

TABLE 1

NUT PLATE ASSEMBLY PART NO.	L ±.005	T GRIP RANGE	
		MIN.	MAX.
122005-0	.130	.030	.060
122005-1	.160	.061	.090
122005-2	.190	.091	.120
122005-3	.220	.121	.150
122005-4	.250	.151	.180
122005-5	.280	.181	.210
122005-6	.310	.211	.240
122005-7	.340	.241	.270
122005-8	.370	.271	.300
122005-9	.400	.301	.330
122005-10	.430	.331	.360
122005-11	.460	.361	.390
122005-12	.490	.391	.420
122005-13	.520	.421	.450
122005-14	.550	.451	.480
122005-15	.580	.481	.510
122005-16	.610	.511	.540
122005-17	.640	.541	.570
122005-18	.670	.571	.600
122005-19	.700	.601	.630
122005-20	.730	.631	.660
122005-21	.760	.661	.690
122005-22	.790	.691	.720
122005-23	.820	.721	.750
122005-24	.850	.751	.780
122005-25	.880	.781	.810
122005-26	.910	.811	.840
122005-27	.940	.841	.870
122005-28	.970	.871	.900
122005-29	1.000	.901	.930
122005-30	1.030	.931	.960

NOTES, UNLESS OTHERWISE SPECIFIED:

1. MATERIAL:

- 1.1 NUT: A286 CRES PER AMS5731 OR AMS5734.
1.2 CAGE: 17-7PH CRES STEEL PER AMS5528 OR AMS5529
1.3 GROMMET: 304 CRES PER AMS-QQ-S-763, OR MIL-S-23195.

2. HEAT TREAT:

- 2.1 NUT: 160 KSI PER AMS-H-6875 OR AMS2759.
2.2 CAGE: CONDITION TH1050 PER AMS-H-6875 OR AMS2759.
2.3 GROMMET: NONE

3. FINISH:

- 3.1 NUT: SILVER PLATE PER AMS2410 AND DRY FILM LUBE PER AS5272.
APPLIED ANTI-SEIZE COMPOUND PER MIL-PRF-709 TO INTERNAL THREADS ONLY.
3.2 CAGE: PASSIVATE PER AMS2700, METHOD 1, TYPE 2 OR TYPE 8, CLASS 1.
3.3 GROMMET: PASSIVATE PER AMS2700.

4. NUT ELEMENT FLOATS .010 MIN. FROM CENTERED POSITION.

5. TOLERANCE, UNLESS OTHERWISE SPECIFIED:

.XX= ±.020, .XXX= ±.010 AND ANGLES= ±2°

6. NUT ELEMENT IS REMOVABLE AND REPLACEABLE. TO REPLACE NUT ELEMENT ORDER PART NO. 122006 AND TOOL PART NO. 129004.

7. ORDERING OPTIONS:

- 7.1 ORDERED NUT PLATE ASSEMBLY PART NO. 122005-() CONSISTS OF NUT ELEMENT, CAGE AND GROMMET.
7.2 COMPONENTS PART MAY BE ORDERED SEPARATELY FROM THE FOLLOWING PART NUMBERS:
NUT ELEMENT: 122006
CAGE: 122007
GROMMET: 123004-()

8. EXAMPLE OF PART NO. CALLOUT:

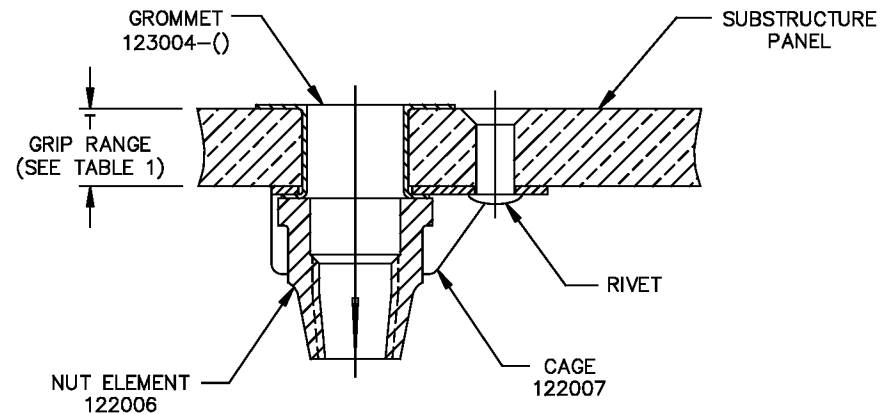
122005-8
L= .370
(GROMMET LENGTH)
BASIC PART NO.

TABLE 2

NUT ELEMENT SELF-LOCKING TORQUE CAPABLE OF 500 CYCLES SEATED AT ROOM TEMPERATURE			
SEATING TORQUE	INSTALLATION TORQUE	BREAKAWAY TORQUE	TEST HARDWARE PART NO.
40 IN-LBS. MAX.	18 IN-LBS. MAX.	2 IN-LBS. MIN.	121500-() OR EQUIVALENTS

TABLE 3

MECHANICAL PROPERTIES		
AXIAL TENSILE STRENGTH	TORQUE-OUT STRENGTH	PUSHOUT STRENGTH
2,900 LBS. MIN.	65 IN-LBS. MIN.	100 LBS. MIN.



B	ECN 9386	06-22-10
A	ECN 8995	12-04-08
ISSUE	ECN NUMBER	DATE
PROJECT No. 0412-007		

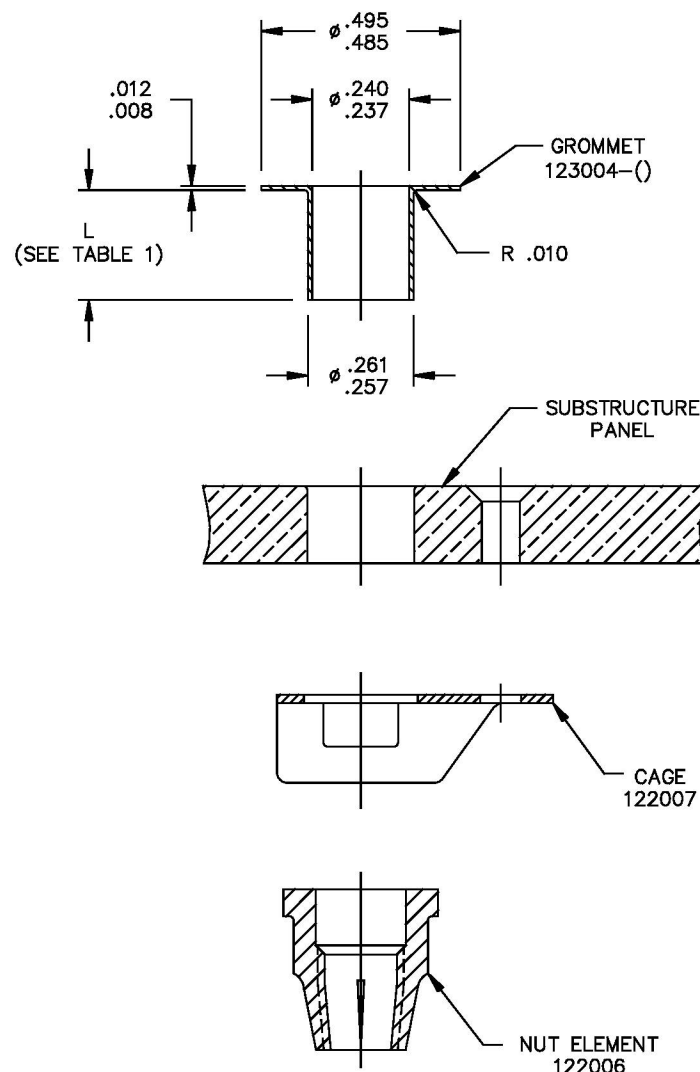
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ITEM NO.	QTY. REQ'D	PART NO.	DESCRIPTION	MATERIAL OR NOTES
1	1	122005-8	NUT PLATE ASSY., MINI MONADLOC FOR COMPOSITE APPLICATION LOW PROFILE GROMMET, FLOATING	
NEXT ASSEMBLY		DIMENSIONING AND TOLERANCING PER ANSI Y14.5M. UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES DECIMALS FRACTION ANGLES MATERIAL: SEE NOTE 1 HEAT TREAT: SEE NOTE 2 FINAL PROTECTIVE FINISH: SEE NOTE 3		
THIRD ANGLE PROJECTION		IBM # DRAWN BY: T. TRAN DATE: 05-14-04 ENG. APPROVAL: IK DATE: 01-25-08 QUAL. ACCEPT.: FD DATE: 01-25-08 MFG. ACCEPT.: JA DATE: 01-25-08		
li si AEROSPACE THE MONADNOCK COMPANY 18301 E. ARENTH AVE CITY OF INDUSTRY, CALIFORNIA		CODE IDENT. NO. 60119 SIZE A DRAWING NUMBER: 122005-() SALES SHEET 1 OF 4		

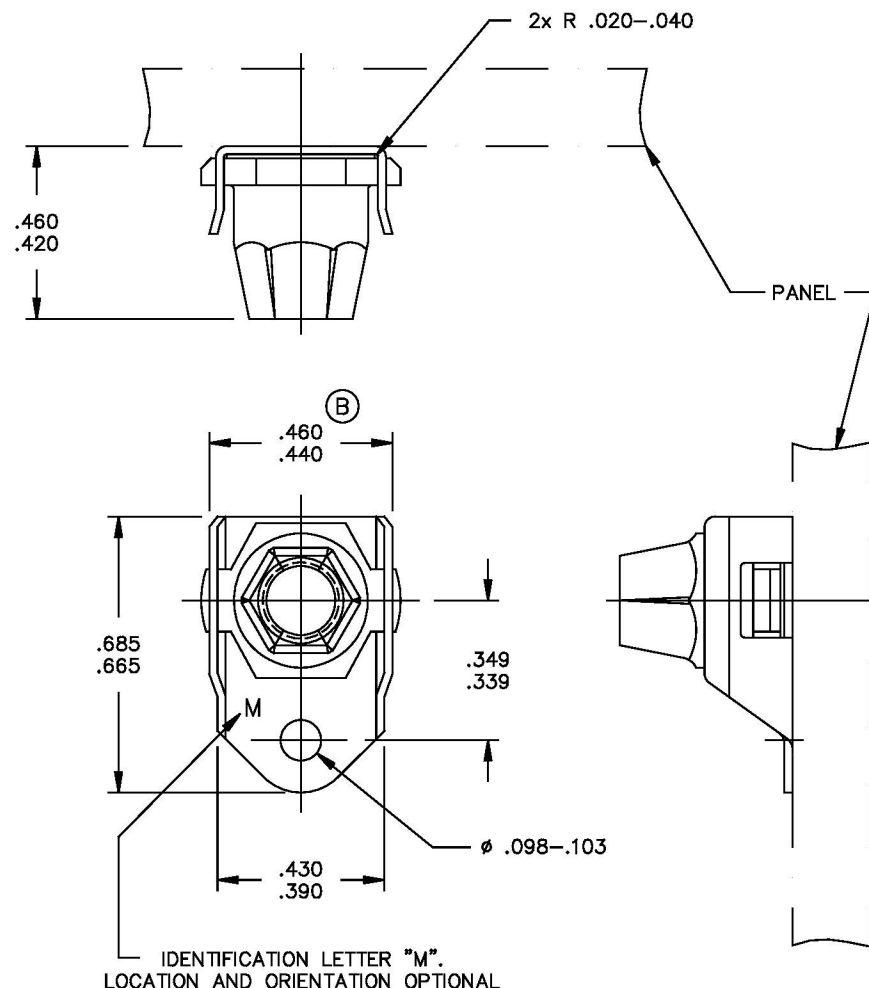
122005–()

NUT PLATE COMPONENTS

SEE NOTE 7
FOR COMPONENT ORDERING



NUT PLATE ENVELOPE



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—	—		DRAWN BY: T. TRAN	
—	—		DATE: 05–14–04	
—	—		ENG. APPROVAL: IK	
—	—		DATE: 01–25–08	CODE IDENT. NO. 60119 SIZE A DRAWING NUMBER: 122005–()
—	—		QUAL. ACCEPT.: FD	
—	—		DATE: 01–25–08	
—	—		MFG. ACCEPT.: JA	
—	—		DATE: 01–25–08	SALES SHEET 2 OF 4

122005-()

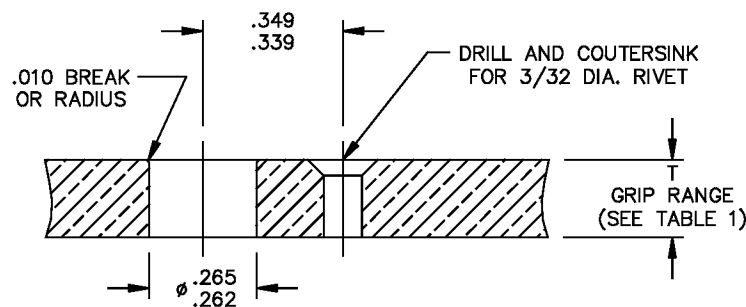


FIGURE 1
PANEL PREPARATION

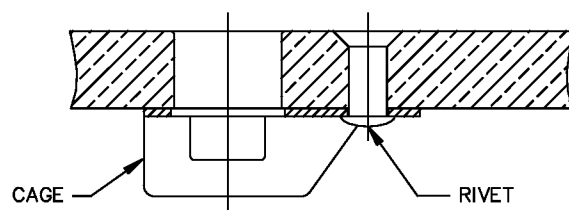


FIGURE 2
CAGE INSTALLATION

PANEL PREPARATION AND INSTALLATION PROCEDURE:

1. PREPARE PANEL HOLES AS SHOWN IN FIGURE 1.
2. RIVET CAGE TO SUBSTRUCTURE PANEL AS SHOWN IN FIGURE 2.
3. INSERT GROMMET AND CAGE INTO PANEL HOLE, AND PRIMARY FLARE TOOL INTO CAGE AND GROMMET THRU BACK-UP TOOL AS SHOWN IN FIGURE 3. APPLY A COMPRESSIVE LOAD IN DIRECTION OF ARROWS TO PRE-FLARE GROMMET AGAINST CAGE. REMOVE THE PRIMARY FLARE TOOL.
4. INSERT THE FINAL FLARE TOOL THRU BACK-UP TOOL AS SHOWN IN FIGURE 4. APPLY LOAD IN DIRECTION OF ARROWS TO FLARE THE GROMMET FLAT AGAINST THE CAGE. CHECK THE GROMMET FOR TIGHTNESS AND FLATNESS OF THE FLARED AREA. INCREASE PRESSURE IF NECESSARY TO BRING THE EDGE OF THE GROMMET TO LIE FLAT IN THE CAGE.
5. PLACE NUT BASE INTO WINDOW OF CAGE & SNAP INTO CAGE AS SHOWN IN FIGURE 5.
6. FIGURE 6, SHOWN COMPLETED OF ASSEMBLY.

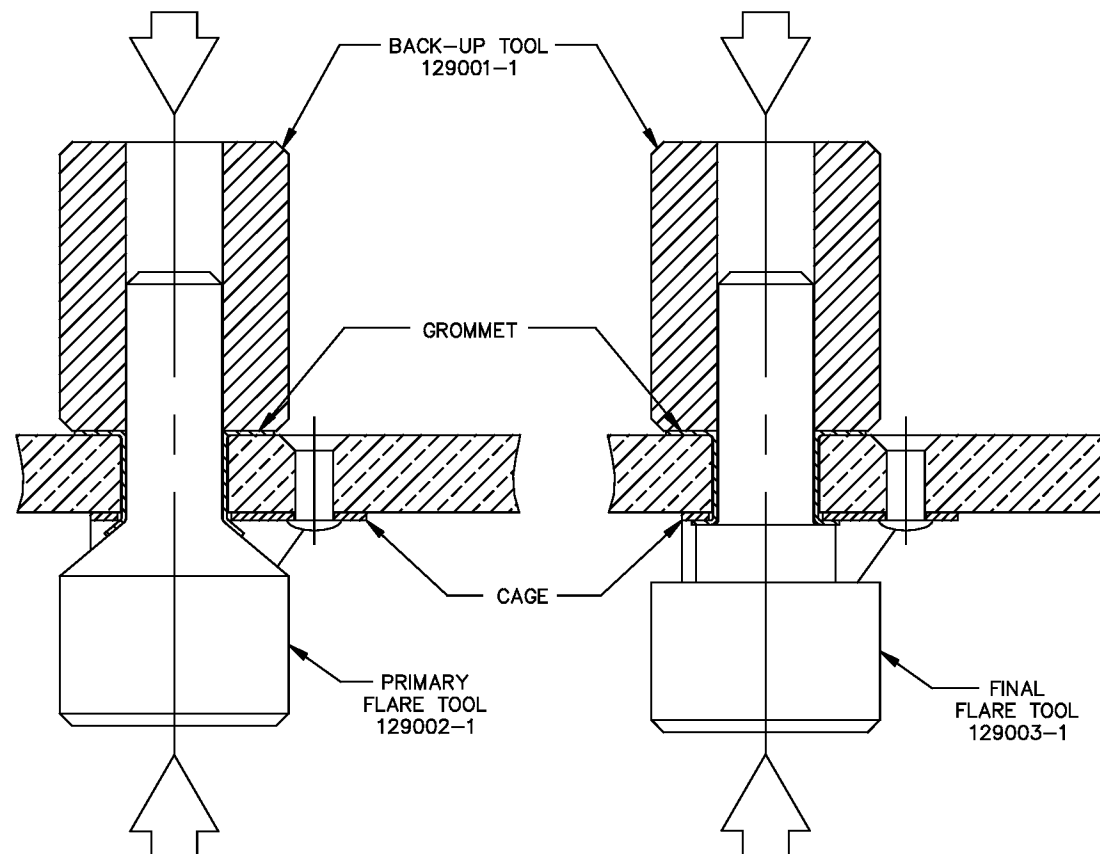


FIGURE 3
PRIMARY INSTALLATION

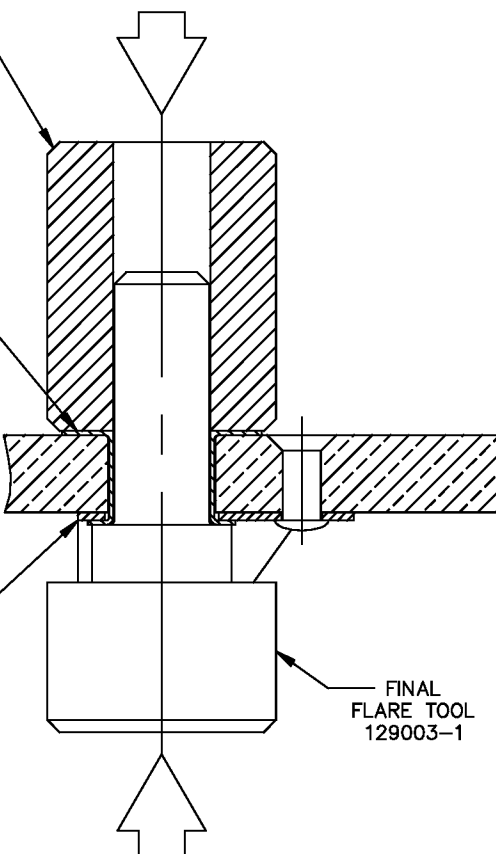


FIGURE 4
FINAL INSTALLATION

B	ECN 9386	06-22-10
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THIRD ANGLE PROJECTION		IBM # DRAWN BY: T.TRAN DATE: 05-14-04 ENG. APPROVAL: IK DATE: 01-25-08 QUAL. ACCEPT.: FD DATE: 01-25-08 MFG. ACCEPT.: JA DATE: 01-25-08		
		lsiaerospacethe monadnock company 18301 E. ARENTH AVE CITY OF INDUSTRY, CALIFORNIA TITLE: NUT PLATE ASSY., MINI MONADLOC FOR COMPOSITE APPLICATION LOW PROFILE GROMMET, FLOATING CODE IDENT. NO. 60119 SIZE A DRAWING NUMBER: 122005-() SCALE: — SALES SHEET 3 OF 4		

122005–()

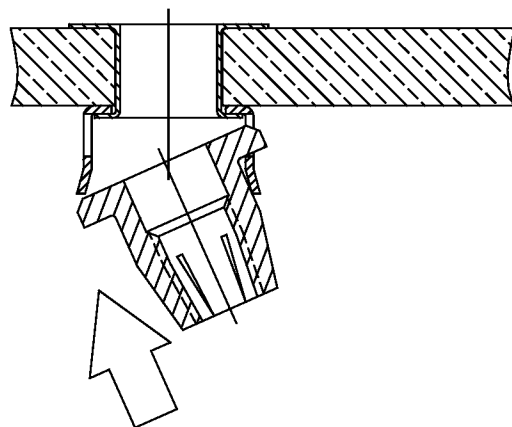


FIGURE 5
NUT ELEMENT INSTALLATION

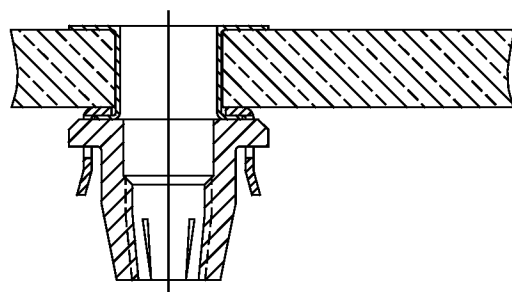


FIGURE 6
COMPLETED INSTALLATION

B	ECN 9386	06–22–10
A	ECN 8995	12–04–08
ISSUE	ECN NUMBER	DATE
PROJECT No. 0412–007		

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			MATERIAL: SEE NOTE 1	DRAWN BY: DATE T. TRAN 05–14–04 ENG. APPROVAL: DATE IK 01–25–08 QUAL. ACCEPT.: DATE FD 01–25–08 MFG. ACCEPT.: DATE JA 01–25–08
THIRD ANGLE PROJECTION			HEAT TREAT: SEE NOTE 2 FINAL PROTECTIVE FINISH: SEE NOTE 3	CODE INDENT. NO. 60119 SIZE A DRAWING NUMBER: 122005–() SCALE: — SALES SHEET 4 OF 4