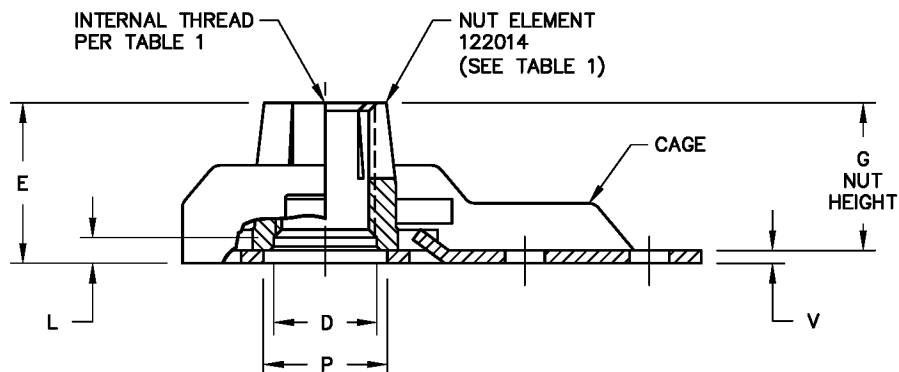
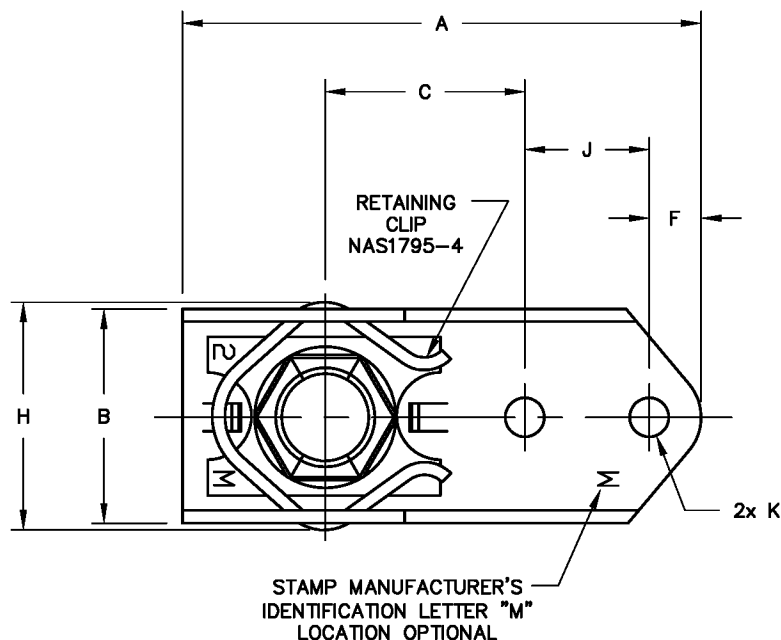


122030



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

9. PART NO. CALLOUT EXAMPLE:

122030-4-8C

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.

D	ECN 9542	10-08-10
C	ECN 9070	02-22-10
ISSUE	ECN NUMBER	DATE
PROJECT No. 0712-008		

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		
		IBM #	—	
		DRAWN BY:	DATE	lisi AEROSPACE THE MONADNOCK COMPANY 18301 E. ARENTH AVE CITY OF INDUSTRY, CALIFORNIA TITLE: NUT PLATE, FLOATING SINGLE LUG, CLIP-IN, 2 LEAD THD. A286 CRES 160 KSI, 250 CYCLES
		T. TRAN	09-26-07	
		ENG. APPROVAL:	DATE	
		IK	11-12-07	
		QUAL. ACCEPT.:	DATE	CODE INDENT. NO. SIZE DRAWING NUMBER: 60119 B 122030
		FD	11-12-07	
		MFG. ACCEPT.:	DATE	
		JA	11-12-07	SCALE: — SALES SHEET 1 OF 2

122030

TABLE 1

NUT PLATE PART NO.	NUT ELEMENT PART NO. FOR [8] REPLACEMENT	THREAD SIZE PER FED-STD-H28 2 LEAD, MODIFIED MINOR Ø	A MAX.	B MAX.	C ±.005	Ø D C'BORE REF.	E MAX.	F MIN.	G REF.	H MAX.	J ±.002	Ø K +.005 -.000	L MIN.	Ø P MIN.	V ±.005
122030-4-2()	122014-4-2()	.2500-28UNF-3B	1.306	.547	.500	.254	.467	.125	.420	.584	.312	.098	.162	.312	.032
122030-4-3()	122014-4-3()						.537		.490				.232		
122030-4-4()	122014-4-4()						.607		.560				.302		
122030-4-5()	122014-4-5()						.677		.630				.372		
122030-4-6()	122014-4-6()						.747		.700				.442		
122030-4-7()	122014-4-7()						.817		.770				.512		
122030-4-8()	122014-4-8()						.887		.840				.582		

TABLE 2

PART NO.	SEATING TORQUE REF.	INSTALLATION TORQUE REF.	BREAKAWAY TORQUE REF.	PUSHOUT STRENGTH	TORQUE-OUT STRENGTH	AXIAL TENSILE STRENGTH REF.
122030-4-2()	110 IN-LBS MAX.	30 IN-LBS MAX.	3.5 IN-LBS MIN.	100 LBS MIN.	110 IN-LBS MIN.	2,213 LBS MIN.
122030-4-3()						
122030-4-4()						
122030-4-5()						
122030-4-6()						
122030-4-7()						
122030-4-8()						

D	ECN 9542	10-08-10
C	ECN 9070	02-22-10
ISSUE	ECN NUMBER	DATE
PROJECT No. 0712-008		

REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF
THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN
PERMISSION OF LSI 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°	IBM # —
			MATERIAL: SEE NOTE 1	DRAWN BY: DATE T. TRAN 09-26-07
		PREVIOUS ASSEMBLY	HEAT TREAT: SEE NOTE 2	ENG. APPROVAL: DATE IK 11-12-07
			FINAL PROTECTIVE FINISH: SEE NOTE 3	QUAL. ACCEPT.: DATE FD 11-12-07
				MFG. ACCEPT.: DATE JA 11-12-07
				CODE INVENT. NO. 60119
				SIZE B
				DRAWING NUMBER: 122030
				SCALE: —
				SALES
				SHEET 2 OF 2

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

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