

NOTES (UNLESS OTHERWISE SPECIFIED):

1. GENERAL REQUIREMENTS

1.1 MATERIAL:

1.1.1 NUT SHALL BE A286 CRES PER AMS5731, AMS5732, OR AMS5737.

1.1.2 SPRING, CHANNEL, AND RECEPTACLE SHALL BE 17-7PH CRES PER AMS5528 OR AMS5529.

1.2 FINISH:

(L) 1.2.2 NUT SHALL BE PASSIVATED PER AMS2700, TYPE 2 OR 8, OR CADMIUM PLATED PER AMS-QQ-P-418, TYPE AND CLASS OPTIONAL IF NUTS MEET SALT SPRAY REQUIREMENTS OF AMS-QQ-P-416, TYPE II. EMBRITTLEMENT TEST PER AMS-QQ-P-416 DOES NOT APPLY.

1.2.2 SPRING SHALL BE PASSIVATED PER AMS2700, TYPE 2 OR 8.

1.2.3 CHANNEL SHALL BE PASSIVATED PER AMS2700, TYPE 2 OR 8, OR CADMIUM PLATED PER AMS-QQ-P-416, TYPE II, CLASS 2.

1.2.4 RECEPTACLE SHALL BE PASSIVATED PER AMS2700, TYPE 2 OR 8; CADMIUM PLATED PER AMS-QQ-P-416, TYPE II, CLASS 2; CADMIUM PLATED PER AMS-QQ-P-416, TYPE II, CLASS 2 WITH BMS10-11 PRIMER, TYPE I, CLASS A, GRADE A OR E; PASSIVATED PER AMS2700, TYPE 2 OR 8 AND ALUMINUM PIGMENT COATED PER BMS10-85, TYPE I, CLASS A; ZINC NICKEL PLATED PER BAC5637, TYPE II, CLASS 2; OR ZINC-NICKEL PLATED PER AMS2417, TYPE 2, EXCEPT HYDROGEN EMBRITTLEMENT TESTING IS NOT REQUIRED.

1.2.5 MOLYBDENUM DISULFIDE SOLID FILM LUBRICANT PER ASS272, TYPE I OR II WITH FLUID RESISTANCE REQUIREMENTS OF BMS 3-8 ON ALL PARTS, EXCEPT RECEPTACLE, WHEN PRIMED PER BMS 10-11, OR ALUMINUM PIGMENT COATED PER BMS 10-85. ASS272 SHALL BE IN ACCORDANCE WITH THE QPL IN AS5272SUP.

L 1.2.6 FOR FINISH CODE 'CG', APPLY ONE COAT OF BMS 10-11 PRIMER PER BAC5736. ALL SURFACES OF RECEPTACLE SHALL BE PRIMED, EXCEPT TOOLING MARKS ARE ACCEPTABLE WHERE PRIMER IS MECHANICALLY REMOVED ON RECEPTACLE UPON ASSEMBLY FORMING OF NUTPLATE. INCOMPLETE COVERAGE INSIDE THE BEND RADIUS IS ACCEPTABLE. FLAKING OF PRIMER ON AND INWARD OF THE INDICATED RADI ONLY SHALL NOT BE CAUSE FOR REJECTION.

1.3 NUT SHALL BE CAPABLE OF RADIAL FLOAT FROM CAGE CENTERLINE PER TABLE 1.

2. ACCEPTANCE REQUIREMENTS:

① 2.1 PROCUREMENT SPECIFICATION REQUIREMENTS SHALL BE PER BPS-N-70, CLASS 125TC4, OR CLASS 125TC3 EXCEPT AS NOTED. TORQUE-OUT REQUIREMENTS SHALL BE 45 IN-LBS MINIMUM. TENSILE STRENGTH OF NUT ASSEMBLY IS 700 LBS MINIMUM. TENSILE VALUES OF NUT ELEMENT WHEN TESTED OUT OF THE ASSEMBLY SHALL BE PER TABLE 1.

2.2 SPRING LOAD TEST:

2.2.1 SAMPLE PER ATTRIBUTE SAMPLING PLAN A OF BPS-N-70.

2.2.2 SPRING LOAD SHALL BE 25 ± 3 LBS WHEN THE NUT SHANK PROTRUDES FROM THE BEARING SURFACE OF THE RECEPTACLE A DISTANCE EQUAL TO THE NOMINAL STRUCTURE THICKNESS. ADDITIONAL PROTRUSION OF $.013 \pm .007$ WILL CAUSE THE NUT ELEMENT FLANGE TO BOTTOM OUT.

3. IDENTIFY "NO CODE", "C" AND "CM" CODE NUTS WITH PERMANENT PAINT OR "DYKEM" ON TOP OF CHANNEL IN THE FORM OF DOT OR SPRAY DOT AFTER LUBRICATING. "NO CODE" NUTS SHALL BE PAINTED YELLOW, "C" CODE NUTS SHALL BE PAINTED WHITE, AND "CM" CODE NUTS SHALL BE PAINTED BLUE. OVERSPRAY IS ACCEPTABLE ON THE TOP THREADS AND RECEPTACLE.

4. DIMENSIONS APPLY AFTER FINISH UNLESS OTHERWISE SPECIFIED.

5. DIMENSIONS APPLY PRIOR TO APPLICATION OF BMS 10-11 PRIMER.

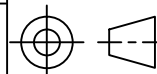
6. MINIMUM RADIAL FLOAT APPLIES WITH NUT INSTALLED ONTO STRUCTURE WITH BOTH BLIND AND SOLID RIVETS.

7. EDGE BREAK REQUIRED, .005 MIN. BEARING SURFACE SHALL BE FLAT TO FULL RADIUS. SHARP EDGES ON CORNERS OR CENTER ARE PROHIBITED.

8. THE GRAPHIC DEPICTIONS ARE ENVELOPES. PART MAY VARY IN FORM AND SHAPE. BUT MUST MEET DIMENSIONAL REQUIREMENTS.

FAA-TSO AUTHORIZED PART

L	12140	JC	1/20/20	REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN PERMISSION OF LISI AEROSPACE THE MONADNOCK COMPANY IS PROHIBITED
K	10689	TD	8/28/14	
REV.	ECN NO.	INIT.	DATE	




UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS: DECIMALS FRACTION ANGLES ±.005 — ±1°		IBM NUMBER: —		 AEROSPACE THE MONADNOCK COMPANY 18301 E. ARENTH AVE CITY OF INDUSTRY, CALIFORNIA			
MATERIAL: NOTED		PROJECT NUMBER: 9918-002		TITLE: NUTPLATE, SELF-LOCKING, FLOATING, SPRING LOADED, A286 NUT ELEMENT			
HEAT TREAT: NOTED		DRAWN BY: DATE JGR 05/05/99					
FINAL PROTECTIVE FINISH: NOTED		APPROVED BY: DATE CKT 05/26/99		CAGE CODE 60119		SIZE: A DRAWING NUMBER: 187010-()()()	
				SCALE: NONE		SALES	
						SHEET 1 OF 2	

TABLE I 5 L

SIZE DASH NO.	T NOMINAL THREAD SIZE	ØC	ØD	ØE	RADIAL FLOAT MINIMUM 6	MINIMUM TENSILE STRENGTH (LBS)
3A	.1900-32	.195 .200	.265 .270	.340 .345	.10	2,460
3B	.1900-32	.195 .200		.250 .255	.15	2,460
4B	.2500-28	.265 .270		.340 .345	.10	4,580

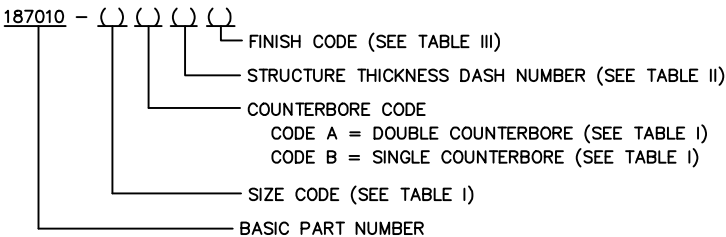
TABLE II 5

SECOND DASH NUMBER	STRUCTURE THICKNESS +.004 -.005	A ±.005	B REF. (-3A ONLY)	H MAX	SECOND DASH NUMBER	STRUCTURE THICKNESS +.004 -.005	A ±.005	B REF. (-3A ONLY)	H MAX
1	.035	.173	.048	.313	14	.165	.303	.178	.443
2	.045	.183	.058	.323	15	.175	.313	.188	.453
3	.055	.193	.068	.333	16	.185	.323	.198	.463
4	.065	.203	.078	.343	17	.195	.333	.208	.473
5	.075	.213	.088	.353	18	.205	.343	.218	.483
6	.085	.223	.098	.363	19	.215	.353	.228	.493
7	.095	.233	.108	.373	20	.225	.363	.238	.503
8	.105	.243	.118	.383	21	.235	.373	.248	.513
9	.115	.253	.128	.393	22	.245	.383	.258	.523
10	.125	.263	.138	.403	23	.255	.393	.268	.533
11	.135	.273	.148	.413	24	.265	.403	.278	.543
12	.145	.283	.158	.423	25	.275	.413	.288	.553
13	.155	.293	.168	.433					

TABLE III

FINISH CODE	FINISH REQUIREMENTS
NONE	CADMIUM PLATED NUT ELEMENT, PASSIVATED SPRING, CHANNEL, AND RECEPTACLE. SOLID FILM LUBE ALL PARTS (CLASS 125TC4).
C	CADMIUM PLATED NUT ELEMENT, CHANNEL, AND RECEPTACLE, PASSIVATED SPRING, SOLID FILM LUBE ALL PARTS (CLASS 125TC4).
CG	CADMIUM PLATED NUT ELEMENT, CHANNEL, AND RECEPTACLE, PASSIVATED SPRING AND BMS10-11 PRIMERED RECEPTACLE. SOLID FILM LUBE ALL PARTS (EXCEPT RECEPTACLE) (CLASS 125TC3).
CM	PASSIVATED NUT ELEMENT, CHANNEL, SPRING, AND RECEPTACLE. SOLID FILM LUBE ALL PARTS (CLASS 125TC4).
K	PASSIVATED NUT ELEMENT, CHANNEL, AND SPRING. SOLID FILM LUBE ALL PARTS (EXCEPT RECEPTACLE) (CLASS 125TC3). RECEPTACLE PASSIVATED, AND ALUMINUM PIGMENT COATED.
ZN	PASSIVATED NUT ELEMENT, CHANNEL, AND SPRING. ZINC NICKEL PLATED RECEPTACLE. SOLID FILM LUBE ALL PARTS (CLASS 125TC4).

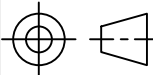
L EXAMPLE OF PART NUMBER CODING:



FAA-TSO AUTHORIZED PART

L	12140	JC	1/20/20
K	10689	TD	8/28/14
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



NEXT ASSEMBLY	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS: DECIMALS FRACTION ANGLES ±.005 - ±1°	IBM NUMBER: -	lisi AEROSPACE THE MONADNOCK COMPANY 18301 E. ARENTH AVE. CITY OF INDUSTRY, CALIFORNIA		
END ITEM	MATERIAL: NOTED	PROJECT NUMBER: 9918-002			
THIRD ANGLE PROJECTION	HEAT TREAT: NOTED	DRAWN BY: DATE JGR 05/05/99			
	FINAL PROTECTIVE FINISH: NOTED	APPROVED BY: DATE CKT 05/26/99			
TITLE: NUTPLATE, SELF-LOCKING, FLOATING, SPRING LOADED, A286 NUT ELEMENT			CAGE CODE 60119	SIZE A	DRAWING NUMBER: 187010-() () () ()
SCALE: NONE			SALES		SHEET 2 OF 2