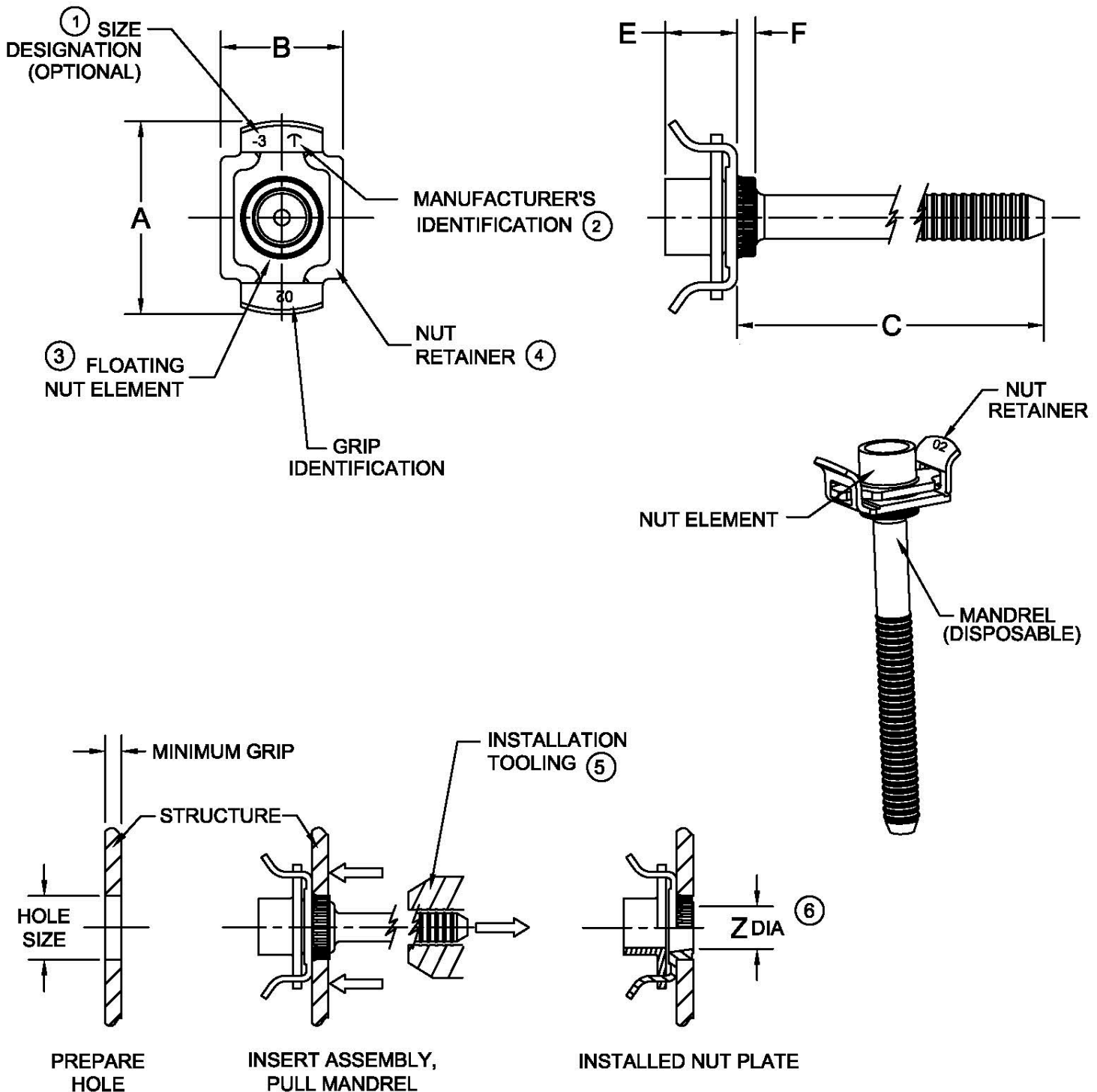




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**NUT PLATE INSTALLATION SEQUENCE**

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  NAS 523 CODE:	CHERRY® LIGHTWEIGHT RIVETLESS NUT-PLATE 0.030 INCH BOLT CLEARANCE	SHEET 1 OF 4		PART NUMBER
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**TABLE I: ASSEMBLY DIMENSIONS**

NUT DESIGNATION	THREAD SIZE ⑦	A MAX	B MAX	C		E MAX	Z ⑥	INSTALLATION HOLE SIZE
				STD LENGTH	SHORT LENGTH			
-3	.1900-32UNJF-3B	.650	.405	1.450	1.100	.260	.218	.253 .249
-4	.2500-28UNJF-3B	.700	.500	1.375	1.100	.320	.280	.315 .311

**TABLE II: RETAINER GRIP SELECTION**

RETAINER GRIP DASH NO.	MINIMUM GRIP	F REF		MAXIMUM GRIP
		-3	-4	
-01 ⑧ ⑩	.040	.036	---	BASED ON CUSTOMER APPLICATION. CONSULT CHERRY FOR OPTIONS
-02	.062	.055	.055	
-03	.125	.110	.110	
-04	.190	---	.170	

**TABLE III: MECHANICAL PROPERTIES**

NUT DESIGNATION	RETAINER GRIP DASH NO.	NUT ELEMENT PER NAS1794		ASSEMBLY MECHANICAL PROPERTIES ⑧	
		AXIAL TENSILE STRENGTH OF ALLOY STEEL AND CRES AT ROOM TEMPERATURE (lbf, MIN)		TORQUE-OUT (in-lbf, MIN)	PUSH-OUT (lbf, MIN)
-3	-01	2460		40	75
	-02 & LONGER			60	100
-4	ALL GRIPS	4580		100	125

**TABLE IV: MATERIAL AND FINISH ⑨**

NUT				RETAINER			MANDREL	
MATERIAL CODE	MATERIAL	FINISH CODE	FINISH	MATERIAL	FINISH CODE	FINISH	MATERIAL	FINISH ⑪
A	STEEL AISI 1050 PER AMS5085 OR AIAI 4130 PER AMS6351	NO CODE	CAD-PLATE PER AMS-QQ-P-416 AND DRY FILM LUBE PER NASM25027	A-286 CRES PER AMS5525	NO CODE	PASSIVATE PER AMS2700	A-286 CRES PER AMS5525	PARTIALLY COPPER COATED OR PASSIVATE PER AMS2700
					CC	ALUMINUM COAT PER NAS 4006		

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**NOTES:**

- ① FASTENER DIAMETER DESIGNATION STAMPED ON RETAINER, OPTIONAL.
- ② MANUFACTURER'S IDENTIFICATION LETTER "T" STAMPED ON RETAINER.
- ③ 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.
- ④ RETAINER BASE CONFIGURATION IS OPTIONAL WITHIN THE LIMITS OF DIMENSIONS "A" AND "B".
- ⑤ USE CHERRY INSTALLATION TOOL, ADAPTER, AND PULLING HEAD AS SHOWN IN TABLE BELOW, OR CONSULT CHERRY AEROSPACE FOR OTHER INSTALLATION TOOLING OPTIONS.

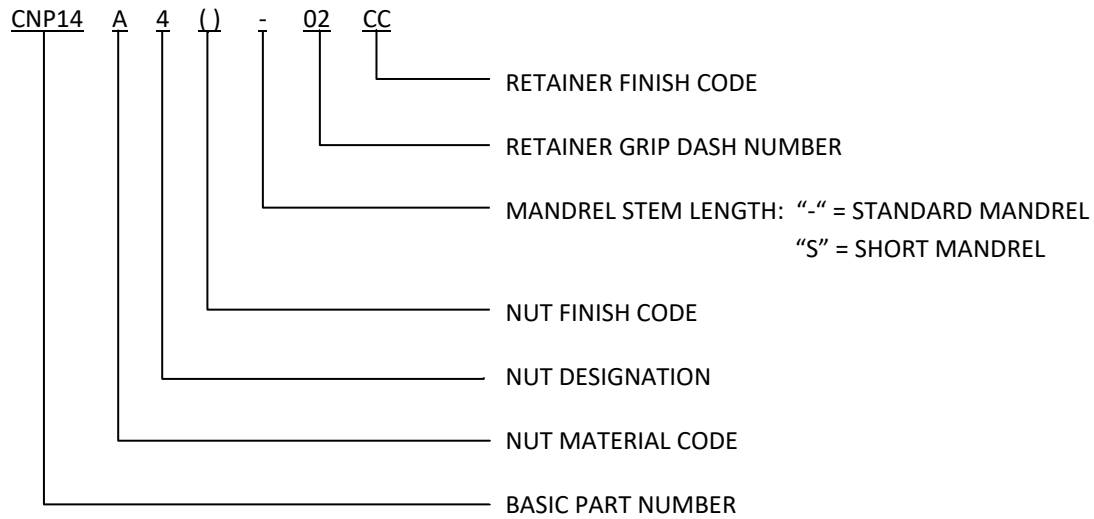
FASTENER DIAMETER DESIGNATION	INSTALLATION TOOL	ADAPTER	PULLING HEAD
			STD & SHORT MANDREL
-3	G704B	N/A	H704-249NP
	G750A	750A-088	
-4	G704B	N/A	H704-311NP
	G750A	750A-088	

- ⑥ "Z" IS THE EXPECTED INTERNAL DIAMETER OF THE RETAINER AFTER INSTALLATION; UP TO .005" SMALLER MEASUREMENT IS ACCEPTABLE.
- ⑦ THREADS IN ACCORDANCE WITH SAE AS8879 BEFORE THREAD LOCK AND LUBRICATTION.
- ⑧ 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. -3 DIAMETER -01 GRIP TORQUE-OUT AND PUSH-OUT VALUES TO BE AS TABULATED IN MECHANICAL PROPERTIES TABLE. TEST PER NASM25027.
- ⑨ MATERIAL DESIGNATION REFERS TO CHEMICAL COMPOSITION ONLY PER APPROPRIATE SPECIFICATION.
- ⑩ IN MINIMUM GRIP INSTALLATIONS, ANY BURRS WHICH EXTEND BEYOND THE BACK SIDE OF THE STRUCTURE MAY BE REMOVED BY DEBURRING.
- ⑪ 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

# CNP14

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
M	28 Sep 20	20-0377	• REVISED NOTE ⑥	AA