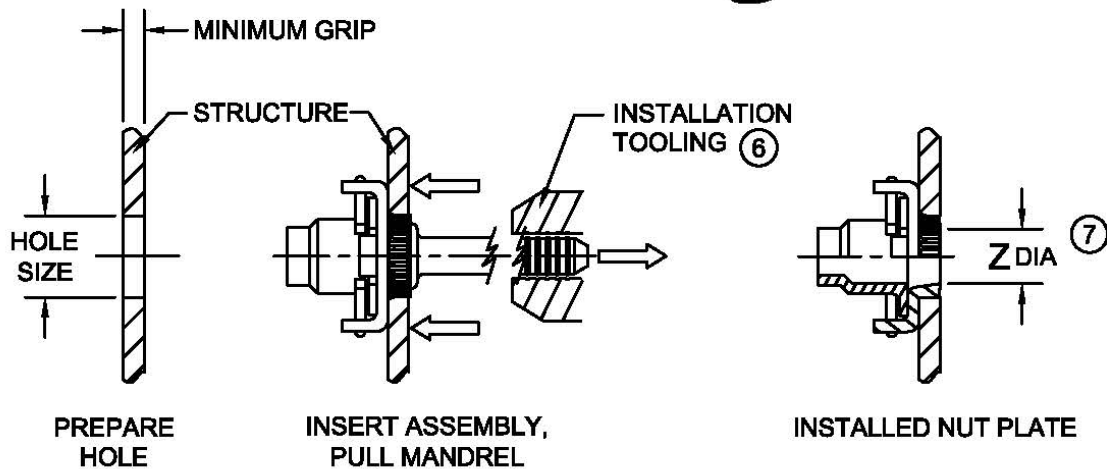
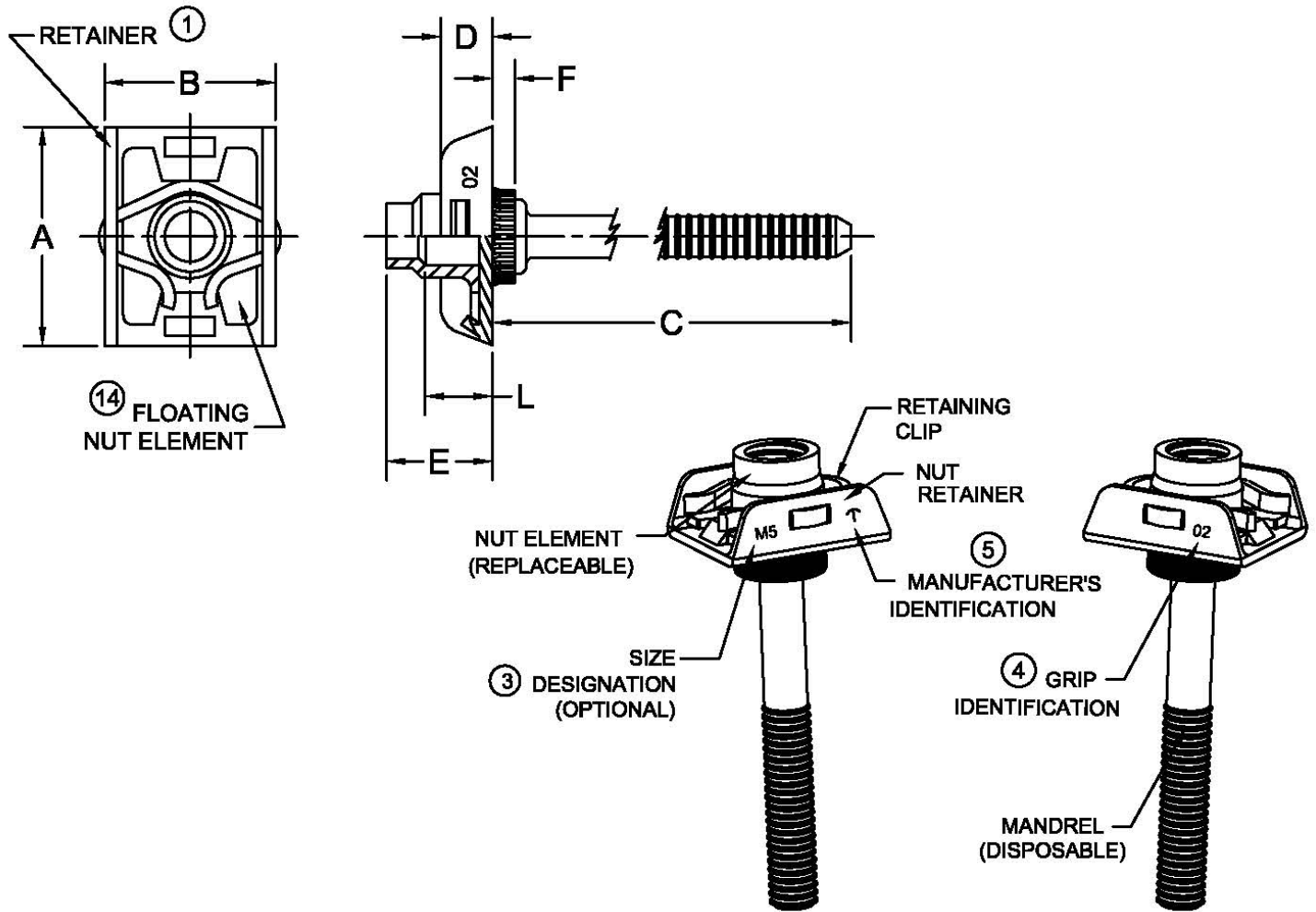




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NUT PLATE INSTALLATION SEQUENCE

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: ISO5858 & LN65016	CHERRY® METRIC RIVETLESS NUT-PLATE SIZE SPECIFIC BOLT CLEARANCE (14)	SHEET 1 OF 5		PART NUMBER
		ISSUE	12-23-05	CNP15
NAS 523 CODE:		REV.	Y 7-08-15	



TABLE I: ASSEMBLY DIMENSIONS

NUT DESIGNATION	NUT ELEMENT ⑫			A MAX	B MAX	C REF		D REF	E MAX	Z ⑦	INSTALLATION HOLE SIZE	RETAINING CLIP
	THREAD SIZE ⑧	C'BORE DASH NO.	L MIN			STD	SHORT ⑪					
M4	MJ4x0,7-4H6H	-2	3,09 (.122)	15,1 (.595)	12,4 (.490)	36,8 (1.450)	27,9 (1.100)	6,2 (.245)	8,1 (.320)	5,5 (.217)	6,32/6,43 (.249/.253)	NAS1795-3
		-3	5,03 (.198)						9,73 (.383)			
M5	MJ5x0,8-4H6H	-2	3,30 (.130)	15,1 (.595)	12,4 (.490)	36,8 (1.450)	27,9 (1.100)	6,2 (.245)	8,1 (.320)	5,5 (.217)	6,32/6,43 (.249/.253)	NAS1795-3
		-3	5,03 (.198)						9,73 (.383)			
		-4	5,23 (.236)						10,72 (.422)			
M6	MJ6x1-4H5H	-2	3,43 (.135)	18,8 (.740)	15,2 (.595)	34,93 (1.375)	27,9 (1.100)	6,73 (.265)	9,37 (.368)	7,11 (.280)	7,90/8,00 (.311/.315)	NAS1795-4
		-3	5,03 (.198)						11,05 (.435)			

TABLE II: RETAINER GRIP SELECTION

RETAINER GRIP DASH NO.	MINIMUM GRIP	F REF			MAXIMUM GRIP
		M4	M5	M6	
-01 ⑨ ⑫ ⑬	1,0 (.040)	0,8 (.032)		---	BASED ON CUSTOMER APPLICATION. CONSULT CHERRY FOR OPTIONS.
-02	1,6 (.062)	1,4 (.055)		1,45 (.057)	
-03	3,2 (.125)	2,7 (.110)		---	

TABLE III: MECHANICAL PROPERTIES

NUT DESIGNATION	RETAINER GRIP DASH NO.	NUT ELEMENT		ASSEMBLY MECHANICAL PROPERTIES ⑨	
		BOLT CLEARANCE	AXIAL TENSILE STRENGTH AT ROOM TEMPERATURE N, MINIMUM (lbf, MIN)	TORQUE-OUT (in-lbf, MIN)	PUSH-OUT (lbf, MIN)
M4	-01	1,5 (.059)	6320 (1421)	4,8 (42.5)	333 (75)
	-02 & LONGER			5,1 (45.0)	360 (81)
M5	-01	0,5 (.020)	10240 (2300)	4,8 (42.5)	333 (75)
	-02 & LONGER			7,2 (63.7)	460 (103)
M6	ALL GRIPS	1,12 (.044)	14400 (3237)	10,4 (92.0)	570 (128)

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TABLE IV: MATERIAL AND FINISH ⑩

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 AND NAS1794	A286 CRES PER AMS 5525	---	PASSIVATE PER AMS2700	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 ⑩		ALUM. COAT PER NAS 4006 CLASS NC					
		CF	COPPER-FREE NUT PER ABS2120		---	PASSIVATE PER AMS2700				
					CC	ALUM. COAT PER NAS 4006				
					GCC ⑩	ALUM. COAT PER NAS 4006 CLASS NC				
		EV	PASSIVATE PER AMS 2700 EVERLUBE® ESNALUBE 382		---	PASSIVATE PER AMS2700				
					CC	ALUM. COAT PER NAS 4006				
					GCC ⑩	ALUM. COAT PER NAS 4006 CLASS NC				
		N ⑫	NON-CRIMPED, ALUMINUM PIGMENTED COATING PER NAS4006		NO CODE	PASSIVATE PER AMS2700				
					CC	ALUM. COAT PER NAS 4006				
		P	SILVER PLATE PER AMS2410 .0002 MIN THICKNESS PER NAS1794		---	PASSIVATE PER AMS2700				
CC	ALUM. COAT PER NAS 4006									
GCC ⑩	ALUM. COAT PER NAS 4006 CLASS NC									

(CONT.)

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TABLE IV: MATERIAL AND FINISH (CONT.) ⑩

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	GN	NON-CRIMPED, ALUMINUM PIGMENTED COATING PER NAS4006	A286 CRES PER AMS 5525	---	PASSIVATE PER AMS2700	A286 CRES PER AMS 5731	PASSIVATE PER AMS 2700	XM-28 PER ASTM-A-313	PASSIVATE PER AMS 2700
					GCC ⑩	ALUM. COAT PER NAS 4006 CLASS NC				

NOTES:

- ① RETAINER BASE CONFIGURATION OPTIONAL WITHIN THE LIMITS OF DIMENSIONS “A” AND “B”.
- ② ALL DIMENSIONS ARE IN MILLIMETERS (INCHES).
- ③ FASTENER SIZE DESIGNATION STAMPED ON RETAINER, OPTIONAL.
- ④ FASTENER GRIP IDENTIFICATION STAMPED ON RETAINER.
- ⑤ MANUFACTURER’S IDENTIFICATION LETTER “T” STAMPED ON RETAINER.
- ⑥ USE CHERRY® INSTALLATION TOOL AND PULLING HEAD AS SHOWN IN TABLE BELOW, OR CONSULT CHERRY AEROSPACE FOR OTHER INSTALLATION TOOLING OPTIONS.

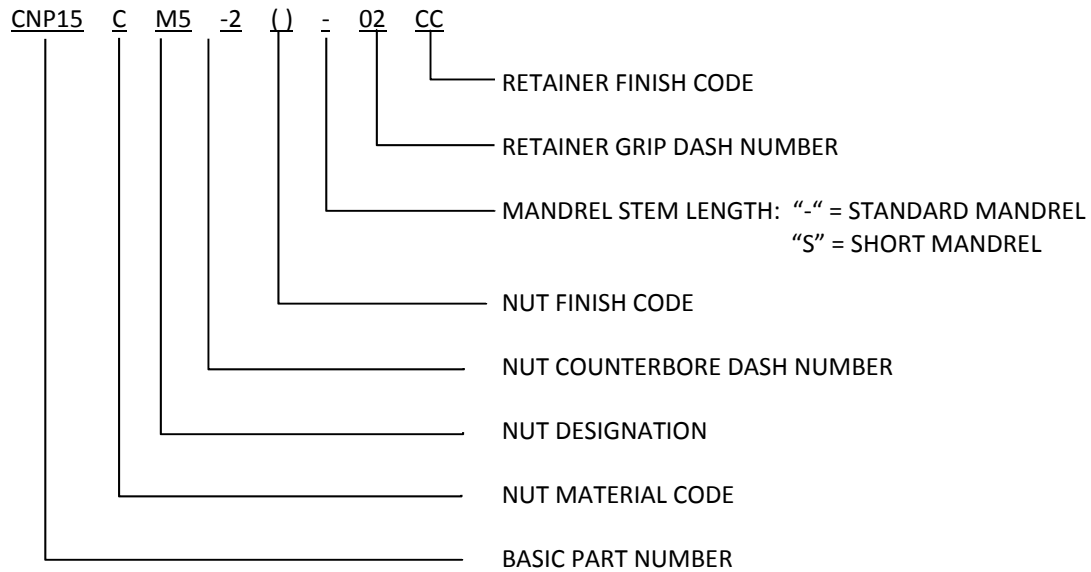
FASTENER DIAMETER DESIGNATION	INSTALLATION TOOL	PULLING HEAD
M4 & M5	G704B OR	H704-249NP
M6	G800	H704-311NP

- ⑦ “Z” IS MINIMUM I.D. OF NUT RETAINER AFTER INSTALLATION.
- ⑧ THREADS IN ACCORDANCE WITH SAE AS8879 BEFORE THREAD LOCK AND LUBRICATION.
- ⑨ 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. M4, M5 AND M6 DIAMETER TORQUE-OUT AND PUSH-OUT VALUES TO BE AS TABULATED IN MECHANICAL PROPERTIES TABLE. TEST PER ISO5858.
- ⑩ MATERIAL DESIGNATION REFERS TO CHEMICAL COMPOSITION ONLY PER APPROPRIATE SPECIFICATION.
- ⑪ SHORT MANDREL OPTION IS ONLY AVAILABLE FOR -01 AND -02 GRIP LENGTHS.
- ⑫ “N” CODE PARTS HAVE FREE-RUNNING NUT ELEMENT (WITHOUT CRIMP) WHICH MEET ONLY AXIAL TENSILE PERFORMANCE OF LN65016.
- ⑬ IN MINIMUM GRIP INSTALLATIONS, ANY BURRS WHICH EXTEND BEYOND THE BACK SIDE OF THE STRUCTURE MAY BE REMOVED BY DEBURRING.
- ⑭ FLOAT OF NUT ELEMENT OF ASSEMBLY SHALL NOT BE LESS THAN . VALUES SHOWN IN MECHANICAL PROPERTIES CHART.
- ⑮ OPTIONAL: LUBE MAY BE APPLIED TO MANDREL FOR PERFORMANCE
- ⑯ 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

CNP15

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
Y	7-08-15	14-1300	<ul style="list-style-type: none">• ADDED REACH COMPLIANT COATING GCC AND GN• ADDED NOTE 16• GENERAL CLEANUP AND STANDARDIZATION	MC