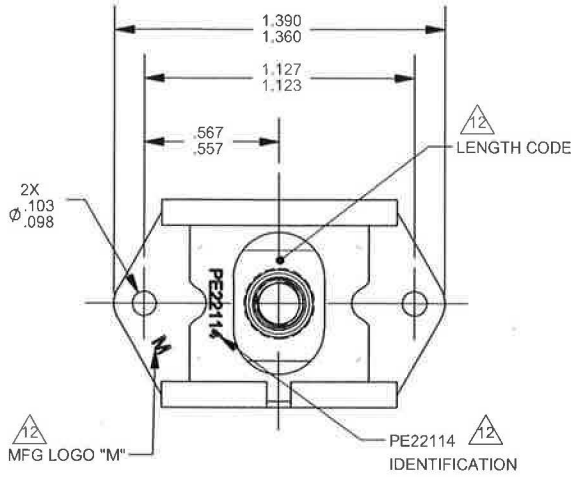
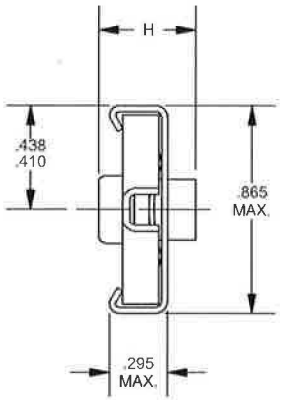
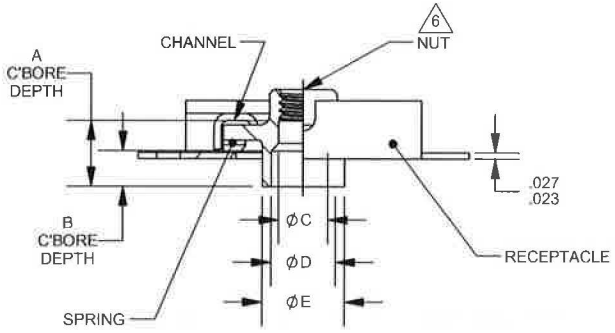
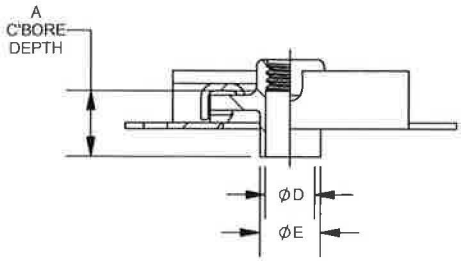




ISO VIEW



CODE "A" CONFIGURATION



CODE "B" CONFIGURATION

EXAMPLE OF PART NUMBER CODING:

187025 - 3 A 2

- LENGTH CODE (SEETABLE 2)
- C'BORE CONFIGURATION CODE (SEE TABLE 1)
- SIZE CODE (SEE TABLE 1)
- BASIC PART NUMBER

NOTES:

1. MATERIAL:
   NUT: A286 CRES PER AMS5525, AMS5731, AMS5732 OR AMS5737.
   SPRING, CHANNEL AND RECEPTACLE: 17-7PH PER AMS5528 OR AMS5529.
2. FINISH:
   NUT AND SPRING: PASSIVATE PER AMS2700.
   CHANNEL AND RECEPTACLE: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. EMBRITTLEMENT TEST PER AMS-QQ-P-416 NOT REQUIRED.
3. SOLID-FILM LUBRICANT OF ALL PARTS, EXCEPT OPTIONAL ON CHANNEL, MEETING THE REQUIRMENTS OF NASM25027, AND HYDRAULIC FLUID RESISTANCE WHEN TESTED PER METHOD 7001 OF FEDERAL TEST METHOD STANDARD NO.791, USING SAE AS1241 PHOSPHATE ESTER HYDRAULIC FLUID.
4. ALL SURFACES OF RECEPTACLE TO BE LUBRICATED (WHEN SPECIFIED), EXCEPT TOOLING MARKS ARE ACCEPTABLE WHERE LUBRICATION IS MECHANICALLY REMOVED UPON ASSEMBLY FORMING OF NUTPLATE.
5. NUT ELEMENT SHALL BE CAPABLE OF RADIAL FLOAT PER TABLE 1 FROM RECEPTACLE CENTERLINE.
6. UPPER THREAD PORTION OF NUT DEFORMED TO PROVIDE SELF-LOCKING FEATURE.
7. ACCEPTANCE REQUIREMENTS:
   NUTPLATE ASSEMBLY SHALL MEET THE REQUIREMENTS OF NASM25027 EXCEPT AS NOTED:
   - TORQUE-OUT REQUIREMENT PER NASM25027 NOT REQUIRED
   - TENSILE STRENGTH OF NUT AND ASSEMBLY PER TABLE 1.
8. SPRING LOAD SHALL BE 25 ±3 LBS. WHEN THE NUT ELEMENT SHANK PROTRUDES FROM THE BEARING SURFACE OF THE RECEPTACLE AT A DISTANCE EQUAL TO THE NOMINAL STRUCTURE THICKNESS. ADDITIONAL PROTRUSION OF .013 ±.007 WILL CAUAE THE NUT ELEMENT FLANGE TO BOTTOM OUT.
9. WITH SCREW REMOVED, SPRING SHALL HOLD NUT IN ANY SELECTED POSITION WITHIN LIMITS OF THE FLOAT TO PERMIT ALIGNMENT OF THE NUT AND SCREW DURING REASSEMBLY.
10. PRELOAD IS OBTAINED AND LIMITED BY PULLING THE SHOULDER OF THE NUT UP TO THE SURFACE OF THE MOVABLE MEMBER CONTROLLING INITIAL COMPRESSION OF THE SPRING.
11. ALL DIMENSIONS APPLY AFTER FINISH PRIOR TO THE APPLICATION OF SOLID-FILM LU8BRICANT.
12. ALL MARKINGS INDENTED .010 MAXIMUM. ORIENTATION OPTIONAL.

FAA-TSO AUTHORIZED PART

REV.	ECN NUMBER	BY	DATE
E	12389	PS	07/30/21
D	11000	JC	04/30/13

NEXT ASSEMBLY: -

THIRD ANGLE PROJECTION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS:
DECIMALS: .XXX = ±.010 ANGLES: ±5°

MATERIAL: NOTED

HEAT TREAT: NOTED

FINAL PROTECTIVE FINISH: NOTED

IBM NUMBER: -

PROJECT NUMBER: --

DRAWN BY: T.TRAN DATE: 10/27/10

APPROVED BY: R.THORNTON DATE: 12/08/10

lisi AEROSPACE

THE MONADNOCK COMPANY
16728 E. GALE AVE.
CITY OF INDUSTRY, CALIFORNIA

TITLE: NUTPLATE ASSY,
HI-FLOAT,SPRING LOADED,
A286 CRES NUT ELEMENT, 450 °F

CODE IDENT. NO.	SIZE	DRAWING NUMBER
60119	B	187025

SCALE: NONE | SALES | SHEET 1 OF 2

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TABLE 1

SIZE CODE	THREAD SIZE PER AS8879	ØC	ØD	ØE	RADIAL FLOAT (MINIMUM) △5	AXIAL TENSILE STRENGTH (LBS. MINIMUM) △7		PUSH-OUT LOAD (LBS. MINIMUM) △7
						NUT ELEMENT	ASSEMBLY	
3A( )	.1900-32UNJF-3B	.200 .195	.270 .265	.345 .340	.100	2,460	700	100
3B( )	.1900-32INJF-3B	--	.200 .195	.255 .250	.150	2,460		100
4B( )	.2500-28UNJF-3B	.270 .265	--	.345 .340	.100	4,580		125

TABLE 2

LENGTH CODE	STRUCTURE THICKNESS +.004 -.005	-3A( )			-3B( )		-4B( )	
		A ±.005	B	H MAX.	A ±.005	H MAX.	A ±.005	H MAX.
1	.035	.173	.048	.313	.173	.313	.173	.313
2	.045	.183	.058	.323	.183	.323	.183	.323
3	.055	.193	.068	.333	.193	.333	.193	.333
4	.065	.203	.078	.343	.203	.343	.203	.343
5	.075	.213	.088	.353	.213	.353	.213	.353
6	.085	.223	.098	.363	.223	.363	.223	.363
7	.095	.233	.108	.373	.233	.373	.233	.373
8	.105	.243	.118	.383	.243	.383	.243	.383
9	.115	.253	.128	.393	.253	.393	.253	.393
10	.125	.263	.138	.403	.263	.403	.263	.403
11	.135	.273	.148	.413	.273	.413	.273	.413
12	.145	.283	.158	.423	.283	.423	.283	.423
13	.155	.293	.168	.433	.293	.433	.293	.433
22	.245	.383	.258	.523	.383	.523	.383	.523

SEE SHEET 1 OF 2

REV.	ECN NUMBER	BY	DATE

NEXT ASSEMBLY

THIRD ANGLE PROJECTION

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ARE AS FOLLOWS
DECIMALS ANGLES
.XXX = ±.010 ±5°

MATERIAL: NOTED

HEAT TREAT: NOTED

FINAL PROTECTIVE FINISH: NOTED

IBM NUMBER:

PROJECT NUMBER:

		DATE
DRAWN BY:	T.TRAN	10/27/10
APPROVED BY:	R.THORNTON	12/08/10

lisi AEROSPACE
THE MONADNOCK COMPANY
16728 E. GALE AVE.
CITY OF INDUSTRY, CALIFORNIA

TITLE: NUTPLATE ASSY., HI-FLOAT, SPRING LOADED, A286 CRES NUT ELMENT, 450 °F

CODE IDENT. NO.	SIZE	DRAWING NUMBER
60119	B	187025

SCALE:	SHEET
NONE	SALES 2 OF 2

FORME050A rev.G