

## 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)
  - 2.2 NUT: HEAT TREAT OR COLD WORK TO MEET THE PERFORMANCE REQUIREMENTS PER BACN10FX. ROCKWELL HARDNESS NOT TO EXCEED 83.5 MAX. HR15N (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 BACN10FX 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 FILM LUBRICANT PER AS5272, TYPE I, MEETING THE HYDRAULIC FLUID RESISTANCE REQUIREMENTS OF BMS3-8.
5. QUALIFICATION AND PROCUREMENT PER BPS-N-70, CLASS 125TA4, EXCEPT AS NOTED. QUALIFICATION AND ACCEPTANCE REQUIREMENTS PER BACN10FX.
6. AXIAL TENSILE STRENGTH - 4,580 LBS MINIMUM
7. LOCALIZED REMOVAL OF CADMIUM PLATE AND SOLID FILM LUBRICANT COMMON TO TOP OF NUT ELEMENT DUE TO THE INSTALLATION INTO THE CLIP IS ACCEPTABLE.
8. DIMENSIONS APPLY AFTER CADMIUM PLATE AND BEFORE THE APPLICATION OF SOLID FILM LUBRICANT AND BMS10-11 PRIMER.
9. 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:

1 3 4 0 0 0 0 - 4 ( )

CLIP FINISH (SEE NOTE 3)

BASIC PART NUMBER

## FAA-TSO AUTHORIZED PART

NEXT ASSEMBLY		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS:		IBM NUMBER:		lisi AEROSPACE THE MONADNOCK COMPANY					
END ITEM		DECIMALS FRACTION ANGLES ±.010 — ±1°		—		PROJECT NUMBER:		18728 E. GALE AVE. CITY OF INDUSTRY, CALIFORNIA			
		MATERIAL: NOTED		—		TITLE:		NUT ASSEMBLY, CLIP-ON, 1/4-28 SIZE, (BACN10FX)			
THIRD ANGLE PROJECTION		HEAT TREAT: NOTED		DRAWN BY: DATE		CAGE CODE SIZE DRAWING NUMBER:					
				CKT 9/7/88		60119 A		13400000-4( )			
		FINAL PROTECTIVE FINISH: NOTED		APPROVED BY: DATE		SCALE: NONE		SALES		SHEET 1 OF 1	
				CKT 9/7/88							

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
H	11742	JC	5/1/18	
G	11109	JC	6/8/16	