

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	
800°F	450°F								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	.0071
-3	L3	.1900-32UNJF-3B	.416	.194	.343	.250	.625	.062	.270	.210	.035	2,460	.20	.0071
-4	L4	.2500-28UNJC-3B	.516	.254	.406	.281	.750	.062	.330	.270	.045	4,580	.40	.0084
-5	L5	.3125-24UNJC-3B	.609	.317	.469	.328	.875	.062	.393	.333	.045	7,390	.64	.0146
-6	L6	.3750-24UNJF-3B	.726	.379	.562	.344	1.000	.062	.455	.395	.055	11,450	1.06	.0186

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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 7 () () - ()

BASIC PART NUMBER

FIRST DASH NO. FOR THREAD
SIZE PER TABLE I

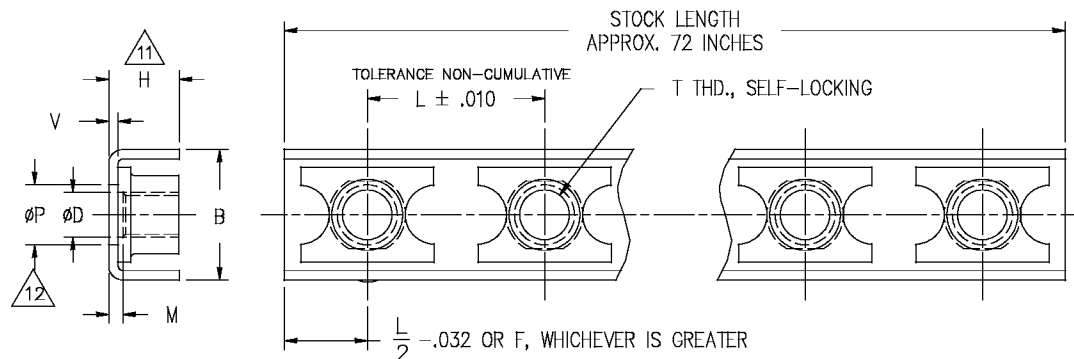
SECOND DASH NO FOR NUT ELEMENT
SPACING PER TABLE II

NUMBER OF NUT ELEMENTS WHEN LESS
THAN STOCK LENGTH IS DESIRED

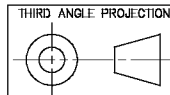
- 11 'H' MAX APPLIES TO NUT ELEMENTS AND CHANNEL.
12 HOLE IN CHANNEL MUST PROVIDE FOR FULL FLOAT
OF NUT ELEMENT BUT NEED NOT BE CIRCULAR

NOTES (UNLESS OTHERWISE SPECIFIED) :

- MATERIAL:
1.1 CHANNEL: CORROSION RESISTANT STEEL
1.2 NUT: A286 CRES PER AMS5525, AMS5735 OR AMS5737.
- FINISH:
2.1 CHANNEL: PASSIVATE PER AMS2700.
- NUT:
2.2.1 450°F NUT ELEMENTS – PASSIVATE PER AMS2700, AND DRY FILM LUBRICANT APPROVED IN ACCORDANCE WITH NASM25027.
2.2.2 800°F NUT ELEMENTS – SILVER PLATED IN ACCORDANCE WITH AMS2410. PLATE THICKNESS MEASURED ON ANY EXTERNAL SURFACE OF THE NUT ELEMENT SHALL NOT BE LESS THAN 0.0002 INCHES. THREADS SHALL SHOW COMPLETE COVERAGE BUT THICKNESS REQUIREMENT ON THREAD IS WAIVED.
- HEAT TREAT: NUT ELEMENT HARDNESS TO BE 49 HRC MAX.
- 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 THAT 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 FINISH AND CRIMP.
- MAGNETIC PERMEABILITY: SHALL BE LESS THAN 2.0 (AIR=1.0) FOR A FIELD STRENGTH H=200 OERSTEDS USING A MAGNETIC PERMEABILITY INDICATOR PER MIL-I-17214 OR EQUIVALENT.



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.	0718-011	

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 NOTED		IBM #	DRAWN BY: DATE		lisi AEROSPACE THE MONADNOCK COMPANY 18301 E. ARENTH AVE CITY OF INDUSTRY, CALIFORNIA TITLE: GANG CHANNEL, LOW HEIGHT, CRES, SELF-LOCKING NUT, A286, 125 KSI Ftu (MS21065)				
				TSC 05/07/07						
PREVIOUS ASSEMBLY —	HEAT TREAT: N/A		ENG. APPROVAL: DATE		CODE IDENT. NO.		SIZE	DRAWING NUMBER:		
			TSC 05/07/07							
FINAL PROTECTIVE FINISH: NOTED		QUAL. ACCEPT.: DATE		60119		B	188007(())-()			
		MFG. ACCEPT.: DATE								
		JA 05/07/07		SCALE: NONE		SALES		SHEET 1 OF 1		