

13060000-()-()()

APPROX. WEIGHT LBS./100	FIRST DASH NO.	A	EDGE DISTANCE MAX.	SECOND DASH NO.	B MIN.	PANEL THICKNESS RANGE
.29	-1	.275	.250	-1	.060	.020-.060
.33	-2	.405	.375	-2	.125	.060-.125
.45	-3	.510	.38-.50	-3	.160	.020-.160
.45	-4	.530	.38-.50	-4	.187	.125-.187
.51	-5	.660	.50-.62	-5	.250	.187-.250
				-6	.125	.020-.125
				-7	.160	.090-.160
				-8	.250	.160-.250

DIMENSIONING AND TOLERANCING PER ANSI Y14.5M
NOTES (UNLESS OTHERWISE SPECIFIED):

1. .200 $\pm$.010 FOR PARTS WITH "A" DIM. .275, .200 MAX. FOR PARTS WITH "A" DIM. .405, .250 $\pm$.010 FOR PARTS WITH "A" DIM. .510, .530 OR .660.

2. MATERIAL:

2.1. CLIP: C1050 CARBON STEEL PER ASTM A684/A684M.

HEAT TREAT: AUSTEMPER TO HRC 48-51 PER MPS0009.

2.2. NUT: C1050 CARBON STEEL PER ASTM A684/A684M.

HEAT TREAT: AUSTEMPER TO HRC 40-45 PER MPS0009.

3. FINISH

3.1 NO SUFFIX:

3.1.1. CLIP: CADMIUM PLATED PER AMS-QQ-P-416, TYPE II, CLASS 2;
BAKE FOR 23 HOURS MIN. AT 375°F $\pm$ 25°F WITHIN 2 HOURS AFTER PLATING.3.1.2. NUT: CADMIUM PLATED PER AMS-QQ-P-416, TYPE II, CLASS 2;
BAKE FOR 23 HOURS MIN. AT 375°F $\pm$ 25°F WITHIN 2 HOURS AFTER PLATING.
DRY FILM LUBRICANT PER AS5272, TYPE 1.

3.2 SUFFIX 'ZW':

3.2.1. CLIP: ZINC PLATED PER ASTM B633, TYPE III, CLASS SC2, CLEAR TRIVALENT CHROMATE;
BAKE FOR 4 HOURS MIN. AT 375°F $\pm$ 25°F WITHIN 2 HOURS AFTER PLATING.3.2.1. NUT: ZINC PLATED PER ASTM B633, TYPE III, CLASS SC2, CLEAR TRIVALENT CHROMATE;
BAKE FOR 4 HOURS MIN. AT 375°F $\pm$ 25°F WITHIN 2 HOURS AFTER PLATING.
DRY FILM LUBRICANT PER AS5272, TYPE 1.4. INSTALLATION HOLE SIZE: ϕ .190-.229.

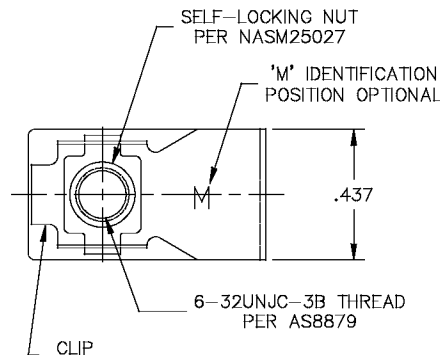
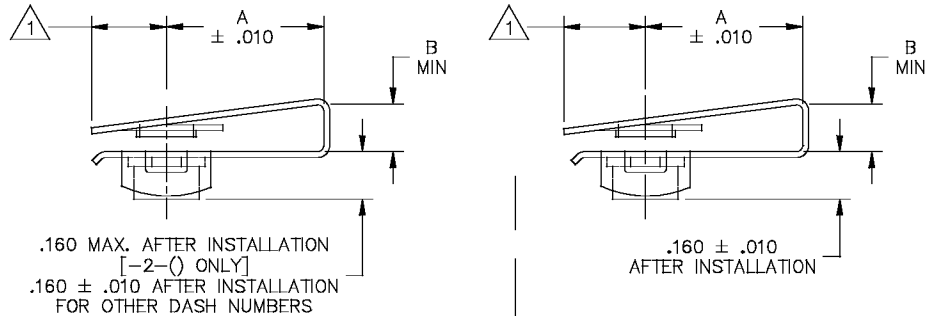
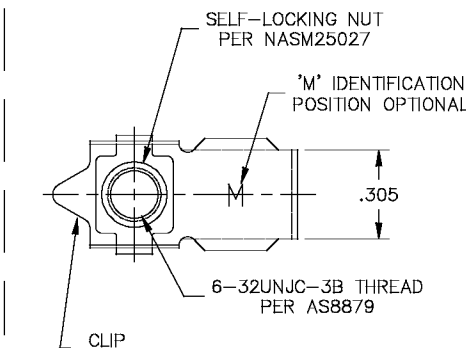
5. PROCUREMENT SPECIFICATION PER NASM25027.

6. PART NUMBER EXAMPLE:

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FINISH
SECOND DASH NO. PANEL THICKNESS (SEE TABLE)
FIRST DASH NO. "A" DIM. (SEE TABLE)

FAA-TSO AUTHORIZED PART

FOR -3-6 AND -5-6 ASSEMBLIES
SEE ALTERNATE CONFIGURATIONALTERNATE CONFIGURATION
FOR -3-6 AND -5-6 ASSEMBLIES

J	ECN 9095	10/07/09
H	ECN 8966	11/24/08
ISSUE	ECN NUMBER	DATE
PROJECT No.		

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THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN
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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		IBM #	lisi AEROSPACE THE MONADNOCK COMPANY 18301 E. ARENTH AVE. CITY OF INDUSTRY, CALIFORNIA TITLE: NUT ASSEMBLY CLIP-ON TYPE 6-32 SIZE
	MATERIAL:		DRAWN BY: DATE	
	HEAT TREAT:		ENG. APPROVAL: DATE	
	FINAL PROTECTIVE FINISH:		QUAL. ACCEPT.: DATE	
PREVIOUS ASSEMBLY	NOTED		CKT 04/07/88	CODE IDENT. NO. SIZE 60119 B
	NOTED		CKT 04/07/88	
			MFG. ACCEPT.: DATE	DRAWING NUMBER: 13060000-()-()()
			- -	
			SALES NONE	SALES SHEET 1 OF 1