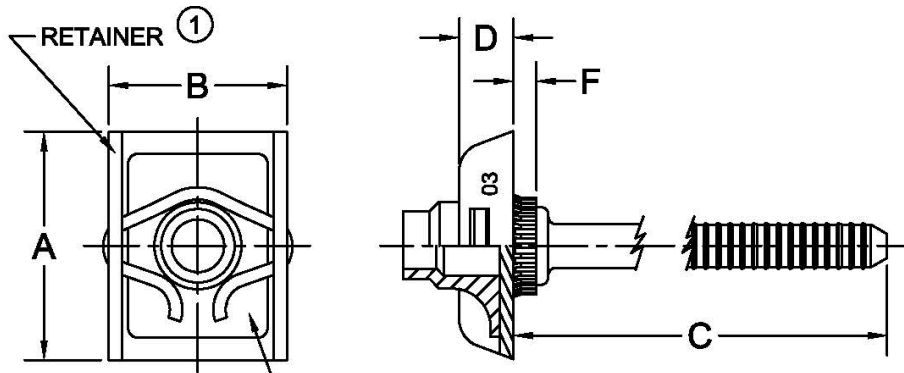
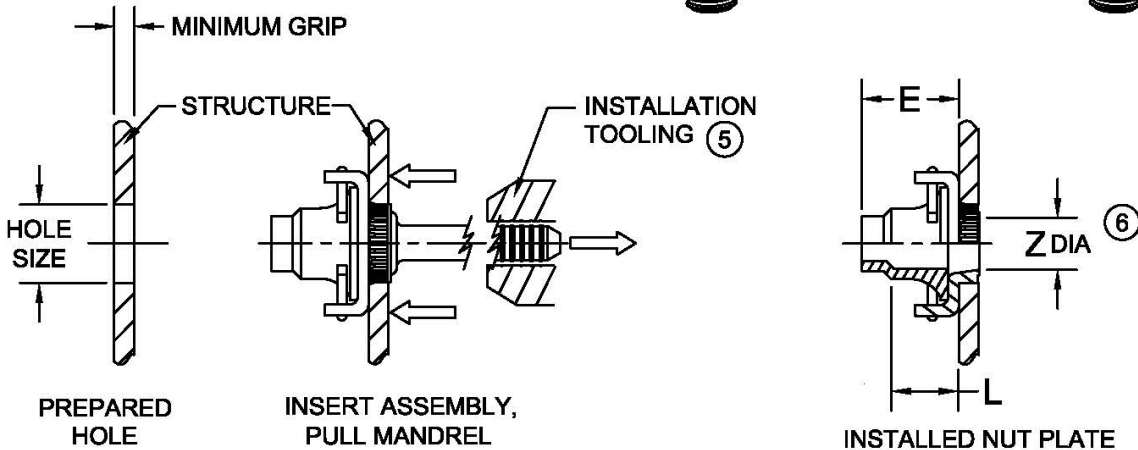
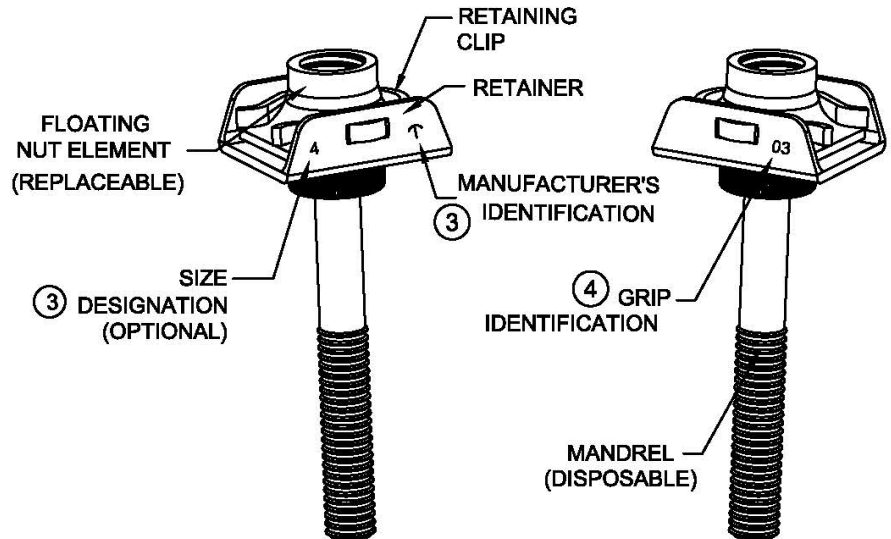




PRINTED COPIES OF THIS DOCUMENT ARE FOR "REFERENCE" ONLY. CURRENT REVISIONS ARE AVAILABLE ONLINE.



② FLOATING NUT ELEMENT (REPLACEABLE)



**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

**CHERRY® RIVETLESS NUT-PLATE**  
0.120 INCH BOLT CLEARANCE

SHEET 1 OF 6

PART NUMBER

ISSUE

10-27-05

REV.

Y 21 Mar 23

**CNP16**



**TABLE I: ASSEMBLY DIMENSIONS**

NUT DESIGNATION	NUT ELEMENT			A MAX	B MAX	C REF	D REF	E MAX	Z MIN ⑥	INSTALLATION HOLE SIZE
	THREAD SIZE ⑦	C'BORE DASH NO.	L MIN							
-3	.1900-32UNJF-3B	-1	.070	.700	.600	1.400	.320	.265	.310	.346 .343
		-2	.128					.345		
		-3	.191					.408		
-4	.2500-28UNJF-3B	-1	.070	.715	.705	1.400	.320	.315	.373	.408 .404
		-2	.128					.395		

**TABLE II: RETAINER GRIP SELECTION**

RETAINER GRIP DASH NO.	MINIMUM GRIP	F REF		MAXIMUM GRIP
		-3	-4	
-1.5 ⑩ ⑪	.055	.047	.047	BASED ON CUSTOMER APPLICATION. CONSULT CHERRY FOR OPTIONS
-03	.125	.120	.120	

**TABLE III: MECHANICAL PROPERTIES**

NUT DESIGNATION	RETAINER GRIP DASH NO.	NUT ELEMENT	ASSEMBLY MECHANICAL PROPERTIES ⑧	
		AXIAL TENSILE STRENGTH OF CRES AT ROOM TEMPERATURE (lbf, MIN)	TORQUE-OUT (in-lbf, MIN)	PUSH-OUT (lbf, MIN)
-3	ALL GRIPS	2460	60	100
-4	-1.5	4580	TBD	TBD
	-03 & UP		100	125

SHEET 2 OF 6			PART NUMBER	
ISSUE	10-27-05		CNP16	
REV.	Y	21 Mar 23		



**TABLE IV: MATERIAL AND FINISH ⑨**

NUT				RETAINER			MANDREL		RETAINING CLIP	
MATERIAL CODE	MATERIAL	FINISH CODE	FINISH	MATERIAL	FINISH CODE	FINISH	MATERIAL	FINISH ⑫	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 OR A286 CRES PER AMS5525	PASSIVATE PER AMS 2700
			CC		ALUM. COAT PER NAS 4006					
			GCC ⑬		ALUM. COAT PER NAS 4006 CLASS NC					
		CF	COPPER-FREE NUT PER ABS2120 AND DRY FILM LUBE PER NASM25027		---	PASSIVATE PER AMS2700				
			CC		ALUM. COAT PER NAS 4006					
			GCC ⑬		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 ⑬		ALUM. COAT PER NAS 4006 CLASS NC					
		P	SILVER PLATE PER AMS2410 .0002 MIN THICKNESS PER NAS1794		---	PASSIVATE PER AMS2700				
			CC		ALUM. COAT PER NAS 4006					
			GCC ⑬		ALUM. COAT PER NAS 4006 CLASS NC					

(cont.)

SHEET 3 OF 6			PART NUMBER	
ISSUE	10-27-05		CNP16	
REV.	Y	21 Mar 23		



TABLE IV: MATERIAL AND FINISH (cont.) ⑨

NUT				RETAINER			MANDREL		RETAINING CLIP	
MATERIAL CODE	MATERIAL	FINISH CODE	FINISH	MATERIAL	FINISH CODE	FINISH	MATERIAL	FINISH ⑫	MATERIAL	FINISH
C	A286 CRES PER AMS 5525, AMS 5732, OR AMS 5737	V	IVD COAT (EXCEPT THREADED AREA) PER MIL-DTL-83488, TYPE II, CLASS 1	A286 CRES PER AMS 5525	---	PASSIVATE PER AMS2700	A286 CRES PER AMS 5731	PASSIVATE PER AMS 2700	XM-28 PER ASTM-A- 313  OR  A286 CRES PER AMS5525	PASSIVATE PER AMS 2700
			V		IVD COAT PER MIL-DTL-83488, TYPE II, CLASS 1					
		GV ⑬	IVD ALUMINUM COAT PER MIL-DTL-83488, CLASS 3, TYPE II (SUPPLEMENTAL: MIL-DTL-5541, CL 1A, TYPE II)		---	PASSIVATE PER AMS2700				
			IVD ALUMINUM COAT PER MIL- DTL-83488, CLASS 3, TYPE II (SUPPLEMENTAL: MIL-DTL-5541, CL 1A, TYPE II)		GV ⑬	IVD ALUMINUM COAT PER MIL- DTL-83488, CLASS 3, TYPE II (SUPPLEMENTAL: MIL-DTL-5541, CL 1A, TYPE II)				

SHEET 4 OF 6			PART NUMBER
ISSUE	10-27-05		CNP16
REV.	Y	21 Mar 23	



**NOTES:**

- ① RETAINER BASE CONFIGURATION IS OPTIONAL WITHIN THE LIMITS OF DIMENSIONS “A” AND “B”.
- ② FLOAT OF NUT ELEMENT OF ASSEMBLY SHALL NOT BE LESS THAN .060 INCH RADIALLY FROM CENTERED POSITION. NUT CONFIGURATION OPTIONAL.
- ③ FASTENER DIAMETER DESIGNATION AND MANUFACTURER’S IDENTIFICATION LETTER “T” STAMPED ON RETAINER IN APPROXIMATE LOCATIONS AS SHOWN.
- ④ GRIP IDENTIFICATION STAMPED ON RETAINER IN APPROXIMATE LOCATION AS SHOWN.
- ⑤ USE CHERRY INSTALLATION TOOL AND PULLING HEAD AS SHOWN IN TABLE BELOW, OR CONSULT CHERRY AEROSPACE FOR OTHER INSTALLATION TOOLING OPTIONS.

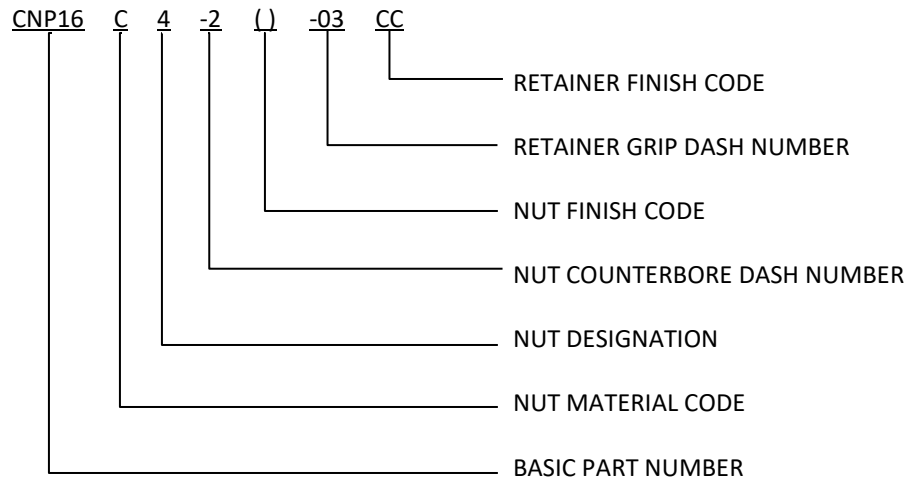
FASTENER DIAMETER DESIGNATION	INSTALLATION TOOL	PULLING HEAD
-3	G704B	H704-343NP
	G800	
-4	G84	H704-311NP

- ⑥ “Z” IS MINIMUM I.D. OF NUT RETAINER AFTER INSTALLATION.
- 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.
- ⑨ MATERIAL DESIGNATION REFERS TO CHEMICAL COMPOSITION ONLY PER APPROPRIATE SPECIFICATION.
- ⑩ FASTENER GRIP IDENTIFICATION STAMPED ON RETAINER. -1.5 GRIP TO BE IDENTIFIED “15”.
- ⑪ IN MINIMUM GRIP INSTALLATIONS, ANY BURRS WHICH EXTEND BEYOND THE BACK SIDE OF THE STRUCTURE MAY BE REMOVED BY DEBURRING.
- ⑫ LUBE MAY BE APPLIED TO MANDREL FOR PERFORMANCE.
- ⑬ FINISH CODES WITH THE PREFIX “G” INDICATE REACH COMPLIANT COATING.

SHEET 5 OF 6		PART NUMBER
ISSUE	10-27-05	
REV.	Y	21 Mar 23
<b>CNP16</b>		



### EXAMPLE OF CHERRY PART NUMBER:



SHEET 6 OF 6		PART NUMBER
ISSUE	10-27-05	CNP16
REV.	Y 21 Mar 23	

# STANDARDS PAGE REVISION LOG

# CNP16

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
W	7-23-15	15-0236	ADDED -3 COUNTERBORE TO -3 NUT DESIGNATION IN TABLE I	MC
Y	21 Mar 23	22-0272	REMOVED NOTE ⑫ AND RENUMBERED NOTES ⑬ AND ⑭	PN