

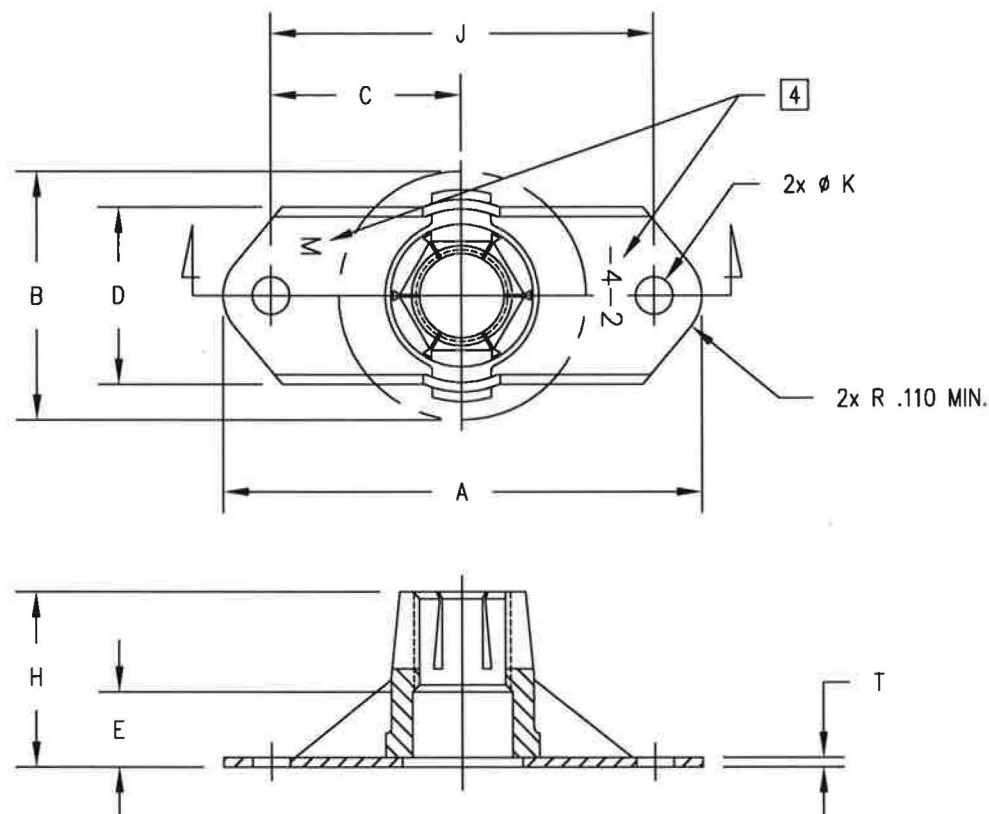
122003-()-()

TABLE 1

FIRST DASH NO.	THREAD SIZE PER FED-STD-H28 2 LEAD, MODIFIED MINOR ϕ	A MAX.	B MAX. REF.	C $\pm .005$	D $\pm .015$	J $\pm .002$	K $+.005$ $-.000$	T $\pm .005$	AXIAL STRENGTH LBS. MIN.	PUSH-OUT LBS. MIN.	TORQUE-OUT IN-LBS. MIN.
-4	.2500-28UNF-3B	1.275	.645	.500	.460	1.000	.098	.025	2,845	400	100
-5	.3125-24UNF-3B	1.275	.740	.500	.580	1.000	.125	.030	4,600	400	160
-6	.3750-24UNF-3B	1.275	.830	.500	.630	1.000	.125	.030	7,360	400	240

TABLE 2

SECOND DASH NO.	-4 SIZE		-5 SIZE		-6 SIZE	
	H MAX	E MIN	H MAX	E MIN	H MAX	E MIN
-2	.452	.160	.535	.160	.610	.160
-4	.592	.300	.675	.300	.750	.300
-6	.732	.440	.815	.440	.890	.440
-8	.872	.580	.955	.580	1.030	.580
-10	1.012	.720	1.095	.720	1.170	.720
-12	1.152	.860	1.235	.860	1.310	.860
-14	1.292	1.000	1.375	1.000	1.450	1.000



ITEM NO.	QTY. REQ'D	PART NO.	DESCRIPTION	MATERIAL OR NOTES
NEXT ASSEMBLY				
END ITEM			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES DECIMALS FRACTION ANGLES $\pm .010$ $-$ $\pm 5^\circ$	IBM # $-$
			MATERIAL: NOTED	DRAWN BY: DATE T. TRAN 09/20/05
			HEAT TREAT: NOTED	ENG. APPROVAL: DATE IK 05/03/07
			FINAL PROTECTIVE FINISH: NOTED	QUAL. ACCEPT.: DATE FD 05/03/07
				MFG. ACCEPT.: DATE TB 05/03/07
			lisi AEROSPACE THE MONADNOCK COMPANY 18301 E. ARENTH AVE CITY OF INDUSTRY, CALIFORNIA TITLE: NUTPLATE, RIVETED, TWO LUG, FLOATING A286 CRES CODE INVENT. NO. 60119 SIZE B DRAWING NUMBER: 122003-()-() SCALE: N/A SALES SHEET 1 OF 2	

-	-	-
A	11327	3/16/17
ISSUE	ECN NUMBER	DATE
PROJECT No.	0512-012	

REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF
THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN
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NOTES, UNLESS OTHERWISE SPECIFIED:

1. MATERIAL:
NUT ELEMENT: A286 CRES PER AMS5732, AMS5737 OR AMS5731.
CAGE: 17-7 CRES PER AMS5528 OR MIL-S-25043.
2. HEAT TREAT:
NUT ELEMENT: 160 KSI MIN. PER AMS-H-6875 OR AMS2759.
CAGE: CONDITION TH1050 PER AMS-H-6875 OR AMS2759.
3. FINISH:
NUT ELEMENT: SILVER PLATE PER AMS2410 AND DRY FILM LUBE PER AS5272.
ANTI-SEIZE COMPOUND PER MIL-PRF-907 APPLIED TO INTERNAL THREADS AFTER DRY FILM LUBE.
CAGE: PASSIVATE PER AMS2700.
4. PARTS SHALL BE PERMANENTLY MARKED WITH MANUFACTURER'S IDENTIFICATION LETTER "M", FIRST & SECOND DASH NO. PER TABLE 2 .010 MAXIMUM DEPTH, MARKING LOCATION & ORIENTATION ARE OPTIONAL.
5. NUT ELEMENT RADIAL FLOAT SHALL NOT LESS THAN .020 INCHES FROM THE CENTERED POSITION. NUT ELEMENT SHALL BE CAPABLE OF ENGAGEMENT WITH BOLT AT MAXIMUM MISALIGNED POSITION.
6. PARTS SHALL BE VISIBLY UNIFORM IN QUALITY AND APPEARANCE. THEY SHALL BE FREE OF BURRS, CRACKS, CHIPS, SHARP CUTTING EDGES, AND OTHER DEFECTS THAT WILL ADVERSELY EFFECT LIFE AND SERVICEABILITY OF THE PARTS OR ATTACHED PANEL.
7. UNLESS OTHERWISE SPECIFIED, ALL SURFACE ROUGHNESS SHALL HAVE A 125 RMS MAX. PER ASME B46.1.
8. NUTPLATE ASSEMBLY MUST CONFORMS TO LOCKHEED DRAWING NO. JSFN12 & MEET THE REQUIREMENTS OF LOCKHEED SPEC. 2GNT00002.
9. EXAMPLE OF NUTPLATE ASSEMBLY PART NUMBER CALLOUT:

122003-()-()

SECOND DASH NUMBER PER TABLE 2.

INTERNAL THREAD SIZE PER TABLE 1.

BASIC PART NO.

EXAMPLE OF NUT ELEMENT PART NUMBER CALLOUT:

122003 N-()-()

SECOND DASH NUMBER PER TABLE 2.

INTERNAL THREAD SIZE PER TABLE 1.

NUT ELEMENT COMPONENT

BASIC PART NO.

-	-	-
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ITEM NO.	QTY. REQ'D	PART NO.	DESCRIPTION	MATERIAL OR NOTES
END ITEM			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES DECIMALS FRACTION ANGLES ±.010 — ±5° MATERIAL: NOTED	lisi AEROSPACE THE MONADNOCK COMPANY 18301 E. ARENTH AVE CITY OF INDUSTRY, CALIFORNIA TITLE: NUTPLATE, RIVETED, TWO LUG, FLOATING A286 CRES CODE IDENT. NO. 60119 SIZE B DRAWING NUMBER: 122003-()-() SCALE N/A SALES SHEET 2 OF 2
PREVIOUS ASSEMBLY			HEAT TREAT: NOTED FINAL PROTECTIVE FINISH: NOTED	
			IBM # — DRAWN BY: T. TRAN DATE 09/20/05 ENG. APPROVAL: IK DATE 05/03/07 QUAL. ACCEPT.: FD DATE 05/03/07 MFG. ACCEPT.: TB DATE 05/03/07	