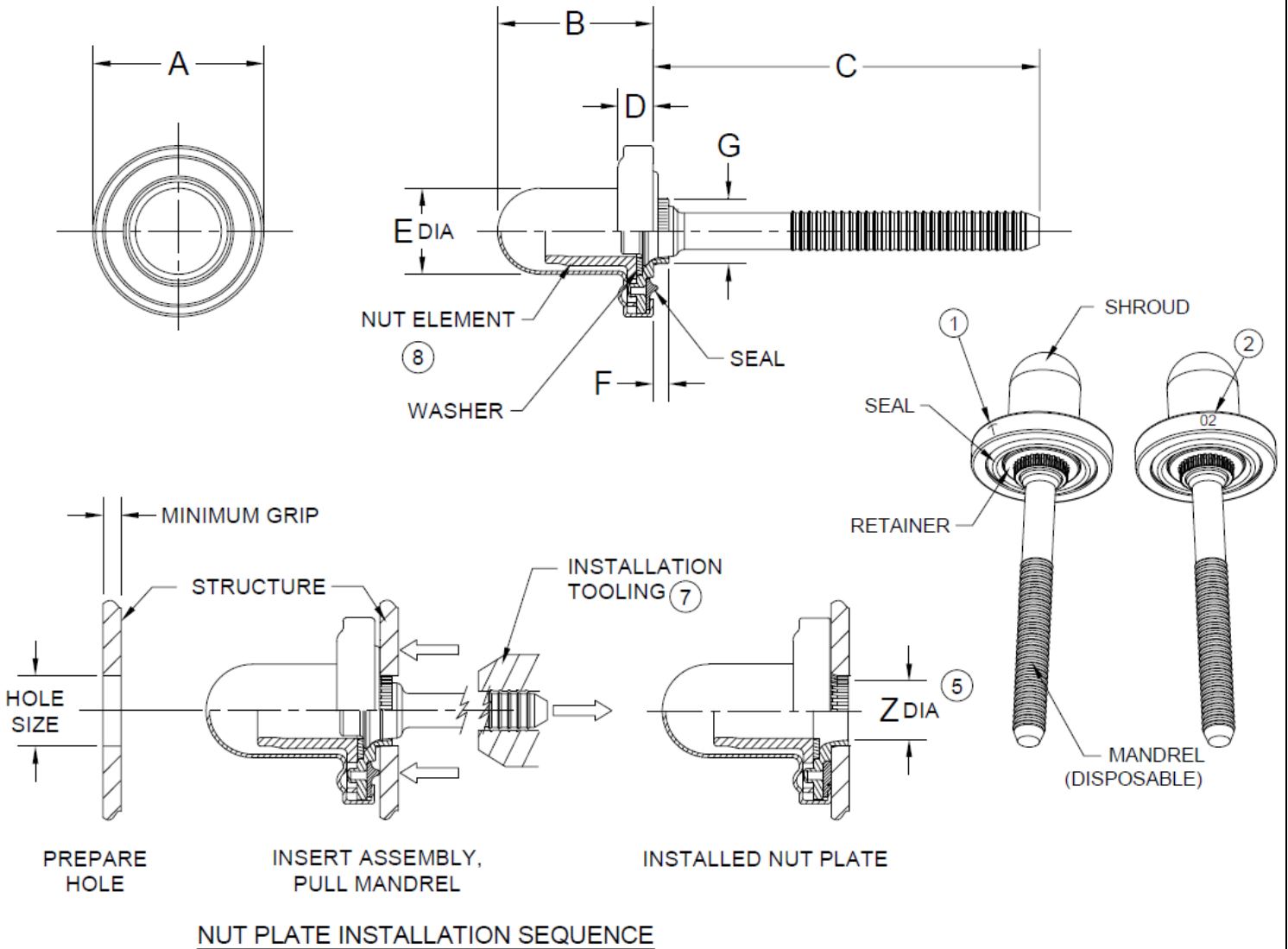




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ASSEMBLY DIMENSIONS

NUT DESIGNATION	NUT ELEMENT	A	B	C	D	E	G	Z	INSTALLATION HOLE SIZE
	THREAD SIZE (6)	MAX	MAX	REF	MAX	MAX	REF	MIN	
-3	.1900-32UNJF-3B	.670	.650	1.400	.175	.330	.250	.218	.249/.253

SEE SHEET 2 FOR F DIMENSIONS

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) (11)	CHERRY® RIVETLESS NUT-PLATE SEALING VERSION 0.030 INCH TOTAL FLOAT	SHEET 1 OF 4		PART NUMBER
NAS 523 CODE: ---		ISSUE	2-27-06	CNP05
		REV.	T 04-30-19	



NUT PLATE GRIP SELECTION

RETAINER GRIP DASH NO.	MINIMUM GRIP (in)	F REF	MAXIMUM GRIP
-02 ^⑩	.062	.055	BASED ON CUSTOMER APPLICATION. CONSULT CHERRY FOR OPTIONS

MECHANICAL PROPERTIES

NUT DESIGNATION AND RETAINER GRIP DASH NO.		NUT ELEMENT		ASSEMBLY MECHANICAL ^③ PROPERTIES	
NUT DESIGNATION	RETAINER GRIP DASH NO.	THREAD SIZE ^⑥	AXIAL TENSILE STRENGTH OF ALLOY STEEL AND CRES AT ROOM TEMPERATURE (lbf, MINIMUM)	TORQUE-OUT (in-lbf, MINIMUM)	PUSH-OUT (lbf, MINIMUM)
				-3	-02

④ MATERIAL AND FINISH

BASIC PART NO.	NUT				RETAINER			MANDREL	
	MAT'L CODE	MAT'L	FINISH CODE	FINISH	MAT'L	FINISH CODE	FINISH	MAT'L	FINISH ^⑭
CNP05	C	A286 CRES PER AMS5525, AMS5732, OR AMS5737	NO CODE	PASSIVATE PER AMS 2700 AND DRY FILM LUBE PER NASM25027	A286 CRES PER AMS5525	NO CODE	PASSIVATE PER AMS 2700	A286 CRES PER AMS5731	PARTIALLY COPPER COATED OR PASSIVATE PER AMS 2700

SHROUD		SEAL		WASHER	
MATERIAL	FINISH	MATERIAL	FINISH	MATERIAL	FINISH
304 CRES PER AMS 5513 AND ASTM-A-240	PASSIVATE PER AMS 2700	FLUORO-SILICONE RUBBER PER MIL-R-25988	NONE	POLYPHTHALIMIDE (PPA) PER ASTM-D-5336 GROUP 1, CLASS 1, GRADE 1	NONE

SHEET 2 OF 4			PART NUMBER	
ISSUE	2-27-06		CNP05	
REV.	T	04-30-19		

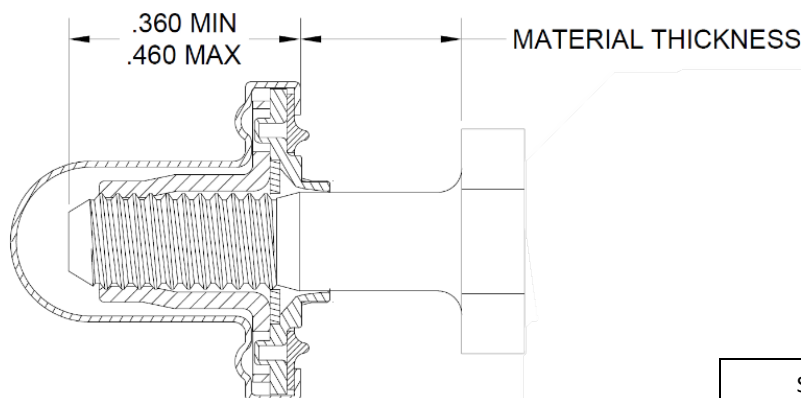


NOTES:

- ① MANUFACTURER'S IDENTIFICATION LETTER "T" STAMPED ON SHROUD
- ② GRIP IDENTIFICATION STAMPED ON SHROUD
- ③ TORQUE-OUT AND PUSH-OUT VALUES APPLY TO ASSEMBLIES INSTALLED IN THE RECOMMENDED HOLE SIZE IN 2024-T3, 7075-T6, OR AN EQUIVALENT STRENGTH ALUMINUM ALLOY.
- ④ MATERIAL DESIGNATION REFERS TO CHEMICAL COMPOSITION ONLY PER APPROPRIATE SPECIFICATION
- ⑤ "Z" IS MINIMUM I.D. OF RETAINER AFTER INSTALLATION
- ⑥ THREADS IN ACCORDANCE WITH SAE AS8879 BEFORE THREAD LOCK AND LUBRICATION
- ⑦ USE CHERRY® INSTALLATION TOOL AND PULLING HEAD AS SHOWN IN TABLE BELOW, OR CONSULT CHERRY AEROSPACE FOR OTHER INSTALLATION TOOLING OPTIONS:

FASTENER DIAMETER	INSTALLATION TOOL	PULLING HEAD
-3	G704B	H704-249NP
	G800	H704-249NP

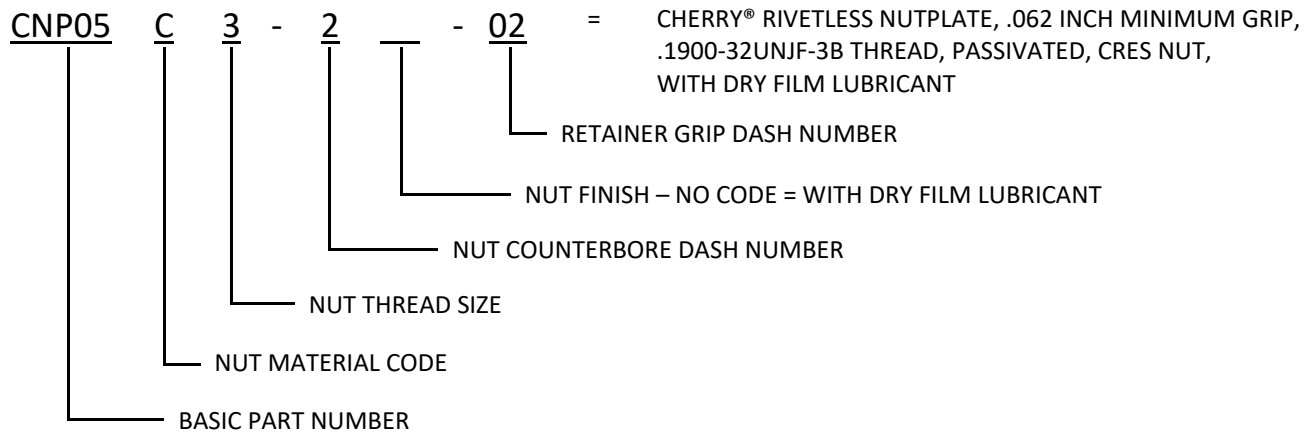
- ⑧ FLOAT OF NUT ELEMENT OF ASSEMBLY SHALL NOT BE LESS THAN .015 INCH RADIALLY FROM CENTERED POSITION. NUT ELEMENT SHALL BE CAPABLE OF ENGAGEMENT WITH BOLT IN THE MAXIMUM MISALIGNED POSITION.
- 9. ALL DIMENSIONS ARE IN INCHES
- ⑩ IN MINIMUM GRIP INSTALLATIONS, ANY BURRS WHICH EXTEND BEYOND THE BACK SIDE OF THE STRUCTURE MAY BE REMOVED BY DEBURRING.
- ⑪ PRODUCT QUALIFIED TO QUALIFICATION TEST REQUIREMENTS OF NAS1473 AND NAS1474.
- 12. **CAUTION:** THIS PRODUCT IS INTENDED TO HAVE A BOLT FULLY ENGAGED AT ALL TIMES. FAILURE TO DO SO MAY COMPROMISE THE SEALING INTEGRITY OF THE ASSEMBLY.
- 13. RECOMMENDED BOLT LENGTH: MATERIAL THICKNESS PLUS .330 MIN TO .460 MAX WILL PROVIDE FULL THREAD ENGAGEMENT:
- ⑭ OPTIONAL: LUBE MAY BE APPLIED TO MANDREL FOR PERFORMANCE.



SHEET 3 OF 4		PART NUMBER
ISSUE	2-27-06	
REV.	T	04-30-19
CNP05		



EXAMPLE OF CHERRY PART NUMBER:



SHEET 4 OF 4		PART NUMBER
ISSUE	2-27-06	CNP05
REV.	T 04-30-19	

STANDARDS PAGE REVISION LOG

CNP05

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
T	04-30-19	19-0224	• SHEET 1 – CHANGED DIA. Z FROM MAX. TO MIN.	AA