

NOTES, UNLESS OTHERWISE SPECIFIED:

1. MATERIAL:

1.1 NUT ELEMENT: 4140 ALLOY STEEL PER AMS6382 OR AMS6349. OR 8740 PER AMS6322 OR EQUIVALENT.

1.2 SPRING & HOUSING: 17-7 PH CRES PER AMS5528 OR AMS5529.

1.3 CAGE: 300 SERIES CRES PER AMS5903 OR EQUIVALENT.

2. HEAT TREAT:

2.1 NUT ELEMENT: 180-200 KSI PER AMS-H-6875 OR AMS2759.

2.2 SPRING: CONDITION RH950 PER AMS-H-6875 OR AMS2759.

2.3 HOUSING: CONDITION TH1050 PER AMS-H-6875 OR AMS2759.

2.4 CAGE: NONE.

3. FINISH:

3.1 CAD PLATE PER AMS-QQ-P-416, TYPE I, CLASS 2 AND DRY FILM LUBE PER MIL-PRF-46010. ANTI-SEIZE COMPOUND PER MIL-PRF-907 IS PERMISSIBLE ON INTERNAL THREADS OF NUT ELEMENT AFTER DRY FILM LUBE.

4. THE NUT ELEMENT, CAGE, HOUSING AND SPRING SHALL FORM ONE INTEGRAL UNIT.

5. THE NUT ELEMENT SHALL BE CAPABLE OF .100 RADIAL FLOAT FROM CENTERLINE.

6. PARTS SHALL BE VISIBLY UNIFORM IN QUALITY AND APPEARANCE. THEY SHALL BE FREE OF BURRS, CRACKS, CHIPS, SHARP CUTTING EDGES, AND OTHER DEFECTS THAT WILL ADVERSELY EFFECT LIFE AND SERVICEABILITY.

7. TOLERANCES, UNLESS OTHERWISE SPECIFIED:

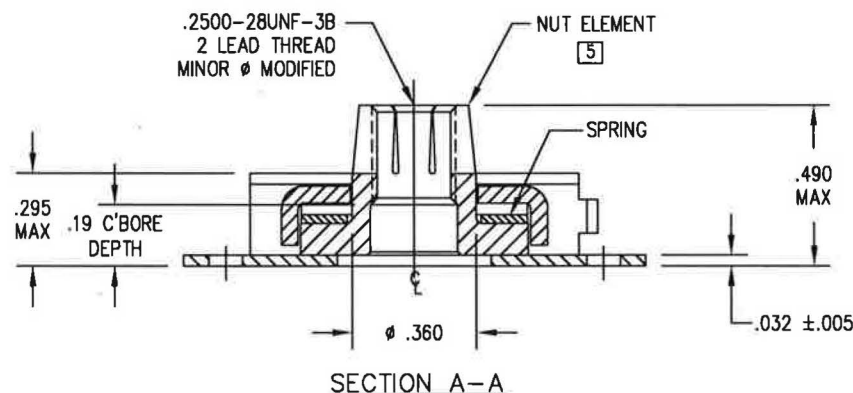
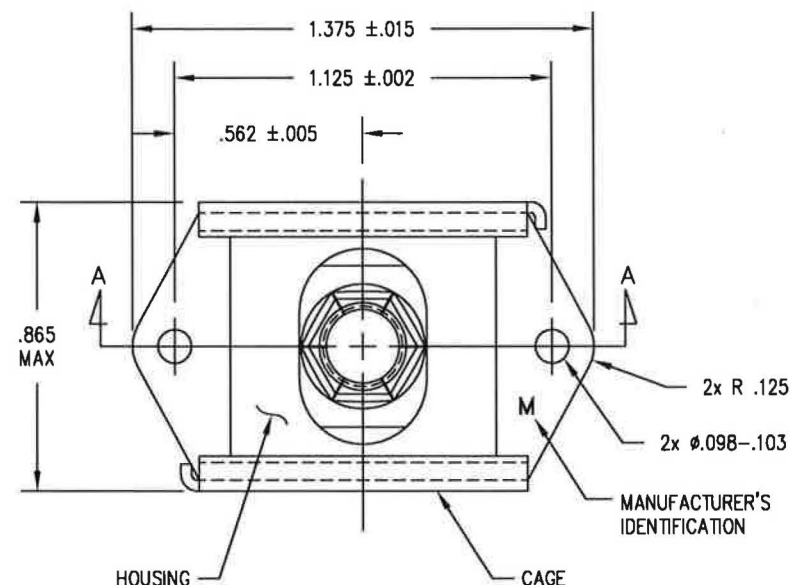
.XX= ± 0.030 , .XXX= ± 0.010 .

8. NUTPLATE ASSEMBLY IS DESIGNED TO BE USED WITH LOCKHEED STUD BOLT PART NO. C9537-4-().

9. NUTPLATE ASSEMBLY SHALL MEET THE REQUIREMENTS OF GENERAL DYNAMICS DRAWING NO. C9743.

10. THE SELF-LOCKING FEATURE SHALL BE A FLAT BEAM TYPE AND MEET THE REQUIREMENTS PER TABLE BELOW:

CAPABLE OF 1,500 SEATED CYCLES SELF-LOCKING TORQUE AT ROOM TEMPERATURE			
INSTALLATION TORQUE	SEATING TORQUE	BREAKAWAY TORQUE	TEST BOLT PART NO.
30 IN-LBS. MAX.	100 IN-LBS.	3.5 IN-LBS. MIN.	C9537-4-()



B	11327	3/16/17
A	8291	2/23/05
ISSUE	ECN NUMBER	DATE
PROJECT No.	041B-012	

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ITEM NO.	QTY. REQ'D	PART NO.	DESCRIPTION	MATERIAL OR NOTES
NEXT ASSEMBLY		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES DECIMALS FRACTION ANGLES		
		MATERIAL: SEE NOTE		
PREVIOUS ASSEMBLY		HEAT TREAT: SEE NOTE		
		FINAL PROTECTIVE FINISH: SEE NOTE		
		IBM #	lisia AEROSPACE THE MONADNOCK COMPANY 18301 E. ARENTH AVE. CITY OF INDUSTRY, CALIFORNIA	
		DRAWN BY: T. TRAN	DATE: 09/22/04	TITLE: NUTPLATE ASSEMBLY, FLOATING FLAT BEAM LOCK, 2 LEAD THREAD ALLOY STEEL 180 KSI
		ENG. APPROVAL: PYB	DATE: 12/03/04	
		QUAL. ACCEPT.: BG	DATE: 12/06/04	
		MFG. ACCEPT.: JA	DATE: 12/07/04	
		CODE IDENT. NO. 60119	SIZE B	DRAWING NUMBER: 122009-4
		SCALE: -	SALES	SHEET 1 OF 1