PUNCH NO. ENDING WITH "T" IS TAMPER RESISTANT, SEE DWG PSC-H-504 FOR TAMPER I.D. HOLE DETAILS.

REVISION REV A: 11/9/10 REV B: 3/16/11 REV C: 10/25/11

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DRAWN G.DILLING	DATE 3/25/10	DRAWING NUMBER PSC-H-526									
CHECKED: G.DILLING	DATE 9/29/10	SHEET 1 OF 1									
<p>PHILLIPS II® PHILLIPS® POZIDRIV® ACR® POZISQUARE® PHILLIPS SQUARE-DRIV® TORQ-SET® TRI-WING® MORTORQ® HEXSTIX® AND POZILOCK® ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY</p>											



DRIVE SIZE	+.0005 -.0000	+.012 -.003	+.004 -.000	+.0005 -.0005	+.010 -.010	+.000 -.002	+.005 -.000
	ØA	ØB	C	ØD	E	L	ØM
HS15	.1440	.165	.193	.5625	.484	.625	.147
HS20	.1690	.201	.193	.5625	.469	.625	.173
HS25	.1940	.230	.193	.8750	.438	.625	.197
HS27	.2180	.242	.193	.8750	.407	.625	.221
HS30	.2390	.275	.193	.8750	.407	.625	.242
HS40	.2880	.324	.193	.8750	.500	.750	.291
HS45	.3360	.387	.193	1.0000	.625	1.000	.339
HS50	.3780	.428	.193	1.0000	.625	1.000	.381

REVISION REV A:3/6/11 REV B:2/24/14

NOTES:

1. "A" TO BE CONCENTRIC TO "D" WITHIN .002 T.I.R.
2. MATERIAL: MI, Rc 61-63, OR EQUIVALENT.

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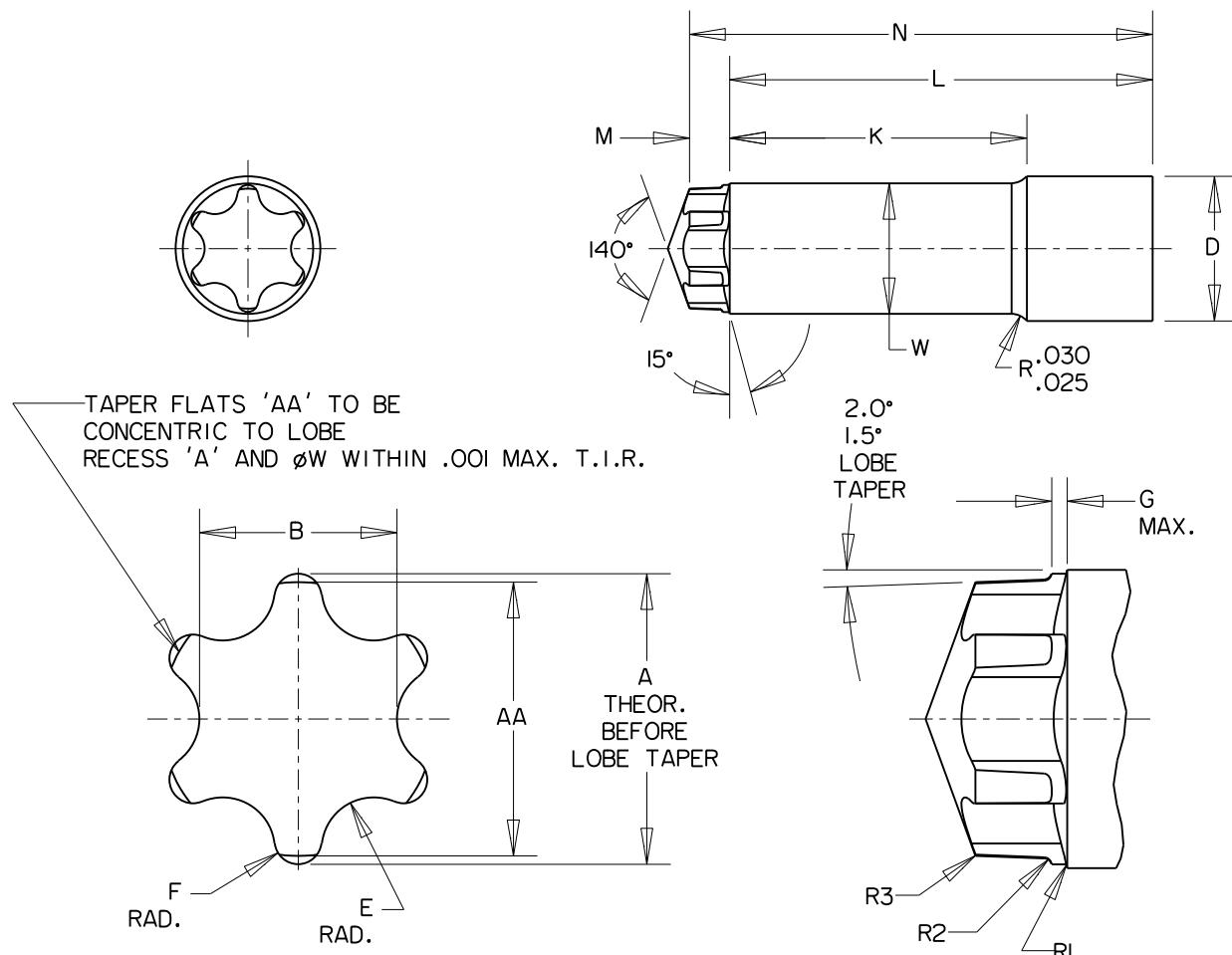
TITLE: HEXSTIX®
HOLDER STANDARDS FOR PIN TOOLING

DRAWN G.DILLING	DATE 9/13/10	DRAWING NUMBER
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CHECKED: G.DILLING	DATE 9/13/10	PSC-H-527
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PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A.
PHONE: 774-396-6190 FAX: 508-966-2326

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SEE NOTE 4 AND 5

DRIVE SIZE	PIN NO.	$+.0000$ -.0010 AA	$+.0000$ -.0010 A	$+.0000$ -.0010 B	$+.001$ -.003 D	E REF	F REF	G MAX	$+.010$ -.000 K	L	M REF	N	R1	R2	R3	$+.0005$ -.0000 W	RECESS PEN DEPTH
HS15	HS15-528-M3.5	.1325 .1320	.1405	.0960	.158	.0265	.0113	.006	.441	.631 .629	.054	.685 .683	.005 .003	.002 .006	.003 .001	.1450	.059 .049
HS20	HS20-528-M4	.1555	.1650	.1125	.194	.0319	.0127	.008	.441	.631 .629	.053	.685 .682	.005 .003	.002 .006	.004 .002	.1700	.059 .049
HS20	HS20-528-M4.5	.1555	.1650	.1125	.194	.0319	.0127	.008	.441	.631 .629	.069	.701 .698	.005 .003	.002 .006	.004 .002	.1700	.075 .065
HS25	HS25-528-M5	.1790	.1900	.1290	.216	.0342	.0155	.010	.444	.636 .632	.072	.708 .704	.007 .004	.003 .007	.004 .002	.1950	.079 .069
HS25	HS25-528-M6	.1790	.1900	.1290	.216	.0342	.0155	.010	.444	.636 .632	.091	.727 .723	.007 .004	.003 .007	.004 .002	.1950	.098 .088

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. "A" TO BE CONCENTRIC TO "W" WITHIN .001 MAX. T.I.R.
3. MATERIAL: MI, Rc 61-63 OR EQUIVALENT.
4. PIN NO. WITH "O.S." AFTER DESCRIPTION SIGNIFY A OVERSIZE RECESS.
SEE DRAWING PSC-H-501 FOR OVERSIZE "AA" DIMENSION OF PIN.
5. PIN NO. ENDING WITH "T" IS TAMPER RESISTANT. SEE DWG PSC-H-504 FOR TAMPER I.D. HOLE DETAILS.

REVISION REV A: II/9/10 REV B:3/16/11 REV C:10/25/11 REV D:2/24/14

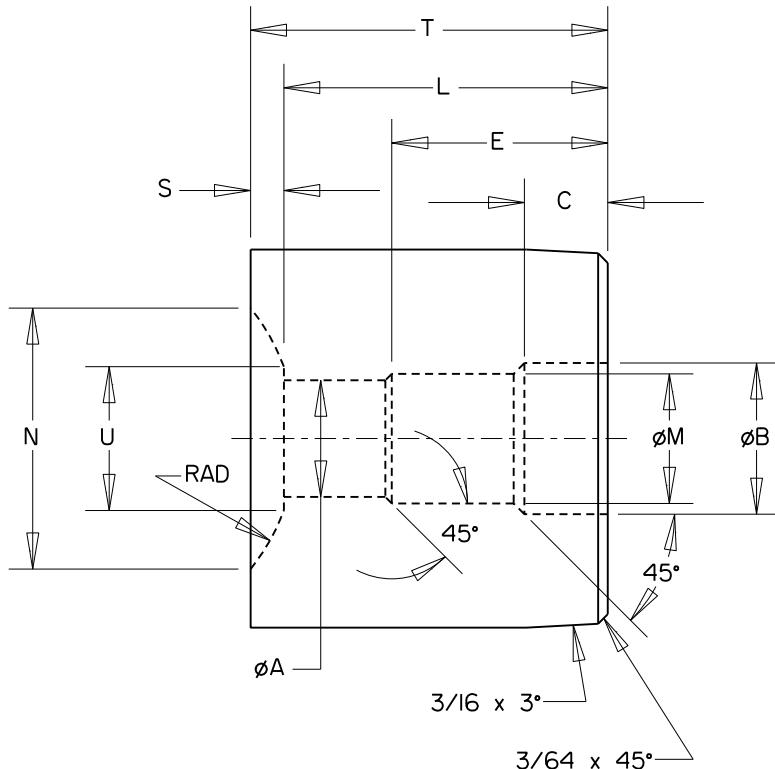
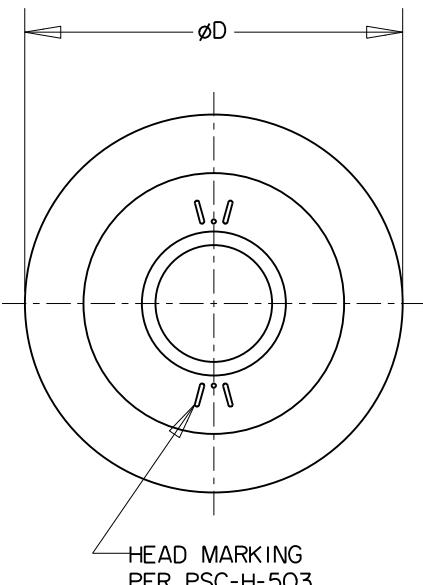
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TITLE: HEXSTIX®
PUNCH PIN FOR LE DOUBLE ANGLE HEAD SCREW

DRAWN G.DILLING	DATE 6/30/10	DRAWING NUMBER PSC-H-528
CHECKED: G.DILLING	DATE 9/28/10	SHEET 1 OF 1
PHILLIPS SCREW CO., 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326		

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AND POZILOCK® ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY



DRIVE SIZE	HOLDER	+.0005 -.0000	+.012 -.003	+.004 -.000	+.0005 -.0005	+.010 -.010	+.000 -.002	+.005 -.000	+.005 -.000	RAD REF	S REF	+.000 -.004	+.004 -.000
		ØA	ØB	C	ØD	E	L	ØM	ØN		T	ØU	
HS15	HS15-529H	.1440	.165	.193	.5625	.484	.625	.147	.261	.199	.032	.657	.163
HS20	HS20-529H	.1690	.201	.193	.5625	.469	.625	.173	.312	.237	.039	.664	.192
HS25	HS25-529H	.1940	.230	.193	.8750	.438	.625	.197	.363	.279	.045	.670	.221
HS27	HS27-529H	.2180	.242	.193	.8750	.407	.625	.221	.414	.318	.052	.677	.248
HS30	HS30-529H	.2390	.275	.193	.8750	.407	.625	.242	.480	.378	.061	.686	.274
HS40	HS40-529H	.2880	.324	.193	.8750	.500	.750	.291	.602	.481	.077	.827	.331
HS45	HS45-529H	.3360	.387	.193	1.0000	.625	1.000	.339	.726	.593	.092	1.092	.388
HS50	HS50-529H	.3780	.428	.193	1.2500	.625	1.000	.381	.847	.706	.107	1.107	.438

REVISION REV A:3/16/11 REV B:2/24/14

NOTES:

1. "A" TO BE CONCENTRIC TO "D" WITHIN .002 T.I.R.
2. MATERIAL: MI, Rc 58-60, OR EQUIVALENT.

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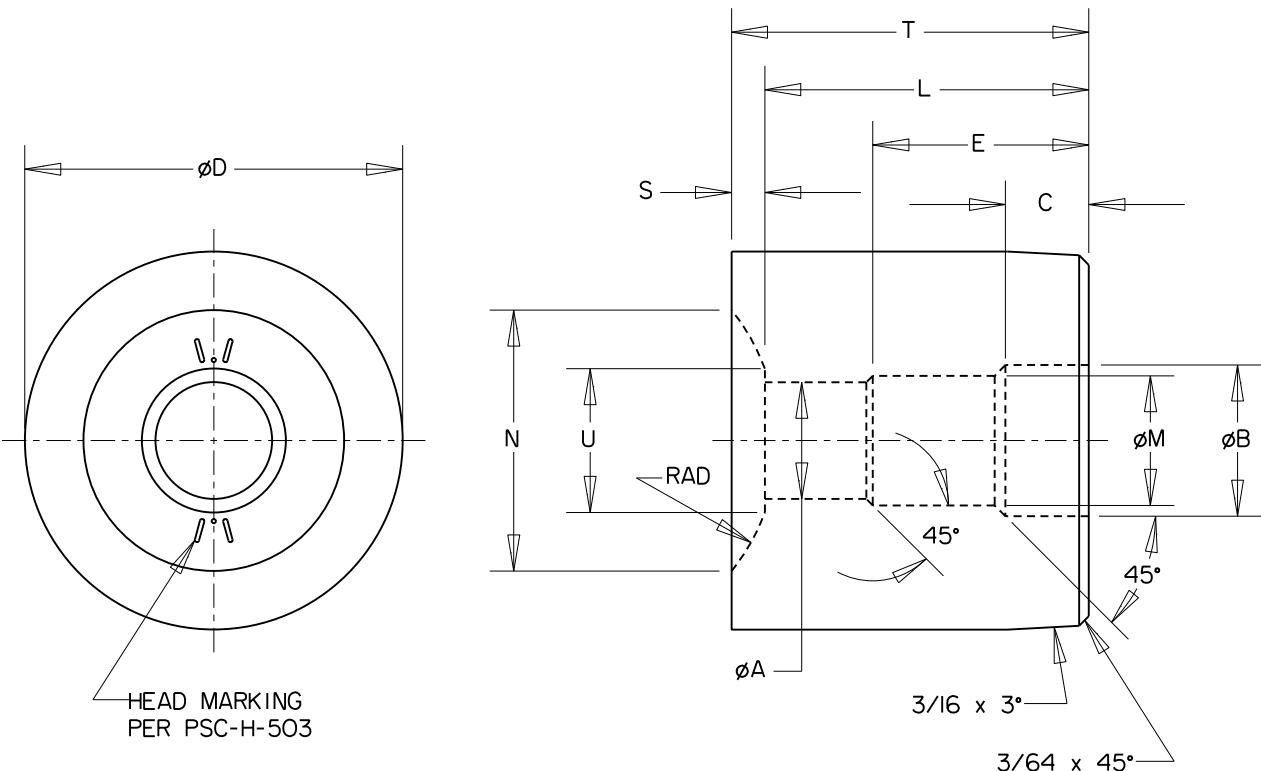
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TITLE: HEXSTIX® PAN HEAD (INCH)
HOLDER WITH HEAD PARTIALLY IN DIE

DRAWN G.DILLING	DATE 11/11/10	DRAWING NUMBER PSC-H-529
CHECKED: G.DILLING	DATE 11/11/10	SHEET 1 OF 1

PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A.
PHONE: 774-396-6190 FAX: 508-966-2326

PHILLIPS II® PHILLIPS® POZIDRIV® ACR® POZISQUARE® PHILLIPS SQUARE-DRIV® TORQ-SET® TRI-WING® MORTORQ® HEXSTIX®
AND POZILOCK® ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY



DRIVE SIZE	HOLDER	+.0005 -.0000	+.012 -.003	+.004 -.000	+.0005 -.0005	+.010 -.010	+.000 -.002	+.005 -.000	+.005 -.000	RAD REF	S REF	+.000 -.004	+.004 -.000
		ØA	ØB	C	ØD	E	L	ØM	ØN	T	ØU		
HS15	HS15-530H	.1440	.165	.193	.5625	.484	.625	.147	.264	.198	.033	.659	.163
HS20	HS20-530H	.1690	.201	.193	.5625	.469	.625	.173	.305	.212	.042	.668	.192
HS25	HS25-530H	.1940	.230	.193	.8750	.438	.625	.197	.364	.259	.050	.676	.221
HS25	HS25-530H-A	.1940	.230	.193	.8750	.438	.625	.197	.421	.340	.055	.681	.221
HS30	HS30-530H	.2390	.275	.193	.8750	.407	.625	.242	.461	.329	.064	.690	.274
HS40	HS40-530H	.2880	.324	.193	.8750	.500	.750	.291	.618	.479	.083	.835	.331
HS50	HS50-530H	.3780	.428	.193	1.2500	.625	1.000	.381	.774	.573	.107	1.107	.438

REVISION REV A:3/16/11 REV B:2/24/14

NOTES:

1. "A" TO BE CONCENTRIC TO "D" WITHIN .002 T.I.R.
2. MATERIAL: MI, Rc 58-60, OR EQUIVALENT.

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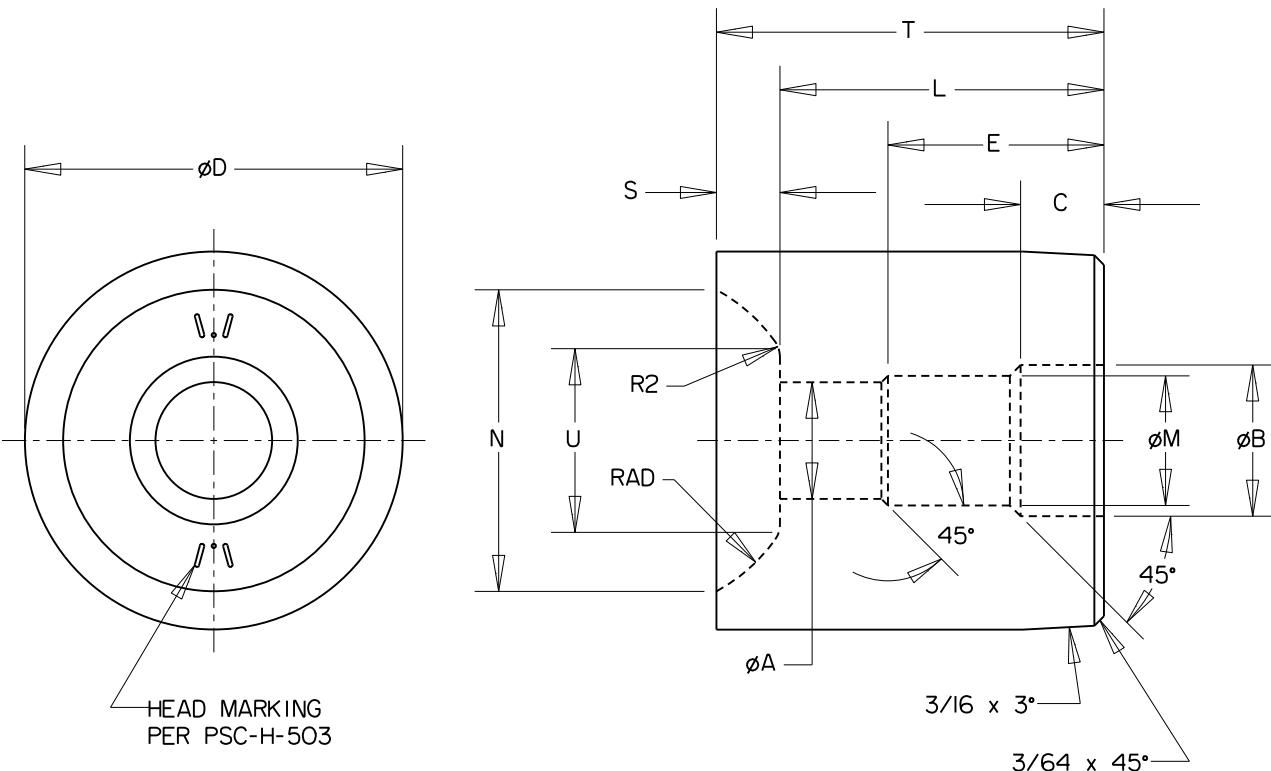
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TITLE: HEXSTIX® PAN HEAD (METRIC)
HOLDER WITH HEAD PARTIALLY IN DIE

DRAWN G.DILLING	DATE 11/11/10	DRAWING NUMBER PSC-H-530
CHECKED: G.DILLING	DATE 11/11/10	SHEET 1 OF 1

PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A.
PHONE: 774-396-6190 FAX: 508-966-2326

PHILLIPS II® PHILLIPS® POZIDRIV® ACR® POZISQUARE® PHILLIPS SQUARE-DRIV® TORQ-SET® TRI-WING® MORTORQ® HEXSTIX®
AND POZILOCK® ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY



DRIVE SIZE	HOLDER	ϕA	ϕB	C	ϕD	E	L	ϕM	ϕN	RAD REF	S REF	T	ϕU	R2
HS15	HS15-53IH	.1440	.165	.193	.5625	.484	.625	.147	.384	.240	.078	.703	.189	.040
HS20	HS20-53IH	.1690	.201	.193	.5625	.469	.625	.173	.448	.282	.088	.713	.227	.040
HS25	HS25-53IH	.1940	.230	.193	.8750	.438	.625	.197	.511	.316	.103	.728	.262	.040
HS27	HS27-53IH	.2180	.242	.193	.8750	.407	.625	.221	.573	.356	.118	.743	.278	.040
HS40	HS40-53IH	.2880	.324	.193	.8750	.500	.750	.291	.698	.398	.147	.897	.425	.060
HS45	HS45-53IH	.3360	.387	.193	1.0000	.625	1.000	.339	.823	.484	.171	1.171	.406	.060
HS45	HS45-53IH-A	.3360	.387	.193	1.2500	.625	1.000	.339	.948	.576	.201	1.201	.465	.060
HS50	HS50-53IH	.3780	.428	.193	1.5000	.625	1.000	.381	1.073	.634	.230	1.230	.570	.090

REVISION REV A:3/16/11 REV B:2/24/14

NOTES:

1. "A" TO BE CONCENTRIC TO "D" WITHIN .002 T.I.R.
2. MATERIAL: MI, Rc 58-60, OR EQUIVALENT.

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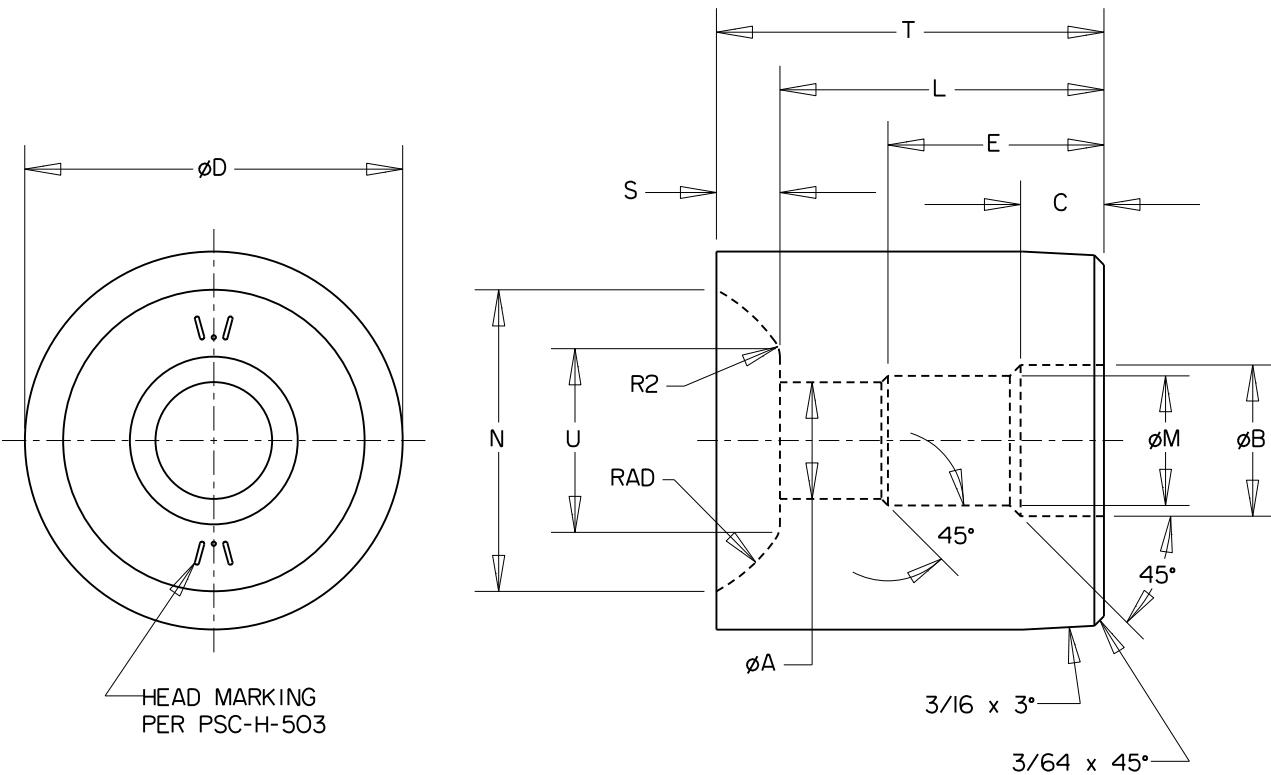
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TITLE: HEXSTIX®
TRUSS HEAD HOLDER (INCH)

DRAWN G.DILLING	DATE 11/12/10	DRAWING NUMBER PSC-H-53I
CHECKED: G.DILLING	DATE 11/12/10	SHEET 1 OF 1

PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A.
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AND POZILOCK® ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY



DRIVE SIZE	HOLDER	$+.0005$ $-.0000$	$+.012$ $-.003$	$+.004$ $-.000$	$+.0005$ $-.0005$	$+.010$ $-.010$	$+.000$ $-.002$	$+.005$ $-.000$	$+.005$ $-.000$	RAD REF	S REF	$+.000$ $-.004$	$+.004$ $-.000$	R2
		ϕA	ϕB	C	ϕD	E	L	ϕM	ϕN			T	ϕU	
HS15	HS15-53IH	.1440	.165	.193	.5625	.484	.625	.147	.384	.240	.078	.703	.189	.040
HS20	HS20-53IH	.1690	.201	.193	.5625	.469	.625	.173	.448	.282	.088	.713	.227	.040
HS30	HS30-532H	.2390	.275	.193	.8750	.407	.625	.242	.573	.362	.115	.741	.274	.040
HS40	HS40-53IH	.2880	.324	.193	.8750	.500	.750	.291	.698	.398	.147	.897	.425	.060
HS50	HS50-532H	.3780	.428	.193	1.2500	.625	1.000	.381	.823	.426	.215	1.216	.570	.090

REVISION REV A:3/16/11 REV B:2/24/14

NOTES:

1. "A" TO BE CONCENTRIC TO "D" WITHIN .002 T.I.R.
2. MATERIAL: MI, Rc 58-60, OR EQUIVALENT.

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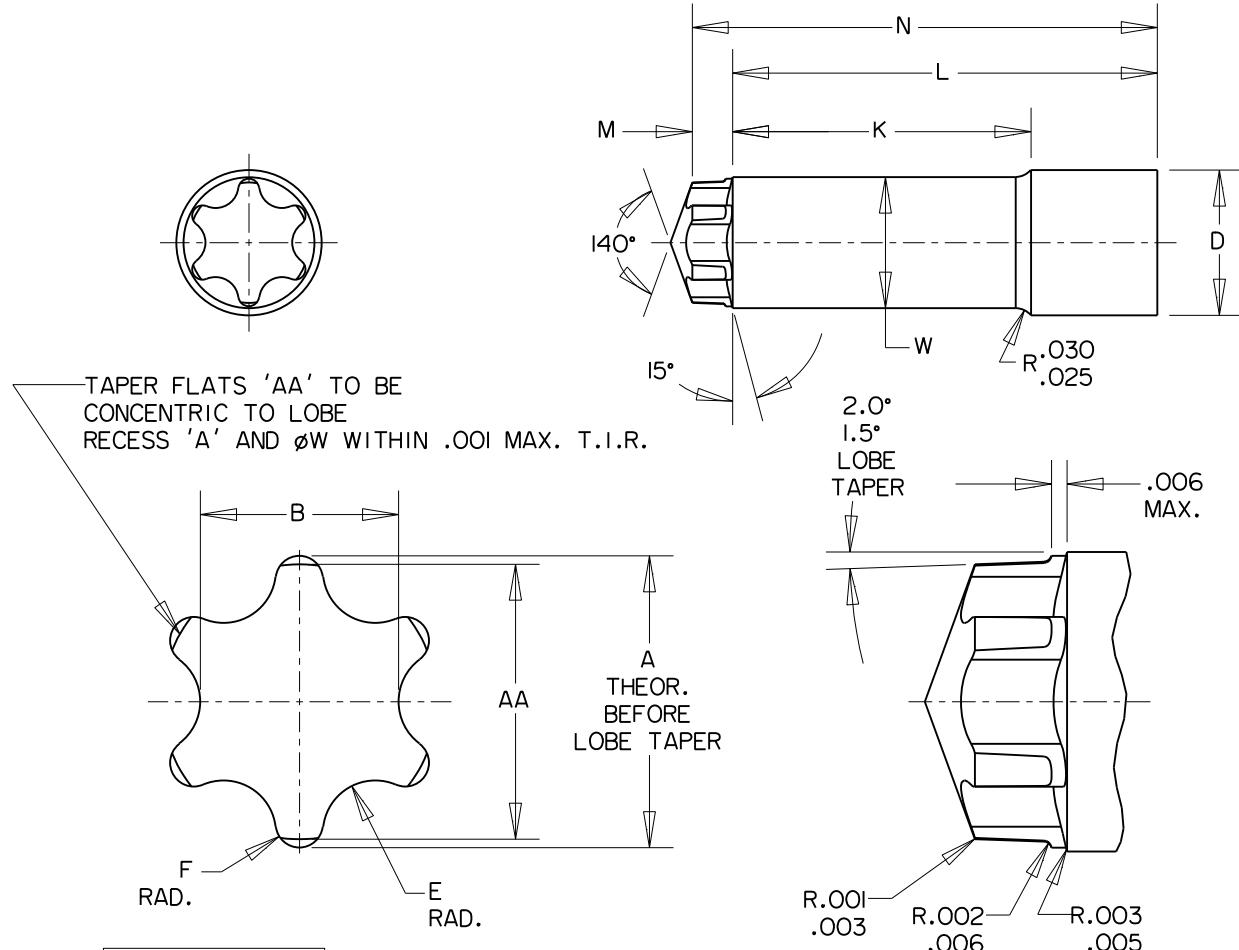
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TITLE: HEXSTIX®
TRUSS HEAD HOLDER (METRIC)

DRAWN G.DILLING	DATE 11/12/10	DRAWING NUMBER PSC-H-532
CHECKED: G.DILLING	DATE 11/12/10	SHEET 1 OF 1

PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A.
PHONE: 774-396-6190 FAX: 508-966-2326

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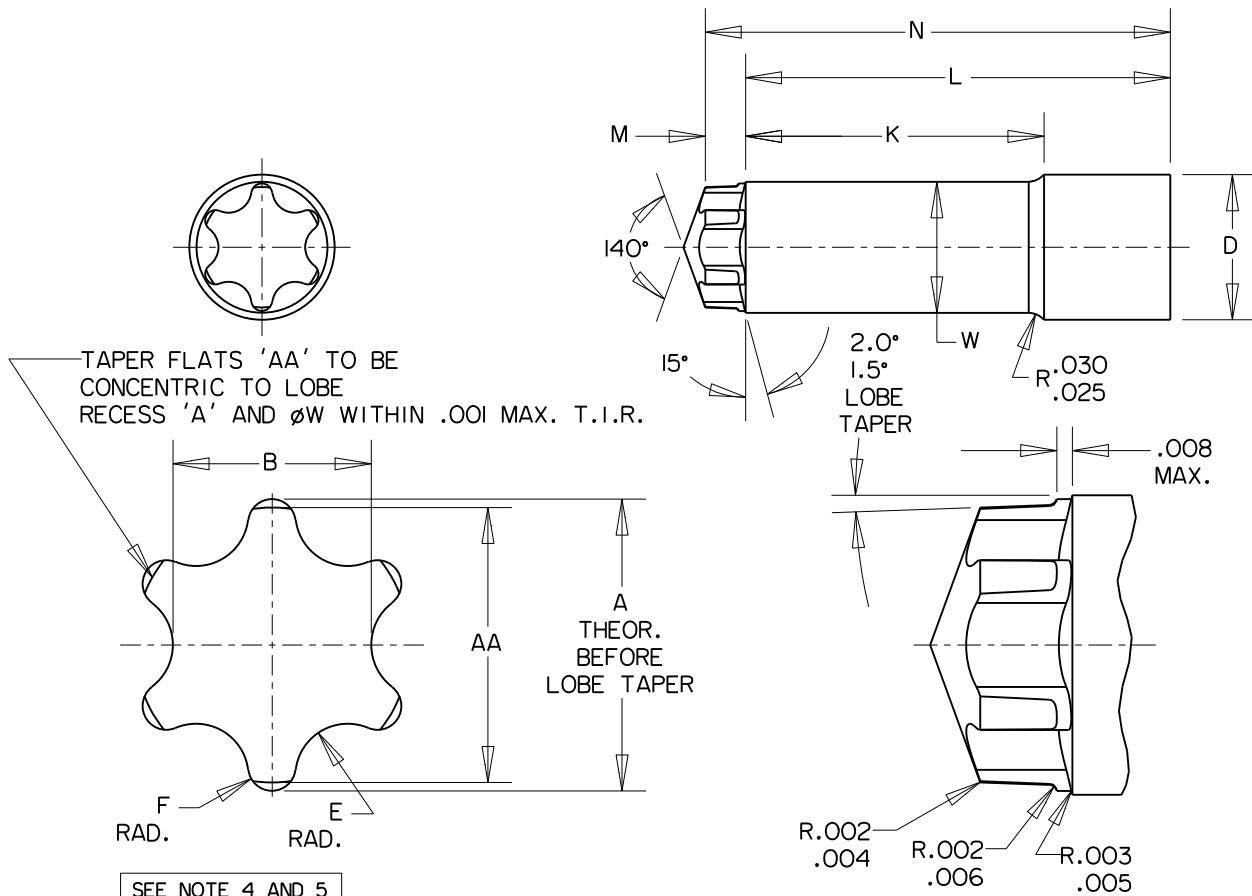
SEE NOTE 4 AND 5															
DRIVE SIZE	PIN NO.	+.0000 -.0005 AA	+.0000 -.0010 A	+.0000 -.0010 B	+.001 -.003 D	E REF	F REF	+.020 -.000 K	+.004 .000 L	M REF	+.007 -.000 N	+.0005 -.0000 W	RECESS PEN DEPTH		
HS15	HS15-250	.1325	.1405	0.096	.158	.0265	.0113	.441	.629	.060	.689	.1450	.070 .060		
HS15	HS15-251	.1325	.1405	0.096	.158	.0265	.0113	.441	.629	.045	.674	.1450	.055 .045		
HS15	HS15-252	.1325	.1405	0.096	.158	.0265	.0113	.441	.629	.070	.699	.1450	.080 .070		
HS15	HS15-253	.1325	.1405	0.096	.158	.0265	.0113	.441	.629	.035	.664	.1450	.045 .035		
HS15	HS15-254	.1325	.1405	0.096	.158	.0265	.0113	.441	.629	.050	.679	.1450	.060 .050		
HS15	HS15-255	.1325	.1405	0.096	.158	.0265	.0113	.441	.629	.033	.662	.1450	.043 .033		
HS15	HS15-256	.1325	.1405	0.096	.158	.0265	.0113	.441	.629	.041	.670	.1450	.051 .041		

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. "A" TO BE CONCENTRIC TO "W" WITHIN .001 MAX. T.I.R.
3. MATERIAL: MI, Rc 61-63 OR EQUIVALENT.
4. PIN NO. WITH "O.S." AFTER DESCRIPTION SIGNIFY A OVERSIZE RECESS.
SEE DRAWING PSC-H-501 FOR OVERSIZE "AA" DIMENSION OF PIN.
5. PIN NO. ENDING WITH "T" IS TAMPER RESISTANT, SEE DWG PSC-H-504 FOR TAMPER I.D. HOLE DETAILS.

REVISION REV A: 11/9/10 REV B:3/16/11 REV C:10/25/11 REV D:2/24/14

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DRAWN G.DILLING		DATE 6/30/10	DRAWING NUMBER PSC-HS15-250	
CHECKED: G.DILLING		DATE 6/30/10	SHEET 1 OF 1	
PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326				
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SEE NOTE 4 AND 5													
DRIVE SIZE	PIN NO.	+.0000 -.0010 AA	+.0000 -.0010 A	+.0000 -.0010 B	+.001 -.003 D	E REF	F REF	.020 -.000 K	.004 .000 L	M REF	.007 -.000 N	.0005 -.0000 W	RECESS PEN DEPTH
HS20	HS20-250	.1555	.1650	.1125	.194	.0319	.0127	.441	.629	.089	.718	.1700	.104 .089
HS20	HS20-251	.1555	.1650	.1125	.194	.0319	.0127	.441	.629	.065	.694	.1700	.080 .065
HS20	HS20-252	.1555	.1650	.1125	.194	.0319	.0127	.441	.629	.080	.709	.1700	.095 .080
HS20	HS20-253	.1555	.1650	.1125	.194	.0319	.0127	.441	.629	.050	.679	.1700	.065 .050
HS20	HS20-254	.1555	.1650	.1125	.194	.0319	.0127	.441	.629	.038	.667	.1700	.053 .038
HS20	HS20-255	.1555	.1650	.1125	.194	.0319	.0127	.441	.629	.060	.689	.1700	.075 .060
HS20	HS20-256	.1555	.1650	.1125	.194	.0319	.0127	.441	.629	.056	.685	.1700	.071 .056
HS20	HS20-257	.1555	.1650	.1125	.194	.0319	.0127	.441	.629	.036	.665	.1700	.051 .036
HS20	HS20-258	.1555	.1650	.1125	.194	.0319	.0127	.441	.629	.045	.674	.1700	.060 .045

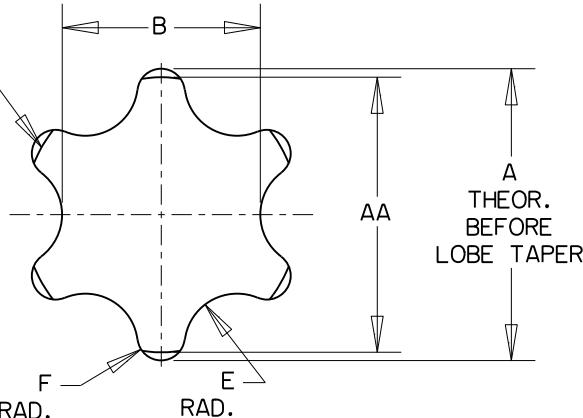
NOTES:

1. DIMENSIONS ARE IN INCHES.
2. "A" TO BE CONCENTRIC TO "W" WITHIN .001 MAX. T.I.R.
3. MATERIAL: MI, RC 61-63 OR EQUIVALENT.
4. PIN NO. WITH "O.S." AFTER DESCRIPTION SIGNIFY A OVERSIZE RECESS. SEE DRAWING PSC-H-501 FOR OVERSIZE "AA" DIMENSION OF PIN.
5. PIN NO. ENDING WITH "T" IS TAMPER RESISTANT, SEE DWG PSC-H-504 FOR TAMPER I.D. HOLE DETAILS.

REVISION REV A: 11/9/10 REV B: 3/16/11 REV C: 10/25/11 REV D: 2/24/14

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DRAWN G.DILLING		DATE 6/28/10	DRAWING NUMBER PSC-HS20-250	
CHECKED: G.DILLING		DATE 6/28/10	SHEET 1 OF 1	
PHILLIPS SCREW CO., 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326				
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TAPER FLATS 'AA' TO BE CONCENTRIC TO LOBE RECESS 'A' AND ϕW WITHIN .001 MAX. T.I.R.



140° 15°

W R.030 .025

2.0°

1.5°

LOBE

TAPER

.010 MAX.

R.002 .004 R.003 .007 R.004 .007

SEE NOTE 4 AND 5

DRIVE SIZE	PIN NO.	+.0000 -.0010 AA	+.0000 -.0010 A	+.0000 -.0010 B	+.001 -.003 D	E REF	F REF	+.020 -.000 K	+.004 .000 L	M REF	+.007 -.000 N	+.0005 -.0000 W	RECESS PEN DEPTH
HS25	HS25-250	.1790	.1900	.1290	.216	.0342	.0155	.444	.632	.115	.747	.1950	.130 .115
HS25	HS25-251	.1790	.1900	.1290	.216	.0342	.0155	.444	.632	.065	.697	.1950	.080 .065
HS25	HS25-252	.1790	.1900	.1290	.216	.0342	.0155	.444	.632	.090	.722	.1950	.105 .090
HS25	HS25-253	.1790	.1900	.1290	.216	.0342	.0155	.444	.632	.055	.687	.1950	.070 .055
HS25	HS25-254	.1790	.1900	.1290	.216	.0342	.0155	.444	.632	.075	.707	.1950	.090 .075
HS25	HS25-255	.1790	.1900	.1290	.216	.0342	.0155	.444	.632	.044	.676	.1950	.059 .044
HS25	HS25-256	.1790	.1900	.1290	.216	.0342	.0155	.444	.632	.060	.692	.1950	.075 .060

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. "A" TO BE CONCENTRIC TO "W" WITHIN .001 MAX. T.I.R.
3. MATERIAL: MI. Rc 6i-63 OR EQUIVALENT.
4. PIN NO. WITH "O.S." AFTER DESCRIPTION SIGNIFY A OVERSIZE RECESS.
SEE DRAWING PSC-H-501 FOR OVERSIZE "AA" DIMENSION OF PIN.
5. PIN NO. ENDING WITH "T" IS TAMPER RESISTANT, SEE DWG PSC-H-504 FOR TAMPER I.D. HOLE DETAILS.

REVISION REV A: 11/9/10 REV B: 3/16/11 REV C: 10/25/11 REV D: 2/24/14

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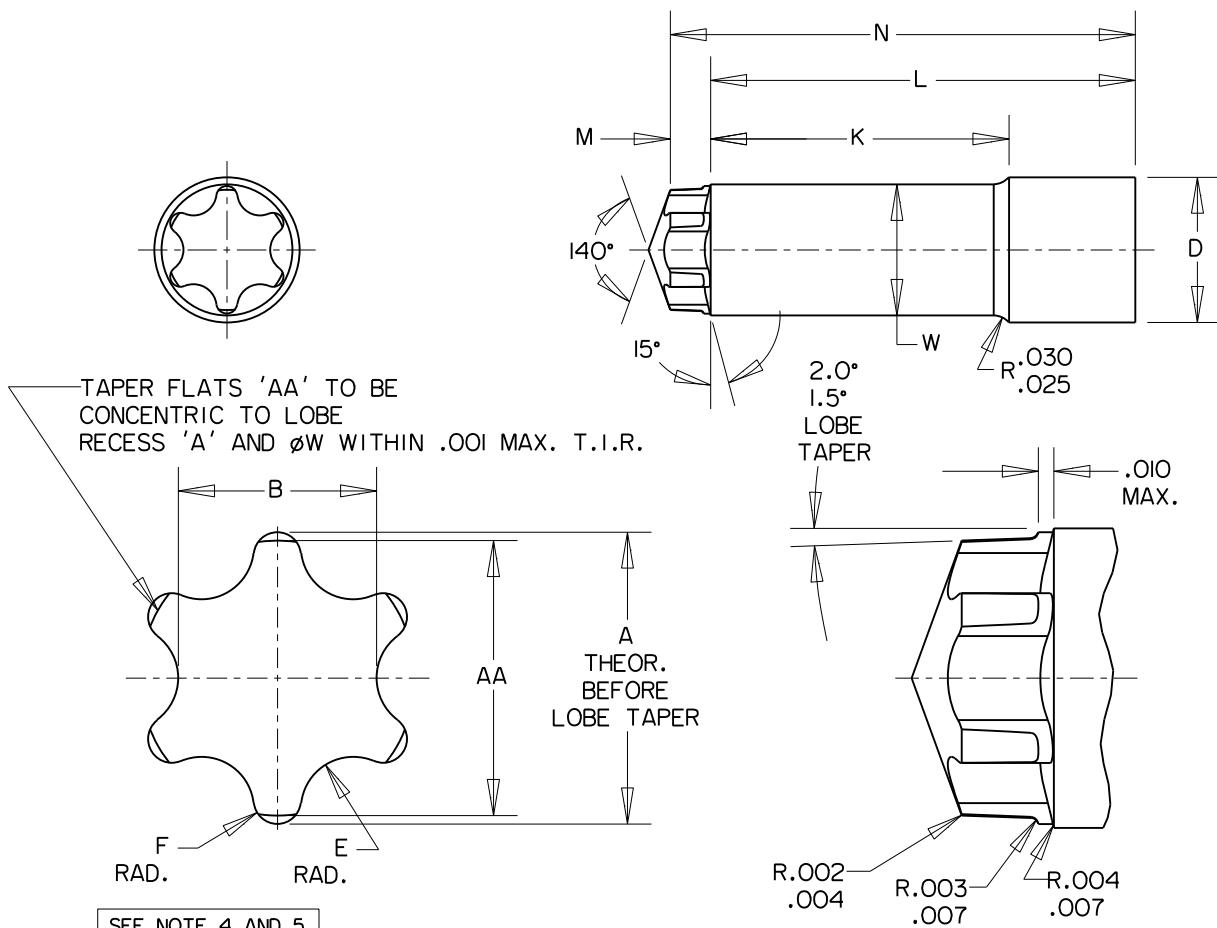
TITLE:
HEXSTIX®
RECESS PUNCH PIN

DRAWN G.DILLING DATE 6/28/10 DRAWING NUMBER
PSC-HS25-250

CHECKED: G.DILLING DATE 6/28/10 SHEET 1 OF 1

PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A.
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SEE NOTE 4 AND 5														
DRIVE SIZE	PIN NO.	+.0000 -.0010 AA	+.0000 -.0010 A	+.0000 -.0010 B	+.001 -.003 D	E REF	F REF	+.020 -.000 K	+.004 -.000 L	M REF	+.007 -.000 N	+.0005 -.0000 W	RECESS PEN DEPTH	
HS27	HS27-250	.2010	.2140	.1446	.236	.0416	.0158	.444	.632	.120	.752	.2190	.135 .120	
HS27	HS27-251	.2010	.2140	.1446	.236	.0416	.0158	.444	.632	.065	.697	.2190	.080 .065	
HS27	HS27-252	.2010	.2140	.1446	.236	.0416	.0158	.444	.632	.105	.737	.2190	.120 .105	
HS27	HS27-253	.2010	.2140	.1446	.236	.0416	.0158	.444	.632	.085	.717	.2190	.100 .085	
HS27	HS27-254	.2010	.2140	.1446	.236	.0416	.0158	.444	.632	.075	.707	.2190	.090 .075	
HS27	HS27-255	.2010	.2140	.1446	.236	.0416	.0158	.444	.632	.050	.682	.2190	.065 .050	
HS27	HS27-258	.2010	.2140	.1446	.236	.0416	.0158	.444	.632	.060	.692	.2190	.075 .060	
HS27	HS27-259	.2010	.2140	.1446	.236	.0416	.0158	.444	.632	.090	.722	.2190	.105 .090	

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. "A" TO BE CONCENTRIC TO "W" WITHIN .001 MAX. T.I.R.
3. MATERIAL: MI, Rc 61-63 OR EQUIVALENT.
4. PIN NO. WITH "O.S." AFTER DESCRIPTION SIGNIFY A OVERSIZE RECESS.
SEE DRAWING PSC-H-501 FOR OVERSIZE "AA" DIMENSION OF PIN.
5. PIN NO. ENDING WITH "T" IS TAMPER RESISTANT. SEE DWG PSC-H-504 FOR TAMPER I.D. HOLE DETAILS.

REVISION REV A: 11/9/10 REV B: 3/16/11 REV C: 10/25/11 REV D: 2/24/14

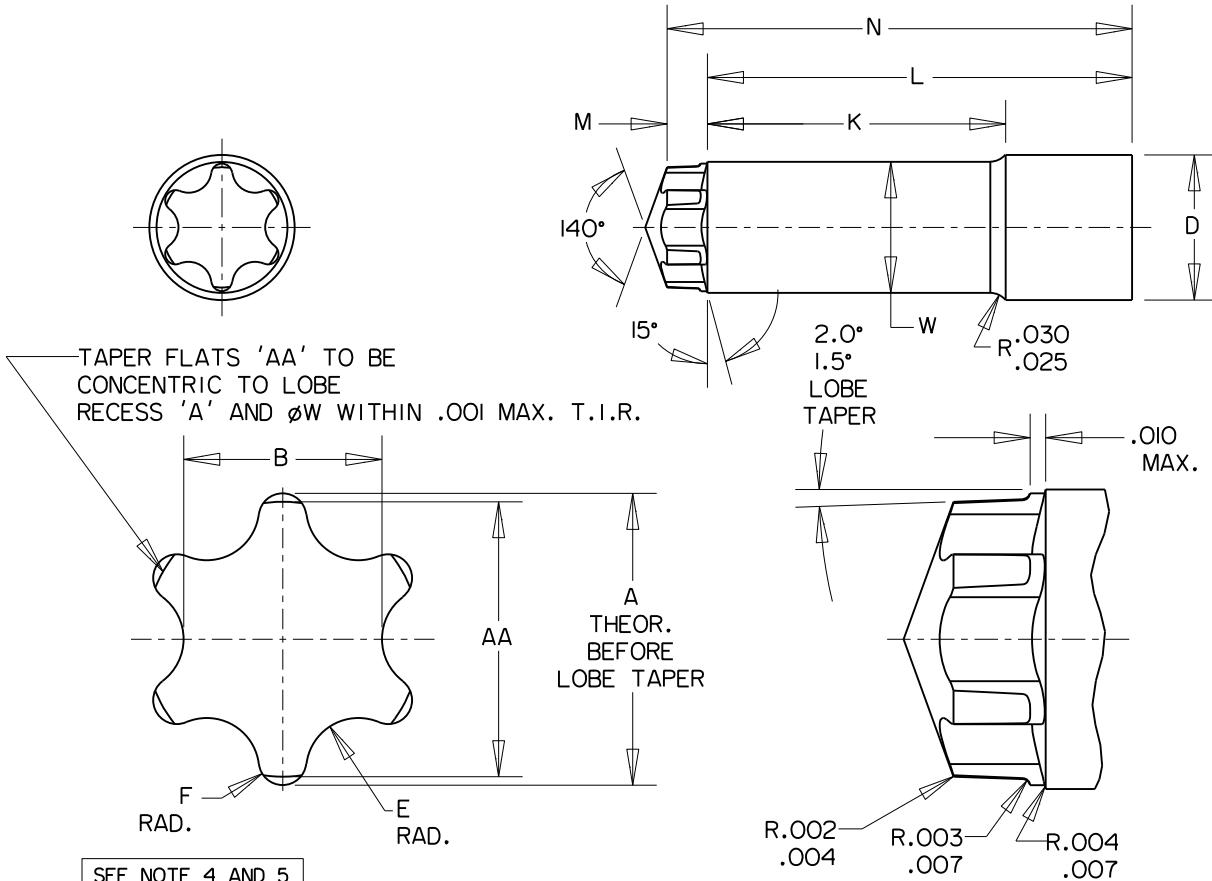
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TITLE:
HEXSTIX®
RECESS PUNCH PIN

DRAWN G.DILLING	DATE 7/06/10	DRAWING NUMBER PSC-HS27-250
CHECKED: G.DILLING	DATE 9/13/10	SHEET 1 OF 1

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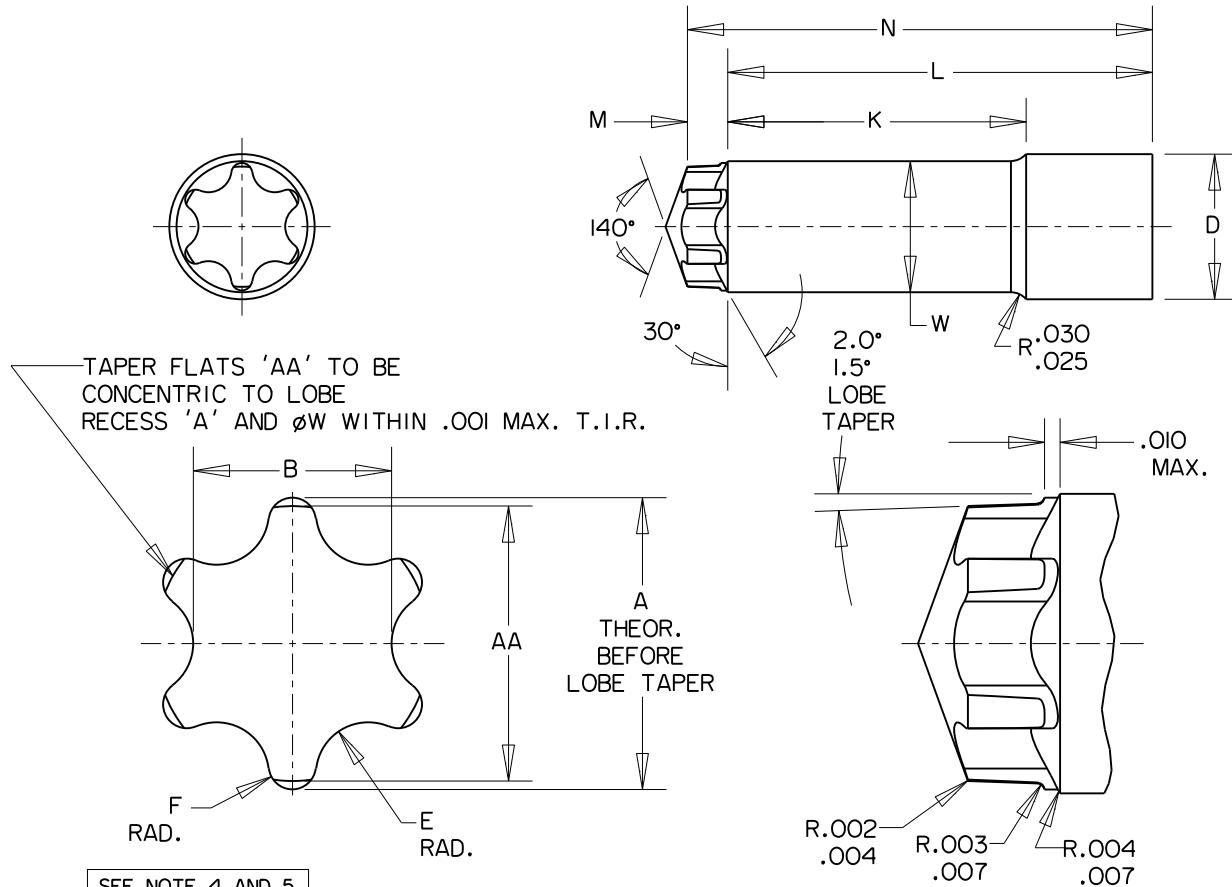
SEE NOTE 4 AND 5													
DRIVE SIZE	PIN NO.	+.0000 -.0010 AA	+.0000 -.0010 A	+.0000 -.0010 B	+.001 -.003 D	E REF	F REF	+.020 -.000 K	+.004 .000 L	M REF	+.007 -.000 N	+.0005 -.0000 W	RECESS PEN DEPTH
HS30	HS30-250	.2225	.2350	.1600	.269	.0450	.0181	.444	.632	.125	.757	.2400	.140 .125
HS30	HS30-251	.2225	.2350	.1600	.269	.0450	.0181	.444	.632	.090	.722	.2400	.105 .090
HS30	HS30-252	.2225	.2350	.1600	.269	.0450	.0181	.444	.632	.105	.737	.2400	.120 .105
HS30	HS30-253	.2225	.2350	.1600	.269	.0450	.0181	.444	.632	.070	.702	.2400	.085 .070
HS30	HS30-254	.2225	.2350	.1600	.269	.0450	.0181	.444	.632	.055	.687	.2400	.070 .055
HS30	HS30-255	.2225	.2350	.1600	.269	.0450	.0181	.444	.632	.043	.675	.2400	.058 .043
HS30	HS30-256	.2225	.2350	.1600	.269	.0450	.0181	.444	.632	.080	.712	.2400	.095 .080
HS30	HS30-257	.2225	.2350	.1600	.269	.0450	.0181	.444	.632	.075	.707	.2400	.090 .075
HS30	HS30-258	.2225	.2350	.1600	.269	.0450	.0181	.444	.632	.060	.692	.2400	.075 .060
HS30	HS30-260	.2225	.2350	.1600	.269	.0450	.0181	.444	.632	.065	.697	.2400	.080 .065

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. "A" TO BE CONCENTRIC TO "W" WITHIN .001 MAX. T.I.R.
3. MATERIAL: MI, Rc 61-63 OR EQUIVALENT.
4. PIN NO. WITH "O.S." AFTER DESCRIPTION SIGNIFY A OVERSIZE RECESS.
SEE DRAWING PSC-H-501 FOR OVERSIZE "AA" DIMENSION OF PIN.
5. PIN NO. ENDING WITH "T" IS TAMPER RESISTANT. SEE DWG PSC-H-504 FOR TAMPER I.D. HOLE DETAILS.

REVISION REV A: II/9/10 REV B:3/16/11 REV C:10/25/11 REV D:2/24/14

(C) COPYRIGHT 2014 PHILLIPS SCREW COMPANY. ALL RIGHTS RESERVED.		TITLE: HEXSTIX® RECESS PUNCH PIN		
DRAWN G.DILLING		DATE 6/30/10	DRAWING NUMBER PSC-HS30-250	
CHECKED: G.DILLING		DATE 6/30/10	SHEET 1 OF 1	
PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326				
PHILLIPS II® PHILLIPS® POZIDRIV® ACR® POZISQUARE® PHILLIPS SQUARE-DRIV® TORQ-SET® TRI-WING® MORTORQ® HEXSTIX® AND POZILOCK® ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY				



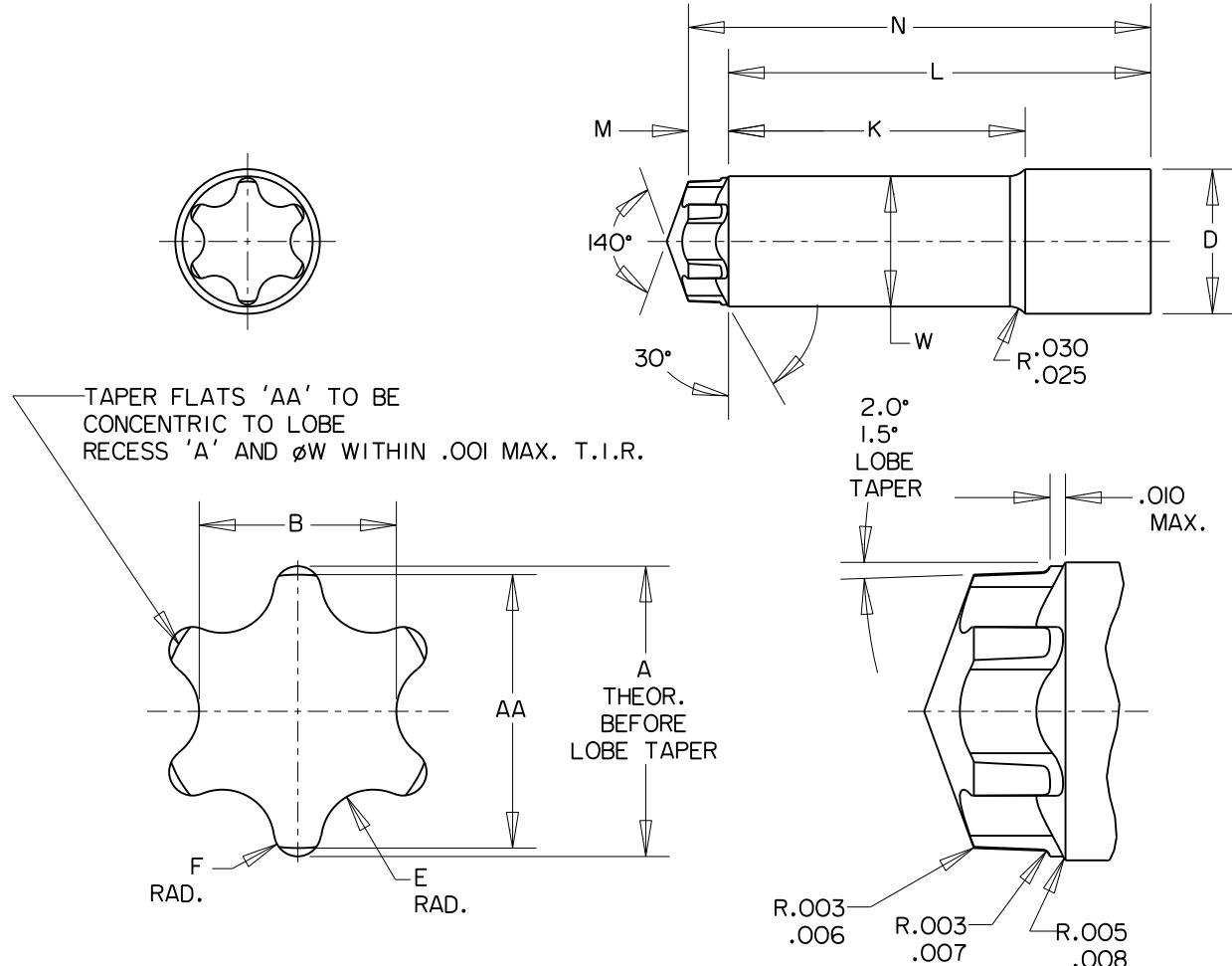
DRIVE SIZE	PIN NO.	SEE NOTE 4 AND 5											
		+ .0000 -.0010	+ .0000 -.0015	+ .0000 -.0015	+ .001 -.003	E REF	F REF	+ .020 -.000	+ .004 .000	M REF	+ .006 -.000	+ .0005 -.0000	RECESS PEN DEPTH
HS40	HS40-250	.2680	.2840	.1925	.318	.0540	.0218	.572	.760	.135	.895	.2890	.150 .135
HS40	HS40-251	.2680	.2840	.1925	.318	.0540	.0218	.572	.760	.110	.870	.2890	.125 .110
HS40	HS40-252	.2680	.2840	.1925	.318	.0540	.0218	.572	.760	.125	.885	.2890	.140 .125
HS40	HS40-253	.2680	.2840	.1925	.318	.0540	.0218	.572	.760	.120	.880	.2890	.135 .120
HS40	HS40-254	.2680	.2840	.1925	.318	.0540	.0218	.572	.760	.097	.857	.2890	.112 .097
HS40	HS40-255	.2680	.2840	.1925	.318	.0540	.0218	.572	.760	.085	.845	.2890	.100 .085
HS40	HS40-256	.2680	.2840	.1925	.318	.0540	.0218	.572	.760	.070	.830	.2890	.085 .070
HS40	HS40-257	.2680	.2840	.1925	.318	.0540	.0218	.572	.760	.090	.850	.2890	.105 .090
HS40	HS40-260	.2680	.2840	.1925	.318	.0540	.0218	.572	.760	.080	.840	.2890	.095 .080

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. "A" TO BE CONCENTRIC TO "W" WITHIN .001 MAX. T.I.R.
3. MATERIAL: MI, RC 61-63 OR EQUIVALENT.
4. PIN NO. WITH "O.S." AFTER DESCRIPTION SIGNIFY A OVERSIZE RECESS.
SEE DRAWING PSC-H-501 FOR OVERSIZE "AA" DIMENSION OF PIN.
5. PIN NO. ENDING WITH "T" IS TAMPER RESISTANT. SEE DWG PSC-H-504 FOR TAMPER I.D. HOLE DETAILS.

REVISION REV A: 11/9/10 REV B: 3/16/11 REV C: 10/25/11 REV D: 2/24/14

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DRAWN G.DILLING		DATE 7/06/10	DRAWING NUMBER PSC-HS40-250	
CHECKED: G.DILLING		DATE 10/27/10	SHEET 1 OF 1	
PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326				
PHILLIPS II® PHILLIPS® POZIDRIV® ACR® POZISQUARE® PHILLIPS SQUARE-DRIV® TORQ-SET® TRI-WING® MORTORQ® HEXSTIX® AND POZILOCK® ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY				



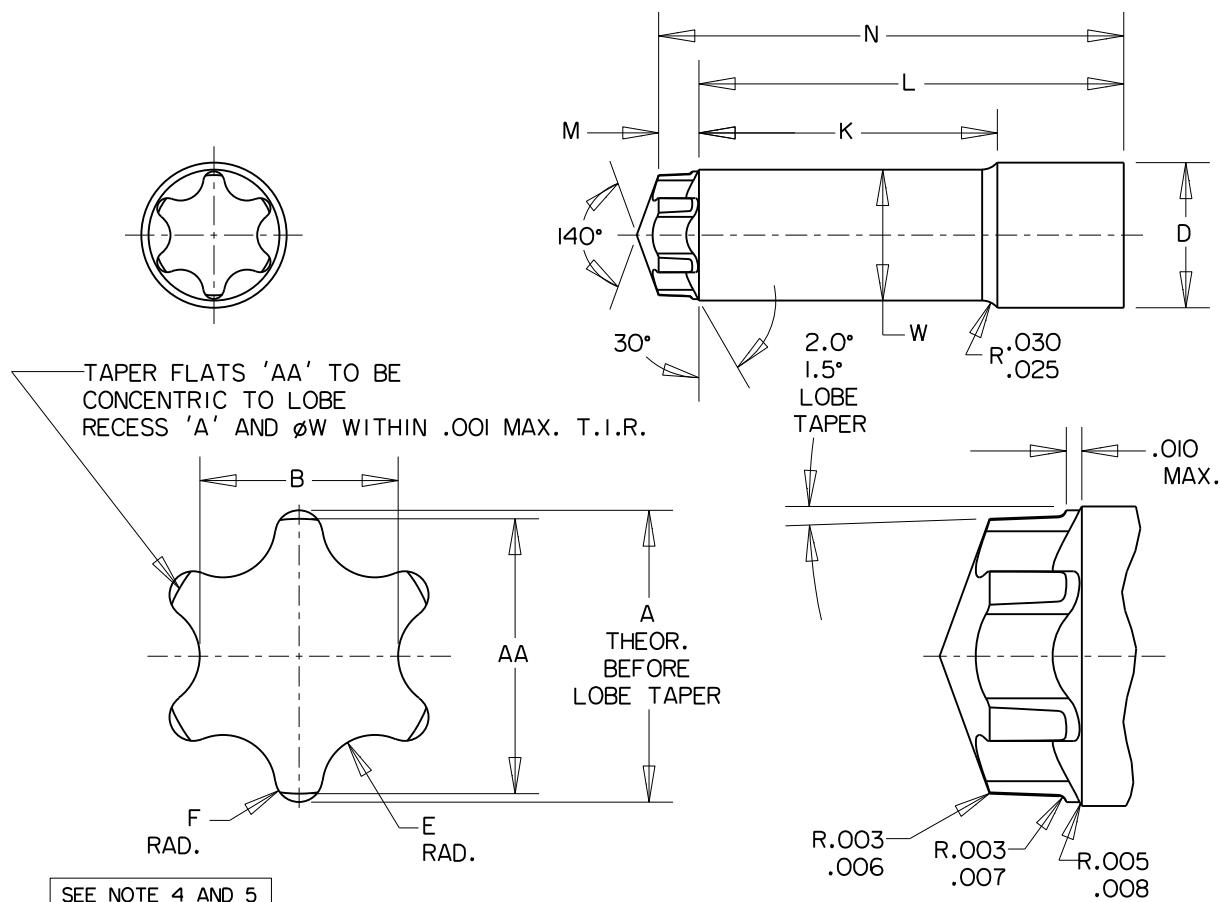
SEE NOTE 4 AND 5														
DRIVE SIZE	PIN NO.	+.0000 -.0010 AA	+.0000 -.0015 A	+.0000 -.0015 B	+.001 -.003 D	E REF	F REF	+.020 -.000 K	+.004 .000 L	M REF	+.007 -.000 N	+.0005 -.0000 W	RECESS PEN DEPTH	
HS45	HS45-250	.3130	.3315	.2240	.381	.0682	.0229	.822	1.010	.155	1.165	.3370	.170 .155	
HS45	HS45-251	.3130	.3315	.2240	.381	.0682	.0229	.822	1.010	.115	1.125	.3370	.130 .115	
HS45	HS45-252	.3130	.3315	.2240	.381	.0682	.0229	.822	1.010	.140	1.150	.3370	.155 .140	
HS45	HS45-253	.3130	.3315	.2240	.381	.0682	.0229	.822	1.010	.110	1.120	.3370	.125 .110	
HS45	HS45-254	.3130	.3315	.2240	.381	.0682	.0229	.822	1.010	.085	1.095	.3370	.100 .085	
HS45	HS45-256	.3130	.3315	.2240	.381	.0682	.0229	.822	1.010	.105	1.115	.3370	.120 .105	

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. "A" TO BE CONCENTRIC TO "W" WITHIN .001 MAX. T.I.R.
3. MATERIAL: MI, Rc 61-63 OR EQUIVALENT.
4. PIN NO. WITH "O.S." AFTER DESCRIPTION SIGNIFY A OVERSIZE RECESS.
SEE DRAWING PSC-H-501 FOR OVERSIZE "AA" DIMENSION OF PIN.
5. PIN NO. ENDING WITH "T" IS TAMPER RESISTANT, SEE DWG PSC-H-504 FOR TAMPER I.D. HOLE DETAILS.

REVISION REV A: 11/9/10 REV B: 3/16/11 REV C: 10/25/11 REV D: 2/24/14

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DRAWN G.DILLING		DATE 7/06/10	DRAWING NUMBER PSC-HS45-250	
CHECKED: G.DILLING		DATE 10/27/10	SHEET 1 OF 1	
PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326				
PHILLIPS II® PHILLIPS® POZIDRIV® ACR® POZISQUARE® PHILLIPS SQUARE-DRIV® TORQ-SET® TRI-WING® MORTORQ® HEXSTIX® AND POZILOCK® ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY				



SEE NOTE 4 AND 5

DRIVE SIZE	PIN NO.	+.0000 -.0010 AA	.0000 -.0015 A	+.0000 -.0015 B	.001 -.003 D	E REF	F REF	.020 -.000 K	.004 .000 L	M REF	+.007 -.000 N	.0005 -.0000 W	RECESS PEN DEPTH
HS50	HS50-250	.3530	.3740	.2560	.422	.0690	.0305	.822	1.010	.154	1.164	.3790	.169 .154
HS50	HS50-251	.3530	.3740	.2560	.422	.0690	.0305	.822	1.010	.135	1.145	.3790	.150 .135
HS50	HS50-252	.3530	.3740	.2560	.422	.0690	.0305	.822	1.010	.160	1.170	.3790	.175 .160
HS50	HS50-253	.3530	.3740	.2560	.422	.0690	.0305	.822	1.010	.095	1.105	.3790	.110 .095
HS50	HS50-255	.3530	.3740	.2560	.422	.0690	.0305	.822	1.010	.176	1.186	.3790	.191 .176
HS50	HS50-256	.3530	.3740	.2560	.422	.0690	.0305	.822	1.010	.129	1.139	.3790	.144 .129
HS50	HS50-257	.3530	.3740	.2560	.422	.0690	.0305	.822	1.010	.110	1.120	.3790	.125 .110
HS50	HS50-258	.3530	.3740	.2560	.422	.0690	.0305	.822	1.010	.143	1.153	.3790	.158 .143
HS50	HS50-259	.3530	.3740	.2560	.422	.0690	.0305	.822	1.010	.120	1.130	.3790	.135 .120

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. "A" TO BE CONCENTRIC TO "W" WITHIN .001 MAX. T.I.R.
3. MATERIAL: MI, Rc 61-63 OR EQUIVALENT.
4. PIN NO. WITH "O.S." AFTER DESCRIPTION SIGNIFY A OVERSIZE RECESS.
SEE DRAWING PSC-H-501 FOR OVERSIZE "AA" DIMENSION OF PIN.
5. PIN NO. ENDING WITH "T" IS TAMPER RESISTANT, SEE DWG PSC-H-504 FOR TAMPER I.D. HOLE DETAILS.

REVISION REV A: 11/9/10 REV B:3/16/11 REV C:10/25/11 REV D:2/24/14

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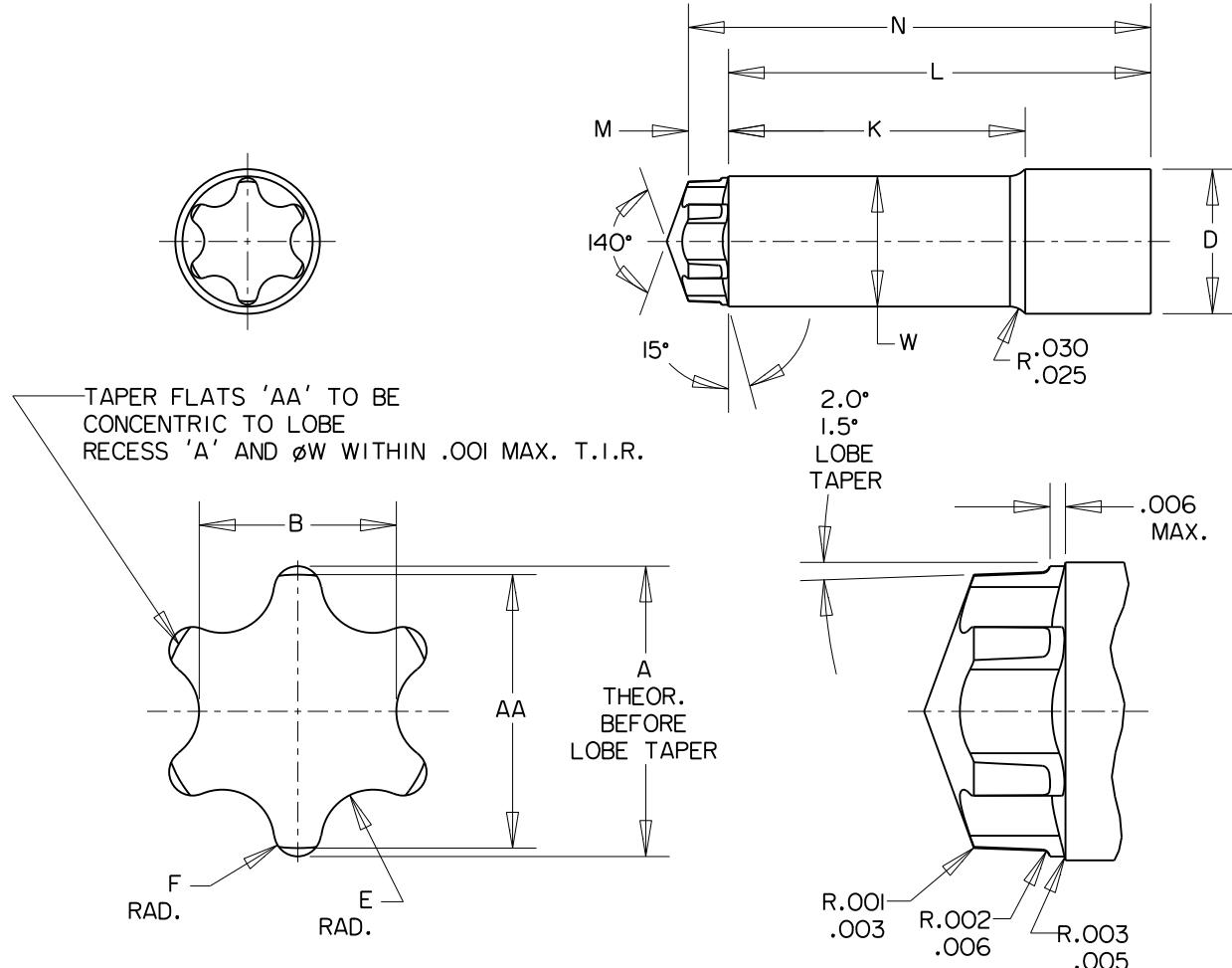
TITLE:
HEXSTIX®
RECESS PUNCH PIN

DRAWN G.DILLING	DATE 7/06/10	DRAWING NUMBER PSC-HS50-250
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CHECKED: G.DILLING	DATE 10/27/10	SHEET 1 OF 1
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PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A.
PHONE: 774-396-6190 FAX: 508-966-2326

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AND POZILOCK® ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY



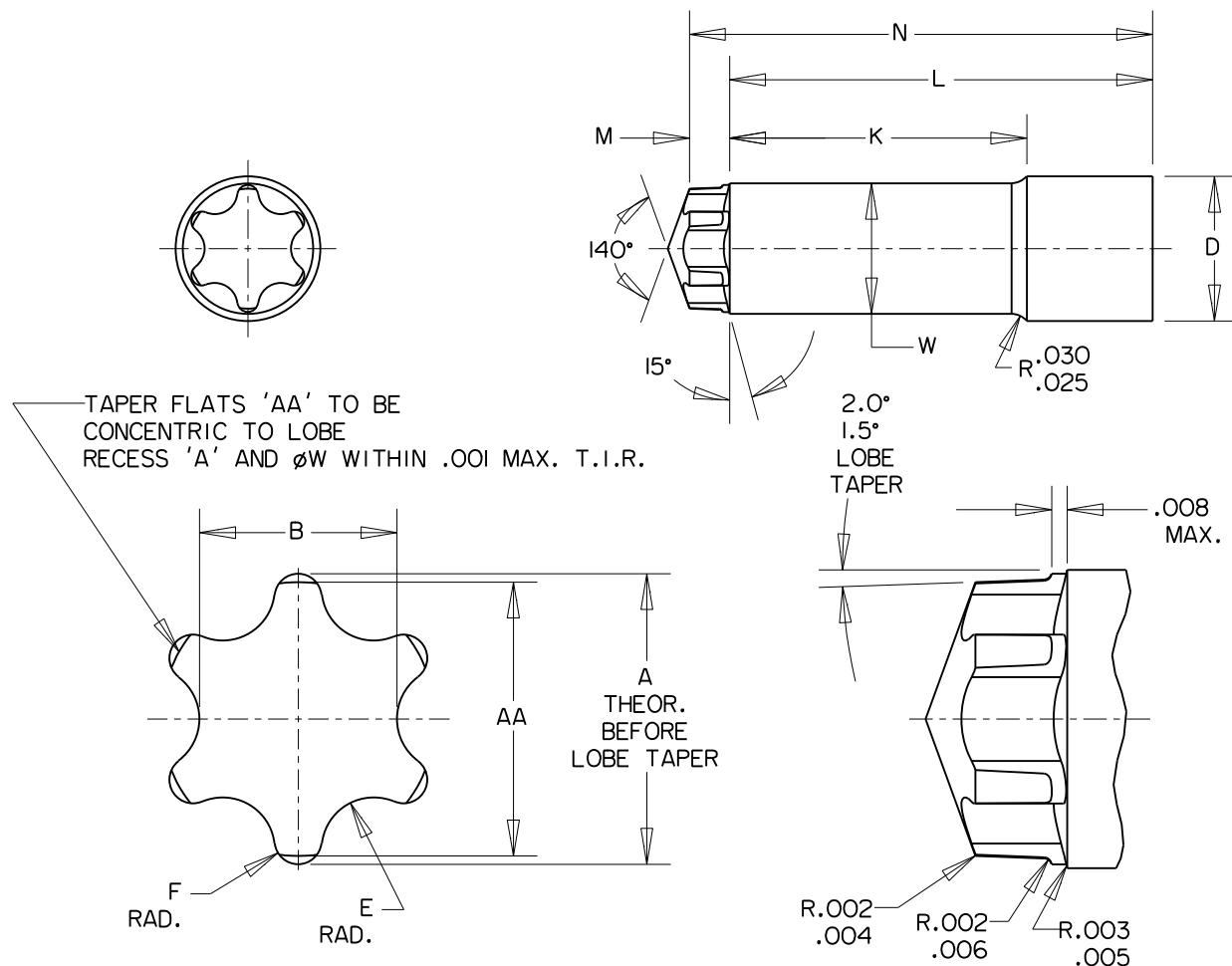
SEE NOTE 4 AND 5														
DRIVE SIZE	PIN NO.	+.0000 -.0005 AA	+.0000 -.0010 A	+.0000 -.0010 B	+.001 -.003 D	E REF	F REF	+.010 -.000 K	+.002 .000 L	M REF	+.002 -.000 N	+.0005 -.0000 W	RECESS PEN DEPTH	
HSI5	HSI5-531	.1325	.1405	0.096	.158	.0265	.0113	.441	.629	.062	.691	.1450	.067 .058	
HSI5	HSI5-532	.1325	.1405	0.096	.158	.0265	.0113	.441	.629	.055	.684	.1450	.061 .051	
HSI5	HSI5-533	.1325	.1405	0.096	.158	.0265	.0113	.441	.629	.049	.678	.1450	.054 .045	
HSI5	HSI5-534	.1325	.1405	0.096	.158	.0265	.0113	.441	.629	.042	.671	.1450	.048 .038	

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. "A" TO BE CONCENTRIC TO "W" WITHIN .001 MAX. T.I.R.
3. MATERIAL: MI, Rc 61-63 OR EQUIVALENT.
4. PIN NO. WITH "O.S." AFTER DESCRIPTION SIGNIFY A OVERSIZE RECESS.
SEE DRAWING PSC-H-501 FOR OVERSIZE "AA" DIMENSION OF PIN.
5. PIN NO. ENDING WITH "T" IS TAMPER RESISTANT. SEE DWG PSC-H-504 FOR TAMPER I.D. HOLE DETAILS.

REVISION REV A: 11/9/10 REV B: 3/16/11 REV C: 10/25/11 REV D: 2/24/14

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	DRAWN G.DILLING	DATE 7/6/10	DRAWING NUMBER PSC-HS15-530
CHECKED: G.DILLING	DATE 7/6/10	SHEET 1 OF 1	
PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326			
PHILLIPS II® PHILLIPS® POZIDRIV® ACR® POZISQUARE® PHILLIPS SQUARE-DRIV® TORQ-SET® TRI-WING® MORTORQ® HEXSTIX® AND POZILOCK® ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY			



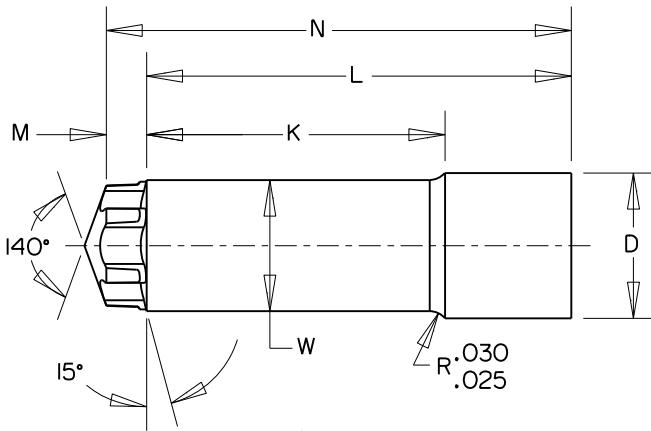
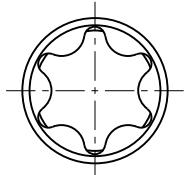
SEE NOTE 4 AND 5															
DRIVE SIZE	PIN NO.	+.0000 -.0010 AA	+.0000 -.0010 A	+.0000 -.0010 B	+.001 -.003 D	E REF	F REF	+.020 -.000 K	+.003 .000 L	M REF	+.003 -.000 N	+.0005 -.0000 W	RECESS PEN DEPTH		
HS20	HS20-531	.1555	.1650	.1125	.194	.0319	.0127	.441	.629	.073	.702	.1700	.079 .068		
HS20	HS20-532	.1555	.1650	.1125	.194	.0319	.0127	.441	.629	.065	.694	.1700	.071 .060		
HS20	HS20-533	.1555	.1650	.1125	.194	.0319	.0127	.441	.629	.057	.686	.1700	.064 .053		
HS20	HS20-534	.1555	.1650	.1125	.194	.0319	.0127	.441	.629	.049	.678	.1700	.056 .045		

NOTES:

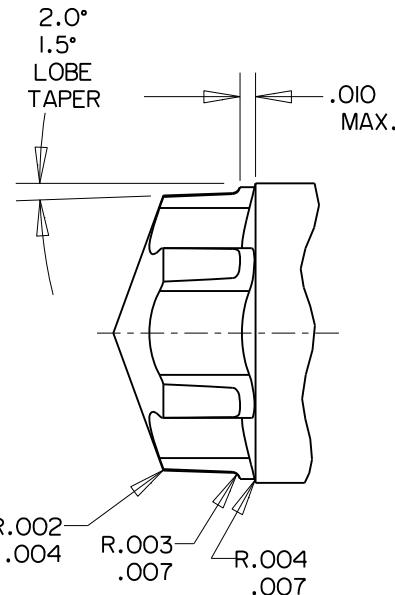
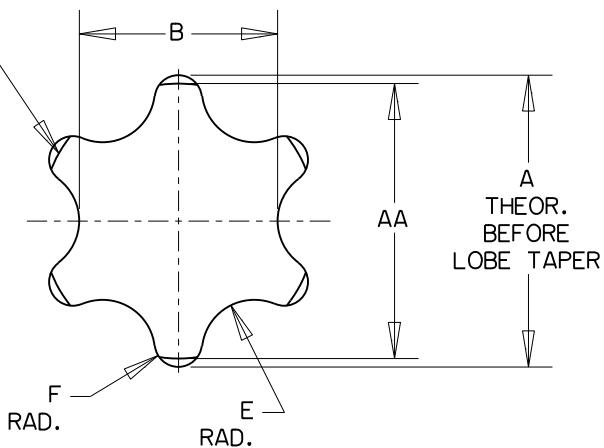
1. DIMENSIONS ARE IN INCHES.
2. "A" TO BE CONCENTRIC TO "W" WITHIN .001 MAX. T.I.R.
3. MATERIAL: MI, RC 61-63 OR EQUIVALENT.
4. PIN NO. WITH "O.S." AFTER DESCRIPTION SIGNIFY A OVERSIZE RECESS.
SEE DRAWING PSC-H-501 FOR OVERSIZE "AA" DIMENSION OF PIN.
5. PIN NO. ENDING WITH "T" IS TAMPER RESISTANT. SEE DWG PSC-H-504 FOR TAMPER I.D. HOLE DETAILS.

REVISION REV A: II/9/10 REV B:3/16/11 REV C:10/25/11 REV D:2/24/14

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	DRAWN G.DILLING	DATE 7/6/10	DRAWING NUMBER PSC-HS20-530
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PHILLIPS SCREW CO., 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326			
PHILLIPS II® PHILLIPS® POZIDRIV® ACR® POZISQUARE® PHILLIPS SQUARE-DRIV® TORQ-SET® TRI-WING® MORTORQ® HEXSTIX® AND POZILOCK® ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY			



TAPER FLATS 'AA' TO BE
CONCENTRIC TO LOBE
RECESS 'A' AND ϕW WITHIN .001 MAX. T.I.R.



SEE NOTE 4 AND 5

DRIVE SIZE	PIN NO.	+.0000 -.0010 AA	+.0000 -.0010 A	+.0000 -.0010 B	+.001 -.003 D	E REF	F REF	.020 -.000 K	.004 .000 L	M REF	.004 -.000 N	.0005 -.0000 W	RECESS PEN DEPTH
HS25	HS25-531	.1790	.1900	.1290	.216	.0342	.0155	.444	.632	.084	.716	.1950	.091 .078
HS25	HS25-532	.1790	.1900	.1290	.216	.0342	.0155	.444	.632	.075	.707	.1950	.082 .069
HS25	HS25-533	.1790	.1900	.1290	.216	.0342	.0155	.444	.632	.066	.698	.1950	.073 .061
HS25	HS25-534	.1790	.1900	.1290	.216	.0342	.0155	.444	.632	.057	.689	.1950	.064 .052

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. "A" TO BE CONCENTRIC TO "W" WITHIN .001 MAX. T.I.R.
3. MATERIAL: MI, Rc 61-63 OR EQUIVALENT.
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SEE DRAWING PSC-H-501 FOR OVERSIZE "AA" DIMENSION OF PIN.
5. PIN NO. ENDING WITH "T" IS TAMPER RESISTANT. SEE DWG PSC-H-504 FOR TAMPER I.D. HOLE DETAILS.

REVISION REV A: 11/9/10 REV B: 3/16/11 REV C: 10/25/11 REV D: 2/24/14

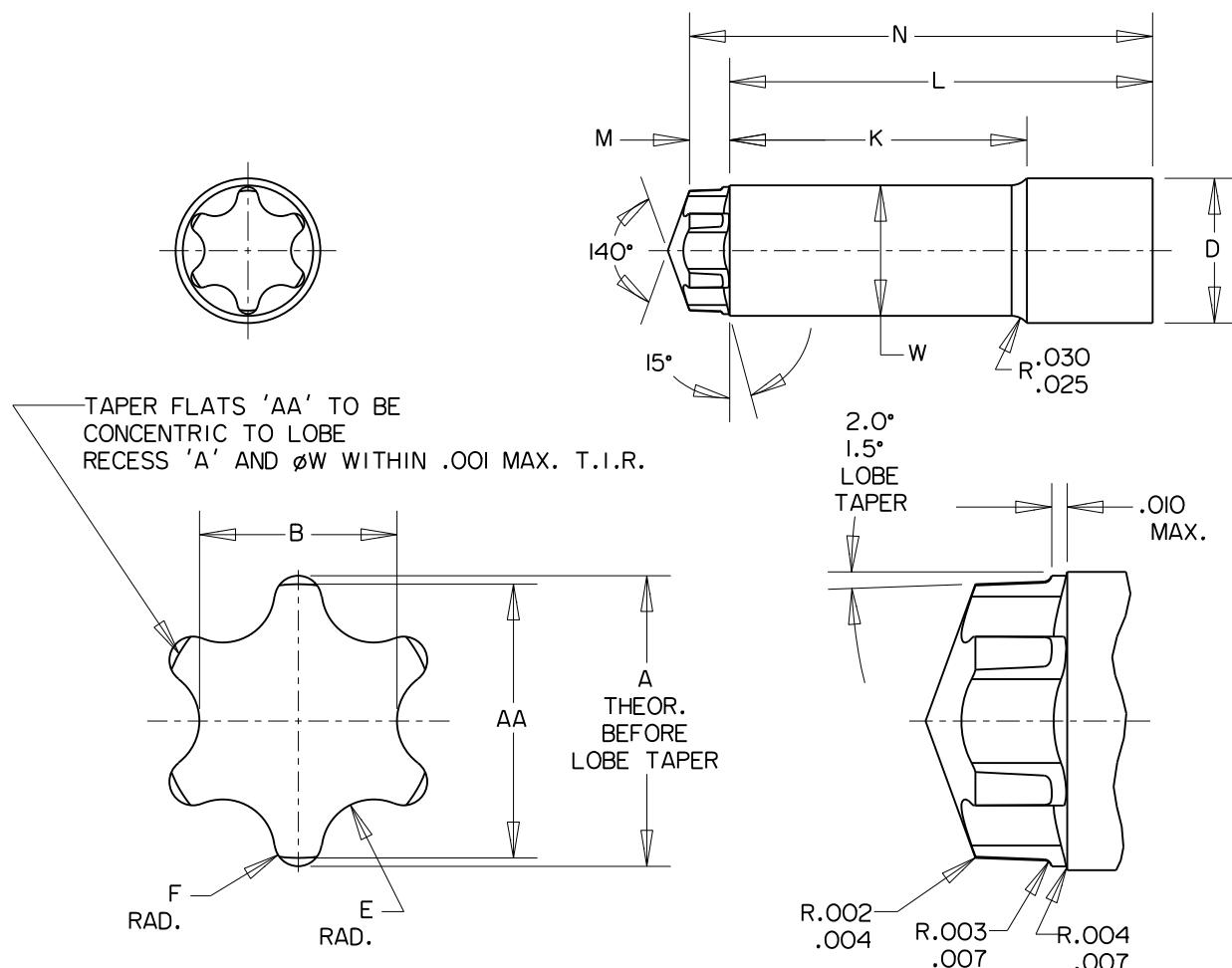
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TITLE: HEXSTIX®
RECESS PUNCH PIN

DRAWN G.DILLING	DATE 7/6/10	DRAWING NUMBER PSC-HS25-530
CHECKED: G.DILLING	DATE 7/6/10	SHEET 1 OF 1
PHILLIPS SCREW CO., 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326		

PHILLIPS II® PHILLIPS® POZIDRIV® ACR® POZISQUARE® PHILLIPS SQUARE-DRIV® TORQ-SET® TRI-WING® MORTORQ® HEXSTIX®
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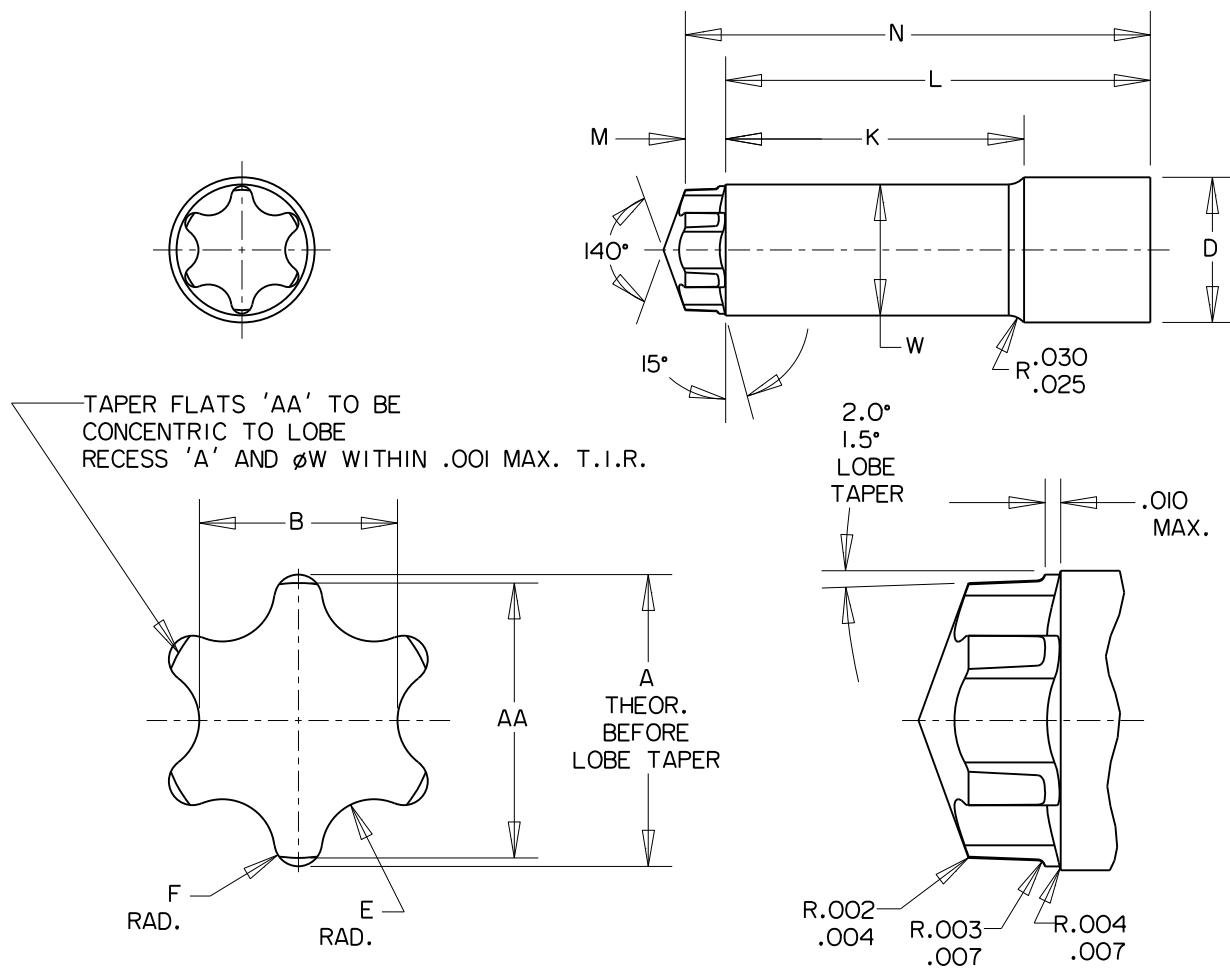
SEE NOTE 4 AND 5														
DRIVE SIZE	PIN NO.	+.0000 -.0010 AA	+.0000 -.0010 A	+.0000 -.0010 B	+.001 -.003 D	E REF	F REF	+.020 -.000 K	+.004 .000 L	M REF	+.005 -.000 N	+.0005 -.0000 W	RECESS PEN DEPTH	
HS27	HS27-531	.2010	.2140	.1446	.236	.0416	.0158	.444	.632	.094	.726	.2190	.102 .088	
HS27	HS27-532	.2010	.2140	.1446	.236	.0416	.0158	.444	.632	.084	.716	.2190	.092 .078	
HS27	HS27-533	.2010	.2140	.1446	.236	.0416	.0158	.444	.632	.074	.706	.2190	.082 .068	
HS27	HS27-534	.2010	.2140	.1446	.236	.0416	.0158	.444	.632	.064	.696	.2190	.072 .058	

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. "A" TO BE CONCENTRIC TO "W" WITHIN .001 MAX. T.I.R.
3. MATERIAL: MI, Rc 61-63 OR EQUIVALENT.
4. PIN NO. WITH "O.S." AFTER DESCRIPTION SIGNIFY A OVERSIZE RECESS.
SEE DRAWING PSC-H-501 FOR OVERSIZE "AA" DIMENSION OF PIN.
5. PIN NO. ENDING WITH "T" IS TAMPER RESISTANT. SEE DWG PSC-H-504 FOR TAMPER I.D. HOLE DETAILS.

REVISION REV A: II/9/10 REV B:3/16/11 REV C:10/25/11 REV D:2/24/14

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	DRAWN G.DILLING	DATE 7/06/10	DRAWING NUMBER PSC-HS27-530
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PHILLIPS SCREW CO. 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326			
PHILLIPS II® PHILLIPS® POZIDRIV® ACR® POZISQUARE® PHILLIPS SQUARE-DRIV® TORQ-SET® TRI-WING® MORTORQ® HEXSTIX® AND POZILOCK® ARE REGISTERED TRADEMARKS OF THE PHILLIPS SCREW COMPANY			



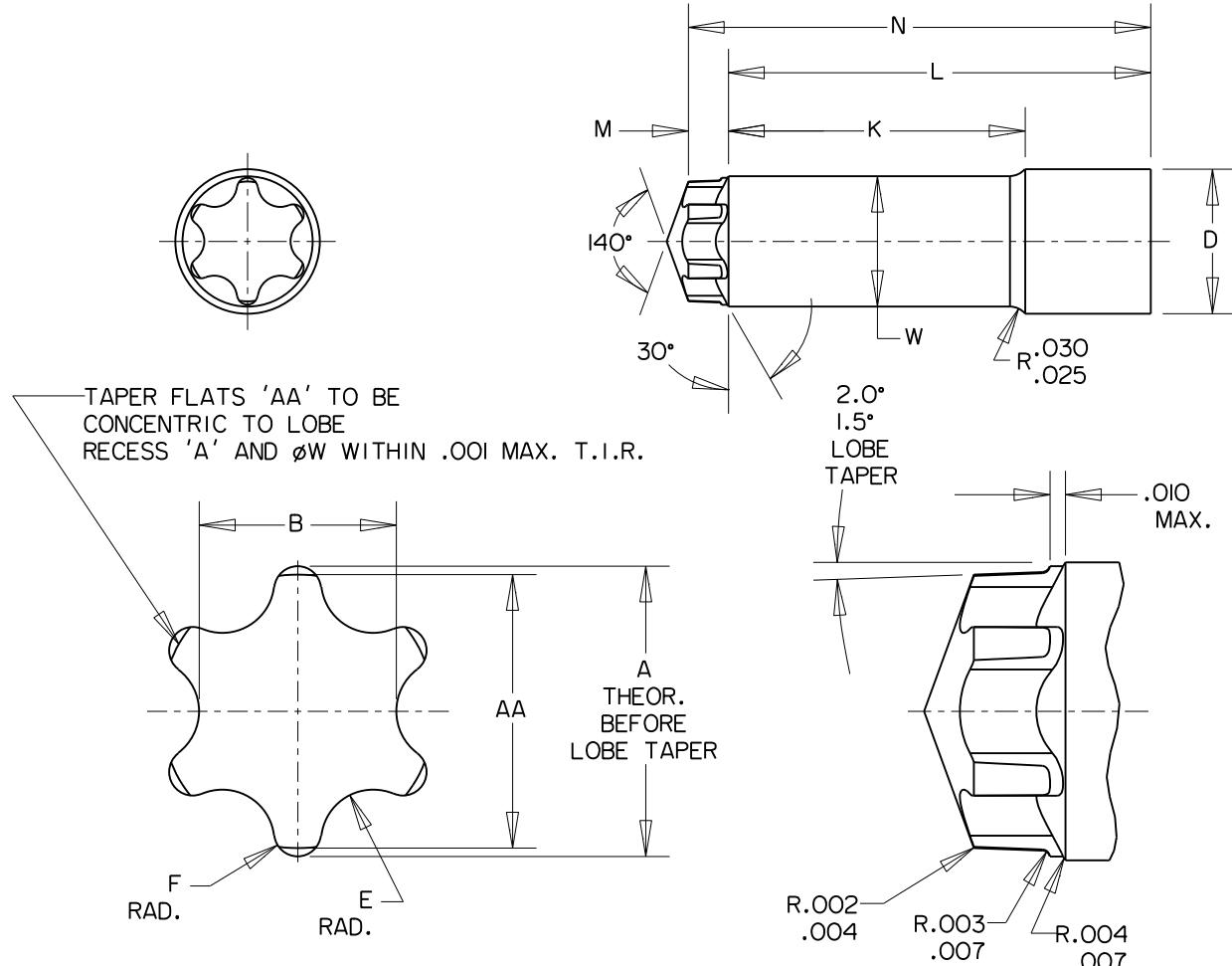
SEE NOTE 4 AND 5															
DRIVE SIZE	PIN NO.	+.0000 -.0010	+.0000 -.0010	+.0000 -.0010	.001 -.003	E REF	F REF	.020 -.000	.004 .000	M REF	.005 -.000	.0005 -.0000	RECESS PEN DEPTH		
HS30	HS30-531	.2225	.2350	.1600	.269	.0450	.0181	.444	.632	.104	.736	.2400	.113 .097		
HS30	HS30-532	.2225	.2350	.1600	.269	.0450	.0181	.444	.632	.093	.725	.2400	.102 .086		
HS30	HS30-533	.2225	.2350	.1600	.269	.0450	.0181	.444	.632	.082	.714	.2400	.091 .075		
HS30	HS30-534	.2225	.2350	.1600	.269	.0450	.0181	.444	.632	.070	.702	.2400	.080 .064		

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. "A" TO BE CONCENTRIC TO "W" WITHIN .001 MAX. T.I.R.
3. MATERIAL: MI, Rc 61-63 OR EQUIVALENT.
4. PIN NO. WITH "O.S." AFTER DESCRIPTION SIGNIFY A OVERSIZE RECESS.
SEE DRAWING PSC-H-501 FOR OVERSIZE "AA" DIMENSION OF PIN.
5. PIN NO. ENDING WITH "T" IS TAMPER RESISTANT. SEE DWG PSC-H-504 FOR TAMPER I.D. HOLE DETAILS.

REVISION REV A: 11/9/10 REV B: 3/16/11 REV C: 10/25/11 REV D: 2/24/14

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	DRAWN G.DILLING	DATE 7/6/10	DRAWING NUMBER PSC-HS30-530
CHECKED: G.DILLING	DATE 7/6/10	SHEET 1 OF 1	
PHILLIPS SCREW CO., 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326			
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SEE NOTE 4 AND 5														
DRIVE SIZE	PIN NO.	+.0000 -.0010 AA	+.0000 -.0015 A	+.0000 -.0015 B	+.001 -.003 D	E REF	F REF	+.020 -.000 K	+.004 .000 L	M REF	+.006 -.000 N	+.0005 -.0000 W	RECESS PEN DEPTH	
HS40	HS40-531	.2680	.2840	.1925	.318	.0540	.0218	.572	.760	.125	.885	.2890	.136 .117	
HS40	HS40-532	.2680	.2840	.1925	.318	.0540	.0218	.572	.760	.112	.872	.2890	.122 .104	
HS40	HS40-533	.2680	.2840	.1925	.318	.0540	.0218	.572	.760	.098	.858	.2890	.109 .090	
HS40	HS40-534	.2680	.2840	.1925	.318	.0540	.0218	.572	.760	.085	.845	.2890	.096 .077	

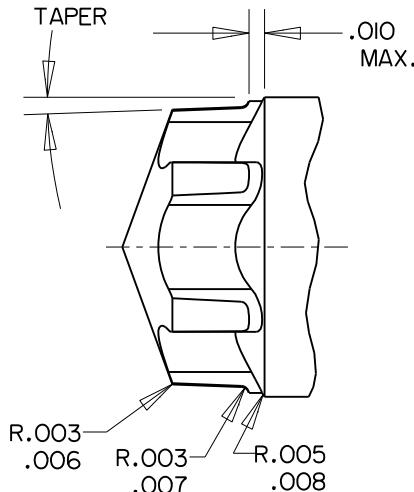
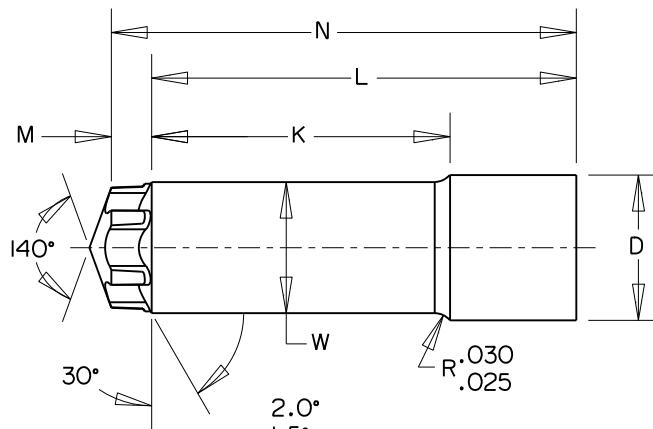
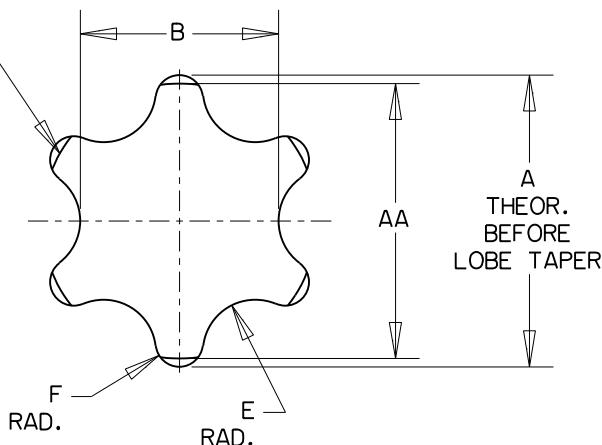
NOTES:

1. DIMENSIONS ARE IN INCHES.
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3. MATERIAL: MI. RC 61-63 OR EQUIVALENT.
4. PIN NO. WITH "O.S." AFTER DESCRIPTION SIGNIFY A OVERSIZE RECESS.
SEE DRAWING PSC-H-501 FOR OVERSIZE "AA" DIMENSION OF PIN.
5. PIN NO. ENDING WITH "T" IS TAMPER RESISTANT. SEE DWG PSC-H-504 FOR TAMPER I.D. HOLE DETAILS.

REVISION REV A: II/9/10 REV B:3/16/11 REV C:10/25/11 REV D:2/24/14

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CHECKED: G.DILLING		DATE 10/27/10	SHEET 1 OF 1	
PHILLIPS SCREW CO., 155 FARM STREET, BELLINGHAM, MA 02019 U.S.A. PHONE: 774-396-6190 FAX: 508-966-2326				
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TAPER FLATS 'AA' TO BE CONCENTRIC TO LOBE RECESS 'A' AND ϕW WITHIN .001 MAX. T.I.R.



SEE NOTE 4 AND 5														
DRIVE SIZE	PIN NO.	+.0000 -.0010 AA	+.0000 -.0015 A	+.0000 -.0015 B	+.001 -.003 D	E REF	F REF	+.020 -.000 K	+.004 .000 L	M REF	+.007 -.000 N	+.0005 -.0000 W	RECESS PEN DEPTH	
HS45	HS45-531	.3130	.3315	.2240	.381	.0682	.0229	.822	1.010	.146	1.156	.3370	.159 .137	
HS45	HS45-532	.3130	.3315	.2240	.381	.0682	.0229	.822	1.010	.131	1.141	.3370	.144 .122	
HS45	HS45-533	.3130	.3315	.2240	.381	.0682	.0229	.822	1.010	.115	1.125	.3370	.128 .106	
HS45	HS45-534	.3130	.3315	.2240	.381	.0682	.0229	.822	1.010	.100	1.110	.3370	.112 .090	

NOTES:

1. DIMENSIONS ARE IN INCHES.
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3. MATERIAL: MI, Rc 6I-63 OR EQUIVALENT.
4. PIN NO. WITH "O.S." AFTER DESCRIPTION SIGNIFY A OVERSIZE RECESS. SEE DRAWING PSC-H-501 FOR OVERSIZE "AA" DIMENSION OF PIN.
5. PIN NO. ENDING WITH "T" IS TAMPER RESISTANT, SEE DWG PSC-H-504 FOR TAMPER I.D. HOLE DETAILS.

REVISION REV A: 11/9/10 REV B: 3/16/11 REV C: 10/25/11 REV D: 2/24/14

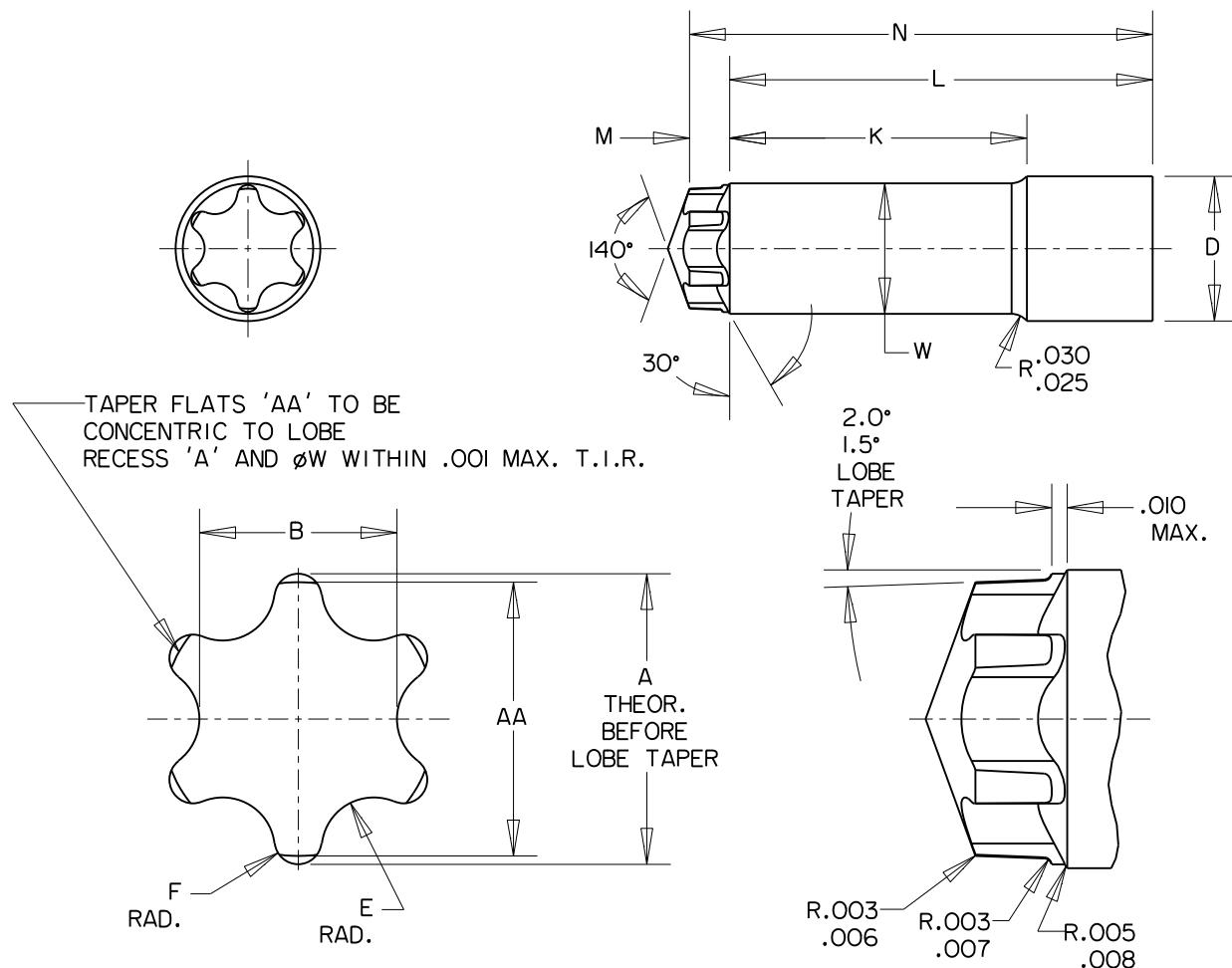
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TITLE:
HEXSTIX®
RECESS PUNCH PIN

DRAWN G.DILLING	DATE 7/06/10	DRAWING NUMBER PSC-HS45-530
CHECKED: G.DILLING	DATE 10/27/10	SHEET 1 OF 1

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DRIVE SIZE	PIN NO.	SEE NOTE 4 AND 5											
		+.0000 -.0010 AA	+.0000 -.0015 A	+.0000 -.0015 B	+.001 -.003 D	E REF	F REF	+.020 -.000 K	+.004 .000 L	M REF	+.007 -.000 N	+.0005 -.0000 W	RECESS PEN DEPTH
HS50	HS50-531	.3530	.3740	.2560	.422	.0690	.0305	.822	1.010	.165	1.175	.3790	.180 .155
HS50	HS50-532	.3530	.3740	.2560	.422	.0690	.0305	.822	1.010	.148	1.158	.3790	.162 .137
HS50	HS50-533	.3530	.3740	.2560	.422	.0690	.0305	.822	1.010	.130	1.140	.3790	.144 .120
HS50	HS50-534	.3530	.3740	.2560	.422	.0690	.0305	.822	1.010	.112	1.122	.3790	.127 .102

NOTES:

1. DIMENSIONS ARE IN INCHES.
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CHECKED: G.DILLING		DATE 10/27/10	SHEET 1 OF 1	
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