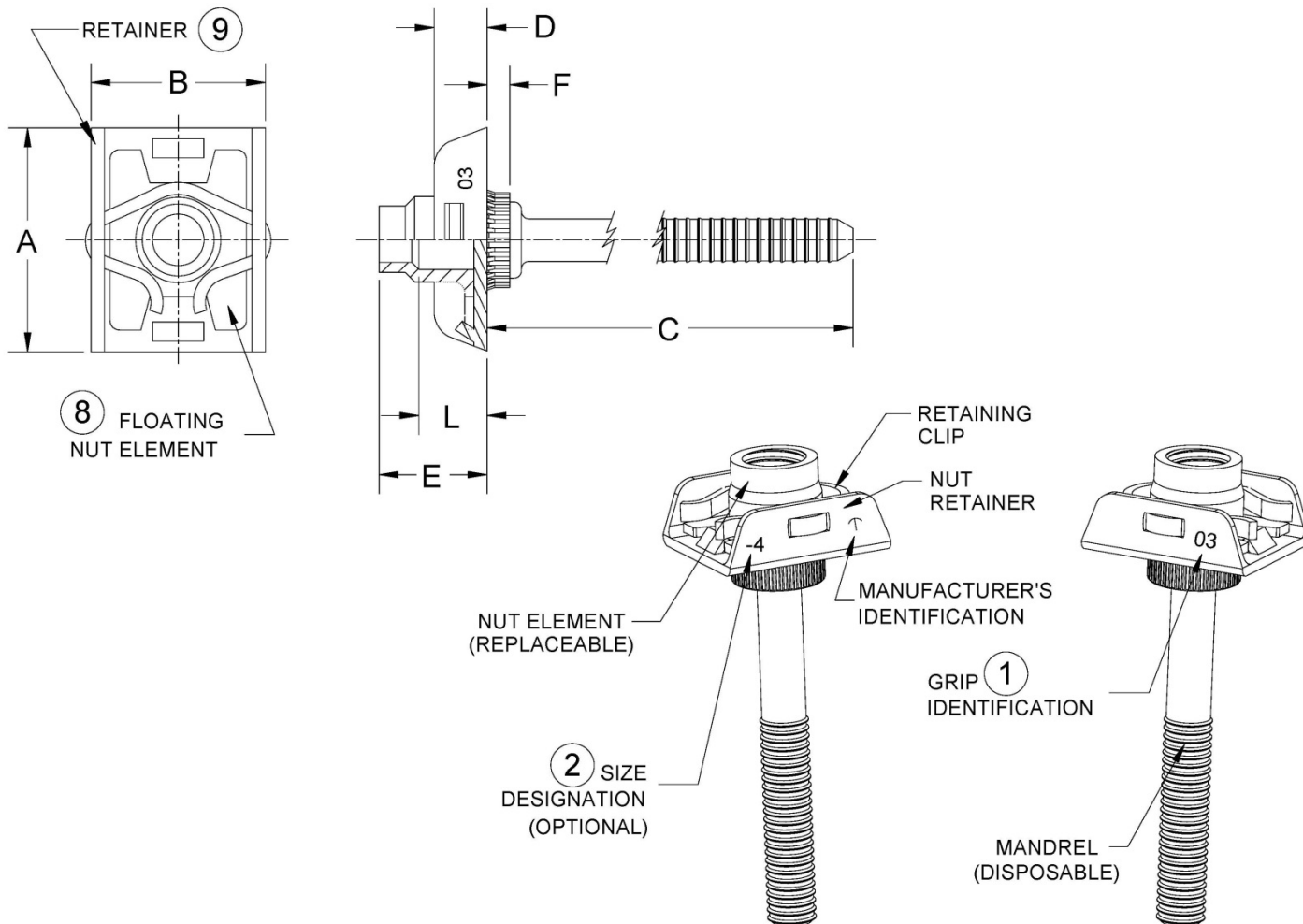




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**NUT PLATE INSTALLATION SEQUENCE**

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 (3)

**CHERRY® RIVETLESS NUT-PLATE**  
0.060 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								
-4	.2500-28 UNJF-3B	-2	.135	.740	.595	1.375	.265	.365	.310	.343/.347	NAS1795-4

**TABLE II: RETAINER GRIP SELECTION**

RETAINER GRIP DASH NO.	MINIMUM GRIP	F REF	MAXIMUM GRIP
-03	.125	.120	BASED ON CUSTOMER APPLICATION.  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)
-4	-03	5060	100	125

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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	CC	ALUM. COAT PER NAS 4006	A286 CRES PER AMS 5731	PASSIVATE PER AMS 2700	XM-28 PER ASTM-A-313	PASSIVATE PER AMS 2700
			GCC ⑪		ALUM. COAT PER NAS 4006 CLASS NC					
		EV	PASSIVATE PER AMS 2700 AND DRY FILM LUBRICANT PER PWA-36545-3		CC	ALUM. COAT PER NAS 4006				
			GCC ⑪		ALUM. COAT PER NAS 4006 CLASS NC					

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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 ASSEMBLY TORQUE-OUT AND PUSH-OUT PER PWA-384. VALUES APPLY TO ASSEMBLIES INSTALLED IN THE RECOMMENDED HOLE SIZE IN 2024-T3, 7075-T73, OR AN EQUIVALENT STRENGTH ALUMINUM ALLOY.
- 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.

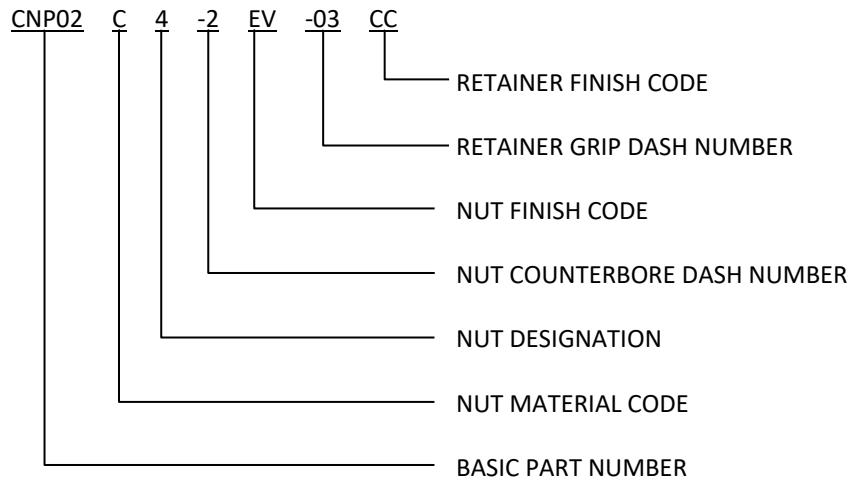
NUT DESIGNATION	INSTALLATION TOOL	PULLING HEAD
-4	G704B	H704-343NP
	G800	

- ⑧ FLOAT OF NUT ELEMENT OF ASSEMBLY SHALL NOT BE LESS THAN .030 INCH RADIALLY FROM CENTERED POSITION. NUT ELEMENT SHALL BE CAPABLE OF ENGAGEMENT WITH BOLT IN THE MAXIMUM MISALIGNED POSITION.
- ⑨ RETAINER BASE CONFIGURATION OPTIONAL WITHIN THE LIMITS OF DIMENSIONS "A" AND "B".
- 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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REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
AG	28 Sep 20	20-0377	• REVISED NOTE ⑤	AA