

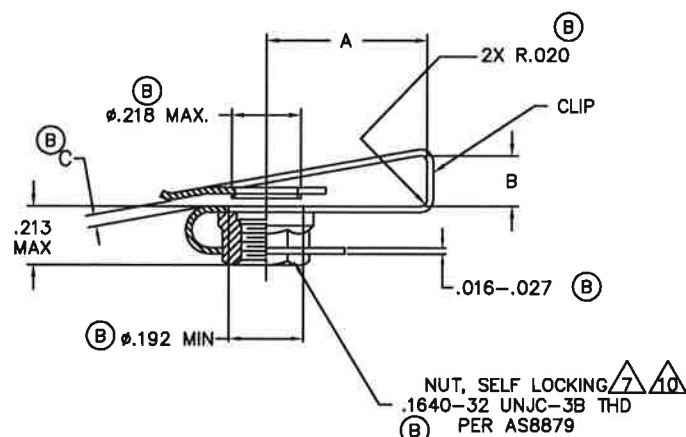
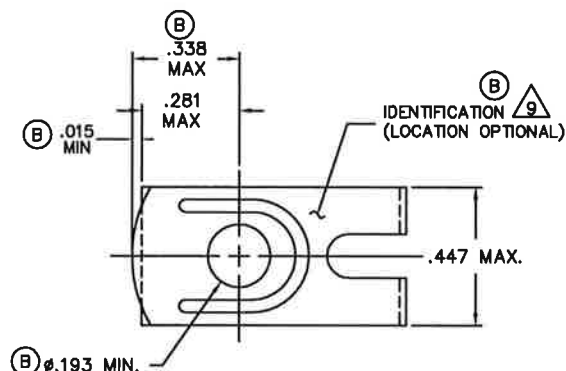


TABLE 1 (B)

DASH NUMBER	A	B MIN.	C	SHEET THICKNESS	NOMINAL EDGE MARGIN	INSTALLATION HOLE
-1	.500-.530	.095	N/A	.020-.090	.350-.500	N/A
-2	.650-.680	.095	N/A	.020-.090	.510-.650	N/A
-3	.650-.680	.155	N/A	.091-.150	.510-.650	N/A
-4	.500-.530	.155	N/A	.091-.150	.350-.500	N/A
-5	.725-.755	.235	.002-.120	.140-.230	.600-.710	.231-.237

(B) NOTES (UNLESS OTHERWISE SPECIFIED):

- MATERIAL:
 - CLIP: 1050 CARBON STEEL PER ASTM A684/A684M OR AMS5085
 - NUT: 4037 ALLOY STEEL PER AMS6300 OR ASTM A752
- HEAT TREAT:
 - CLIP: AUSTEMPERED TO 84.5-86.0 HR15N (HRC 48-51)
 - NUT: HEAT TREAT OR COLD WORK TO MEET THE PERFORMANCE REQUIREMENTS PER BACN10FX. ROCKWELL HARDNESS NOT TO EXCEED 83.5 MAX. HR15N (HRC 46 MAX.)
- FINISH:
 - CLIP: NO CODE = CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 1.
 "W" CODE = CADMIUM PLATE PER AMS-QQ-P-416 TYPE I, 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.
 - NUT: CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 2. EMBRITTLEMENT TEST PER AMS-QQ-P-416 DOES NOT APPLY.
- LUBRICATION:
 - CLIP: NONE
 - NUT: SOLID FILM LUBRICANT PER AS5272, TYPE I MEETING THE HYDRAULIC FLUID RESISTANCE REQUIREMENTS OF BMS3-8.
- QUALIFICATION AND PROCUREMENT PER BPS-N-70, CLASS 125TA4, EXCEPT AS NOTED. QUALIFICATION AND ACCEPTANCE REQUIREMENTS PER BACN10FX.
- AXIAL TENSILE STRENGTH - 1.720 LBS MINIMUM
- LOCALIZED REMOVAL OF CADMIUM PLATE AND SOLID FILM LUBRICANT COMMON TO TOP OF NUT ELEMENT DUE TO THE INSTALLATION INTO THE CLIP IS ACCEPTABLE.
- DIMENSIONS APPLY AFTER CADMIUM PLATE AND BEFORE THE APPLICATION OF SOLID FILM LUBRICANT AND BMS10-11 PRIMER.
- IDENTIFY WITH COMPANY LOGO "M". METHOD AND PLACEMENT OF LOGO ON EITHER CLIP OR NUT ARE MANUFACTURER'S OPTION.
- IDENTIFY NUT ELEMENT WITH WHITE PAINT IN THE FORM OF A DOT OR SPRAY AFTER LUBRICATING. OVERSPRAY ACCEPTABLE ON THE TOP OF THREAD AND CLIP.
- CLIP & NUT ASSEMBLY SHALL BE FREE FROM BURRS AND SLIVERS.
- PART NUMBER EXAMPLE:

13080031-() ()

CLIP FINISH CODE (SEE NOTE 3)

DASH NUMBER (SEE TABLE 1)

BASIC PART NUMBER

FAA-TSO AUTHORIZED PART

B	1111	JC	6/14/16	REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN PERMISSION OF LISI AEROSPACE THE MONADNOCK COMPANY IS PROHIBITED
A	6049	-	7/16/98	
REV.	ECN NO.	INIT.	DATE	

NEXT ASSEMBLY	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS: DECIMALS: ±.010 FRACTION: — ANGLES: ±2°	IBM NUMBER: —	lisi AEROSPACE THE MONADNOCK COMPANY 16720 E. GALE AVE. CITY OF INDUSTRY, CALIFORNIA
END ITEM	MATERIAL: NOTED	PROJECT NUMBER: —	
THIRD ANGLE PROJECTION	HEAT TREAT: NOTED	DRAWN BY: DATE CT 6/11/98	TITLE: (B) NUT ASSEMBLY, CLIP-ON, 08-32 SIZE, (BACN10FX)
	FINAL PROTECTIVE FINISH: NOTED	APPROVED BY: DATE CPM 6/26/98	CAGE CODE: 60119 SIZE: A DRAWING NUMBER: 13080031-() ()
		SCALE: NONE	SALES