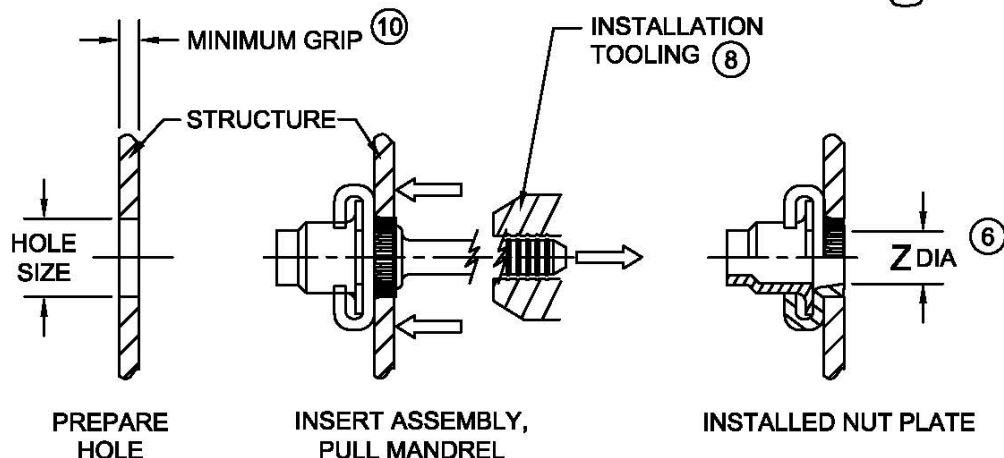
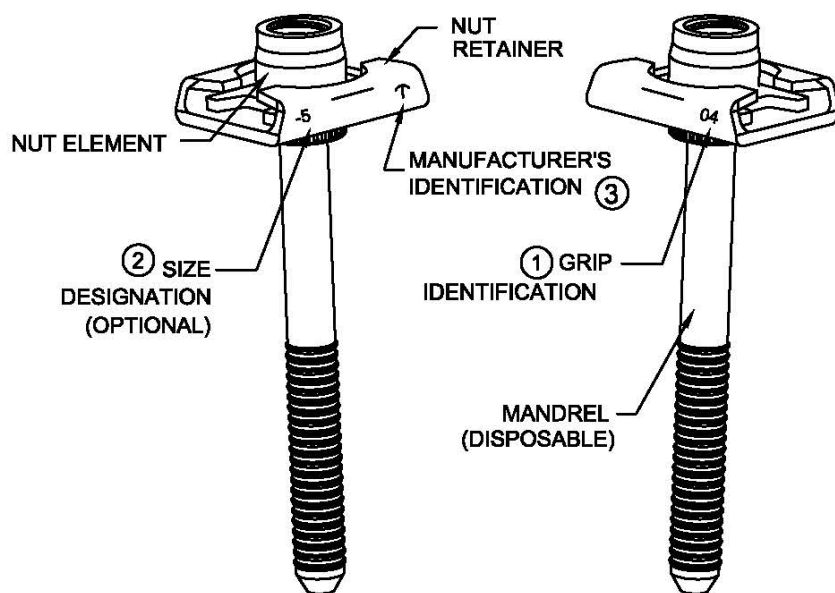
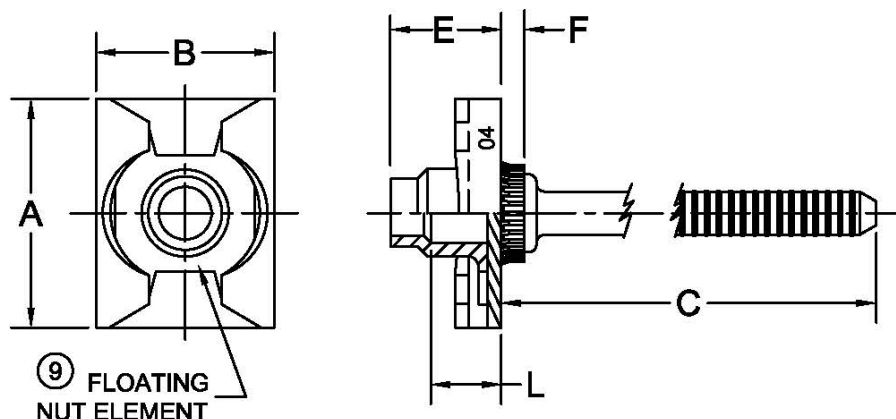




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**NUT PLATE INSTALLATION SEQUENCE**

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:	<b>CHERRY® RIVETLESS NUT-PLATE</b> 0.060 INCH BOLT CLEARANCE	SHEET 1 OF 5		PART NUMBER
PS-CNP-1000		ISSUE	11-20-06	<b>CNP19</b>
NAS 523 CODE:		REV.	N 7-08-15	



**TABLE I: ASSEMBLY DIMENSIONS**

NUT DESIGNATION	NUT ELEMENT			A MAX	B MAX	C REF		E MAX	Z MIN ⑥	INSTALLATION HOLE SIZE
	THREAD SIZE ⑦	CBORE DASH NO.	L MIN			STD LENGTH	LONG LENGTH ⑩			
-5	.3125-18UNC-2B	-1	.036	.775	.665	1.400	2.000	.450	.373	.408 .404

**TABLE II: RETAINER GRIP SELECTION**

RETAINER GRIP DASH NO.	MINIMUM GRIP	F REF	MAXIMUM GRIP	
			STANDARD MANDREL	LONG MANDREL
-03	.125	.110	.500	1.000
-04	.190	.170		

**TABLE III: MECHANICAL PROPERTIES**

NUT DESIGNATION	RETAINER GRIP DASH NO.	NUT ELEMENT PER NAS1794	ASSEMBLY MECHANICAL PROPERTIES ④	
		AXIAL TENSILE STRENGTH OF CRES MATERIAL AT ROOM TEMPERATURE (lbf, MIN)	TORQUE-OUT (in-lbf, MIN)	PUSH-OUT (lbf, MIN)
-5	-03 & LONGER	6360	160	125

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TABLE IV: MATERIAL AND FINISH ⑤

NUT				RETAINER			MANDREL ⑪	
MATERIAL CODE	MATERIAL	FINISH CODE	FINISH	MATERIAL	FINISH CODE	FINISH	MATERIAL	FINISH ⑫
C	A-286 CRES PER AMS5525, AMS5732, OR AMS5757	NO CODE	PASSIVATE PER AMS2700 AND DRY FILM LUBE PER NASM25027	CRES PER AMS5525	NO CODE	PASSIVATE PER AMS2700	A-286 CRES PER AMS5731	PASSIVATE PER AMS2700
					CC	ALUMINUM COAT PER NAS 4006		
					GCC ⑬	ALUMINUM COAT PER NAS 4006, CLASS NC		

NUT				RETAINER			MANDREL ⑪	
MATERIAL CODE	MATERIAL	FINISH CODE	FINISH	MATERIAL	FINISH CODE	FINISH	MATERIAL	FINISH ⑫
A	C1050 CARBON STEEL PER AMS5085	MAGNI 560	ZINC PLATE PER ASTM B633	CRES PER AMS5525	NO CODE	PASSIVATE PER AMS2700	A-286 CRES PER AMS5731	PASSIVATE PER AMS2700
					CC	ALUMINUM COAT PER NAS 4006		

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**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 MANUFACTURER'S IDENTIFICATION LETTER "T" STAMPER ON RETAINER.
- ④ 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.
- ⑤ MATERIAL DESIGNATION REFERS TO CHEMICAL COMPOSITION ONLY PER APPROPRIATE SPECIFICATION.
- ⑥ "Z" IS THE MINIMUM I.D. OF NUT RETAINER AFTER INSTALLATION.
- ⑦ THREADS IN ACCORDANCE WITH ASME B1.1 BEFORE THREAD LOCK AND LUBRICATION.
- ⑧ USE CHERRY® INSTALLATION TOOL, ADAPTER, AND PULLING HEAD AS SHOWN BELOW, OR CONSULT CHERRY AEROSPACE LLC FOR OTHER INSTALLATION TOOLING OPTIONS.

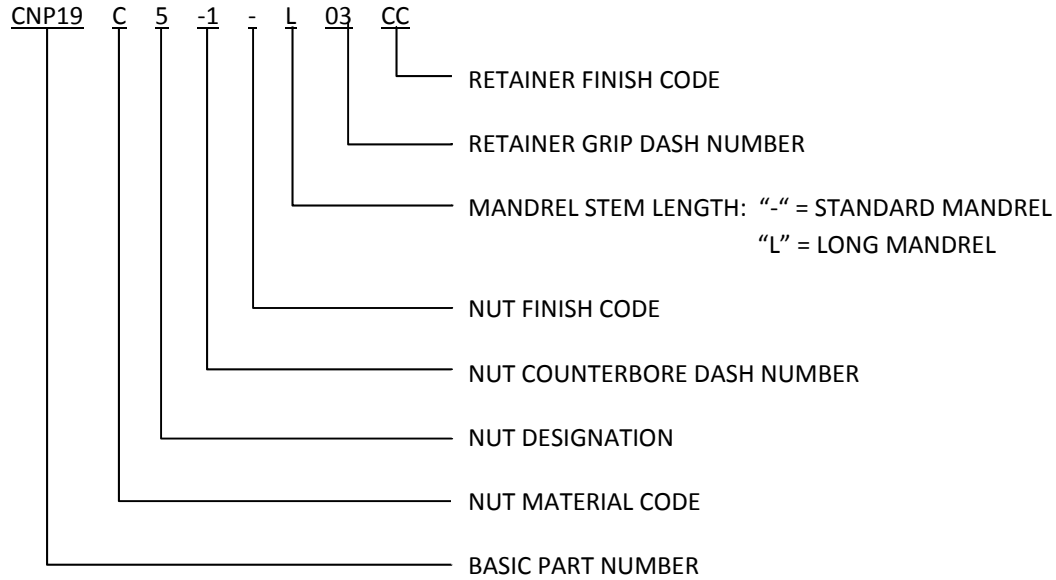
NUT DESIGNATION	INSTALLATION TOOL	PULLING HEAD
-5	G84	H84C-404NP

- ⑨ FLOAT OF NUT ELEMENT OF ASSEMBLY SHALL NOT BE LESS THAN .030 INCH RADIALLY FROM CENTERED POSITION. NUT ELEMENT SHALL BE CAPABLE OF ENGAGEMENT WITH BOLT IN THE MAXIMUM MISALIGNED POSITION.
- ⑩ STANDARD MANDREL MAY BE INSTALLED IN MATERIAL A MAXIMUM OF .500 INCH IN THICKNESS. LONG MANDREL MAY BE INSTALLED IN MATERIAL A MAXIMUM OF 1.000 INCH IN THICKNESS.
- ⑪ MANDREL MATERIAL (STAINLESS OR ALLOY STEEL) AND FINISH IS AT MANUFACTURER'S OPTION.
- ⑫ OPTIONAL: LUBE MAY BE APPLIED TO THE MANDREL FOR PERFORMANCE.
- ⑬ 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

# CNP19

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
N	7-08-15	14-1298	<ul style="list-style-type: none"><li>• ADDED REACH COMPLIANT COATING GCC</li><li>• ADDED NOTE 13</li><li>• GENERAL CLEANUP AND STANDARDIZATION</li></ul>	MC