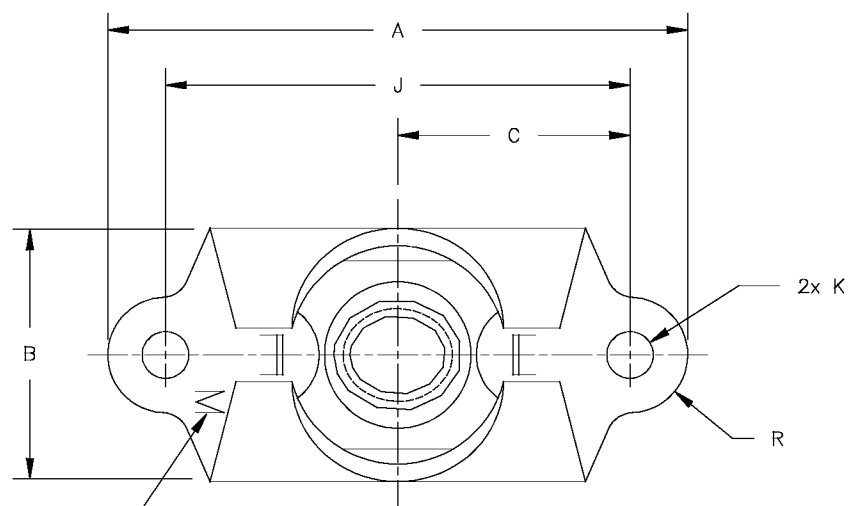


186512-()



STAMP MANUFACTURER'S IDENTIFICATION,
.010 RAISED OR DEPRESSED LOCATION OPTIONAL
MUST BE VISIBLE AFTER ASSEMBLY

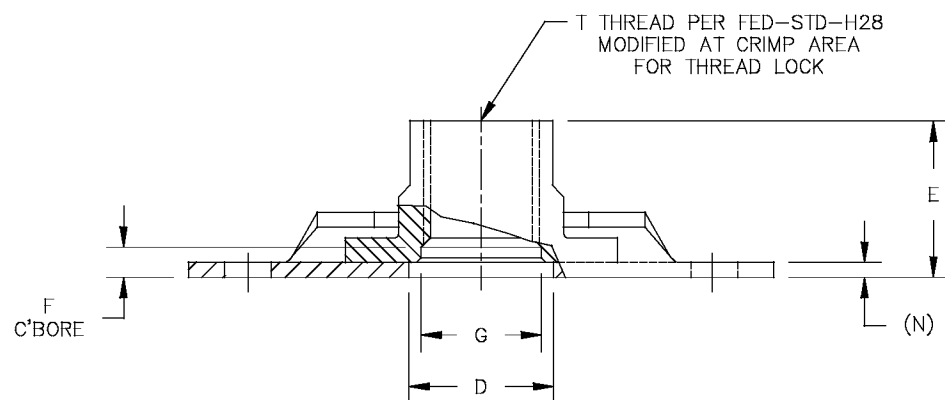


TABLE 1

-()	T THREAD PER FED-STD-H28 CLASS 3B	A MAX	B MAX	Ø C ±.005	Ø D REF	E +.000 -.020	F MIN	Ø G MIN	Ø H	J ±.002	Ø K +.005 -.000	N REF	R RAD MIN.
-3	.1900-32UNF	.948	.416	.344	.250	.290	.062	.194	.200	.688	.098	.025	.100

TABLE 2

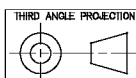
-()	T THREAD PER FED-STD-H28 CLASS 3B	SEATING TORQUE MAX.	AXIAL STRENGTH LBS. MIN.
-3	.1900-32UNF	36	2,460

NOTES (UNLESS OTHERWISE SPECIFIED) :

- MATERIAL:
1.1 NUT AND CAGE: STEEL 1035 PER AMS-QQ-S-700 OR AMS5080, OR 1050 PER AMS5085, 8740 PER AMS6322 OR AMS6358; 4340 PER AMS6359; 4130 PER AMS6350.
- HEAT TREAT:
2.1 NUT AND CAGE: HRC 46 MAXIMUM.
- FINISH:
3.1 NUT AND CAGE: CADMIUM PLATED PER AMS-QQ-P-416, TYPE II, CLASS 2. WITH 23 HOUR BAKE TO RELIEVE HYDROGEN EMBRITTLEMENT, AND DRY FILM LUBE PER AS5272, TYPE I.
- NUT ELEMENT RADIAL FLOAT SHALL NOT LESS THAN .030 INCHES FROM CENTERED POSITION. NUT ELEMENT SHALL BE CAPABLE OF ENGAGEMENT WITH BOLT IN THE MAXIMUM MISALIGNED POSITION.
- PERFORMANCE PER NASM25027, EXCEPT:
NUT ELEMENT SELF-LOCKING FEATURE SHALL BE CAPABLE OF 15 SEATED USEABLE CYCLES WHEN TESTED WITH 160 KSI, CAD PLATED ALLOY STEEL TEST BOLTS.
SEATING TORQUE AND TENSILE REQUIREMENTS PER TABLE 2.

ISSUE	ECN NUMBER	DATE
PROJECT No.	N/A	

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ITEM NO.	QTY. REQ'D	PART NO.	DESCRIPTION	MATERIAL OR NOTES
NEXT ASSEMBLY	END ITEM	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES DECIMALS FRACTION ANGLES ± .010 ± 5°	IBM #	lisi AEROSPACE THE MONADNOCK COMPANY 18301 E. ARENTH AVE CITY OF INDUSTRY, CALIFORNIA
PREVIOUS ASSEMBLY	HEAT TREAT:	NOTED	DRAWN BY: DATE T. TRAN 07-31-08 ENG. APPROVAL: DATE IK 10-03-08 QUAL. ACCEPT.: DATE BG 10-03-08 MFG. ACCEPT.: DATE TB 10-03-08	TITLE: NUT PLATE, 2 LUG, FLOATING, SELF-LOCKING STEEL NUT AND CAGE, 15 CYCLE
	FINAL PROTECTIVE FINISH:	NOTED	CODE IDENT. NO. SIZE DRAWING NUMBER: 60119 B 186512-()	SALES SHEET 1 OF 1