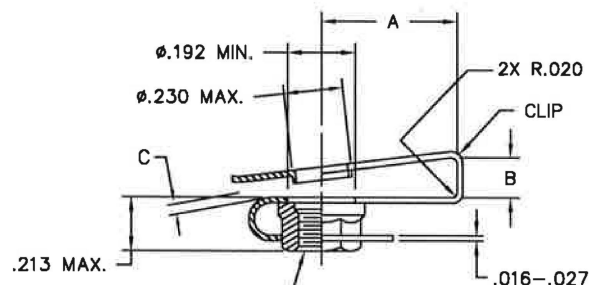
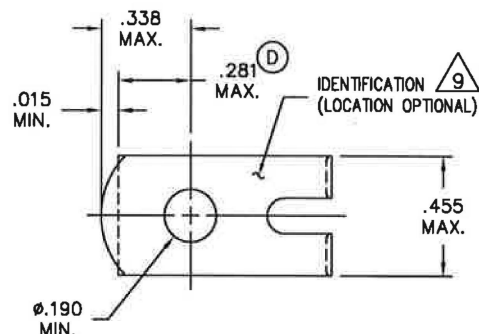


13080032-() ()



NUT, SELF-LOCKING
1640-32 UNJC-3B THD
PER AS8879

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 83.5 MAX. HR15N (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 AS5272, TYPE I, MEETING THE HYDRAULIC FLUID RESISTANCE REQUIREMENTS OF BMS3-B.
5. QUALIFICATION AND PROCUREMENT PER BPS-N-70, CLASS 125TA4, EXCEPT AS NOTED. QUALIFICATION AND ACCEPTANCE REQUIREMENTS PER BACN10FX.
6. AXIAL TENSILE STRENGTH - 1.720 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. 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
11. CLIP & NUT ASSEMBLY SHALL BE FREE FROM BURRS AND SLIVERS.

12. PART NUMBER EXAMPLE:

1 3 0 8 0 0 3 2 - () ()

CLIP FINISH CODE (SEE NOTE 3)

DASH NUMBER (SEE TABLE 1)

BASIC PART NUMBER

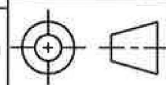
TABLE 1

PART NUMBER	A	B MIN.	C	SHEET THICKNESS	NOMINAL EDGE MARGIN	INSTALLATION HOLE
-1	.650-.680	.355	.210-.300	.310-.350	.350-.650	.231-.327
-2	.500-.0530	.150	.002-.080	.050-.150	.370-.500	.231-.327

NEXT ASSEMBLY

END ITEM

THIRD ANGLE PROJECTION



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS:

DECIMALS	FRACTION	ANGLES
±.010	-	±2°

MATERIAL: NOTED

HEAT TREAT: NOTED

FINAL PROTECTIVE FINISH: NOTED

IBM NUMBER:

PROJECT NUMBER: 9813-007

DRAWN BY: DATE
CKT 6/11/98APPROVED BY: DATE
CPM 6/26/98

lisi AEROSPACE THE MONADNOCK COMPANY
16728 E. GALE AVE.
CITY OF INDUSTRY, CALIFORNIA

TITLE: NUT ASSEMBLY, CLIP-ON, 08-32 SIZE, (BACN10FX)

CAGE CODE SIZE DRAWING NUMBER:
60119 A 13080032-() ()

SCALE: NONE SALES SHEET 1 OF 1

D	11313	JC	3/3/17	REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN PERMISSION OF LISI AEROSPACE THE MONADNOCK COMPANY IS PROHIBITED
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