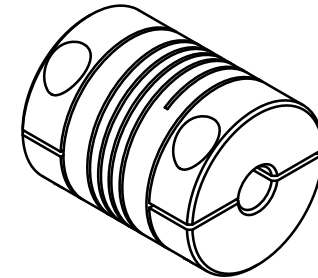
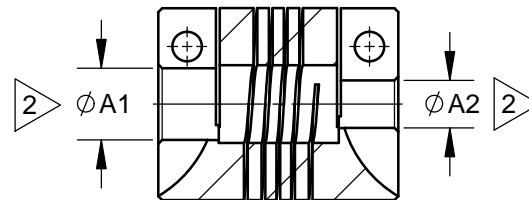
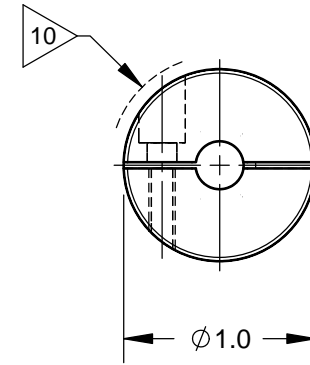
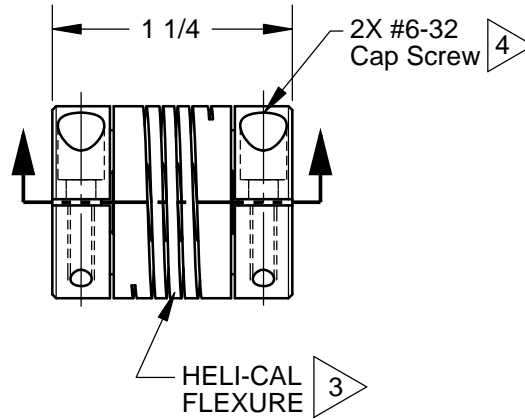


NOTES:

- 1 Refer to Secondary Sheet for Tabulated Data.
- 2 $\phi A1$ and $\phi A2$ component shafts may near butt except:

When any Bore $> \phi .375$ the component shaft MAX penetration is .305.
or
When both Bores $> \phi .375$ the component shaft MAX penetration is .305 & the MIN shaft end to shaft end is .604.
- 3 Hubs and HELI-CAL FLEXURE are made from a single piece of material.
- 4 Integral Clamp attachment, hex, socket, cap screw furnished: both hubs.
- 5 Backlash: None. No lubrication required.
- 6 Permitted axial motion from free length: $\pm .010$
- 7 RPM: Up to 10,000 depending upon application.
- 8 Working torque ratings are based upon continuous duty with noted misalignments applied separately and may be increased with improved alignment: Refer to Tabulated Data
- 9 Permissible shaft misalignment: Angular, up to 5°
Offset, up to .010 (FIM, .020)
- 10 Part will have a $\phi 1.146$ clearance on both ends when any Bore $> \phi .407$ thru $\phi .563$.
- 11 Weight based on ACR100-12-8



NOTICE: THE INFORMATION AND DATA CONTAINED HEREIN IS CONSIDERED PROPRIETARY TO HELICAL PRODUCTS COMPANY, AND SHALL REMAIN THE EXCLUSIVE PROPERTY OF HELICAL. THE HOLDER WILL ASSUME CUSTODY AND CONTROL THAT THIS DOCUMENT WILL NOT BE COPIED, REPRODUCED OR DISCLOSED WITHOUT THE EXPRESS WRITTEN CONSENT OF HELICAL. POSSESSION OF THIS DOCUMENT DOES NOT CONSTITUTE A GRANT TO MANUFACTURE ANY ITEM. Copyright HELICAL PRODUCTS CO.

11-26-14	---	ECR#14102000 Added calc. weight	DCE	EK
07-30-13	---	Redrawn in Solidworks	CL	JAJ/EK
12-18-09	---	Finish was Chromic Acid Anodize; Updated GD&T	HG	JAJ
01-25-99	---	Clerical format update/ No Revision	BJM	MC
DATE	LTR	REVISION	APVR	

Unless otherwise specified all tolerances and dimensions are in inches.

Inch	Metric
X/XX \pm 1/64	X \pm 0.5mm
.XX \pm .01	X.X \pm 0.25mm
.XXX \pm .005	X.XX \pm 0.15mm
Angles $\pm 2^\circ$	

Break sharp corners .010 MAX
All surface finish 63 roughness
Do Not Scale Drawing

 HELICAL PRODUCTS COMPANY		901 West McCoy Lane P.O. BOX 1069 SANTA MARIA, CA. 93456 U.S.A. PHONE (805) 928-3851 FSC13201	
		DRAWN BY MM	DATE 09-12-79
CHECKED BY MC	DATE 09-12-79	MATL 7075-T6 Aluminum Alloy	
APPRVD BY APA	DATE 09-12-79	FINISH Anodize IAW HPS1000	
WEIGHT (calculated) 33 g		DRAWING NUMBER ACR100	REV
SHEET 1 of 5			

TABULATED DATA

UOS all dimensions are in inches.
Copyright HELICAL PRODUCTS CO

MATERIAL: 7075-T6 Aluminum Alloy

FINISH: Anodize IAW HPS1000

Drawing Number

ACR100

REV

DO NOT SCALE DRAWING

SHT 2 of 5

ITEM DESCRIPTION (Part Number)	BORE SIZES		TORQUES (lbin)		
	TOLERANCE +.002in or +0.05mm -.000in or 0		Momentary	Non-Reversing	Shock or Reversing
Ø A1	Ø A2				
ACR100-5-5	.157in	.157in	36	18	9
ACR100-4.5mm-4.5mm	4.50mm	4.50mm	36	18	9
ACR100-6-3mm	.188in	3.00mm	36	18	9
ACR100-6-4M	.188in	.120in	36	18	9
ACR100-6-4	.188in	.125in	36	18	9
ACR100-6-4mm	.188in	4.00mm	36	18	9
ACR100-6-6	.188in	.188in	36	18	9
ACR100-4.98mm-4.98mm	4.98mm	4.98mm	36	18	9
ACR100-5mm-4	5.00mm	.125in	36	18	9
ACR100-5mm-5	5.00mm	.157in	36	18	9
ACR100-5mm-6	5.00mm	.188in	36	18	9
ACR100-5mm-5mm	5.00mm	5.00mm	36	18	9
ACR100-5.66mm-4M	5.66mm	.120in	36	18	9
ACR100-6mm-5	6.00mm	.157in	36	18	9
ACR100-6mm-6	6.00mm	.188in	36	18	9
ACR100-6mm-6mm	6.00mm	6.00mm	36	18	9
ACR100-6.36mm-8	6.36mm	.250in	36	18	9
ACR100-8-3M	.250in	.090in	36	18	9
ACR100-8-2.31mm	.250in	2.31mm	36	18	9
ACR100-8-3mm	.250in	3.00mm	36	18	9
ACR100-8-4M	.250in	.120in	36	18	9
ACR100-8M-4	.250in	.125in	36	18	9
ACR100-8-4	.250in	.125in	36	18	9
ACR100-8-5	.250in	.157in	36	18	9
ACR100-8-4mm	.250in	4.00mm	36	18	9
ACR100-8-6	.250in	.188in	36	18	9
ACR100-8-5mm	.250in	5.00mm	36	18	9
ACR100-8-5.1mm	.250in	5.10mm	36	18	9
ACR100-8-6mm	.250in	6.00mm	36	18	9
ACR100-8-8	.250in	.250in	36	18	9
ACR100-8-10	.250in	.313in	32	16	8
ACR100-8-8mm	.250in	8.00mm	32	16	8
ACR100-8-12	.250in	.375in	28	14	7

TABULATED DATA

UOS all dimensions are in inches.
Copyright HELICAL PRODUCTS CO

MATERIAL: 7075-T6 Aluminum Alloy

FINISH: Anodize IAW HPS1000

Drawing Number

ACR100

REV

DO NOT SCALE DRAWING

SHT 3 of 5

ITEM DESCRIPTION (Part Number)	BORE SIZES		TORQUES (lbin)		
	TOLERANCE +0.002in or +0.05mm -0.000in or 0		Momentary	Non- Reversing	Shock or Reversing
ØA1	ØA2				
ACR100-6.68mm-8	6.68mm	.250in	33	17	8
ACR100-7mm-4mm	7.00mm	4.00mm	32	16	8
ACR100-7mm-8	7.00mm	.250in	32	16	8
ACR100-10-3	.313in	.094in	32	16	8
ACR100-10-4	.313in	.125in	32	16	8
ACR100-10-4mm	.313in	4.00mm	32	16	8
ACR100-10-6	.313in	.188in	32	16	8
ACR100-10-6mm	.313in	6.00mm	32	16	8
ACR100-10-8	.313in	.250in	32	16	8
ACR100-10-10	.313in	.313in	32	16	8
ACR100-8mm-4M	8.00mm	.120in	32	16	8
ACR100-8mm-4	8.00mm	.125in	32	16	8
ACR100-8mm-4mm	8.00mm	4.00mm	32	16	8
ACR100-8mm-6	8.00mm	.188in	32	16	8
ACR100-8mm-5mm	8.00mm	5.00mm	32	16	8
ACR100-8mm-6mm	8.00mm	6.00mm	32	16	8
ACR100-8mm-8	8.00mm	.250in	32	16	8
ACR100-8mm-10	8.00mm	.313in	32	16	8
ACR100-8mm-8mm	8.00mm	8.00mm	32	16	8
ACR100-8.34mm-8.34mm	8.34mm	8.34mm	32	16	8
ACR100-8.35mm-8	8.35mm	.250in	32	16	8
ACR100-11-10	.344in	.313in	30	15	8
ACR100-9mm-6	9.00mm	.188in	30	15	7
ACR100-9mm-5.5mm	9.00mm	5.50mm	30	15	7
ACR100-9mm-8	9.00mm	.250in	30	15	7
ACR100-9.5mm-5mm	9.50mm	5.00mm	28	14	7

TABULATED DATA

UOS all dimensions are in inches.
Copyright HELICAL PRODUCTS CO

MATERIAL: 7075-T6 Aluminum Alloy

FINISH: Anodize IAW HPS1000

Drawing Number

ACR100

REV

DO NOT SCALE DRAWING

SHT 4 of 5

ITEM DESCRIPTION (Part Number)	BORE SIZES		TORQUES (lbin)		
	TOLERANCE +.002in or +0.05mm -.000in or 0		Momentary	Non-Reversing	Shock or Reversing
ØA1	ØA2				
ACR100-12-2.3mm	.375in	2.30mm	28	14	7
ACR100-12-2.31mm	.375in	2.31mm	28	14	7
ACR100-12-3mm	.375in	3.00mm	28	14	7
ACR100-12-4M	.375in	.120in	28	14	7
ACR100-12-4	.375in	.125in	28	14	7
ACR100-12-5	.375in	.157in	28	14	7
ACR100-12-4mm	.375in	4.00mm	28	14	7
ACR100-12-6	.375in	.188in	28	14	7
ACR100-12-4.98mm	.375in	4.98mm	28	14	7
ACR100-12-5mm	.375in	5.00mm	28	14	7
ACR100-12-5.2mm	.375in	5.20mm	28	14	7
ACR100-12-7	.375in	.219in	28	14	7
ACR100-12-5.64mm	.375in	5.64mm	28	14	7
ACR100-12-6mm	.375in	6.00mm	28	14	7
ACR100-12-6.3mm	.375in	6.30mm	28	14	7
ACR100-12-8	.375in	.250in	28	14	7
ACR100-12-6.36mm	.375in	6.36mm	28	14	7
ACR100-12-7mm	.375in	7.00mm	28	14	7
ACR100-12-7.24mm	.375in	7.24mm	28	14	7
ACR100-12-7.5mm	.375in	7.50mm	28	14	7
ACR100-12-7.90mm	.375in	7.90mm	28	14	7
ACR100-12-10	.375in	.313in	28	14	7
ACR100-12-8mm	.375in	8.00mm	28	14	7
ACR100-12-9mm	.375in	9.00mm	28	14	7
ACR100-12-12	.375in	.375in	28	14	7
ACR100-9.8mm-8	9.80mm	.250in	28	14	7
ACR100-9.86mm-9.86mm	9.86mm	9.86mm	28	14	7
ACR100-10mm-3mm	10.00mm	3.00mm	28	14	7
ACR100-10mm-4M	10.00mm	.120in	28	14	7
ACR100-10mm-4	10.00mm	.125in	28	14	7
ACR100-10mm-4mm	10.00mm	4.00mm	28	14	7
ACR100-10mm-5mm	10.00mm	5.00mm	28	14	7
ACR100-10mm-6mm	10.00mm	6.00mm	28	14	7
ACR100-10mm-8M	10.00mm	.250in	28	14	7
ACR100-10mm-8	10.00mm	.250in	28	14	7
ACR100-10mm-10	10.00mm	.313in	28	14	7
ACR100-10mm-8mm	10.00mm	8.00mm	28	14	7
ACR100-10mm-12	10.00mm	.375in	28	14	7

TABULATED DATA

UOS all dimensions are in inches.
Copyright HELICAL PRODUCTS CO

MATERIAL: 7075-T6 Aluminum Alloy

FINISH: Anodize IAW HPS1000

Drawing Number

ACR100

REV

DO NOT SCALE DRAWING

SHT 5 of 5

ITEM DESCRIPTION (Part Number)	BORE SIZES		TORQUES (lbin)		
	TOLERANCE +0.002in or +0.05mm -0.000in or 0		Momentary	Non-Reversing	Shock or Reversing
Ø A1	Ø A2				
ACR100-13-12	.407in	.375in	28	14	7
ACR100-11mm-12	11.00mm	.375in	28	14	7
ACR100-14-12	.438in	.375in	28	14	7
ACR100-12mm-8mm	12.00mm	8.00mm	28	14	7
ACR100-12mm-12	12.00mm	.375in	28	14	7
ACR100-16-4	.500in	.125in	28	14	7
ACR100-16-8	.500in	.250in	28	14	7
ACR100-16-10	.500in	.313in	28	14	7
ACR100-16-12	.500in	.375in	28	14	7
ACR100-14mm-8	14.00mm	.250in	28	14	7
ACR100-18-12	.563in	.375in	28	14	7