

NOTES (UNLESS OTHERWISE SPECIFIED):

1. MATERIAL:

1.1. CLIP: 1050 CARBON STEEL PER ASTM A684/A684M OR AMS5085

1.2. NUT: 4037 ALLOY STEEL PER AMS6300 OR ASTM A752

2. HEAT TREAT:

2.1 CLIP: AUSTEMPERED TO 84.5-86.0 HR15N (HRC 48-51)

HEAT TREAT OR COLD WORK TO MEET THE PERFORMANCE REQUIREMENTS PER BACN10FX. ROCKWELL HARDNESS NOT TO EXCEED 83.5 MAX. HR15N 2.2 NUT:

(HRC 46 MAX.)

3. FINISH:

3.1. 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.

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

BACNIOFX 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.

LUBRICATION:

4.1 CLIP: NONE

4.2 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 - 4,580 LBS MINIMUM

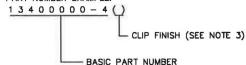
LOCALIZED REMOVAL OF CADMIUM PLATE AND SOLID FILM LUBRICANT COMMON TO TOP OF NUT ELEMENT DUE TO THE INSTALLATION INTO THE CLIP IS ACCEPTABLE.

DIMENSIONS APPLY AFTER CADMIUM PLATE AND BEFORE THE APPLICATION OF SOLID FILM LUBRICANT AND BMS10-11 PRIMER.

IDENTIFY WITH COMPANY LOGO "M". METHOD AND PLACEMENT OF LOGO ON EITHER CLIP OR NUT ARE MANUFACTURER'S OPTION.

10. CLIP & NUT ASSEMBLY SHALL BE FREE FROM BURRS AND SLIVERS.

11. PART NUMBER EXAMPLE:



FAA-TSO AUTHORIZED PART

		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS: DECIMALS FRACTION ANGLES ±.010 - ±1*		IBM NUMBER:	18728 E. GALE AVE. CITY OF HOUSTRY, CALFORNIA					
IE SION TED		MATERIAL:	NOTED	PROJECT NUMBER:	NUT ASSEMBLY, CLIP-ON, 1/4-28 SIZE,					
	THIRD ANGLE PROJECTION	HEAT TREAT:	NOTED	DRAWN BY: DATE CKT 9/7/88	CAGE CODE SIZE DRAWING NUMBER:					
		FINAL PROTECTIVE F	FINISH: NOTED		60119	A	134000	00-4(.)	
				CKT 9/7/88	SCALE: NONE		SALES	SHEET 1	OF	1

11742 5/1/18 REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF THE 11109 JC 6/8/16 PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN PERMISSI OF LISI AEROSPACE THE MONADNOCK COMPANY IS PROHIBITE ECN NO. INIT. DATE

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REV.

FORMEOSOA rev.G