

5300050

NOTES:

1. MATERIAL:

1.1 SPACER: POLYAMIDE, PA0110G33A99900KB138UB069PA133 OR PA0110G33A99900KB165UB083PA107 PER ASTM-D-4066, COLOR NATURAL (WHITE) (SEE ASTM-D-4000 FOR EXPLANATION OF CODING)

1.2 INSERT: STEEL

2. FINISH:

2.1 SPACER: NONE

2.2 INSERT: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 3

3. SURFACE TEXTURE – UPPER AND LOWER SURFACES OF FLANGE TO BE 125 MICROINCHES R_a PER ANSI/ASME B46.1.

4. WORKMANSHIP – REMOVE PARTING LINE FROM FLANGE AND REMOVE FLASH FROM AROUND RIVET HOLES.

5. INSERT SHALL BE MOLED IN PLACE AND SHALL CONFORM TO NASM25027 FOR CONSTRUCTION, THREAD PER FED-STD-H28/2, TENSILE STRENGTH FOR SHEAR NUTS, LOCKING TORQUE, PERMANENT SET, MAXIMUM LOCKING TORQUE, MINIMUM BREAKAWAY TORQUE AND REUSABILITY. INSERT SHALL NOT ROTATE WHEN 60 INCH POUNDS OF TORQUE IS APPLIED PER TORQUE-OUT TEST PER NASM25027. TEST BOLT SHALL BE BACS12GU3K().

SELF-LOCKING DEVICE MAY BE EITHER INCORPORATED INTO THE METAL INSERT OR INCORPORATED AS A NON-METALLIC LOCKING DEVICE INTO THE SPACER. BREAKAWAY TORQUE SHALL BE MEASURED WITH TEST SCREW POSITIONED AS FOLLOWS:

ALL SIZES EXCEPT -4 LENGTH:
POSITION END OF TEST SCREW AT MIDPOINT OF THE INSPECTION HOLE.

-4 LENGTH:
POSITION END OF TEST SCREW FLUSH WITH BOTTOM OF SPACER PLATE.

6. ATTACHING SCREW MUST PENETRATE A MINIMUM OF .36. THIS PENETRATION SHALL RESULT IN FULL ENGAGEMENT OF INSERT THREADS.

7. INSPECTION HOLE IS MANDATORY EXCEPT FOR A "-4" OR "D4" LENGTH.

8. PART NUMBER EXAMPLE:

5 3 0 0 5 0 - () () ()

OVERALL LENGTH (SEE TABLE II)

"-" INDICATES RIVET HOLE DIAMETER OF .098-.108.

"D" INDICATES RIVET HOLE DIAMETER OF .129-.132

PART CONFIGURATION (SEE TABLE I)

BASIC PART NUMBER

ISSUE	DESCRIPTION	DATE
REVISION		

NEXT ASSEMBLY END ITEM	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES DECIMALS FRACTION ANGLES		DRAWN BY: R.A.D. DATE: 06-20-02		 THE MONADNOCK COMPANY CITY OF INDUSTRY, CALIFORNIA
	MATERIAL: NOTED		CHECKED BY: R.DUENAS DATE: 06-20-02		
	HEAT TREAT:		APPROVED BY: T. CSIK DATE: 07-01-02		TITLE: NUT, SPACER PLATE, MOLDED POLYAMIDE, VERTICAL
	FINAL PROTECTIVE FINISH: NOTED		APPROVED BY:		
			MFG. ACCEPT:		
		CODE IDENT. NO. 60119	SIZE B	DRAWING NUMBER: 5300050	
		SCALE: NONE	SALES	SHEET 2 OF 2	