

TABLE 1

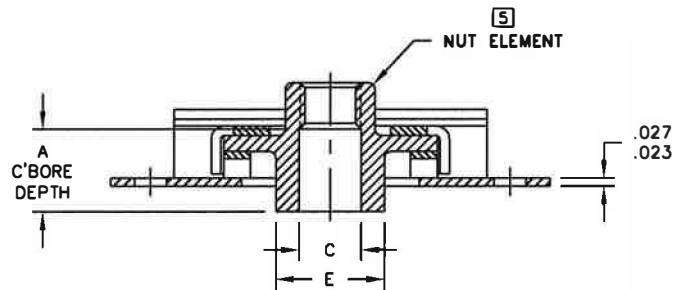
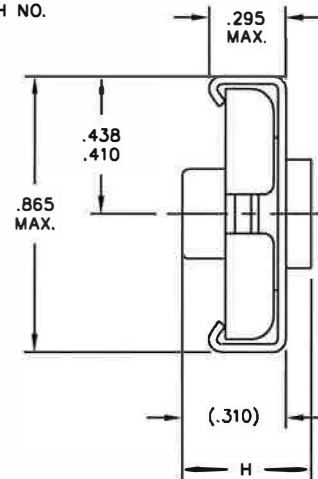
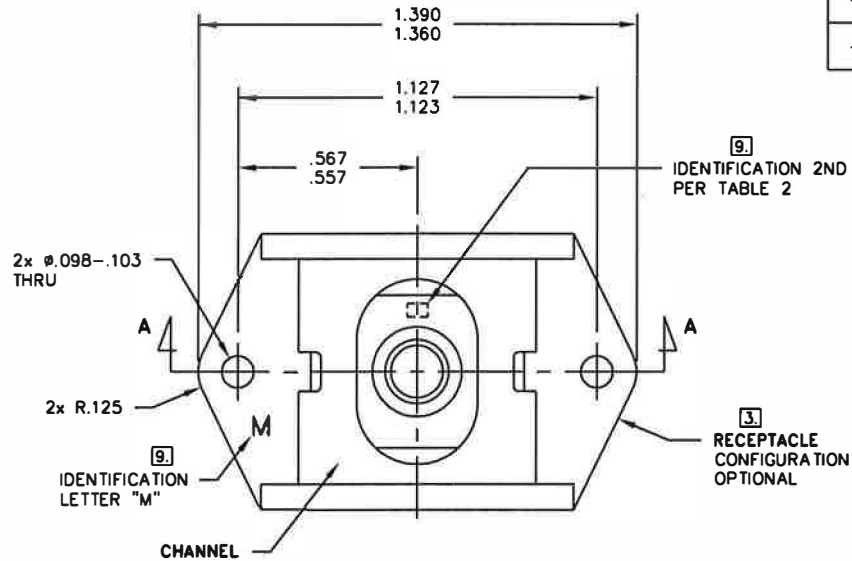
FIRST DASH NO.	THREAD SIZE PER AS8879	ØC	ØE	RADIAL FLOAT MIN. [4]	AXIAL TENSILE STRENGTH		PUSH OUT PER NASM25027
					NUT ELEMENT	NUT PLATE ASSEMBLY	
-3B()	.1900-32UNJF-3B	.200 .195	.255 .250	.150	2,460 LBS MIN.	700 LBS MIN.	100 LBS MIN.
-4B()	.2500-28UNJF-3B	.270 .265	.345 .340	.100	4,580 LBS MIN.	700 LBS MIN.	125 LBS MIN.

TABLE 2

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

TABLE 3

FINISH CODE	FINISH REQUIREMENTS
CM	PASSIVATED NUT ELEMENT, CHANNEL, RECEPTACLE AND SPRING DRY FILM LUBE ALL COMPONENTS.
CMK	PASSIVATED NUT ELEMENT, CHANNEL AND SPRING. ALUMINUM COATED OR HI-KOTE 1 RECEPTACLE. DRY FILM LUBE ALL COMPONENTS EXCEPT RECEPTACLE.



SECTION A-A
FOR CODE "B" (187024-)(B)()

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D	10308	TD	1/29/14
C	9950	JC	7/9/12
REV.	ECN NO.	INIT.	DATE

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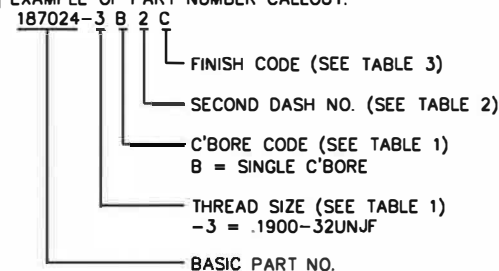
NEXT ASSEMBLY -	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS: DECIMALS ±.010 FRACTION - ANGLE ±5'	IBM NUMBER: -	lisi AEROSPACE THE MONADNOCK COMPANY 18301 E. ARENTH AVE CITY OF INDUSTRY, CALIFORNIA
	MATERIAL: NOTED	PROJECT NUMBER: -	
THIRD ANGLE PROJECTION	HEAT TREAT: NOTED	DRAWN BY: DATE T. TRAN 10/25/10	TITLE: HI-FLOAT NUT PLATE ASSY. SELF-LOCKING, SPRING LOADED, A286 CRES NUT ELEMENT
	FINAL PROTECTIVE FINISH: NOTED	APPROVED BY: DATE RT 12/08/10	CAGE CODE SIZE DRAWING NUMBER: 60119 A 187024
		SCALE: NONE	SALES SHEET 1 OF 2

NOTES, UNLESS OTHERWISE SPECIFIED:

1. MATERIAL:
 - 1.1 NUT ELEMENT: A286 CRES PER AMS5731, AMS5732, OR AMS5737.
 - 1.2 SPRING, CHANNEL AND RECEPTACLE: 17-7PH CRES PER AMS5528 OR AMS5529.
2. FINISH:
 - 2.1 NUT ELEMENT: PASSIVATE PER AMS2700, TYPE 2 OR 8. AND DRY FILM LUBE PER ASS272, TYPE I.
 - 2.2 SPRING: PASSIVATE PER AMS2700, TYPE 2 OR 8. AND DRY FILM LUBE PER ASS272, TYPE I.
 - 2.3 CHANNEL: PASSIVATE PER AMS2700, TYPE 2 OR 8. AND DRY FILM LUBE PER ASS272, TYPE I.
 - 2.4 RECEPTACLE: PASSIVATE PER AMS2700, TYPE 2 OR 8. AND DRY FILM LUBE PER ASS272, TYPE I. FOR CODE "CM" ALUMINUM COATING PER NAS4006 OR HI-KOTE 1 PER HS294. FOR CODE "CMK"
- 2.5 LUBRICATION: DRY FILM LUBRICANT MEETING THE REQUIREMENTS OF NASM25027, AND HYDRAULIC FLUID RESISTANCE WHEN TEST PER METHOD 7001 OF FEDERAL TEST METHOD STANDARD NO. 791, USING SAE AS1241 PHOSPHATE ESTER HYDRAULIC FLUIDS.
3. ALL SURFACES OF RECEPTACLE TO BE LUBRICATED (WHEN SPECIFIED), EXCEPT TOOLING MARKS ARE ACCEPTABLE WHERE LUBRICATION IS MECHANICALLY REMOVED UPON ASSEMBLY FORMING OF NUTPLATE.
4. NUT ELEMENT SHALL BE CAPABLE OF RADIAL FLOAT PER TABLE 1 FROM RECEPTACLE CENTERLINE. MINIMUM RADIAL FLOAT APPLIES WITH NUT PLATE ASSY. INSTALLED ONTO STRUCTURE WITH BOTH BLIND AND SOLID RIVETS.
5. UPPER THREADED PORTION DEFORMED TO PROVIDE SELF-LOCKING FEATURE.
6. ACCEPTANCE REQUIREMENTS:
 - 6.1 NUTPLATE ASSEMBLY SHALL MEET THE REQUIREMENTS OF 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.
 - C, 15 CYCLES OF SELF-LOCKING TORQUE VALUES PER NASM25027.
 - 6.2 SPRING LOAD SHALL BE 25 +/-2 LBS. AT .032 INCH DEFLECTION.
 - 6.3 OPTIONAL TEST METHOD: SPRING LOAD SHALL BE 25 +/-3 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 .013 +/--.007 INCH WILL CAUSE THE NUT ELEMENT FLANGE TO BOTTOM OUT.
7. SAMPLING PER NASM25027, TABLE IX ATTRIBUTE PLAN.
8. DIMENSIONS APPLY AFTER FINISH AND BEFORE LUBRICATION UNLESS OTHERWISE SPECIFIED.

9. MARKING:
 - 9.1 ALL MARKING INDENTED .010 MAXIMUM. ORIENTATION OPTIONAL. EXCEPT MUST BE VISIBLE AFTER ASSY.

10. EXAMPLE OF PART NUMBER CALLOUT:



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C	9950	JC	7/9/12	
REV.	ECN NO.	INIT.	DATE	

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				APPROVED BY: DATE RT 12/08/10		SCALE: NONE SALES SHEET 2 OF 2	