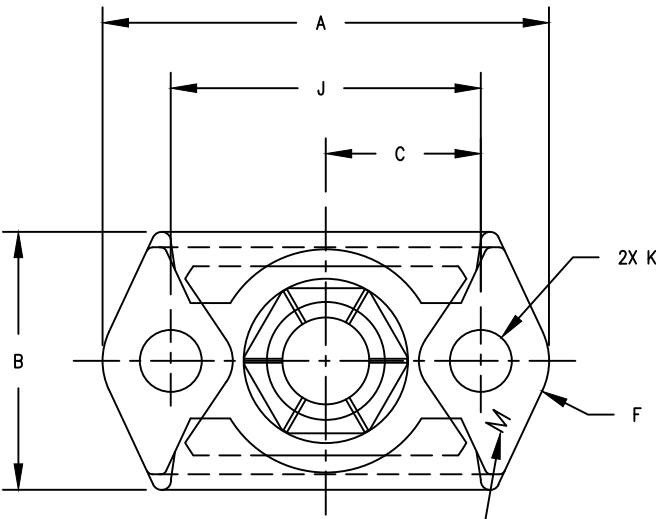
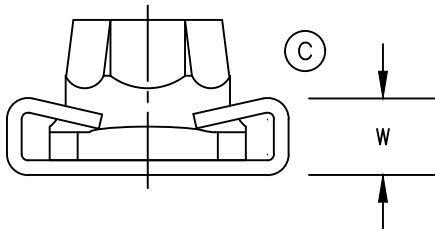
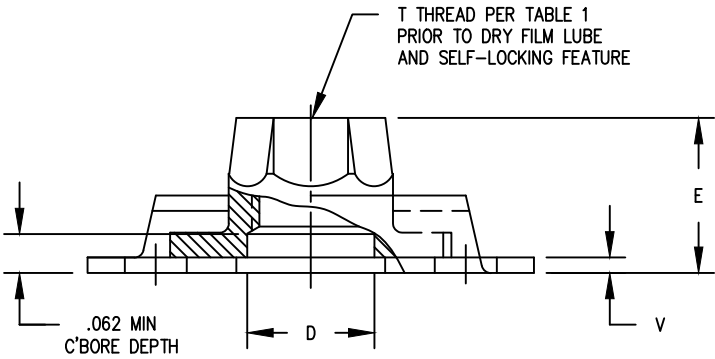




STAMP MANUFACTURER'S
IDENTIFICATION LETTER "M"
LOCATION OPTIONAL

TABLE I

-()	T THREAD PER AS8879 CLASS 3B	A MAX.	B MAX.	C ±.005	∅ D MIN.	E MAX.	F MIN. RAD.	J ±.002	K +.005 -.000	V MAX.	W C	AXIAL STRENGTH LBS. MIN.	SEATING TORQUE MAX. IN-LBS
-3	.1900-32UNJF	.739	.416	.250	.194	.250	.100	.500	.098	.032	.120-.130	2,460	36
-4	.2500-28UNJF	.801	.500	.281	.254	.281	.100	.562	.098	.032		4,580	60
-5	.3125-24UNJF	1.010	.581	.328	.317	.328	.117	.718	.130	.045		7,390	120



FAA-TSO AUTHORIZED PART

C	12636	JC	2/15/23	REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN PERMISSION OF LISI AEROSPACE THE MONADNOCK COMPANY IS PROHIBITED
B	10112	TD	4/30/13	
REV.	ECN NO.	INIT.	DATE	

NEXT ASSEMBLY END ITEM	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS: DECIMALS FRACTION ANGLES ±.010 - ±2°	IBM NUMBER: -	lisi AEROSPACE THE MONADNOCK COMPANY 18301 E. ARENTH AVE CITY OF INDUSTRY, CALIFORNIA		
THIRD ANGLE PROJECTION	MATERIAL: NOTED	PROJECT NUMBER: N/A	TITLE: NUT PLATE, SELF-LOCKING, 2 LUG FLOATING, 250 CYCLE ALLOY STEEL NUT		
	HEAT TREAT: NOTED	DRAWN BY: DATE T. TRAN 07/17/08			
	FINAL PROTECTIVE FINISH: NOTED	APPROVED BY: DATE IK 09/05/08	CAGE CODE 60119	SIZE A	DRAWING NUMBER: 186042-()()
		SCALE: NONE	SALES	SHEET 1 OF 2	

NOTES; UNLESS OTHERWISE SPECIFIED:

1. MATERIAL:

1.1 NUT: 4140 OR 8740 ALLOY STEEL PER AMS6382, AMS6349, AMS6322 OR AMS6327.

1.2 CAGE: 300 SERIES CRES PER AMS5517, AMS5518, AMS5901 OR AMS5903.
2. HEAT TREAT:

2. NUT: 160 KSI MIN PER AMS2759.

2.2 CAGE: NONE
3. FINISH:

3.1 NUT: CADMIUM PLATE PER AMS-QQ-P-416, TYPE I, CLASS 2, WITH 23 HOUR BAKE TO RELIEVE HYDROGEN EMBRITTLEMENT, AND DRY FILM LUBRICATE PER AS272, TYPE I.

3.2 CAGE:

NO SUFFIX = PASSIVATE PER AMS2700.

C = CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2.
4. ANTI-SEIZE COMPOUND PER MIL-PRF-907 IS PERMISSIBLE ON INTERNAL THREADS OF NUT AFTER DRY FILM LUBRICATION.
5. NUT ELEMENT RADIAL FLOAT SHALL NOT LESS THAN .020 INCHES FROM CENTERED POSITION. NUT ELEMENT SHALL BE CAPABLE OF ENGAGEMENT WITH BOLT IN THE MAXIMUM MISALIGNED POSITION.
6. REQUIREMENT:

AXIAL TENSILE, PUSH OUT AND TORQUE OUT PER NASM25027, EXCEPT NUT ELEMENT SELF-LOCKING FEATURE SHALL BE CAPABLE OF 250 SEATED USEABLE CYCLES WHEN TESTED WITH 160 KSI, CADMIUM PLATED ALLOY STEEL BOLTS. SEATING TORQUE REQUIREMENTS PER TABLE 1.

6.1 SELF-LOCKING TORQUE PROCEDURE:

USE 160 KSI, CADMIUM PLATED ALLOY STEEL BOLTS WITH THREAD FORM PER AS8879. USE STEEL PLATES OF THICKNESS EQUAL TO BOLT GRIP. HOLES IN THE PLATES SHALL BE OF SUFFICIENT SIZE TO PRECLUDE BOLT SHANK CONTACT AGAINST THE WALL OF THE HOLE. ENGAGE BOLTS INTO NUTS OBSERVING "MAX LOCKING TORQUE" ENCOUNTERED DURING ENGAGEMENT BUT PRIOR TO A CLAMP UP CONDITION. TORQUE BOLTS TO "SEATING TORQUE" VALUE PER TABLE 1. DISENGAGE BOLT FROM NUT, STOPPING AFTER PRELOAD IS REMOVED WHILE OBSERVING "UNSEATED TORQUE VALUE". REINITIATE DISENGAGEMENT OBSERVING "MIN BREAKAWAY TORQUE" ENCOUNTERED FROM THAT POINT UNTIL DISENGAGEMENT OF THE LOCKING FEATURE OCCURS. TEST BOLTS SHALL BE RANDOMLY INTERCHANGED WITH NUT ELEMENTS ON THE TENTH, TWENTIETH AND TWENTY-FIFTH CYCLES OF THE FIRST TWENTY-FIVE CYCLES AND ON EVERY TWENTY-FIFTH CYCLE THEREAFTER. RECORD DATA ON EVERY TENTH CYCLE. NEW TEST BOLTS (5 MAX PER NUT ELEMENT) MAY BE USED DURING THE TEST IF THE LOCKING TORQUE FALLS BELOW MINIMUM REQUIREMENT. OBSERVE LOCKING TORQUES. IF TORQUES MEET REQUIREMENT, NUT MAY CONTINUE IN THE TEST. THE NEW TEST BOLT SHALL SUBSEQUENTLY BE RANDOMLY INTERCHANGED WITH THE NUT ELEMENTS AS DESCRIBED ABOVE. POWER TOOLS MAY BE UTILIZED FOR ALL INTERMEDIATE CYCLES. IF AVAILABLE POWER TOOL IS UNABLE TO DELIVER REQUIRED SEATING TORQUE, A HAND TORQUE WRENCH MAY BE USED TO COMPLETE THE INSTALLATION CYCLE AND INITIATE THE REMOVAL CYCLE. NUTS SHALL BE ALLOWED TO COOL AFTER INSTALLATION AND/OR REMOVAL PORTION OF EACH REUSE CYCLE AS NECESSARY.

6.2 SELF-LOCKING TORQUE CYCLE REDUCTION:

FOR THE PURPOSE OF QUALITY PERFORMANCE INSPECTION TESTING OF LOCKING TORQUE, REDUCED TESTING MAY BE ACCOMPLISHED UNDER THE FOLLOWING CONDITIONS:

A, FOR A GIVEN SIZE OF NUTPLATE ASSEMBLY, THREE LOTS OF THAT SIZE HAVE PASSED THE 250 CYCLE LOCKING TORQUE QUALITY CONFORMANCE TESTING REQUIREMENTS.

B, FOR A GIVEN SIZE OF NUTPLATE ASSEMBLY, SATISFACTORY TEST DATA DEMONSTRATING THAT THE TORQUE RESULTS AFTER FIFTY REUSE CYCLES ARE SUBSTANTIALLY EQUAL TO THE FIRST FIFTY CYCLES OF A PREVIOUSLY CERTIFIED TEST OF 250 CYLES OF DURATION.
- NOTES; CONTINUE:
7. CONFIGURATION OF NUT AND/OR CAGE ARE OPTIONAL WITHIN THE LIMITS SPECIFIED ON THIS DRAWING.

8. EXAMPLE OF PART NO. CALLOUT:

1 8 6 0 4 2 -3 C

C= CADMIUM PLATED CAGE. (SEE NOTE 3)

-3= .1900-32 THREAD SIZE (SEE TABLE 1)

BASIC PART NO.
- FAA-TSO AUTHORIZED PART
- | | | | | | | | | | | | |
|--|--|--|--|---------------------------|--|--|--|------------------------------------|--|---|--|
| | | | | NEXT ASSEMBLY
END ITEM | | UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS:
DECIMALS FRACTION ANGLES
±.010 - ±2° | | IBM NUMBER:
- | | lisi AEROSPACE THE MONADNOCK COMPANY
18301 E. ARENTH AVE
CITY OF INDUSTRY, CALIFORNIA | |
| | | | | | | MATERIAL:
NOTED | | PROJECT NUMBER:
N/A | | TITLE:
NUT PLATE, SELF-LOCKING, 2 LUG
FLOATING, 250 CYCLE
ALLOY STEEL NUT | |
| | | | | THIRD ANGLE PROJECTION | | HEAT TREAT:
NOTED | | DRAWN BY: DATE
T. TRAN 07/17/08 | | CAGE CODE SIZE DRAWING NUMBER:
60119 A 186042-()() | |
| | | | | | | FINAL PROTECTIVE FINISH:
NOTED | | APPROVED BY: DATE
IK 09/05/08 | | SCALE: NONE SALES SHEET 2 OF 2 | |

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