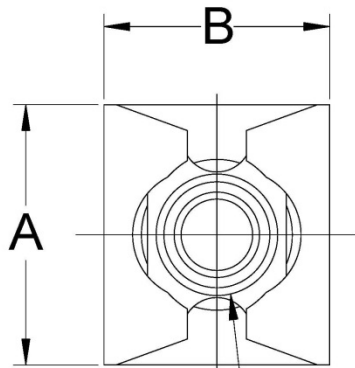
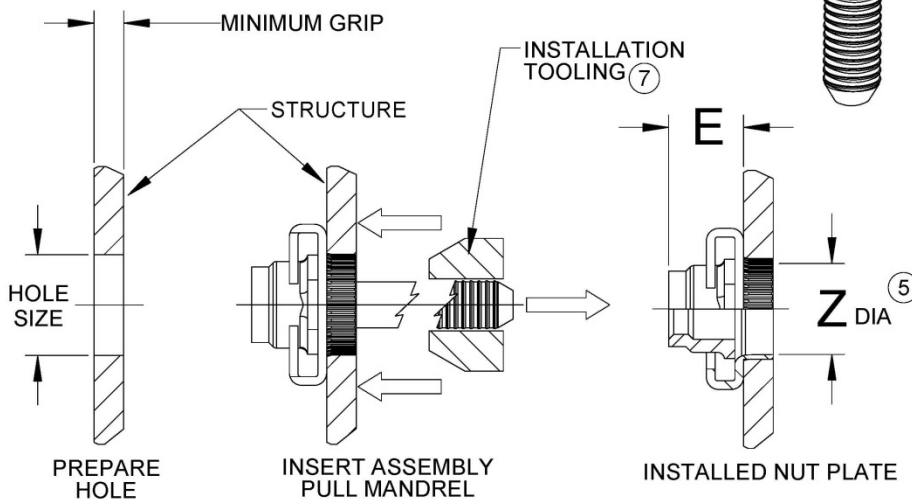
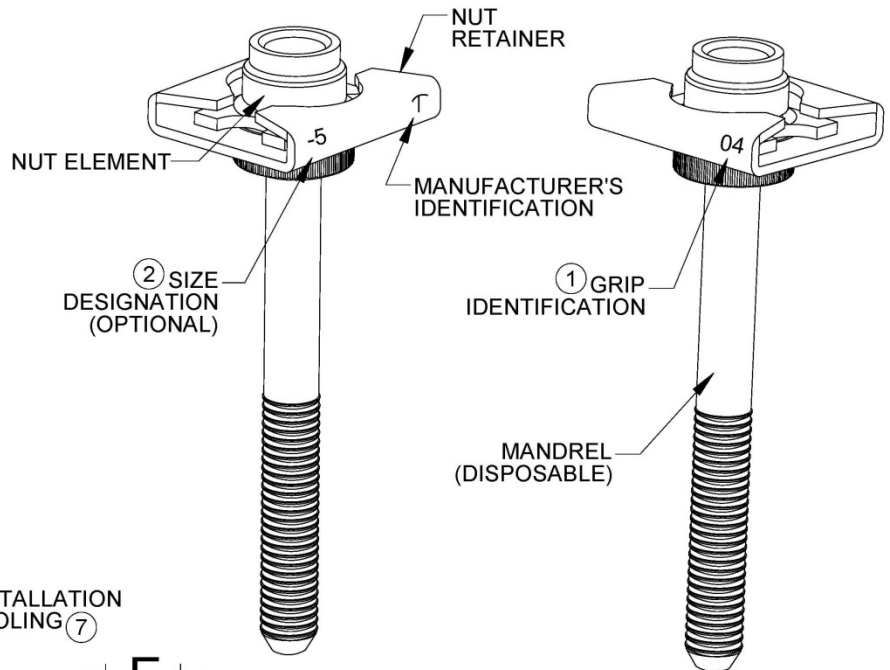
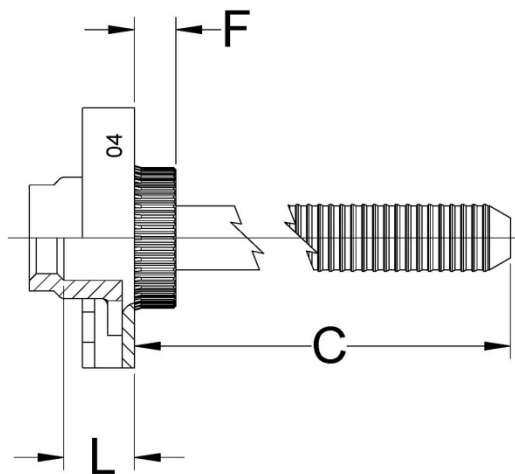




PRINTED COPIES OF THIS DOCUMENT ARE FOR "REFERENCE" ONLY. CURRENT REVISIONS ARE AVAILABLE ONLINE.



⑧ FLOATING NUT ELEMENT



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**  
0.060 INCH BOLT CLEARANCE

SHEET 1 OF 5

PART NUMBER

ISSUE

01-29-04

**CNP04**

REV.

AA

29 Sep 20



**TABLE I: ASSEMBLY DIMENSIONS**

NUT DESIGNATION	NUT ELEMENT – NAS1794			A MAX	B MAX	C REF	E MAX	Z MIN ⑤	INSTALLATION HOLE SIZE
	THREAD SIZE ⑥	C'BORE DASH NO.	L MIN						
-5	.3125-24 UNJF-3B	-1	.071	.775	.665	1.400	.344	.373	.404-.408
		-2	.135				.400		
		-3	.198				.461		
		-4	.260				.524		
		-5	.323				.586		

**TABLE II: RETAINER GRIP SELECTION**

RETAINER GRIP DASH NO.	MINIMUM GRIP	F REF	MAXIMUM GRIP
-03	.125	.110	BASED ON CUSTOMER APPLICATION.  CONSULT CHERRY FOR OPTIONS.
-04	.190	.170	

**TABLE III: MECHANICAL PROPERTIES**

NUT DESIGNATION	RETAINER GRIP DASH NO.	NUT ELEMENT PER NAS1794	ASSEMBLY MECHANICAL PROPERTIES ③	
		AXIAL TENSILE STRENGTH OF CRES AT ROOM TEMPERATURE (lbf, MIN)	TORQUE-OUT (in-lbf, MIN)	PUSH-OUT (lbf, MIN)
-5	ALL GRIPS	7390	160	125

SHEET 2 OF 5			PART NUMBER	
ISSUE	01-29-04		<b>CNP04</b>	
REV.	AA	29 Sep 20		



**TABLE IV: MATERIAL AND FINISH ④**

NUT				RETAINER			MANDREL	
MATERIAL CODE	MATERIAL	FINISH CODE	FINISH	MATERIAL	FINISH CODE	FINISH	MATERIAL	FINISH ⑩
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
					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		

SHEET 3 OF 5			PART NUMBER	
ISSUE	01-29-04		CNP04	
REV.	AA	29 Sep 20		



**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.
- 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.

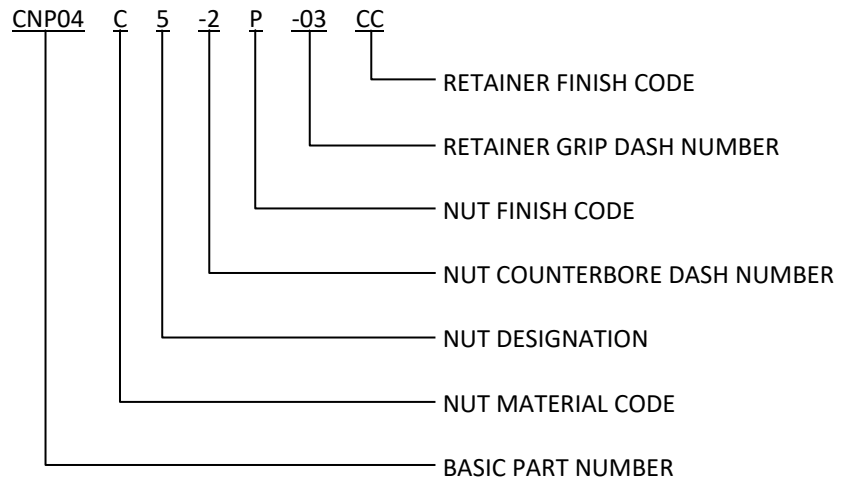
NUT DESIGNATION	INSTALLATION TOOL	PULLING HEAD
-5	G84	H84C-404NP

- 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.

SHEET 4 OF 5		PART NUMBER
ISSUE	01-29-04	
REV.	AA	29 Sep 20
<b>CNP04</b>		



### EXAMPLE OF CHERRY PART NUMBER:



SHEET 5 OF 5		PART NUMBER
ISSUE	01-29-04	CNP04
REV.	AA 29 Sep 20	

**STANDARDS PAGE REVISION LOG**

**CNP04**

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
AA	29 Sep 20	20-0377	• REVISED NOTE ⑤	AA