

FOR CONNECTOR FLANGE

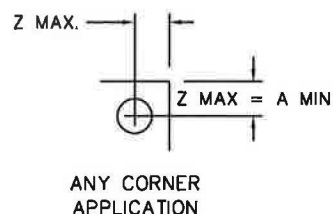


TABLE 1


PART NUMBER	THREAD SIZE	A	B	C	D	H	R	W	J*	CONNECTOR SIZE	COLOR IDENTITY
132003	4-40 UNJC-3B	.123	.150	.080 .070	.068 .058	.140 .125	Ø.138 REF	.414 .460	.067 .057	8,10,12,14	BLK/GREY
132004		.154								16,18,20	WHITE
132005		.169								22, 24	BLUE

* "J" DIMENSION = CONNECTOR FLANGE THICKNESS.

(R) NOTES (UNLESS OTHERWISE SPECIFIED):

- MATERIAL: 1050 CARBON STEEL PER ASTM-A684 (.020 THICK).
- HEAT TREAT: AUSTEMPERED TO 84.0-86.0 HR15N (HRC 46-52).
- FINISH: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. THREADS SHALL SHOW COMPLETE COVERAGE BUT THICKNESS REQUIREMENT IS WAIVED.
COLOR CODE PER TABLE 1. PAINT SHALL NOT BE TOXIC OR CORROSIVE AND SHALL REMAIN PERMANENTLY. PARTS SHALL BE COVERED SUFFICIENTLY TO DISCERN PART SIZE.
- LUBRICATION: SOLID FILM LUBE AS5272, TYPE I, IN ACCORDANCE WITH QPL IN AS5272SUP.
- PROCUREMENT PER BPS-N-70, CLASS 80TA4, EXCEPT AS NOTED. ACCEPTANCE REQUIREMENTS PER BACN10XP.
- TO CALCULATE CORNER HOLE LOCATION SUBTRACT $(Y-X)/2 = "A"$ DIM. OR LESS.
- LOCKING TORQUE PER BPS-N-70 FOR 5 REUSABILITY CYCLES ONLY. MAXIMUM LOCKING TORQUE SHALL BE 5 IN/LBS ON INSTALLATION AND REMOVAL. BREAKAWAY TORQUE SHALL BE 1.0 IN/LBS MINIMUM ON FIRST CYCLE AND 0.5 IN/LBS MINIMUM ON REMAINING CYCLES.
- LOCKING FEATURE SHALL NOT DAMAGE NUT OR BOLT THREADS WHEN TORQUE TESTED.
- DIMENSIONS APPLY AFTER FINISH.
- ALL EDGES SHALL BE FREE FROM BURRS AND SLIVERS.

FAA-TSO AUTHORIZED PART

NEXT ASSEMBLY END ITEM	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS: DECIMALS FRACTION ANGLES ±.010 — ±5°	IBM NUMBER: N/A	lisi AEROSPACE THE MONADNOCK COMPANY 18301 E. ARENTH AVE CITY OF INDUSTRY, CALIFORNIA		
		MATERIAL: SEE NOTE 1	PROJECT NUMBER: —	TITLE: NUT CLIP-ON CORNER	
THIRD ANGLE PROJECTION 	HEAT TREAT: SEE NOTE 2	DRAWN BY: DATE RYT 6/27/72	CAGE CODE 60119	SIZE A	DRAWING NUMBER: 132003-132005
	FINAL PROTECTIVE FINISH: SEE NOTE 3	APPROVED BY: DATE TBW 6/27/72			

R	ECN 10054	JC	1/31/13	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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