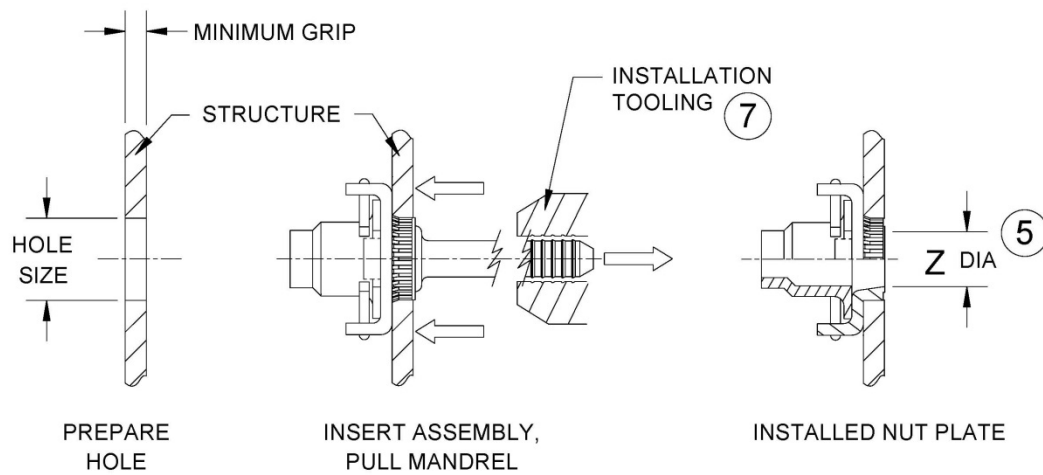
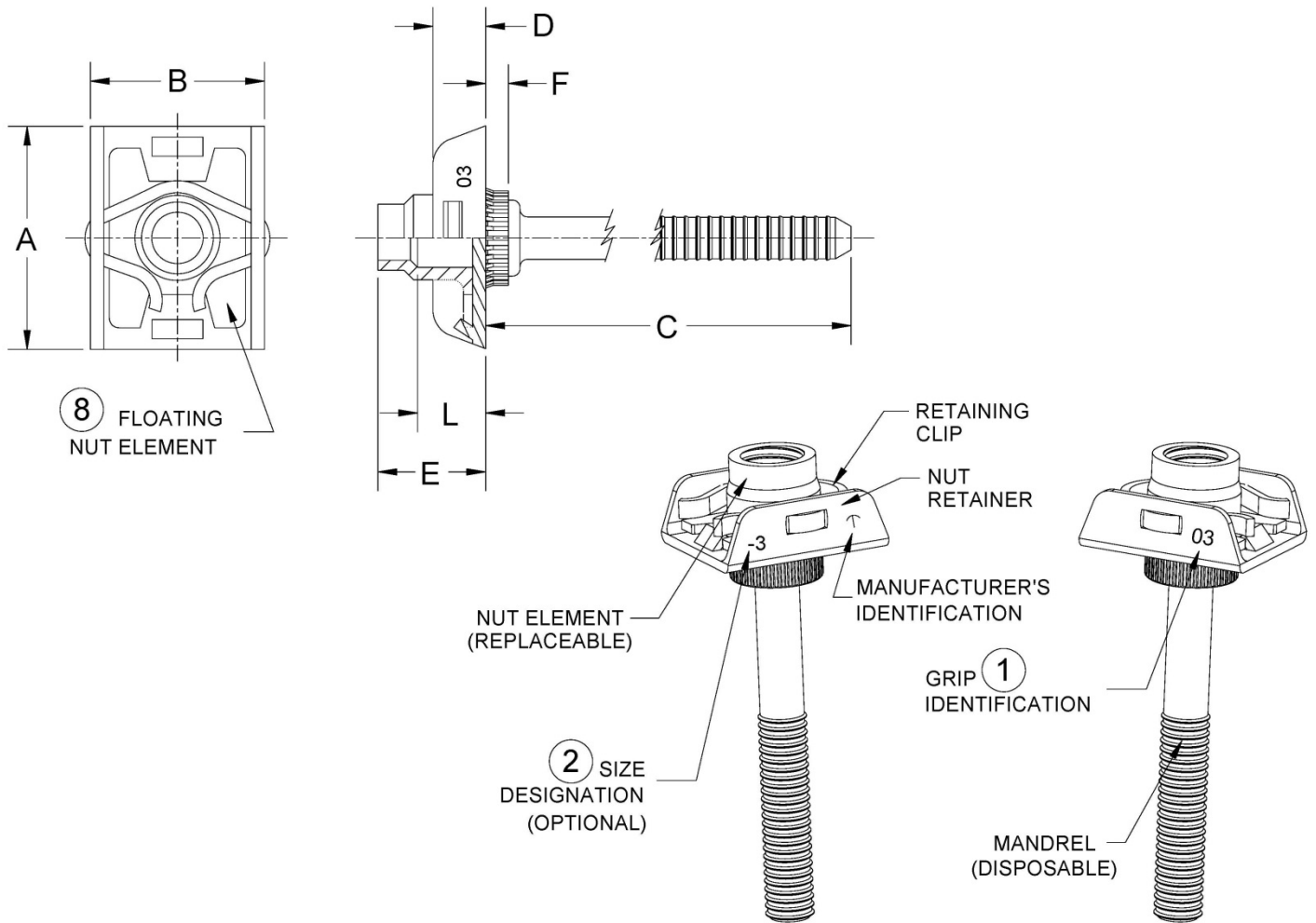




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NUT PLATE INSTALLATION SEQUENCE

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-SHIPED CONDITION OR INSTALLED IN CONDITIONS OTHER THAN SPECIFIED HEREIN.

PROCUREMENT SPECIFICATION:

NASM25027 (3)

CHERRY® RIVETLESS NUT-PLATE
0.024 INCH BOLT CLEARANCE

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TABLE I: ASSEMBLY DIMENSIONS

NUT DESIGNATION	NUT ELEMENT – NAS1794			A MAX	B MAX	C REF	D REF	E MAX	Z MIN ⑤	INSTALLATION HOLE SIZE	RETAINING CLIP
	THREAD SIZE ⑥	C'BORE DASH NO.	L MIN								
-3	.1900-32 UNJF-3B	-1	.074	.595	.490	1.450	.245	.260	.214	.249-.253	NAS1795-3
		-2	.135								
		-3	.198								
		-4	.260								
		-5	.323								

TABLE II: RETAINER GRIP SELECTION

RETAINER GRIP DASH NO.	MINIMUM GRIP	F REF	MAXIMUM GRIP
-01	.040	.032	BASED ON CUSTOMER APPLICATION.
-02	.062	.055	
-03	.125	.110	CONSULT CHERRY FOR OPTIONS.

TABLE III: MECHANICAL PROPERTIES

NUT DESIGNATION	RETAINER GRIP DASH NO.	NUT ELEMENT PER NAS1794	ASSEMBLY MECHANICAL PROPERTIES ③	
		AXIAL TENSILE STRENGTH OF ALLOY STEEL AND CRES AT ROOM TEMPERATURE (lbf, MIN)	TORQUE-OUT (in-lbf, MIN)	PUSH-OUT (lbf, MIN)
-3	-01	2825	40	75
	-02 & LONGER		60	100

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TABLE IV: MATERIAL AND FINISH ④

NUT				RETAINER			MANDREL		RETAINING CLIP	
MATERIAL CODE	MATERIAL	FINISH CODE	FINISH	MATERIAL	FINISH CODE	FINISH	MATERIAL	FINISH ⑩	MATERIAL	FINISH
C	A286 CRES PER AMS 5525, AMS 5732, OR AMS 5737	---	PASSIVATE PER AMS 2700 AND DRY FILM LUBE PER NASM25027	A286 CRES PER AMS 5525	---	PASSIVATE PER AMS 2700	A286 CRES PER AMS 5731	PASSIVATE PER AMS 2700	XM-28 PER ASTM-A-313	PASSIVATE PER AMS 2700
					CC	ALUM. COAT PER NAS 4006				
					GCC ⑪	ALUM. COAT PER NAS 4006 CLASS NC				
		EV	PASSIVATE PER AMS 2700 AND DRY FILM LUBRICATION PER PWA-36545-3		---	PASSIVATE PER AMS 2700				
					CC	ALUM. COAT PER NAS 4006				
					GCC ⑪	ALUM. COAT PER NAS 4006 CLASS NC				
		P	SILVER PLATE PER AMS 2410 .0002 MIN THICKNESS		---	PASSIVATE PER AMS 2700				
					CC	ALUM. COAT PER NAS 4006				
					GCC ⑪	ALUM. COAT PER NAS 4006 CLASS NC				
A	ALLOY OR CARBON STEEL, HEAT TREATED	---	CAD. PLATE PER AMS-QQ-P-416 CL 1 OR 2 AND DRY FILM LUBE PER NASM25027	---	PASSIVATE PER AMS 2700					
				CC	ALUM. COAT PER NAS 4006					

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NOTES:

- ① FASTENER GRIP IDENTIFICATION STAMPED ON RETAINER. RETAINERS WITHOUT GRIP IDENTIFICATION MAY BE USED UNTIL STOCK IS DEPLETED.
- ② FASTENER SIZE DESIGNATION STAMPED ON RETAINER, OPTIONAL.
- ③ 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. -01 RETAINER GRIP TORQUE-OUT AND PUSH-OUT VALUES TO BE TABULATED IN MECHANICAL PROPERTIES TABLE. TEST PER NASM25027.
- ④ MATERIAL DESIGNATION REFERS TO CHEMICAL COMPOSITION ONLY.
- ⑤ "Z" IS THE EXPECTED INTERNAL DIAMETER OF THE RETAINER AFTER INSTALLATION; UP TO .005" SMALLER MEASUREMENT IS ACCEPTABLE.
- ⑥ THREADS IN ACCORDANCE WITH SAE AS 8879 BEFORE THREAD LOCK AND LUBRICATION.
- ⑦ USE CHERRY® INSTALLATION TOOL, ADAPTER, AND PULLING HEAD AS SHOWN BELOW, OR CONSULT CHERRY AEROSPACE LLC FOR OTHER INSTALLATION TOOLING OPTIONS.

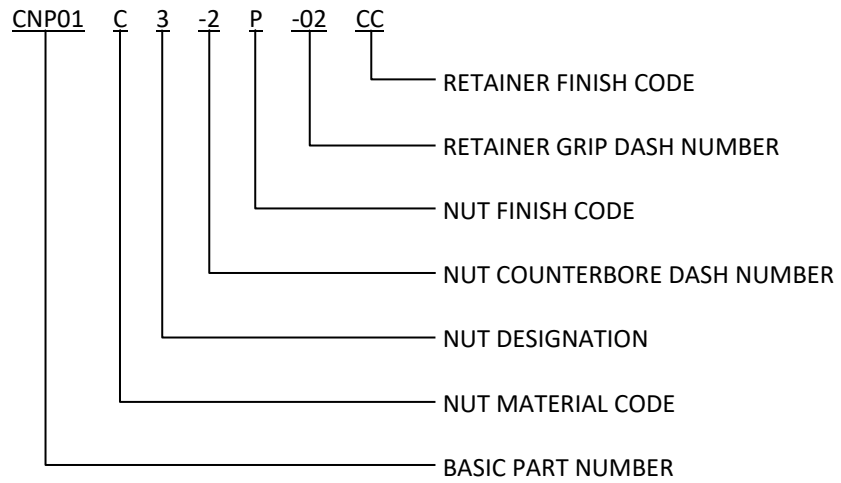
NUT DESIGNATION	INSTALLATION TOOL	PULLING HEAD
-3	G704B	H704-249NP
	G800	

- ⑧ FLOAT OF NUT ELEMENT OF ASSEMBLY SHALL NOT BE LESS THAN .012 INCH RADIALLY FROM CENTERED POSITION. NUT ELEMENT SHALL BE CAPABLE OF ENGAGEMENT WITH BOLT IN THE MAXIMUM MISALIGNED POSITION.
- 9. IN MINIMUM GRIP INSTALLATIONS, ANY BURRS WHICH EXTEND BEYOND THE BACK SIDE OF THE STRUCTURE MAY BE REMOVED BY DEBURRING.
- ⑩ OPTIONAL: LUBE MAY BE APPLIED TO THE MANDREL FOR PERFORMANCE.
- ⑪ FINISH CODES WITH THE PREFIX "G" INDICATE REACH COMPLIANT COATING.

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EXAMPLE OF CHERRY PART NUMBER:



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STANDARDS PAGE REVISION LOG

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REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
AH	28 Sep 20	20-0377	• REVISED NOTE ⑤	AA