

130068()

J NOTES (UNLESS OTHERWISE SPECIFIED):

1. MATERIAL:
 - 1.1. CLIP: 1050 CARBON STEEL PER ASTM A684/A684M OR AMS5085
 - 1.2. NUT: 4037 ALLOY STEEL PER AMS6300 OR ASTM A752
2. HEAT TREAT:
 - 2.1 CLIP: AUSTEMPERED TO 84.5-86.0 HR15N (HRC 48-51)
 - 2.2 NUT: HEAT TREAT OR COLD WORK TO MEET THE PERFORMANCE REQUIREMENTS PER BACN10FX. ROCKWELL HARDNESS NOT TO EXCEED HR15N 83.5 MAX. (HRC 46 MAX.)
3. FINISH:
 - 3.1. CLIP: NO CODE = CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 1.
"G" CODE = CADMIUM PLATE PER AMS-QQ-P-416, TYPE II OR III, CLASS 1. THEN APPLY BMS10-11, TYPE I PRIMER PER THE LATEST REVISION OF PCD EMPS-073 OR IPS-14.
 - 3.1.1 CADMIUM PLATED CLIPS SHALL MEET SALT SPRAY REQUIREMENTS OF AMS-QQ-P-416, TYPE II. EMBRITTLEMENT TEST PER AMS-QQ-P-416 DOES NOT APPLY. EMBRITTLEMENT TEST PER BACN10FX SHALL APPLY.
 - 3.2 NUT: CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 2. EMBRITTLEMENT TEST PER AMS-QQ-P-416 DOES NOT APPLY.
4. LUBRICATION:
 - 4.1 CLIP: NONE
 - 4.2 NUT: SOLID FILM LUBRICANT PER ASS272, TYPE I MEETING THE HYDRAULIC FLUID RESISTANCE REQUIREMENTS OF BMS3-8.
5. QUALIFICATION AND PROCUREMENT PER BPS-N-70, CLASS 125TA4, EXCEPT AS NOTED. QUALIFICATION AND ACCEPTANCE REQUIREMENTS PER BACN10FX.
6. AXIAL TENSILE STRENGTH - 2,460 LBS MINIMUM
7. LOCALIZED REMOVAL OF CADMIUM PLATE AND SOLID FILM LUBRICANT COMMON TO TOP OF NUT ELEMENT DUE TO THE INSTALLATION INTO THE CLIP IS ACCEPTABLE.
8. DIMENSIONS APPLY AFTER CADMIUM PLATE AND BEFORE THE APPLICATION OF SOLID FILM LUBRICANT AND BMS10-11 PRIMER.
9. IDENTIFY WITH COMPANY LOGO "M". METHOD AND PLACEMENT OF LOGO ON EITHER CLIP OR NUT ARE MANUFACTURER'S OPTION.
10. CLIP & NUT ASSEMBLY SHALL BE FREE FROM BURRS AND SLIVERS.
11. PART NUMBER EXAMPLE:
1 3 0 0 6 8 ()

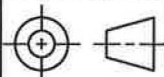
CLIP FINISH (SEE NOTE 3)

BASIC PART NUMBER

INSTALLATION DATA

SHEET THICKNESS	NOMINAL EDGE MARGIN	INSTALLATION HOLE
.140-.230	.600-.710	.219-.229

J	11099	JC	6/3/16	REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN PERMISSION OF LISI AEROSPACE THE MONADNOCK COMPANY IS PROHIBITED
I	8555	PO	5/18/06	
REV.	ECN NO.	INIT.	DATE	

NEXT ASSEMBLY		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS: DECIMALS FRACTION ANGLES ±.010 - -		IBM NUMBER: -	lisi AEROSPACE THE MONADNOCK COMPANY 18728 E. GALE AVE. CITY OF INDUSTRY, CALIFORNIA
END ITEM		MATERIAL: NOTED		PROJECT NUMBER: -	
THIRD ANGLE PROJECTION		HEAT TREAT: NOTED		DRAWN BY: DATE OJS 2/11/71	TITLE: NUT ASSEMBLY, CLIP-ON, 10-32 SIZE, (BACN10FX)
		FINAL PROTECTIVE FINISH: NOTED		APPROVED BY: DATE TBW 2/11/71	CAGE CODE SIZE DRAWING NUMBER: 60119 A 130068()
				SCALE: NONE	SALES SHEET 1 OF 1