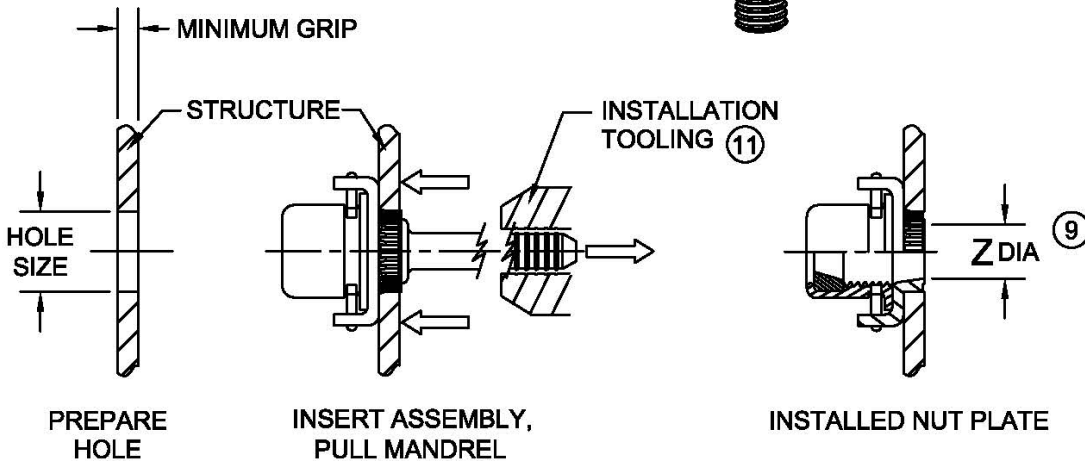
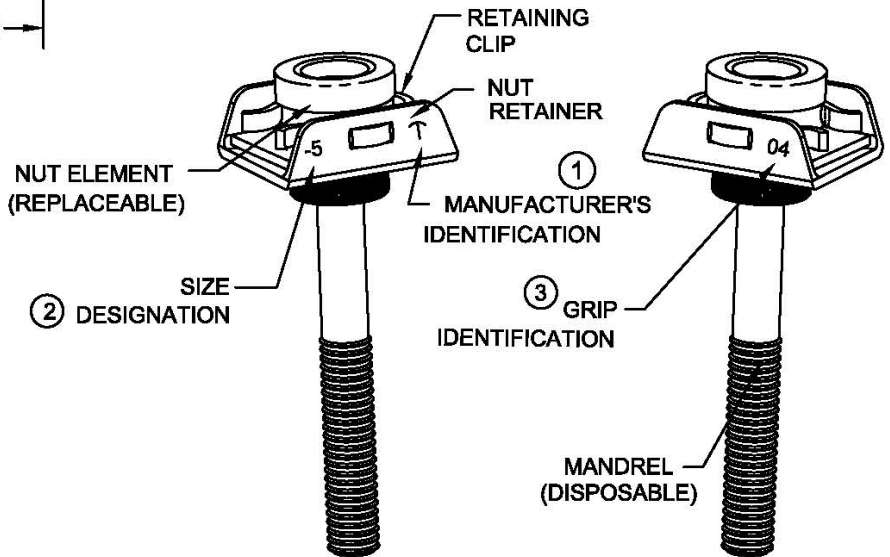
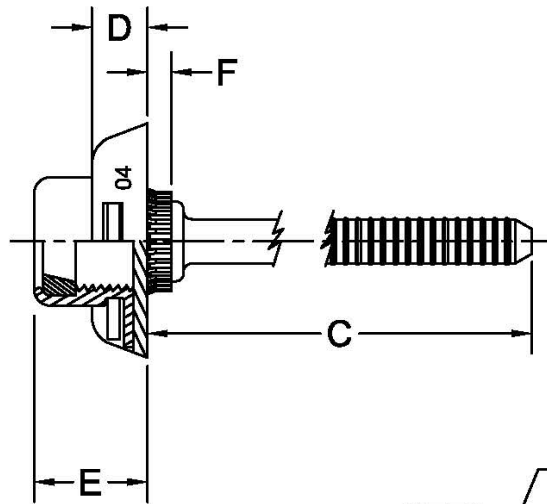
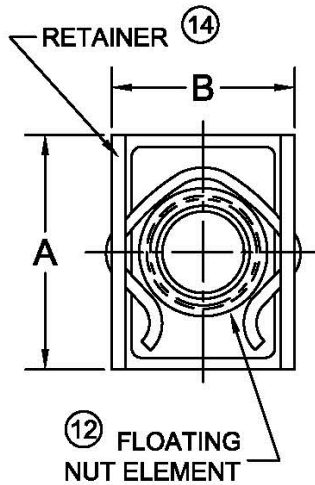




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NUT PLATE INSTALLATION SEQUENCE

NOTICE: ALL DIMENSIONS ARE IN INCHES AND APPLY AFTER FINISH AND BEFORE LUBRICATION UNLESS OTHERWISE SPECIFIED.

WARNING: FASTENERS MAY NOT PERFORM PROPERLY IF ALTERED FROM THE MANUFACTURER'S AS-SHIPPED CONDITION OR INSTALLED IN CONDITIONS OTHER THAN SPECIFIED HEREIN.

PROCUREMENT SPECIFICATION:

NASM25027

CHERRY® RIVETLESS NUT-PLATE
0.012 INCH BOLT CLEARANCE
FOR ALUMINUM ALLOY, 250° MAX

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TABLE I: ASSEMBLY DIMENSIONS

NUT DESIGNATION	THREAD SIZE ⑩	A MAX	B MAX	C REF	D REF	E MAX	Z ⑨	INSTALLATION HOLE SIZE
-5	.3125-24UNJF-3B	.680	.630	1.400	.265	.405	.322 .329	.362 .358

TABLE II: RETAINER GRIP SELECTION

RETAINER GRIP DASH NO.	MINIMUM GRIP	F REF	MAXIMUM GRIP
-04	.190	.170	.250

TABLE III: MECHANICAL PROPERTIES

NUT DESIGNATION	RETAINER GRIP DASH NO.	NUT ELEMENT PER NAS1794		ASSEMBLY MECHANICAL PROPERTIES ⑤	
		AXIAL TENSILE STRENGTH OF ALLOY STEEL AND CRES AT ROOM TEMPERATURE (lbf, MIN)		TORQUE-OUT (in-lbf, MIN)	PUSH-OUT (lbf, MIN)
-5	-04	7390		160	125

TABLE IV: MATERIAL AND FINISH ⑦

NUT				NUT LOCK INSERT MAT'L	RETAINER ⑧			MANDREL		RETAINING CLIP	
MAT'L CODE	MAT'L	FINISH CODE	FINISH		MAT'L	FINISH CODE	FINISH	MAT'L	FINISH ⑮	MAT'L	FINISH
A	CARBON STEEL GRADE 1008, 1035, 1042, 1137, 1141. ALLOY STEEL GRADE 4130	NO CODE	CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2, DRY FILM LUBRICANT PER NASM25027 OR WITH LUBRICANT SOLUBLE IN CLEANER SPECIFIED IN MIL-S-8802	NYLON PER ASTM D4066, GROUP 1, CLASS 1 OR 2	A286 CRES PER AMS5525	CC	ALUMINUM COAT PER NAS4006	A286 CRES PER AMS5731	PARTIALLY COPPER COATED OR PASSIVATE PER AMS2700	XM-28 PER ASTM A313 OR 302 CRES PER AMS5688	PASSIVATE PER AMS 2700

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NOTES:

- ① MANUFACTURER'S IDENTIFICATION LETTER "T" STAMPED ON RETAINER.
- ② FASTENER SIZE DESIGNATION STAMPED ON RETAINER, OPTIONAL.
- ③ FASTENER GRIP IDENTIFICATION STAMPED ON RETAINER.
- 4. ALL DIMENSIONS ARE IN INCHES.
- ⑤ TORQUE-OUT AND PUSH-OUT VALUES APPLY TO ASSEMBLIES INSTALLED IN THE RECOMMENDED HOLE SIZE IN 2024-T3, 7075-T73, OR AN EQUIVALENT STRENGTH ALUMINUM ALLOY..
- 6. VIBRATION LIFE: MINIMUM VIBRATION LIFE REQUIREMENTS SHALL BE THREE TIMES AVERAGE VIBRATION LIFE LISTED IN SPECIFICATION NASM25027..
- ⑦ MATERIAL DESIGNATION REFERS TO CHEMICAL COMPOSITION ONLY PER APPROPRIATE SPECIFICATION.
- ⑧ "CC" SUFFIX INDICATES RETAINER WITH CORROSION RESISTANT ALUMINUM COATING.
- ⑨ "Z" IS I.D. OF NUT RETAINER AFTER INSTALLATION.
- ⑩ THREADS IN ACCORDANCE WITH SAE AS8879 BEFORE THREAD LOCK AND LUBRICATION.
- ⑪ USE CHERRY INSTALLATION TOOL, ADAPTER, AND PULLING HEAD AS SHOWN IN TABLE BELOW, OR CONSULT CHERRY AEROSPACE FOR OTHER INSTALLATION TOOLING OPTIONS.

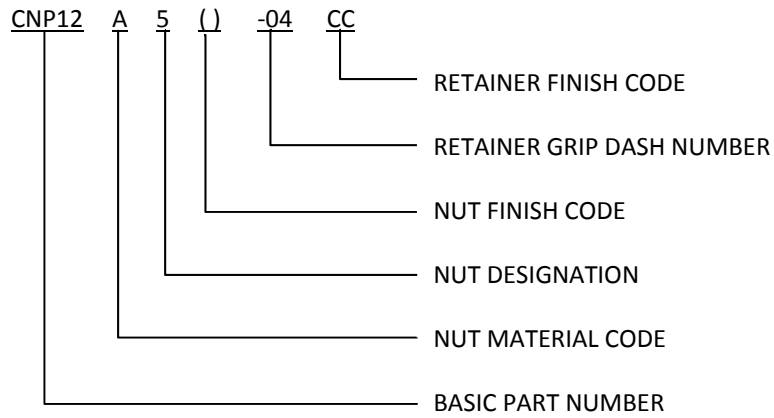
FASTENER DIAMETER DESIGNATION	INSTALLATION TOOL	PULLING HEAD
-5	G84-LS	H725-5-12M

- ⑫ FLOAT OF NUT ELEMENT OF ASSEMBLY SHALL NOT BE LESS THAN .010 INCH RADIALLY FROM CENTERED POSITION. NUT ELEMENT SHALL BE CAPABLE OF ENGAGEMENT WITH BOLT IN THE MAXIMUM MISALIGNED POSITION.
- 13. THE NUT ELEMENT IS PER NASM21077-5.
- ⑭ RETAINER BASE CONFIGURATION OPTIONAL WITHIN THE LIMITS OF DIMENSIONS "A" AND "B".
- ⑮ OPTIONAL: LUBE MAY BE APPLIED TO MANDREL FOR PERFORMANCE.

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EXAMPLE OF CHERRY PART NUMBER:



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STANDARDS PAGE REVISION LOG

CNP12

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
L	7-01-15	14-1302	GENERAL CLEANUP AND STANDARDIZATION	MC