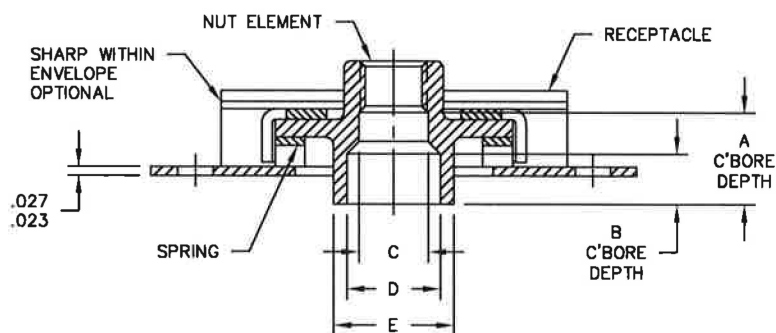
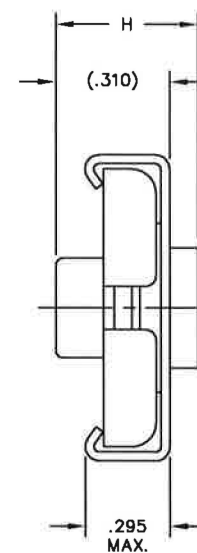
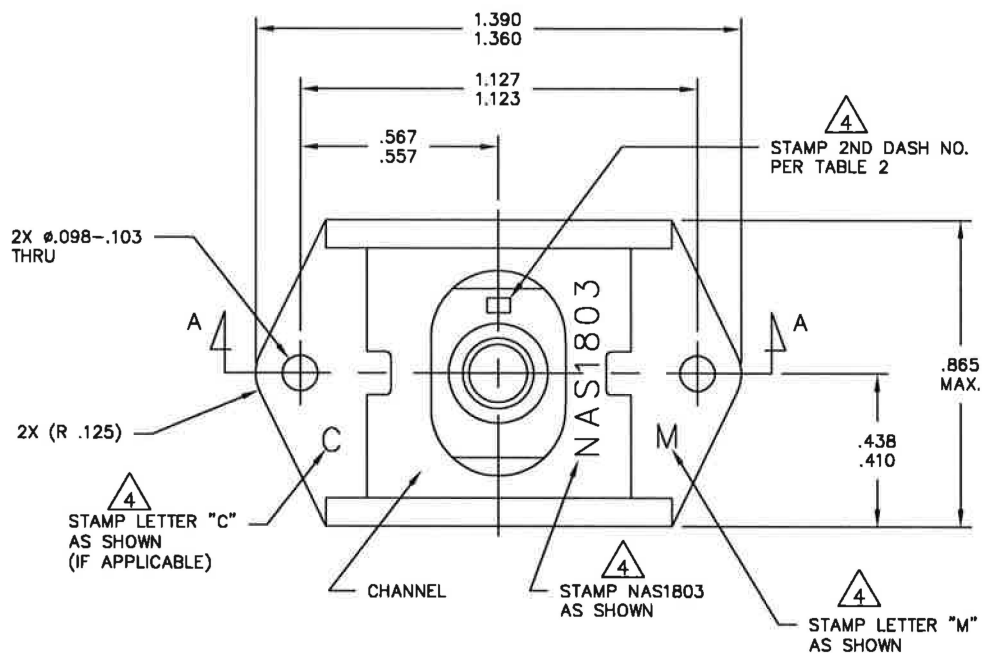
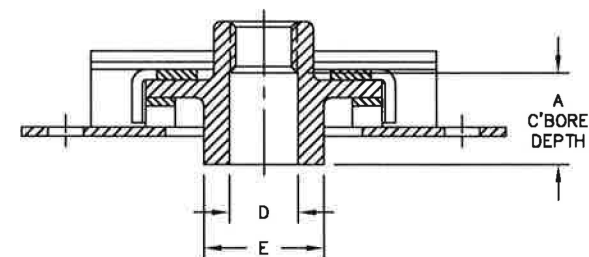


187015-()()()

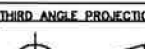


SECTION A-A
FOR CODE "A" : 187015-()A()()



SECTION A-A
FOR CODE "B" : 187015-()B()()

FAA-TSO AUTHORIZED PART

NEXT ASSEMBLY END ITEM	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS: DECIMALS FRACTION ANGLES ±.010 — ±5°			IBM NUMBER: —		lisi AEROSPACE THE MONADNOCK COMPANY 18728 E. GALE AVE. CITY OF INDUSTRY, CALIFORNIA		
	MATERIAL: NOTED			PROJECT NUMBER: 0418-004		TITLE: NUT PLATE, SELF-LOCKING, TWO LUG, FLOATING SPRING LOADED, ALLOY STEEL NUT ELEMENT		
THIRD ANGLE PROJECTION	HEAT TREAT: NOTED			DRAWN BY: DATE TSC 01/01/04		CAGE CODE SIZE DRAWING NUMBER: 60119 A 187015-(())(())		
	FINAL PROTECTIVE FINISH: NOTED			APPROVED BY: DATE PYB 04/08/04		SCALE: NONE		
						SALES SHEET 1 OF 3		

D	11488	JC	6/27/17
C	11047	JC	4/14/16
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

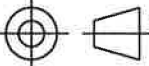
TABLE 1

FIRST DASH NO.	THREAD SIZE PER AS8879	Ø C	Ø D	Ø E	RADIAL FLOAT MIN.	AXIAL TENSILE STRENGTH		PUSH OUT	TORQUE OUT
						NUT ELEMENT	NUT PLATE ASSEMBLY		
-3A()()	.1900-32UNJF-3B	.200 .195	.270 .265	.345 .340	.100	2,460 LBS MIN.	700 LBS MIN.	100 LBS MIN.	N/A SEE NOTE 3
-3B()()	.1900-32UNJF-3B	/	.200 .195	.255 .250	.150	2,460 LBS MIN.	700 LBS MIN.	100 LBS MIN.	
-4B()()	.2500-28UNJF-3B	/	.270 .265	.345 .340	.100	4,580 LBS MIN.	700 LBS MIN.	125 LBS MIN.	

TABLE 2

SECOND DASH NO.	STRUCTURE THICKNESS +.004/- .005	-3A()() SIZE			-3B()() SIZE			-4B()() SIZE		
		A ±.005	(B)	H MAX.	A ±.005	(B)	H MAX.	A ±.005	(B)	H MAX.
1	.035	.173	.048	.313	.173	/	.313	.173	/	.313
2	.045	.183	.058	.323	.183	/	.323	.183	/	.323
3	.055	.193	.068	.333	.193	/	.333	.193	/	.333
4	.065	.203	.078	.343	.203	/	.343	.203	/	.343
5	.075	.213	.088	.353	.213	/	.353	.213	/	.353
6	.085	.223	.098	.363	.223	/	.363	.223	/	.363
7	.095	.233	.108	.373	.233	/	.373	.233	/	.373
8	.105	.243	.118	.383	.243	/	.383	.243	/	.383
9	.115	.253	.128	.393	.253	/	.393	.253	/	.393
10	.125	.263	.138	.403	.263	/	.403	.263	/	.403
11	.135	.273	.148	.413	.273	/	.413	.273	/	.413
12	.145	.283	.158	.423	/	/	/	.283	/	.423
13	.155	.293	.168	.433	/	/	/	.293	/	.433

FAA-TSO AUTHORIZED PART

NEXT ASSEMBLY		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS: DECIMALS FRACTION ANGLES ±.010 - ±5'		IBM NUMBER: -		 AEROSPACE THE MONADNOCK COMPANY 18728 E. GALE AVE. CITY OF INDUSTRY, CALIFORNIA	
END ITEM		MATERIAL: NOTED		PROJECT NUMBER: 0418-004		TITLE: NUT PLATE, SELF-LOCKING, TWO LUG, FLOATING SPRING LOADED, ALLOY STEEL NUT ELEMENT	
THIRD ANGLE PROJECTION		HEAT TREAT: NOTED		DRAWN BY: DATE TSC 01/01/04		CAGE CODE SIZE DRAWING NUMBER: 60119 A 187015-()()())	
		FINAL PROTECTIVE FINISH: NOTED		APPROVED BY: DATE PYB 04/08/04		SCALE: NONE SALES SHEET 2 OF 3	

D	11488	JC	6/27/17	REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN PERMISSION OF LISI AEROSPACE THE MONADNOCK COMPANY IS PROHIBITED
C	11047	JC	4/14/16	
REV.	ECN NO.	INIT.	DATE	

NOTES (UNLESS OTHERWISE SPECIFIED):

1. MATERIAL:

1.1 NUT ELEMENT: AISI 4130 OR AISI 8740 ALLOY STEEL, HEAT TREATED.

1.2 SPRING, CHANNEL AND RECEPTACLE: 17-7PH CRES.

2. FINISH OPTION:

FOR ASSEMBLY PART NO. 187015-()()():

NUT ELEMENT: CADMIUM PLATE PER AMS-QQ-P-416, CLASS 2. TYPE OF PLATING OPTIONAL.

IF NUT ELEMENT MEET SALT SPRAY REQUIREMENTS OF AMS-QQ-P-416, TYPE II.

EMBRITTLEMENT TEST PER AMS-QQ-P-416 DOES NOT APPLY.

SPRING, CHANNEL AND RECEPTACLE: PASSIVATE PER AMS2700.

FOR ASSEMBLY PART NO. 187015-()()()C:

NUT ELEMENT, CHANNEL AND RECEPTACLE: CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 2.

EMBRITTLEMENT TEST PER AMS-QQ-P-416 DOES NOT APPLY.

SPRING: PASSIVATE PER AMS2700.

D

2.1 LUBRICATION:

DRY FILM LUBRICANT ON ALL PARTS, EXCEPT OPTIONAL ON CHANNEL, MEETING THE REQUIREMENTS OF NASM25027, AND HYDRAULIC FLUID RESISTANCE WHEN TEST PER ASTM D2510, USING SAE AS1241 PHOSPHATE ESTER HYDRAULIC FLUIDS.

3. NUTPLATE ASSEMBLY SHALL MEET THE REQUIREMENTS OF NAS1803 AND NASM25027 EXCEPT AS NOTED:

A, TORQUE OUT REQUIREMENTS OF NASM25027 ARE NOT APPLICABLE.

B, TENSILE STRENGTH OF NUTPLATE ASSEMBLY AND NUT ELEMENT PER TABLE 1.

3.1 SPRING LOAD SHALL BE 22-28 LBS. WHEN THE NUT ELEMENT SHANK PROTRUDES FROM THE BEARING SURFACE OF THE RECEPTACLE AT A DISTANCE EQUAL TO THE NOMINAL STRUCTURE THICKNESS. ADDITIONAL PROTRUSION OF .006-.020 INCH WILL CAUSE THE NUT ELEMENT FLANGE TO BOTTOM OUT.

3.2 SAMPLING PER NASM25027, TABLE IX ATTRIBUTE PLAN.

4

ALL MARKING INDENTED .010 MAXIMUM DEPTH, ORIENTATION OPTIONAL.

5. NUT SHALL BE CAPABLE OF RADIAL FLOAT PER TABLE 1 FROM RECEPTACLE CENTER LINE.

6. DIMENSIONS APPLY AFTER FINISH AND BEFORE LUBRICATION.

7. EXAMPLE OF PART NUMBER CALLOUT:

187015-3 A 2 C

FINISH CODE (SEE NOTE 2)

SECOND DASH NO. (SEE TABLE 2)

C'BORE CODE (SEE TABLE 1)

A = DOUBLE C'BORE

B = SINGLE C'BORE

THREAD SIZE (SEE TABLE 1)

-3 = .1900-32UNJF

BASIC PART NO.

FAA-TSO AUTHORIZED PART

D	11488	JC	6/27/17	REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN PERMISSION OF LISI AEROSPACE THE MONADNOCK COMPANY IS PROHIBITED
C	11047	JC	4/14/16	
REV.	ECN NO.	INIT.	DATE	

NEXT ASSEMBLY		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS:		IBM NUMBER:		lisi AEROSPACE THE MONADNOCK COMPANY 18728 E. DALE AVE. CITY OF INDUSTRY, CALIFORNIA	
END ITEM		DECIMALS FRACTION ANGLES ±.010 - ±5°		PROJECT NUMBER: 0418-004		TITLE: NUT PLATE, SELF-LOCKING, TWO LUG, FLOATING SPRING LOADED, ALLOY STEEL NUT ELEMENT	
THIRD ANGLE PROJECTION		MATERIAL: NOTED		DRAWN BY: DATE TSC 01/01/04		CAGE CODE SIZE DRAWING NUMBER: 60119 A 187015-()()()()	
		HEAT TREAT: NOTED		APPROVED BY: DATE PYB 04/08/04		SCALE: NONE SALES SHEET 3 OF 3	
		FINAL PROTECTIVE FINISH: NOTED					