

186502-()D()()

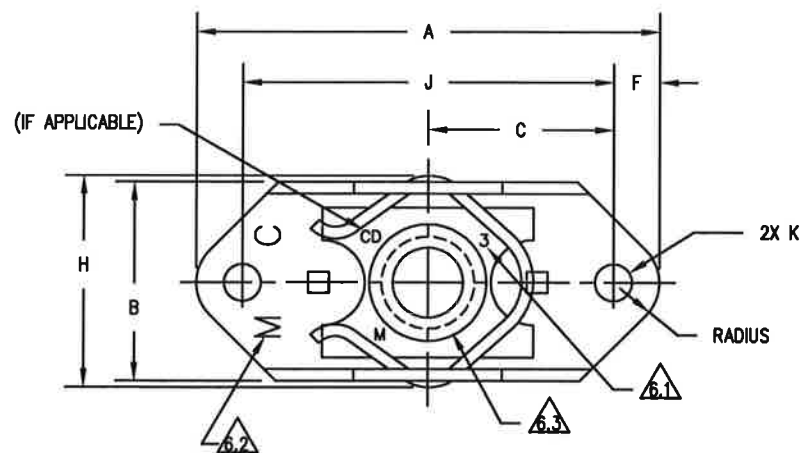


TABLE I

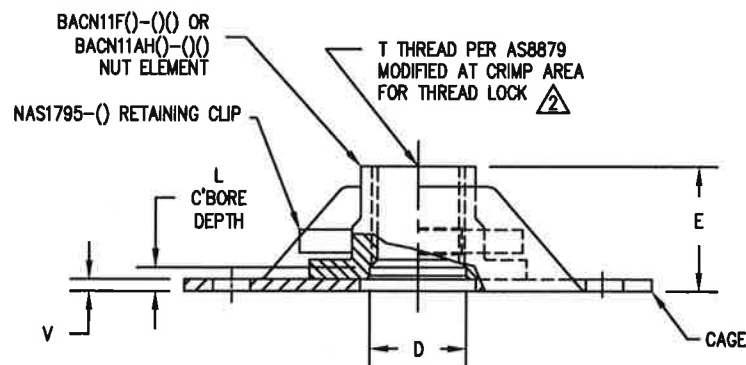
DASH NO	T THREAD SIZE	A MAX	B MAX	C ±.005	#D REF	F MIN	H MAX	J ±.002	#K ±.005 - .000	V ±.005
3D()	.1900-32UNJF-38	.900	.445	.300	.194	.100	.484	.600	.098	.032
4D()	.2500-28UNJC-38	.959	.547	.344	.254	.125	.584	.688	.098	.032
5D()	.3125-24UNJC-38	1.150	.643	.438	.317	.125	.720	.875	.130	.040

TABLE II

DASH NO	E REF	L REF
3D1()	.250	.070
3D2()	.312	.125
3D3()	.375	.188
3D4()	.438	.250
3D5()	.500	.313
3D6()	.562	.375

DASH NO	E REF	L REF
4D1()	.295	.070
4D2()	.357	.125
4D3()	.419	.188
4D4()	.481	.250
4D5()	.543	.313
4D6()	.605	.375

DASH NO	E REF	L REF
5D1()	.344	.070
5D2()	.400	.125
5D3()	.461	.188
5D4()	.524	.250
5D5()	.586	.313
5D6()	.649	.375



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C	10930	JC	10/7/15
B	10047	TD	1/3/13
REV.	ECN NO.	INIT.	DATE

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NEXT ASSEMBLY END ITEM	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS: DECIMALS ±.005 (C) FRACTION - ANGLES ±2'	IBM NUMBER: N/A	lisi AEROSPACE THE MONADNOCK COMPANY 19728 E. GALE AVE. CITY OF INDUSTRY, CALIFORNIA
	MATERIAL: NOTED	PROJECT NUMBER: 0712-002	
THIRD ANGLE PROJECTION	HEAT TREAT: NOTED	DRAWN BY: TSC DATE: 3/21/07	CAGE CODE: 60119 SIZE: A DRAWING NUMBER: 186502-()D()()
	FINAL PROTECTIVE FINISH: NOTED	APPROVED BY: TSC DATE: 3/28/07	SCALE: NONE SALES SHEET 1 OF 2

186502-()D()()

NOTES (UNLESS OTHERWISE SPECIFIED) :

1. MATERIAL:

1.1 CAGE: A286 CRES PER AMS5525.

1.2 NUT (EXTENDED REUSABILITY, 50 CYCLE): BACN11F, A286 CRES PER AMS 5525, AMS 5731, AMS 5732, OR AMS 5737. (REF.)

1.3 NUT (STANDARD REUSABILITY, 15 CYCLE): BACN11AH, A286 CRES PER AMS 5525, AMS 5731, AMS 5732, OR AMS 5737. (REF.)

1.4 CLIP: NAS1795, XM-28 STAINLESS PER ASTM A313/A313M. (REF.)

2. THREADS PER AS8879. NO LETTER 'E' SUFFIX DESIGNATES EXTENDED REUSABILITY NUT. LETTER 'E' SUFFIX DESIGNATES STANDARD REUSABILITY NUT.

3. FINISH SUFFIX DESIGNATIONS:

3.1 NO SUFFIX: NUT ELEMENT IS CADMIUM PLATED PER AMS-QQ-P-416, TYPE II, CLASS 2, AND SOLID FILM LUBRICANT AS NOTED. CAGE IS PASSIVATED PER AMS 2700. CLIP IS PASSIVATED PER AMS 2700. (CLASS 125TC4)

3.2 SUFFIX 'CD': NUT ELEMENT IS CADMIUM PLATED PER AMS-QQ-P-416, TYPE II, CLASS 2, AND SOLID FILM LUBRICANT AS NOTED. CAGE IS CADMIUM PLATED PER AMS-QQ-P-416, TYPE II, CLASS 2. CLIP IS PASSIVATED PER AMS 2700. (CLASS 125TC4)

3.3 SUFFIX 'CM': NUT ELEMENT IS PASSIVATED PER AMS 2700 (COPPER FLASH OR PLATE PER AMS 2418 OPTIONAL), AND SOLID FILM LUBRICANT AS NOTED. CAGE IS PASSIVATED PER AMS 2700. CLIP IS PASSIVATED PER AMS 2700. (CLASS 125TC4)

3.4 SUFFIX 'F': NUT ELEMENT IS SILVER PLATED PER AMS 2410. CAGE IS PASSIVATED PER AMS 2700. CLIP IS PASSIVATED PER AMS 2700. (CLASS 125TC9)

3.5 SUFFIX 'CMN': NUT ELEMENT IS PASSIVATED PER AMS 2700 (COPPER FLASH OR PLATE PER AMS 2418 OPTIONAL) AND SOLID FILM LUBRICANT AS NOTED. CAGE IS ZINC-NICKEL PLATED PER BAC5637, TYPE II, CLASS 2 OR ZINC-NICKEL PLATED PER AMS 2417 TYPE 2 EXCEPT HYDROGEN EMBRITTLEMENT TESTING IS NOT REQUIRED. CLIP IS PASSIVATED PER AMS 2700. (CLASS 125TC4)

3.6 SUFFIX 'CMK': NUT ELEMENT IS PASSIVATED PER AMS 2700 (COPPER FLASH OR PLATE PER AMS 2418 OPTIONAL) AND SOLID FILM LUBRICANT AS NOTED. CAGE IS PASSIVATED PER AMS 2700 AND ALUMINUM PIGMENT COATED PER BMS 10-85, TYPE I, CLASS A. CLIP IS PASSIVATED PER AMS 2700. (CLASS 125TC3)

4. LUBRICATION: NUT – BACN11F AND BACN11AH, SOLID FILM PER AS5272, TYPE I OR II, OR MIL-PRF-46010, TYPE III TO THREADS ONLY, OVERSPRAY ALLOWED. AS5272 SHALL BE IN ACCORDANCE WITH THE QPL IN AS5272SUP. (SILVER PLATED NUTS ARE UNLUBRICATED. PLATING ACTS AS LUBRICANT).

5. NUT FLOAT .020 MINIMUM RADIALLY FROM CENTERED POSITION.

6. MARKING INFORMATION:



NUTS SHALL BE MARKED ON TOP OF FLANGE PER BACN11F OR BACN11AH (REF: MANUFACTURER'S SYMBOL 'M', LETTERS 'CD' FOR CADMIUM PLATED NUT ELEMENTS, C'BORE DASH NO., AND LETTER 'E' FOR STANDARD REUSABILITY NUT). MARKING RAISED OR DEPRESSED .010", LOCATION OPTIONAL BUT MUST BE VISIBLE.



CAGE SHALL BE MARKED WITH MANUFACTURER'S SYMBOL 'M'; LETTER 'C' TO INDICATE PASSIVATED A286 CRES, OR 'CD' TO INDICATE CADMIUM PLATED A286 CRES. MARKING RAISED OR DEPRESSED .010", LOCATION OPTIONAL BUT MUST BE VISIBLE.



BACN11F NUTS (EXTENDED REUSABILITY, 50 CYCLES): MARK WITH PERMANENT WHITE MARK, CLEARLY VISIBLE, AND NOT ON BEARING SURFACE OR ON THREADS. BACN11AH NUTS (STANDARD REUSABILITY, 15 CYCLES): MARK WITH LETTER 'E'. MARKING TO BE RAISED OR DEPRESSED .010". MUST BE CLEARLY VISIBLE.

7. PROCUREMENT SPECIFICATION: BPS-N-70, CLASS 125TC3, TC4, AND TC9 (BACN11G), EXCEPT AS NOTED.

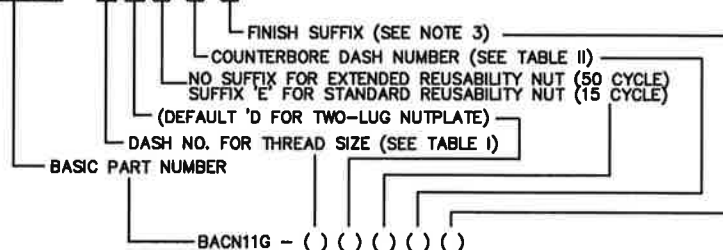


8. MAGNETIC PERMEABILITY: NUT, CLIP, AND CAGE MUST HAVE MAGNETIC PERMEABILITY LESS THAN 2.0 (AIR=1.0) FOR A FIELD STRENGTH H=200 OERSTEDS USING A MAGNETIC PERMEABILITY INDICATOR PER ASTM A342/A342M, METHOD 3.

9. DIMENSIONS APPLY AFTER FINISH.

EXAMPLE PART NUMBER:

1 8 6 5 0 2 - () D () () ()



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B	10047	TD	1/3/13	
REV.	ECN NO.	INIT.	DATE	

<p>END ITEM</p> <p>THIRD ANGLE PROJECTION</p>	<p>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS:</p> <p>DECIMALS ±.005</p> <p>FRACTION C</p> <p>ANGLES ±2'</p>	<p>IBM NUMBER:</p> <p>N/A</p>	<p>liisi AEROSPACE THE MONADNOCK COMPANY</p> <p>16726 E. GALE AVE.</p> <p>CITY OF INDUSTRY, CALIFORNIA</p>		
	<p>MATERIAL:</p> <p>NOTED</p>	<p>PROJECT NUMBER:</p> <p>0712-002</p>	<p>TITLE:</p> <p>NUT PLATE, 2 LUG, FLOATING, SELF-LOCKING, (BACN11G()D()() EQUIV.)</p>		
	<p>HEAT TREAT:</p> <p>NOTED</p>	<p>DRAWN BY:</p> <p>TSC</p> <p>DATE:</p> <p>3/21/07</p>	<p>APPROVED BY:</p> <p>TSC</p> <p>DATE:</p> <p>3/28/07</p>	<p>CAGE CODE</p> <p>60119</p>	<p>SIZE</p> <p>A</p>

DRAWING NUMBER: 186502-()D()()

SCALE NONE SALES SHEET 2 OF 2