

TABLE I

FIRST DASH NO		THREAD SIZE PER AS8879	B MAX	ØD MIN	F MIN	H MAX	L MIN SPCG	M MIN	ØP		V MAX	AXIAL STRENGTH LBS MIN	WEIGHT	
NO DFL	DFL								MAX	MIN			NUT LBS/100	CHANNEL LBS/INCH
-08	L08	.1640-32UNJF-3B	.416	.168	.343	.250	.625	.062	.270	.184	.035	1,720	.19	.0028
-3	L3	.1900-32UNJF-3B	.416	.194	.343	.250	.625	.062	.270	.210	.035	2,460	.20	.0028
-4	L4	.2500-28UNJC-3B	.516	.254	.406	.281	.750	.062	.330	.270	.045	4,580	.43	.0032
-5	L5	.3125-24UNJC-3B	.609	.317	.469	.328	.875	.062	.393	.333	.045	7,390	.64	.0053
-6	L6	.3750-24UNJF-3B	.726	.379	.562	.344	1.000	.062	.455	.395	.055	11,450	1.08	.0073

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TABLE II

SECOND DASH NO	L NUT ELEMENT SPACING	MAXIMUM NUMBER OF NUT ELEMENTS
-5	.625	115
-6	.750	96
-7	.875	82
-8	1.000	72
-9	1.125	64
-10	1.250	57
-11	1.375	52
-12	1.500	48
-13	1.625	44
-14	1.750	41
-15	1.875	38
-16	2.000	36
-18	2.250	32
-20	2.500	28
-24	3.000	24

EXAMPLE PART NUMBER: 1 8 8 0 0 5 ( ) ( ) - ( )

BASIC PART NUMBER

FIRST DASH NO. FOR THREAD  
SIZE PER TABLE I

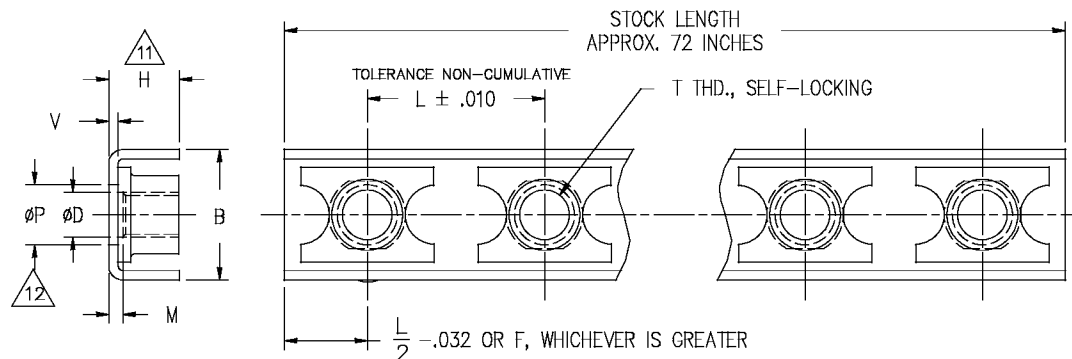
SECOND DASH NO FOR NUT ELEMENT  
SPACING PER TABLE II

NUMBER OF NUT ELEMENTS WHEN LESS  
THAN STOCK LENGTH IS DESIRED

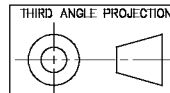
- 11 'H' MAX APPLIES TO NUT ELEMENTS AND CHANNEL.  
12 HOLE IN CHANNEL MUST PROVIDE FOR FULL FLOAT  
OF NUT ELEMENT BUT NEED NOT BE CIRCULAR

NOTES (UNLESS OTHERWISE SPECIFIED) :

- MATERIAL:
  - CHANNEL: ALUMINUM, ALLOY 1100, ANNEALED (UNS A91100), PER AMS-QQ-A-250/1; 2024-T4 (UNS A92024) PER AMS-QQ-A-250/4; 7075-T6 (UNS A97075) PER AMS-QQ-A-250/12 OR /13; OR 2024-T4 (UNS A82024) PER AMS-QQ-A-250/5 OR AMS4040.
  - NUT: CARBON STEEL 1035 (UNS G10350), 1040 (UNS G10400), AND 1050 (UNS G10500) PER ASTM-A-827; 1042 (UNS G10420) PER ASTM-A-29. ALLOY STEEL 4130 (UNS G41300), 4340 (UNS G43400) AND 8740 (UNS G87400) PER ASTM-A-29.
- FINISH:
  - CHANNEL: ALUMINUM CHANNEL - ANODIZE PER MIL-A-8625, TYPE II, CLASS 1, OR CONVERSION COAT PER MIL-C-5541. FOR ALCLAD MAT'L ONLY, NO FINISH IS REQUIRED.
  - NUT: CADMIUM PLATED PER AMS-QQ-P-416, TYPE II, CLASS 2. FOR DRY FILM LUBRICATED NUTS THE TYPE AND CLASS ARE OPTIONAL IF THE NUTS MEET THE SALT SPRAY REQUIREMENTS OF AMS-QQ-P-416, TYPE II.
- HEAT TREAT: NUT ELEMENT HARDNESS TO BE 49 HRC MAX.
- LUBRICATION: DRY FILM LUBRICANT APPROVED IN ACCORDANCE WITH NASM25027. NON-DRY FILM LUBRICANTS SHALL BE SOLUBLE IN THE CLEANER SPECIFIED IN MIL-S-8802.
- LENGTH: TO BE STOCKED IN 72 INCHES ONLY.
- THE ASSEMBLY SHALL PROVIDE A BEARING SURFACE FOR THE NUT ELEMENT WITHIN THE HOUSING. THE CHANNEL CENTERLINE SHALL NOT DEVIATE FROM A STRAIGHT LINE BY MORE THAN 0.015" IN ANY 12 INCHES. THE NUT ELEMENT AND BASE PORTION OF THE ASSEMBLY SHALL FORM ONE INTEGRAL UNIT.
- FLOAT OF THE NUT ELEMENT PORTION OF THE ASSEMBLY SHALL NOT BE LESS THAN .030 NOR MORE THAN .040 LONGITUDINALLY AND NOT LESS THAN .010 NOR MORE THAN .030 Laterally FROM THE CENTERED POSITION. NUT ELEMENT SHALL BE CAPABLE OF ENGAGEMENT WITH A BOLT IN THE MAXIMUM MISALIGNMENT POSITION. MAXIMUM AXIAL FLOAT .020 INCH FOR -08 AND -3, .030 FOR LARGER SIZES.
- PROCUREMENT SPECIFICATION: NASM25027.
- REMOVE ALL BURRS AND BREAK SHARP CORNERS.
- THREADS PER AS8879 BEFORE DRY FILM LUBRICATION AND CRIMP.



CONFIGURATION OF NUT AND CHANNEL OPTIONAL  
WITHIN THE LIMITATIONS IMPOSED BY DIMENSIONS  
AND REQUIREMENTS AS SPECIFIED HEREIN



REPRODUCTION OF THIS DRAWING OR MANUFACTURE OF  
THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN  
PERMISSION OF LI SI AEROSPACE MONADNOCK IS PROHIBITED

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ISSUE	ECN NUMBER	DATE
PROJECT No.	0718-006	

ITEM NO.		QTY. REQ'D	PART NO.	DESCRIPTION		MATERIAL OR NOTES				
NEXT ASSEMBLY  END ITEM		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES NOTED FRACTION ANGLES		IBM #	DRAWN BY: DATE TSC 05/04/07	li si AEROSPACE THE MONADNOCK COMPANY 18301 E. ARENTH AVE CITY OF INDUSTRY, CALIFORNIA			TITLE: GANG CHANNEL, LOW HEIGHT, ALUM., SELF-LOCKING, STEEL NUT, 125 KSI Ftu, 250°F (MS21063)	
PREVIOUS ASSEMBLY  —		MATERIAL: NOTED		HEAT TREAT: N/A	ENG. APPROVAL: DATE TSC 05/07/07	QUAL. ACCEPT.: DATE BG 05/07/07	CODE INDENT. NO. 60119	SIZE B	DRAWING NUMBER: 188005()<()-()	
		FINAL PROTECTIVE FINISH: NOTED		MFG. ACCEPT.: DATE JA 05/07/07	SCALE: NONE	SALES		SHEET 1 OF 1		