

13100037-() () ()

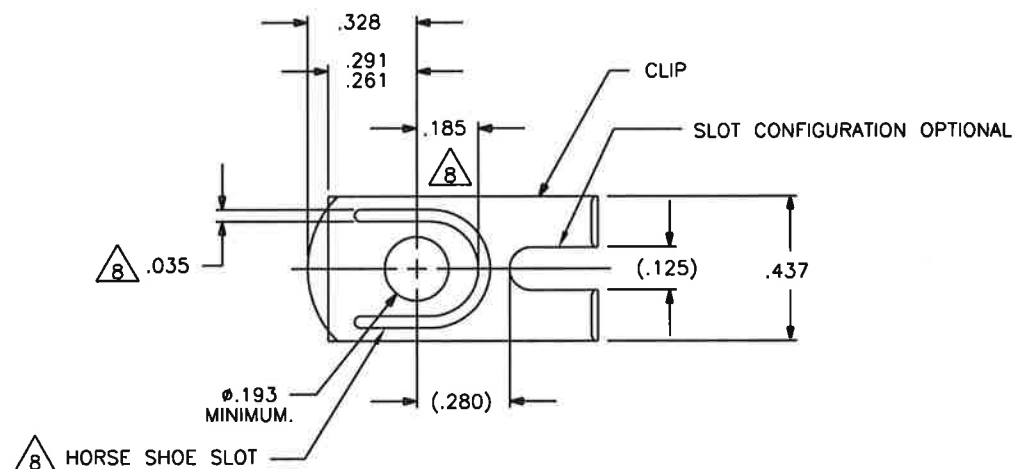


TABLE 1

PART NUMBER	A	B	C		R REF
			MAX	MIN	
13100037-1() ()	.718	.105	.035	.002	.053
13100037-2() ()	.748	.165	.080	.002	.083
13100037-3() ()	.860	.240	.150	.002	.120
13100037-4() ()	.585	.105	.035	.002	.053
13100037-5() ()	.889	.280	.150	.002	.140

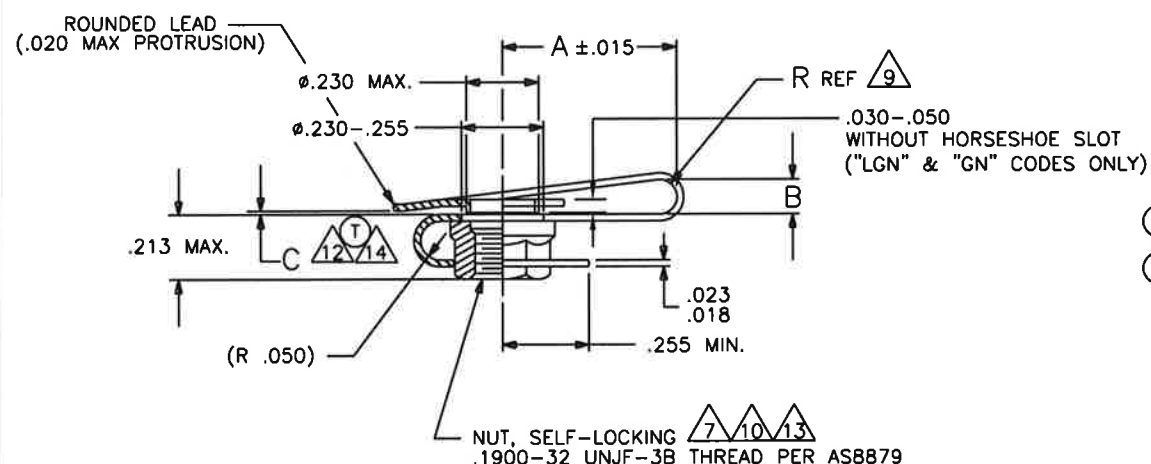



TABLE 2 - INSTALLATION DATA

PART NUMBER	SHEET THICKNESS	RANGE EDGE MARGIN	RECOMMENDED INSTALLATION HOLE	
			"LG", "G" NO CODE	"LGN", "GN"
13100037-1() ()	.035-.095	.370-.650	Ø.231-.285	Ø.231-.340
13100037-2() ()	.080-.155	.370-.650	Ø.231-.285	Ø.231-.340
13100037-3() ()	.150-.230	.370-.725	Ø.231-.285	Ø.231-.340
13100037-4() ()	.035-.095	.370-.500	Ø.231-.285	Ø.231-.340
13100037-5() ()	.150-.270	.370-.734	Ø.231-.285	Ø.231-.340

Ⓣ FAA-TSO AUTHORIZED PART

NEXT ASSEMBLY END ITEM	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS: DECIMALS ± .010 FRACTION - ANGLES -	IBM NUMBER: N/A	 AEROSPACE THE MONADNOCK COMPANY 18301 E. ARDEN AVE. CITY OF INDUSTRY, CALIFORNIA	
MATERIAL:	SEE NOTE 1	PROJECT NUMBER: 9113-008	TITLE: CLIP NUT ASSY, 1032, TITANIUM	
HEAT TREAT:	SEE NOTE 2	DRAWN BY: DATE F.D. 8/30/91	CAGE CODE 60119	SIZE A DRAWING NUMBER: 13100037-() () ()
FINAL PROTECTIVE FINISH:	SEE NOTE 3	APPROVED BY: DATE R.A.D. 9/4/91	SCALE: NONE	SALES SHEET 1 OF 2

T	10783	TD	2/12/15	REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN PERMISSION OF LSI AEROSPACE THE MONADNOCK COMPANY IS PROHIBITED
R	10560	TD	8/14/14	
REV.	ECN NO.	INIT.	DATE	

NOTES (UNLESS OTHERWISE SPECIFIED):

1. MATERIAL:
1.1 CLIP: TITANIUM 15-3-3-3 PER AMS4914.
1.2 NUT: CRES A286 PER AMS5731 OR AMS5734.
2. HEAT TREAT:
2.1 CLIP: IN ACCORDANCE WITH AMS4914, EXCEPT AGE AT 900°F ±10°F FOR 8 HOURS ±30 MINUTES AND AIR COOLED TO ROOM TEMPERATURE.
3. FINISH:
3.1 CLIP: NO CODE = BMS10-85 ALUMINUM PIGMENTED COATING, TYPE I, CLASS A.
"G" CODE = BMS10-11 PRIMER, TYPE I SHALL BE APPLIED TO THE CLIP PER THE LATEST PROCESS CONTROL DOCUMENTS EMPS073 OR IPS-15.
3.2 NUT: "L" CODE = PASSIVATE PER AMS2700, TYPE 8, APPLY SOLID FILM LUBE.
WITHOUT "L" CODE = PASSIVATE PER AMS2700, TYPE 8, APPLY CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2 AND APPLY SOLID FILM LUBE.
4. LUBRICATION:
4.1 CLIP: NONE
4.2 NUT: SOLID DRY FILM LUBE AS5272, TYPE I, IN ACCORDANCE WITH QPL IN AS5272SUP. MUST MEET THE HYDRAULIC FLUID RESISTANCE REQUIREMENTS OF BMS3-8.
5. PROCUREMENT PER BPS-N-70, CLASS 125TC3, EXCEPT AS NOTED.
ACCEPTANCE REQUIREMENTS PER BACN10VR:
5.1 AXIAL TENSILE STRENGTH (NUT ELEMENT ONLY) – 2,460 LBS MINIMUM.
5.2 TORQUE-OUT TEST, NUT ENGAGEMENT TEST AND RETENTION TEST.
5.3 PRIMER REQUIREMENTS – ADHESION TEST PER BSS7225, TYPE I AND APPEARANCE TEST.
6. DIMENSIONS APPLY AFTER FINISH. FOR "G" CODED PARTS ONLY DIMENSIONS APPLY PRIOR TO THE APPLICATION OF BMS10-11 PRIMER.
7. LOCALIZED REMOVAL OF SOLID DRY FILM LUBRICANT COMMON TO THE TOP OF THE NUT ELEMENT DUE TO THE INSTALLATION INTO THE CLIP IS ACCEPTABLE.
8. HORSESHOE REQUIRED FOR "L", "LG" AND "G" CODES ONLY.
9. SINGLE, CONTINUOUS RADIUS REQUIRED.
10. IDENTIFY NUT ELEMENT ONLY WITH MANUFACTURE SYMBOL "M" AND MATERIAL CODE "C". LOCATION AND METHOD OPTIONAL EXCEPT NOT ON THE BEARING SURFACE OF NUT. IDENTIFICATION MUST BE LEGIBLE.
11. CLIP & NUT ASSEMBLY SHALL BE FREE FROM BURRS AND SLIVERS.
12. FOR "G" CODED PARTS ONLY: AT LEAST NINETY PERCENT (90%) OF THE EXPOSED SURFACES OF THE CLIP SHALL BE COATED WITH BMS10-11 PRIMER. THE COATING MAY NOT APPEAR SMOOTH AND UNIFORM. NUMEROUS CONTACT MARKS MAY BE VISIBLE AND ARE NOT GROUNDS FOR REJECTION. THERE SHALL BE NO BONDING OF ADJACENT SURFACES OF CLIP DUE TO THE COATING. SAMPLING SHALL BE PER BSS7286, ISOLATED LOT SAMPLING USING EQUAL PRODUCER'S AND CONSUMER'S RISKS (ERP = 1-IRR) WITH AN EQUAL RISK POINT OF .01. ADHESION TEST BMS10-11 PRIMER PER BSS7225, TYPE I, CLASS 1. SAMPLING SHALL BE PER BSS7286, ISOLATED LOT SAMPLING USING EQUAL PRODUCER'S AND CONSUMER'S RISKS (ERP = 1-IRR) WITH AN EQUAL RISK POINT OF .03.
13. PASSIVATED NUT ELEMENTS WITH FINISH CODES: L, LG, LGN SHALL BE IDENTIFIED WITH "YELLOW" EPOXY PAINT IN THE FORM OF A "DOT" AFTER THE APPLICATION OF SOLID FILM LUBRICATION (OVERSPRAY IS ACCEPTABLE ON TOP OF NUT THREADS AND BASE/BEARING SURFACES).
14. FOR "NO" & "L" CODED PARTS ONLY: THE EXPOSED SURFACES OF THE CLIP SHALL BE UNIFORMLY COATED WITH BMS10-85 ALUMINUM COATING WITH NO LOCATION NOT COATED. THERE SHALL BE NO BONDING OF ADJACENT SURFACES OF THE CLIP DUE TO COATING. SAMPLING SHALL BE PER BSS7286, ISOLATED LOT SAMPLING USING EQUAL PRODUCER'S AND CONSUMER'S RISKS (ERP = 1-IRR) WITH AN EQUAL RISK POINT OF .01. ADHESION TEST PER TAP TEST REQUIREMENTS OF BMS10-85. SAMPLING SHALL BE PER BSS7286, ISOLATED LOT SAMPLING USING EQUAL PRODUCER'S AND CONSUMER'S RISKS (ERP = 1-IRR) WITH AN EQUAL RISK POINT OF .03.

15. HORSESHOE SLOT NOT AVAILABLE FOR SIZES 3 & 5.

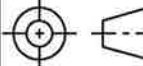
16. PART NUMBER EXAMPLE:

13100037-() () ()

NO CODE=WITH HORSESHOE SLOT
"N" CODE=WITHOUT HORSESHOE SLOT
FINISH CODE (SEE NOTES 3&4 AND TABLE 3)
SIZE CODE (SEE TABLES 1&2)
BASIC PART NUMBER.

TABLE 3.

MONADNOCK PART NUMBER	BOEING PART NUMBER	FINISH AND CONFIGURATION
13100037-()L	BACN10VR()	BMS10-85 COATED CLIP WITH HORSESHOE. PASSIVATED, SOLID FILM LUBED NUT.
13100037-()LG	BACN10VR()G	BMS10-11 PRIMERED CLIP WITH HORSESHOE. PASSIVATED, SOLID FILM LUBED NUT.
13100037-()G	BACN10VR()CG	BMS10-11 PRIMERED CLIP WITH HORSESHOE. PASSIVATED, CADMIUM PLATED SOLID FILM LUBED NUT.
13100037-()LGN	BACN10VR()GN	BMS10-11 PRIMERED CLIP WITHOUT HORSESHOE. PASSIVATED, SOLID FILM LUBED NUT.
13100037-()GN	BACN10VR()CGN	BMS10-11 PRIMERED CLIP WITHOUT HORSESHOE. PASSIVATED, CADMIUM PLATED SOLID FILM LUBED NUT.
13100037-()LN	BACN10VR()N	BMS10-85 COATED CLIP WITHOUT HORSESHOE. PASSIVATED, SOLID FILM LUBED NUT.

NEXT ASSEMBLY	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS: DECIMALS FRACTION ANGLES ±.010 — —		IBM NUMBER: N/A		lisi AEROSPACE THE MONADNOCK COMPANY 18301 E. ARDEN AVE. CITY OF INDUSTRY, CALIFORNIA			
END ITEM	MATERIAL: SEE NOTE 1		PROJECT NUMBER: 9113-008		TITLE: CLIP NUT ASSY, 1032, TITANIUM			
THIRD ANGLE PROJECTION	HEAT TREAT: SEE NOTE 2		DRAWN BY: DATE F.D. 8/30/91		CAGE CODE 60119	SIZE A	DRAWING NUMBER: 13100037-() () ()	
	FINAL PROTECTIVE FINISH: SEE NOTE 3		APPROVED BY: DATE R.A.D. 9/4/91					
					SCALE: NONE	SALES		SHEET 2 OF 2

T	10783	TD	2/12/15	REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN PERMISSION OF LI SI AEROSPACE THE MONADNOCK COMPANY IS PROHIBITED
R	10560	TD	8/14/14	
REV.	ECN NO.	INIT.	DATE	