

13100075-()()

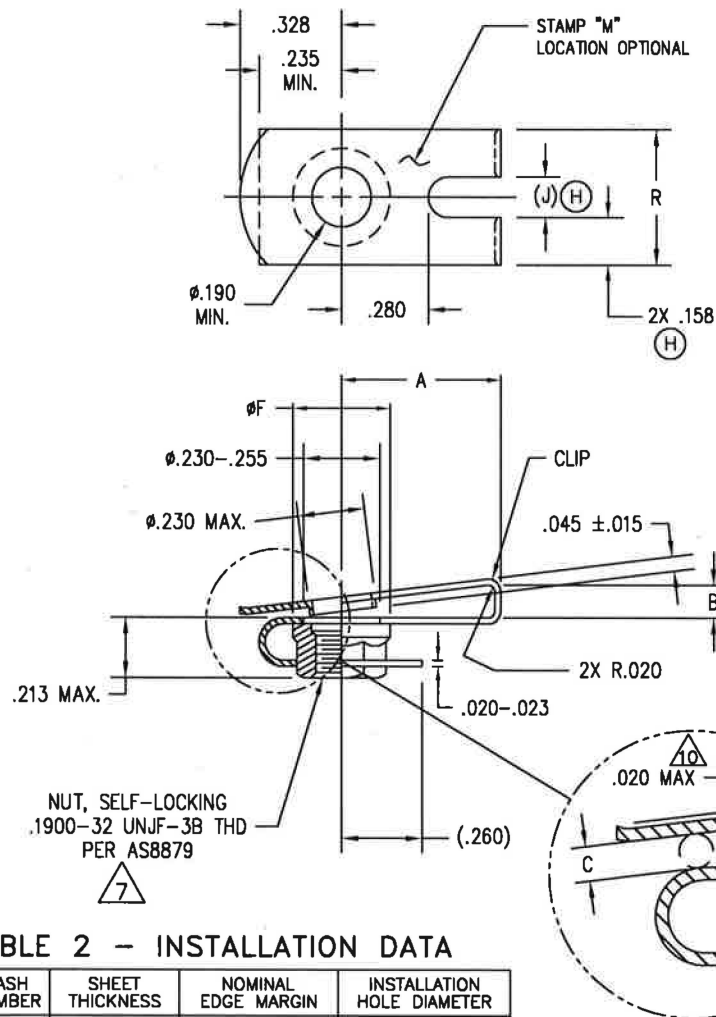


TABLE 2 - INSTALLATION DATA

DASH NUMBER	SHEET THICKNESS	NOMINAL EDGE MARGIN	INSTALLATION HOLE DIAMETER
-1	.020-.150	.350-.650	.231-.327
-2	.310-.350	.350-.650	.231-.327
-3	.140-.230	.350-.710	.231-.327
-4	.050-.150	.370-.500	.231-.327

TABLE 1

DASH NUMBER	A ± .015	B MIN.	C	R	ØF	(J)
-1	.665	.155	.002-.080	.427-.455	.320	.125
-2	.665	.355	.210-.300	.427-.455	.320	.125
-3	.740	.235	.002-.120	.427-.455	.320	.125
-4	.515	.155	.002-.080	.427-.455	.320	.125

NOTES (UNLESS OTHERWISE SPECIFIED):

1. MATERIAL:
  - 1.1 CLIP: 1050 CARBON STEEL PER ASTM A684/A684M OR AMS5085.
  - 1.2 NUT: A286 CRES PER AMS5731, AMS5732, AMS5734, OR AMS5735.
2. HEAT TREAT:
  - 2.1 CLIP: AUSTEMPERED TO 84.5-86.0 HR15N (HRC 48-51)
  - 2.2 NUT: HEAT TREATED
3. FINISH:
  - 3.1 CLIP: NO SUFFIX = CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 1.  
 "G" SUFFIX = CADMIUM PLATE PER AMS-QQ-P-416, TYPE III, CLASS 1.  
 THEN APPLY BMS10-11 PRIMER, TYPE I PER E/M COATING SERVICES PCD #EMPS-073 OR INNOVATIVE COATINGS TECHNOLOGY CORP PCD # IPS-14.
    - 3.1.1 CADMIUM PLATED CLIPS SHALL MEET SALT SPRAY REQUIREMENTS OF AMS-QQ-P-416.
    - 3.1.2 EMBRITTLEMENT TEST PER AMS-QQ-P-416 DOES NOT APPLY, EMBRITTLEMENT TEST PER BACN11K SHALL APPLY.
  - 3.2 NUT: CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 2
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-B.
5. PROCUREMENT PER BPS-N-70, CLASS 125TA4 AND 125TC4, EXCEPT AS NOTED. ACCEPTANCE REQUIREMENTS PER BACN11K.
6. AXIAL TENSILE STRENGTH - 2,460 LBS MINIMUM
7. LOCALIZED REMOVAL OF CADMIUM PLATE AND SOLID DRY FILM LUBRICANT COMMON TO TOP OF NUT ELEMENT DUE TO THE INSTALLATION INTO THE CLIP IS ACCEPTABLE.
8. DIMENSIONS APPLY AFTER FINISH. FOR "G" CODED PARTS ONLY DIMENSIONS APPLY PRIOR TO THE APPLICATION OF BMS10-11 PRIMER.
9. CLIP & NUT ASSEMBLY SHALL BE FREE FROM BURRS AND SLIVERS.
10. IF ROUNDED LEAD IS USED, UPWARD BEND SHALL BE .020 MAX.
11. EACH PRODUCTION LOT OF FASTENERS COATED WITH BMS10-11 PRIMER SHALL BE INSPECTED PER CONFORMANCE TO THE FOLLOWING REQUIREMENTS:  
 APPEARANCE - PARTS SHALL BE VISUALLY EXAMINED FOR COVERAGE. PRIMER CLIPS SHALL HAVE A MINIMUM OF NINETY (90) PERCENT OF THE EXPOSED SURFACES COATED WITH PRIMER. THERE SHALL BE NO BONDING OF ADJACENT SURFACES CAUSED BY THE COATING. THE COATING MAY NOT APPEAR SMOOTH OR UNIFORM. NUMEROUS CONTACT MARKS MAY BE VISIBLE. THESE SHALL NOT BE GROUNDS OF REJECTION. LOCALIZED REMOVAL OF COATING AROUND NUT DUE TO NUT INSTALLATION IS ACCEPTABLE. SAMPLING SHALL BE PER ANSI/ASQ Z1.4, INSPECTION LEVEL S-4, SINGLE SAMPLING PLAN, WITH AN ACCEPTANCE QUALITY LIMIT (AQL) OF ONE PERCENT.  
 ADHESION - PERFORM ADHESION TEST PER BSS7225, TYPE I, CLASS 1 TO MEET DRY ADHESION REQUIREMENTS OF BMS10-11. SAMPLING FOR INSPECTION SHALL BE PER ANSI/ASQ Z1.4, INSPECTION LEVEL S-3, SINGLE SAMPLING PLAN, WITH AN ACCEPTANCE QUALITY LIMIT (AQL) OF ONE PERCENT.

12. PART NUMBER EXAMPLE:

1 3 1 0 0 0 7 5 - ( ) ( )

SUFFIX DENOTES TYPE OF CLIP FINISH:

NO SUFFIX - CADMIUM PLATED CLIP, TYP. II, CL. 1

"G" SUFFIX - CADMIUM PLATED CLIP WITH BMS10-11 PRIMER

DASH NUMBER DESIGNATES "A", "B" AND "C" DIMENSIONS

BASIC PART NUMBER

FAA-TSO AUTHORIZED PART

NEXT ASSEMBLY END ITEM	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS: DECIMALS FRACTION ANGLES ±.010 - ±2°	IBM NUMBER: N/A	lisi AEROSPACE THE MONADNOCK COMPANY 16728 E. GALE AVE. CITY OF INDUSTRY, CALIFORNIA
		PROJECT NUMBER: -	
THIRD ANGLE PROJECTION	MATERIAL: SEE NOTE 1	DRAWN BY: DATE RAD 5/19/98	TITLE: NUT ASSEMBLY, CLIP-ON TYPE, 10-32 SIZE
	HEAT TREAT: SEE NOTE 2	APPROVED BY: DATE CPM 5/19/98	
	FINAL PROTECTIVE FINISH: SEE NOTE 3	CAGE CODE 60119	DRAWING NUMBER: 13100075-()()
		SCALE: NONE	
REV.	ECN NO.	INIT.	DATE
H	11323	JC	3/13/17
G	9940	DW	6/15/12

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