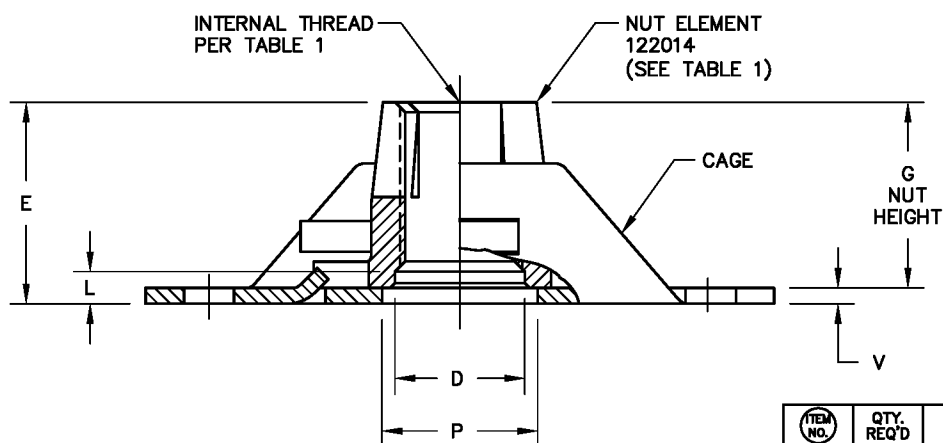
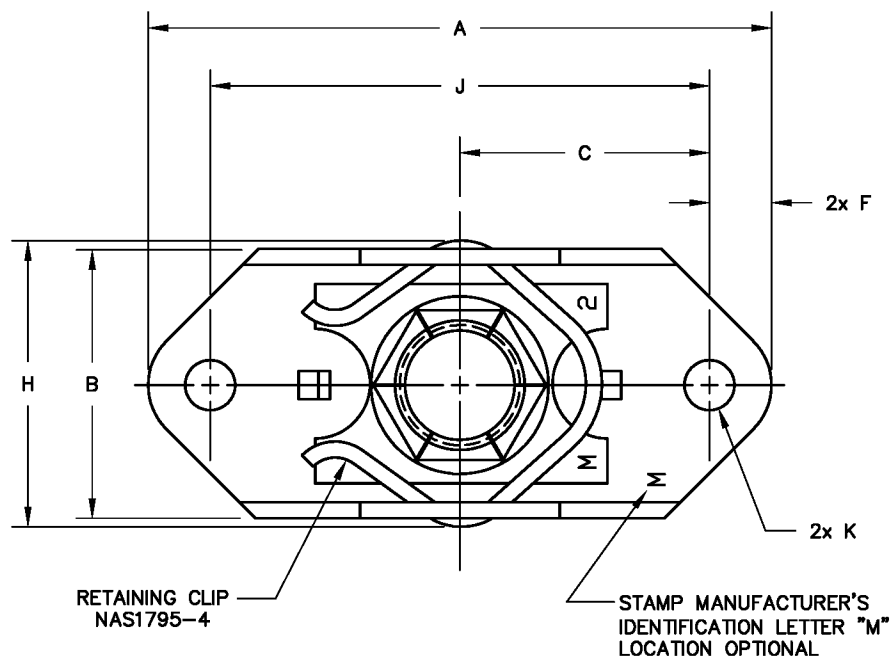


122012



NOTES, UNLESS OTHERWISE SPECIFIED:

1. MATERIAL:
 - 1.1 NUT ELEMENT: A286 CRES PER AMS5731, AMS5732, AMS5734, OR AMS5737. (REF)
 - 1.2 CAGE: 17-7PH CRES PER AMS5528.
 - 1.3 CLIP: XM-28 STAINLESS STEEL SPRING WIRE PER ASTM A313/A313M. (REF)
2. HEAT TREAT:
 - 2.1 NUT ELEMENT: 160 KSI MIN. (REF)
 - 2.2 CAGE: CONDITION TH1050 PER AMS2759.
 - 2.3 CLIP: NONE (REF)
3. FINISH:
 - 3.1 NUT ELEMENT AND CAGE FINISH
 "C"= NUT ELEMENT: CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 2 AND DRY FILM LUBE PER AS5272. TYPE I. (REF)
 CAGE: CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 2.
 - 3.2 CLIP: PASSIVATE PER AMS2700. (REF)
 - 3.3 ANTI-SEIZE COMPOUND PER MIL-PRF-907 APPLIED TO INTERNAL THREADS OF NUT ELEMENT AFTER COATING. (REF)
4. FLOAT: NUT FLOATS .030 MIN. RADIALLY FROM CAGE CENTERLINE.
5. NUT PLATES ARE INTENDED FOR USE WITH LISI STUD BOLT BASIC PART NO. 1080006 OR 121002.
6. BURRS, SLIVERS AND/OR SHARP EDGES NOT PERMITTED.
7. NUT SHALL BE CAPABLE OF 250 SEATED REUSE CYCLES AT ROOM TEMPERATURE. USING TOOL RATED AT 800 RPM FOR INSTALLATION OF THE MATING MALE FASTENER. SELF-LOCKING VALUES MEET THE SPECIFICATION REQUIREMENTS OF NASM25027.

8. NUT ELEMENT IS REMOVABLE AND REPLACEABLE. FOR REPLACEMENT, ORDER NUT ELEMENT PART NO. FROM TABLE 1.

9. PART NO. CALLOUT EXAMPLE:

122012-4-8C

FINISH CODE (SEE NOTE 3)
C= CADMIUM PLATE

C'BORE DEPTH (SEE TABLE 1)
L = .582

THREAD SIZE (SEE TABLE 1)
-4 = .2500-28UNF

BASIC PART NO.

E	ECN 9542	10-08-10
D	ECN 9070	02-22-10
ISSUE	ECN NUMBER	DATE
PROJECT No. 0512-007		

REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN PERMISSION OF LISI AEROSPACE MONADNOCK IS PROHIBITED

ITEM NO.	QTY. REQ'D	PART NO.	DESCRIPTION				MATERIAL OR NOTES			
NEXT ASSEMBLY —		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ANGLES DECIMALS FRACTION ±.010 — ±5°		IBM # —		lisi AEROSPACE THE MONADNOCK COMPANY 18301 E. ARNETH AVE CITY OF INDUSTRY, CALIFORNIA				
				DRAWN BY: DATE T. TRAN 05/02/05						
PREVIOUS ASSEMBLY —		MATERIAL: SEE NOTE 1		ENG. APPROVAL: DATE PYB 02/08/06		TITLE: NUT PLATE, FLOATING 2 LUG, CLIP-IN, 2 LEAD THREAD A286 CRES 160 KSI, 250 CYCLES				
		HEAT TREAT: SEE NOTE 2		QUAL. ACCEPT.: DATE FD 02/14/06						
		FINAL PROTECTIVE FINISH: SEE NOTE 3		MFG. ACCEPT.: DATE JA 02/14/06						
				CODE INDET. NO. 60119		SIZE B	DRAWING NUMBER: 122012			
				SCALE —		SALES			SHEET 1 OF 2	

lisi AEROSPACE THE MONADNOCK COMPANY
18301 E. ARENTH AVE
CITY OF INDUSTRY, CALIFORNIA

TITLE:
NUT PLATE, FLOATING
2 LUG, CLIP-IN, 2 LEAD THREAD
A286 CRES 160 KSI, 250 CYCLES

122012

TABLE 1

NUT PLATE PART NO.	NUT ELEMENT PART NO. 8 FOR REPLACEMENT	THREAD SIZE PER FED-STD-H28 2 LEAD, MODIFIED MINOR Ø	A MAX.	B MAX.	C ±.005	Ø D REF.	E MAX.	F MIN.	G REF.	H MAX.	J ±.002	Ø K +.005 -.000	L MIN.	Ø P MIN.	V ±.005
122012-4-2()	122014-4-2()	.2500-28UNF-3B	1.292	.547	.500	.254	.467	.125	.420	.584	1.000	.098	.162	.312	.032
122012-4-3()	122014-4-3()						.537		.490				.232		
122012-4-4()	122014-4-4()						.607		.560				.302		
122012-4-5()	122014-4-5()						.677		.630				.372		
122012-4-6()	122014-4-6()						.747		.700				.442		
122012-4-7()	122014-4-7()						.817		.770				.512		
122012-4-8()	122014-4-8()						.887		.840				.582		

TABLE 2

NUT PLATE PART NO.	SEATING TORQUE REF.	INSTALLATION TORQUE REF.	BREAKAWAY TORQUE REF.	PUSHOUT STRENGTH	TORQUE-OUT STRENGTH	AXIAL TENSILE STRENGTH REF.
122012-4-2()	110 IN-LBS MAX.	30 IN-LBS MAX.	3.5 IN-LBS MIN.	100 LBS MIN.	110 IN-LBS MIN.	2,213 LBS MIN.
122012-4-3()						
122012-4-4()						
122012-4-5()						
122012-4-6()						
122012-4-7()						
122012-4-8()						

E	ECN 9542	10-08-10
D	ECN 9070	02-22-10
ISSUE	ECN NUMBER	DATE
PROJECT No. 0512-007		

REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF
THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN
PERMISSION OF LISI AEROSPACE MONADNOCK IS PROHIBITED

ITEM NO.	QTY. REQ'D	PART NO.	DESCRIPTION	MATERIAL OR NOTES		
—	—	—	NEXT ASSEMBLY	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES DECIMALS FRACTION ANGLES ±.010 — ±5°		
			MATERIAL:	SEE NOTE 1		
			PREVIOUS ASSEMBLY	HEAT TREAT:		
			—	SEE NOTE 2		
—	—	—	FINAL PROTECTIVE FINISH:	SEE NOTE 3		
			IBN #	—		
			DRAWN BY: DATE	T. TRAN 05/02/05		
			ENG. APPROVAL: DATE	PYB 02/08/06		
—	—	—	QUAL. ACCEPT.: DATE	FD 02/14/06		
			MFG. ACCEPT.: DATE	JA 02/14/06		
			CODE, INDET. NO.	60119		
			SIZE	B		
DRAWING NUMBER:			122012			
SCALE: —			SALES			
SHEET 2 OF 2						