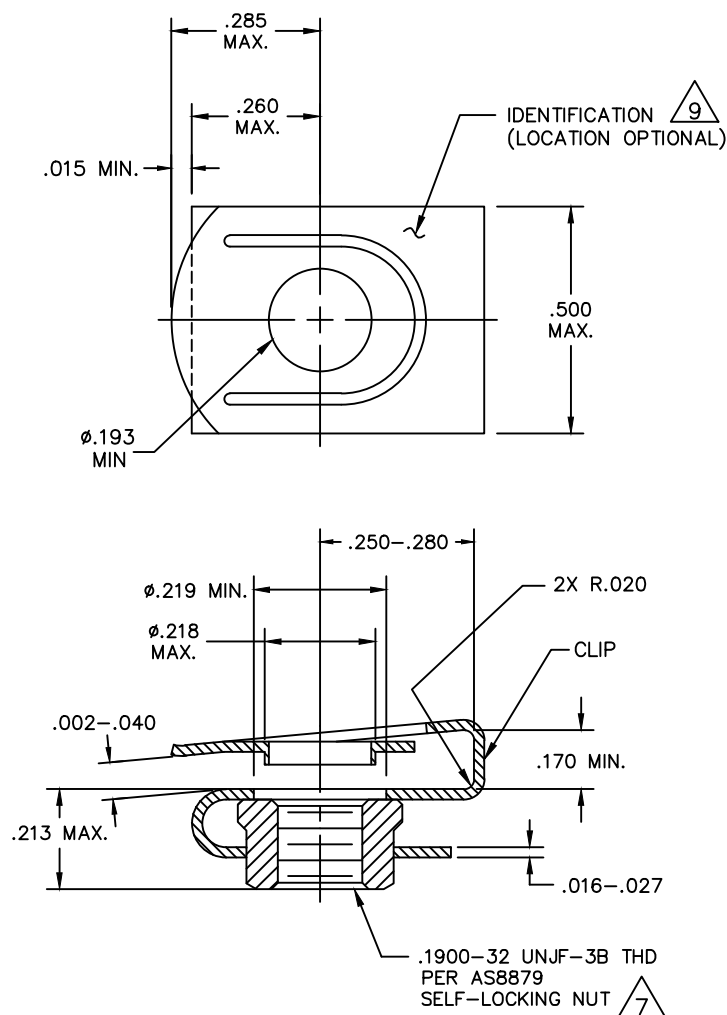


13100058()



NOTES (UNLESS OTHERWISE SPECIFIED):

1. MATERIAL:

1.1. CLIP: 1050 CARBON STEEL PER ASTM A684/A684M OR AMS5085

1.2. NUT: 4037 ALLOY STEEL PER AMS6300 OR ASTM A510/A510M

2. HEAT TREAT:

2.1 CLIP: AUSTEMPERED TO 84.5-86.0 HR15N (HRC 48-51)

2.2 NUT: HEAT TREAT OR COLD WORK TO MEET THE PERFORMANCE REQUIREMENTS PER BACN10FX. ROCKWELL HARDNESS NOT TO EXCEED 83.5 MAX. HR15N (HRC 46 MAX.)

3. FINISH:

3.1. CLIP: NO CODE = CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 1. "G" CODE = CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 1. THEN APPLY BMS10-11, TYPE I PRIMER.

3.1.1 CADMIUM PLATED CLIPS SHALL MEET SALT SPRAY REQUIREMENTS OF AMS-QQ-P-416, TYPE II. EMBRITTLEMENT TEST PER AMS-QQ-P-416 DOES NOT APPLY. EMBRITTLEMENT TEST PER BACN10FX SHALL APPLY.

3.2 NUT: CADMIUM PLATE PER AMS-QQ-P-416 TYPE II, CLASS 2.

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

4. LUBRICATION:

4.1 CLIP: NONE

4.2 NUT: SOLID FILM LUBRICANT PER AS5272, TYPE I MEETING THE HYDRAULIC FLUID RESISTANCE REQUIREMENTS OF BMS3-8.

5. QUALIFICATION AND PROCUREMENT PER BPS-N-70, CLASS 125TA4, EXCEPT AS NOTED. QUALIFICATION AND ACCEPTANCE REQUIREMENTS PER BACN10FX.

6. AXIAL TENSILE STRENGTH - 2.460 LBS MINIMUM

7. LOCALIZED REMOVAL OF CADMIUM PLATE AND SOLID FILM LUBRICANT COMMON TO TOP OF NUT ELEMENT DUE TO THE INSTALLATION INTO THE CLIP IS ACCEPTABLE.

8. DIMENSIONS APPLY AFTER CADMIUM PLATE AND BEFORE THE APPLICATION OF SOLID FILM LUBRICANT AND BMS10-11 PRIMER.

9. IDENTIFY WITH COMPANY LOGO "M". METHOD AND PLACEMENT OF LOGO ON EITHER CLIP OR NUT ARE MANUFACTURER'S OPTION.

10. CLIP & NUT ASSEMBLY SHALL BE FREE FROM BURRS AND SLIVERS.

11. PART NUMBER EXAMPLE:

1 3 1 0 0 5 8 ()

CLIP FINISH CODE (SEE NOTE 3)

BASIC PART NUMBER

TABLE 1 - INSTALLATION DATA

SHEET THICKNESS	EDGE DISTANCE	INSTALLATION HOLE
.050-.160	.230-.250	Ø.219-.229

H	12252	JC	6/3/20	REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN PERMISSION OF LSI AEROSPACE THE MONADNOCK COMPANY IS PROHIBITED
G	11120	JC	6/22/16	
REV.	ECN NO.	INIT.	DATE	

NEXT ASSEMBLY		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS: DECIMALS FRACTION ANGLES ±.010 — —		IBM NUMBER: N/A		lisi AEROSPACE THE MONADNOCK COMPANY 18301 E. GALE AVE CITY OF INDUSTRY, CALIFORNIA			
END ITEM		MATERIAL: SEE NOTE 1		PROJECT NUMBER: 9413-018		TITLE: NUT ASSEMBLY CLIP-ON, 10-32 SIZE, (BACN10FX)			
THIRD ANGLE PROJECTION		HEAT TREAT: SEE NOTE 2		DRAWN BY: DATE CKT 2/24/95		CAGE CODE SIZE DRAWING NUMBER:		60119 A 13100058()	
		FINAL PROTECTIVE FINISH: SEE NOTE 3		APPROVED BY: DATE CKT 2/24/95		SCALE: NONE		SALES SHEET 1 OF 1	