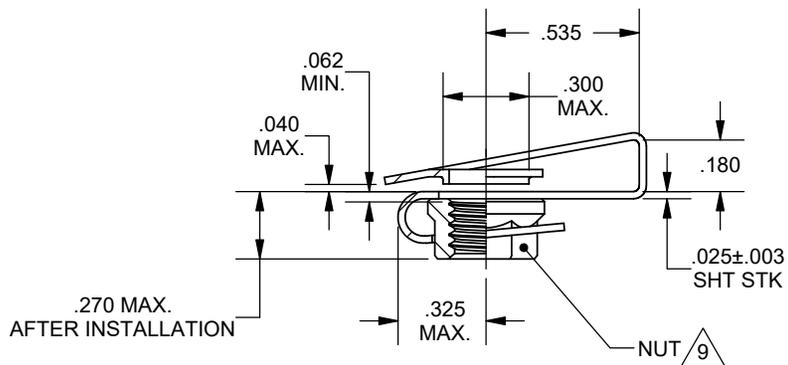
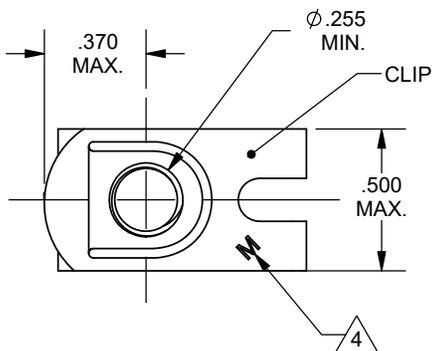




**ISO
VIEW**



NOTES:

1. MATERIAL:
CLIP: A286 CRES PER AMS5525.
NUT: A286 CRES PER AMS5731, AMS5732, AMS5737 OR AMS5525.
2. HEAT TREAT:
CLIP & NUT: AGE TO 140KSI MINIMUM PER AMS2759/3.
3. FINISH:
CLIP: PASSIVATE PER AMS2700.
NUT: PASSIVATE PER AMS2700 AND SOLID-FILM LUBRICANT PER AS5272, TYPE I.
4. PARTS SHALL BE MARKED WITH MANUFACTURERS LOGO "M" ON THIS SURFACE. LOCATION OPTIONAL.
5. PARTS SHALL BE VISIBLY UNIFORM IN QUALITY AND APPEARANCE. THEY SHALL BE FREE OF BURRS, CRACKS, CHIPS, SHARP CUTTING EDGES, AND OTHER DEFECT THAT WILL ADVERSELY AFFECT LIFE AND SERVICEABILITY OF THE PARTS OR THE ATTACHED PANEL.
6. CLIP SURFACE FINISH SHALL BE NO GREATER THE 125 MICROINCHES Ra.
7. CONFORMANCE REQUIREMENTS PER NASM25027, WITH THE FOLLOWING EXCEPTION:
PUSH-OUT SHALL BE TESTED BY APPLYINH A 10 LB. LOAD TO THE HEAD OF THE TEST BOLT OR SCREW WHILE THE NUT ELEMENT IS ENGAGED. THE RESULTING DEFORMATION SHALL NOT IMPAIR NUT ENGAGEMENT AND SHALL NOT RESULT IN LOSS OF CLIP RETENTION TO THE PANEL AFTER THE LOAD IS REMOVED.
LOCKING TORQUE TEST IS TO BE PERFORMED WITH A BARE 6AL-4V TITANIUM BOLT FOR 5 CYCLES, AND MEET THE VALUES PER NASM25027.
8. PANEL APPLICATION DATE:
PANEL THICKNESS RANGE: .050-.125
EDGE DISTANCE: .500 MAX.
INSTALLATION HOLE SIZE: $\phi .305-.312$
9. .2500-28 UNJF-3B THREAD PER AS8879 BEFORE LUBRICATION AND THREAD LOCK.

C	12380	PS	06/15/21
B	11668	JC	02/09/18
REV.	ECN NUMBER	BY	DATE

REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT THE WRITTEN PERMISSION OF LISI AEROSPACE - THE MONADNOCK COMPANY IS PROHIBITED.

NEXT ASSEMBLY -	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS: DECIMALS .XXX = ±.010 ANGLES ±1°		IBM NUMBER: --		lisi THE MONADNOCK COMPANY 16728 E. GALE AVE. CITY OF INDUSTRY, CALIFORNIA			
	MATERIAL: SEE NOTES		PROJECT NUMBER: --		TITLE: NUT ASSEMBLY, CLIP-ON, CRES, 1/4-28 SIZE			
	HEAT TREAT: SEE NOTES		DRAWN BY: DATE R.D. 12/08/93		CODE IDENT. NO. 60119	SIZE B	DRAWING NUMBER 13400001	
	FINAL PROTECTIVE FINISH: SEE NOTES		APPROVED BY: DATE R.DUENAS 12/13/90		SCALE: NONE	SALES	SHEET 1 OF 1	