

13100025()

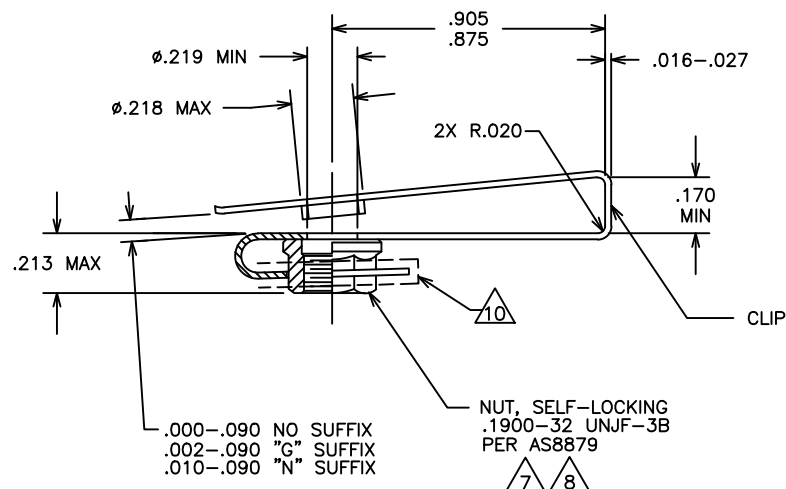
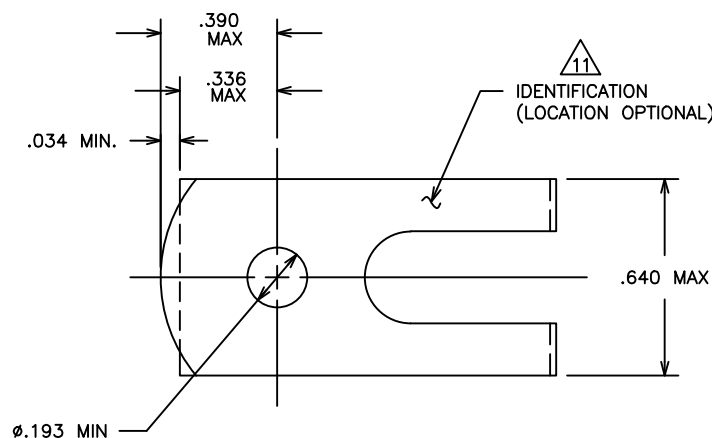


TABLE 1 - INSTALLATION DATA

SHEET THICKNESS	EDGE DISTANCE	INSTALLATION HOLE
.100-.160	.750-.870	Ø .219 - .229

NOTES (UNLESS OTHERWISE SPECIFIED):

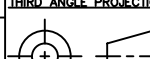
- MATERIAL:
 - CLIP: 1050 CARBON STEEL PER ASTM A684/A684M OR AMS5085
 - NUT: 4037 ALLOY STEEL PER AMS6300 OR ASTM A752
- HEAT TREAT:
 - CLIP: AUSTEMPERED TO 84.5-86.0 HR15N (HRC 48-51)
 - NUT: HEAT TREAT OR COLD WORK TO MEET THE PERFORMANCE REQUIREMENTS PER BACN10FX. ROCKWELL HARDNESS NOT TO EXCEED 83.5 MAX. HR15N (HRC 46 MAX.)
- FINISH:
 - CLIP: NO CODE = CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 1.
"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
(N) "N" CODE = CADMIUM PLATE PER AMS-QQ-P-416, TYPE II OR TYPE III CLASS 1. THEN APPLY NYLON 11 COATING PER THE LATEST REVISION OF MSPS0027.
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 - 2,460 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.
- LOCALIZED REMOVAL OF NYLON AROUND NUT ELEMENT DUE TO THE INSTALLATION INTO THE CLIP IS ACCEPTABLE.
- DIMENSIONS APPLY AFTER CADMIUM PLATE AND BEFORE THE APPLICATION OF SOLID FILM LUBRICANT, NYLON 11 AND BMS10-11 PRIMER.
- FOR "N" CODE, NYLON 11 NOT ALLOWED ON TOP, BOTTOM AND THRU HEX AS SHOWN BY DASH LINES.
- IDENTIFY WITH COMPANY LOGO "M". METHOD AND PLACEMENT OF LOGO ON EITHER CLIP OR NUT ARE MANUFACTURER'S OPTION.
- CLIP & NUT ASSEMBLY SHALL BE FREE FROM BURRS AND SLIVERS.
- PART NUMBER EXAMPLE:

1 3 1 0 0 2 5 ()

CLIP FINISH CODE (SEE NOTE 3)

BASIC PART NUMBER

FAA-TSO AUTHORIZED PART

NEXT ASSEMBLY		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS:		IBM NUMBER:		lisi AEROSPACE THE MONADNOCK COMPANY			
END ITEM		DECIMALS FRACTION ANGLES ±.010 — —		—		16728 E. GALE AVE CITY OF INDUSTRY, CALIFORNIA			
		MATERIAL: SEE NOTE 1		PROJECT NUMBER: —		TITLE: NUT ASSEMBLY, CLIP-ON, 10-32 SIZE (BACN10FX)			
THIRD ANGLE PROJECTION		HEAT TREAT: SEE NOTE 2		DRAWN BY: DATE RAD 1/26/90		CAGE CODE SIZE		DRAWING NUMBER:	
		FINAL PROTECTIVE FINISH: SEE NOTE 3		APPROVED BY: DATE CKT 1/31/90		60119 A		13100025()	
						SCALE: NONE		SALES SHEET 1 OF 1	

N	11357	JC	4/13/17	REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN PERMISSION OF LISI AEROSPACE THE MONADNOCK COMPANY IS PROHIBITED
M	11114	JC	6/15/16	
REV.	ECN NO.	INIT.	DATE	