

(C) NOTES (UNLESS OTHERWISE SPECIFIED):

1. MATERIAL:
 - 1.1 CLIP: 1050 CARBON STEEL PER ASTM A684/A684M
 - 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) PER AMS-H-6875
 - 2.2 NUT: 130 KSI MIN
3. FINISH:
 - 3.1 CLIP: "NO" CODE = CADMIUM PLATE PER AMS-QQ-P-416, TYPE II OR TYPE III, CLASS 1. THEN APPLY NYLON 11 COAT PER THE LATEST REVISION MSPS0027.
 "G" CODE = CADMIUM PLATE PER AMS-QQ-P-416, TYPE II OR TYPE 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 THE SALT SPRAY REQUIREMENTS OF AMS-QQ-P-416, TYPE II. 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. EMBRITTLEMENT TEST PER AMS-QQ-P-416 DOES NOT APPLY.
4. LUBRICATION:
 - 4.1 CLIP: NONE
 - 4.2 NUT: SOLID DRY FILM LUBE AS5272, TYPE I MEETING THE HYDRAULIC FLUID RESISTANCE REQUIREMENTS OF BMS3-8.
5. PROCUREMENT PER BPS-N-70, CLASS 125TA4 AND 125TC4, EXCEPT AS NOTED. QUALIFICATION AND 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. PRIMED CLIP SHALL HAVE A MINIMUM OF NINETY (90) PERCENT OF THE EXPOSED SURFACES OF THE CLIP COATED WITH PRIMER. NYLON COATED CLIPS SHALL HAVE COMPLETE COVERAGE EXCEPT AS NOTED ON THE GRAPHIC. THERE SHALL BE NO BONDING OF ADJACENT SURFACES CAUSED BY THE COATINGS. THE COATINGS MAY NOT APPEAR SMOOTH OR UNIFORM. NUMEROUS CONTACT MARKS MAY BE VISIBLE. THESE SHALL NOT BE GROUNDS FOR REJECTION. LOCALIZED REMOVAL OF COATINGS AROUND NUT DUE TO NUT INSTALLATION INTO CLIP 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.
9. DIMENSIONS APPLY AFTER CADMIUM PLATE AND BEFORE THE APPLICATION OF SOLID FILM LUBRICANT, NYLON 11 AND BMS10-11 PRIMER.
10. FOR "NO" CODE, NYLON 11 COATING IS NOT ALLOWED ON THE TOP, BOTTOM AND THRU HEX AS SHOWN BY THE DASH LINES. NYLON COATING IN NOTED AREAS ADJACENT TO NUT IS MANUFACTURER'S OPTION.
11. IDENTIFY WITH COMPANY LOGO "M". METHOD AND PLACEMENT OF LOGO ON EITHER CLIP OR NUT ARE MANUFACTURER'S OPTION.
12. CLIP & NUT ASSEMBLY SHALL BE FREE FROM BURRS AND SLIVERS.
13. PART NUMBER EXAMPLE:

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

FINISH CODE (SEE NOTE 3) (C)

SIZE CODE (SEE TABLE 1)

BASIC PART NUMBER

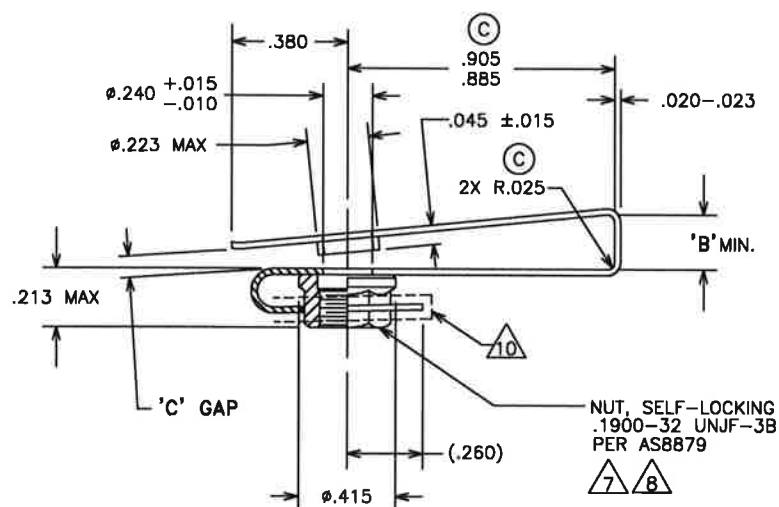
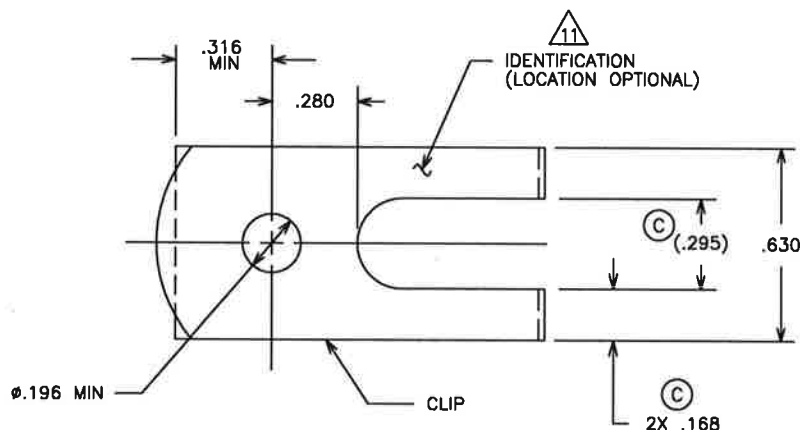


TABLE 1 - INSTALLATION DATA

PART NUMBER	SHEET THICKNESS	EDGE DISTANCE	INSTALLATION HOLE	'B' MIN.	'C' GAP
13100108-7	.100-.195	.350-.870	Ø.224-.391	.200	.010-.090
13100108-8	.200-.310	.350-.870	Ø.224-.391	.315	.010-.205

REV.	ECN NO.	INIT.	DATE	REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN PERMISSION OF LISI AEROSPACE THE MONADNOCK COMPANY IS PROHIBITED
C	11165	JC	8/24/16	
B	10917	JC	9/29/15	

NEXT ASSEMBLY	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS: DECIMALS: ±.010 FRACTION: — ANGLES: —	IBM NUMBER:	—	lisi AEROSPACE THE MONADNOCK COMPANY 16728 E. GALE CITY OF INDUSTRY, CALIFORNIA
END ITEM	MATERIAL: NOTED	PROJECT NUMBER:	—	
THIRD ANGLE PROJECTION	HEAT TREAT: NOTED	DRAWN BY: JC	DATE: 5/8/15	TITLE: NUT ASSEMBLY, CLIP-ON, 10-32 SIZE (BACN11K) (C) CAGE CODE: 60119 SIZE: A DRAWING NUMBER: 13100108-()
	FINAL PROTECTIVE FINISH: NOTED	APPROVED BY: TT	DATE: 5/9/15	SCALE: NONE SALES SHEET 1 OF 1