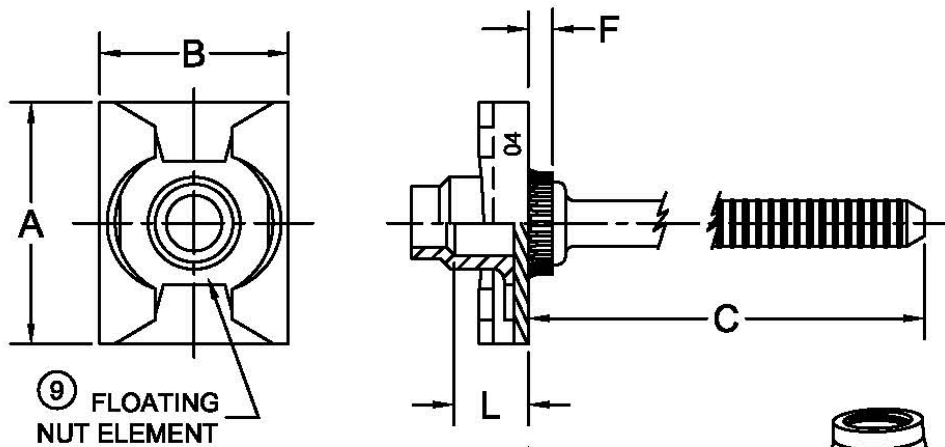
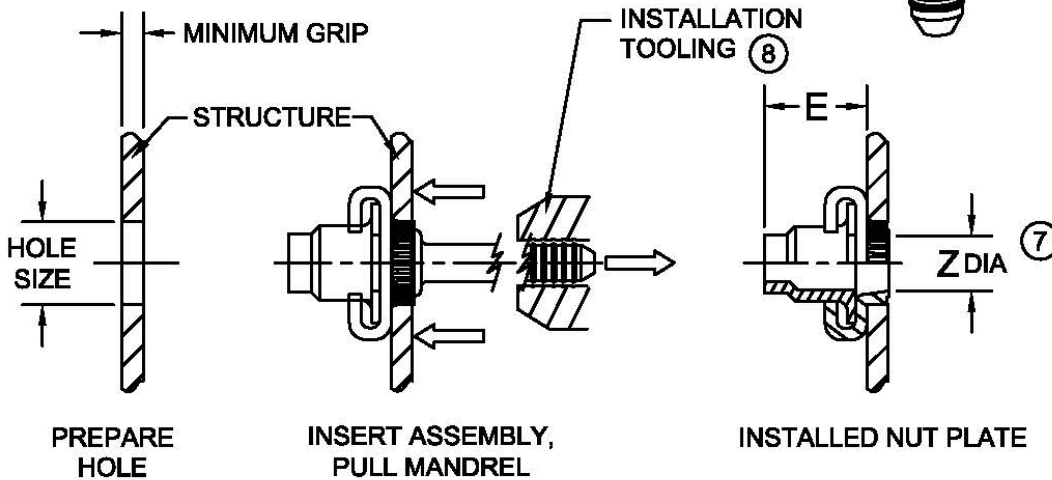
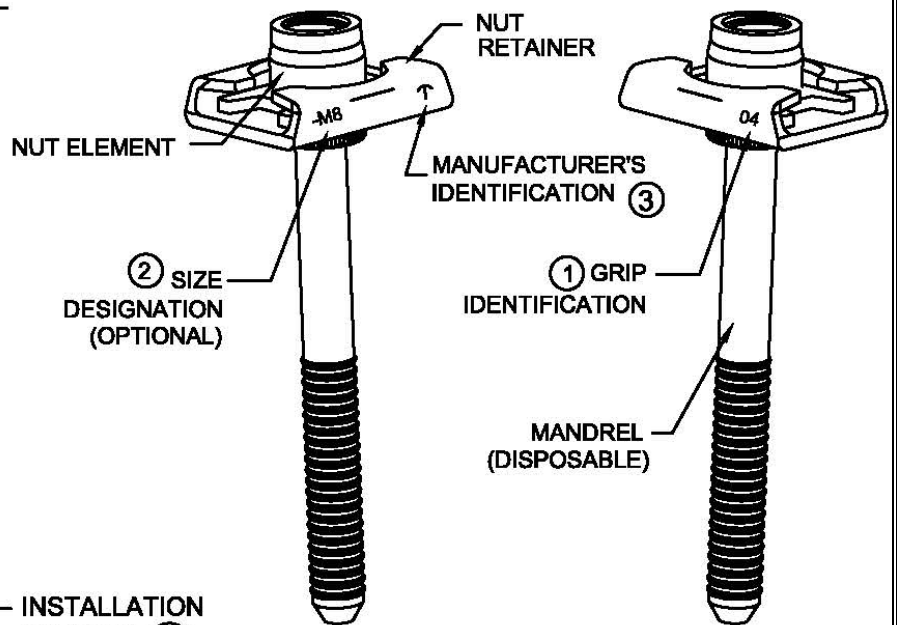




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⑨ FLOATING NUT ELEMENT



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:	CHERRY® RIVETLESS NUT-PLATE 1,47mm BOLT CLEARANCE	SHEET 1 OF 5		PART NUMBER
ISO5858 & LN65016		ISSUE	8-20-09	CNP25
NAS 523 CODE:		REV.	D 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	C'BORE DASH NO.	L MIN						
M8	MJ8x1-4H5H	-2	3,43 (.135)	19,7 (.775)	16,9 (.665)	35,56 (1.400)	11,43 (.450)	9,5 (.373)	10,26/10,36 (.404/.408)
		-3	5,03 (.198)				12,45 (.490)		

TABLE II: RETAINER GRIP SELECTION

RETAINER GRIP DASH NO.	MINIMUM GRIP	F REF
-03	3,175 (.125)	2,79 (.110)
-04	4,826 (.190)	4,32 (.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 N, MINIMUM (lbf, MIN)	TORQUE-OUT Nm, MINIMUM (in-lbf, MIN)	PUSH-OUT N, MINIMUM (lbf, MIN)
M8	-03 & LONGER	30,000 (6744)	18,4 (163)	570 (128)

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TABLE IV: MATERIAL AND FINISH ⑤

NUT				RETAINER			MANDREL	
MATERIAL CODE	MATERIAL	FINISH CODE	FINISH	MATERIAL	FINISH CODE	FINISH	MATERIAL	FINISH ⑬
C	A286 CRES PER AMS 5525, AMS 5732, OR AMS 5737	---	PASSIVATE PER AMS 2700 AND DRY FILM LUBE PER NASM25027 ⑫	A286 CRES PER AMS 5525	---	PASSIVATE PER AMS2700	A286 CRES PER AMS 5731	PASSIVATE PER AMS 2700
			CC		ALUM. COAT PER NAS 4006			
			GCC ⑭		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 ⑭		ALUM. COAT PER NAS 4006 CLASS NC			
		N ⑪	NON-CRIMPED ALUMINUM PIGMENTED COATING PER NAS4006		---	PASSIVATE PER AMS2700		
			CC		ALUM. COAT PER NAS 4006			
			GCC ⑭		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 ⑭		ALUM. COAT PER NAS 4006 CLASS NC			
GN ⑪ ⑭	NON-CRIMPED ALUMINUM COAT PER NAS4006, CLASS NC	---	PASSIVATE PER AMS2700					
	GCC ⑭	ALUM. COAT PER NAS 4006 CLASS NC						

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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 IDENTIFICATION STAMPED ON RETAINER, OPTIONAL.
- ③ MANUFACTURER'S IDENTIFICATION LETTER "T" STAMPED 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 MINIMUM I.D. OF NUT RETAINER AFTER INSTALLATION.
- ⑦ THREADS IN ACCORDANCE WITH SAE AS8879 BEFORE THREAD LOCK AND LUBRICATION.
- ⑧ USE CHERRY® INSTALLATION TOOL, ADAPTER, AND PULLING HEAD AS SHOWN IN TABLE BELOW, OR CONSULT CHERRY AEROSPACE FOR OTHER INSTALLATION TOOLING OPTIONS.

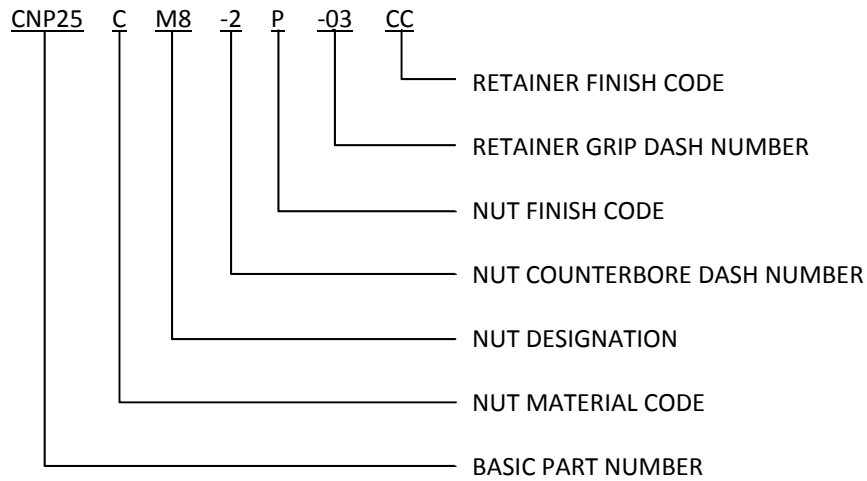
NUT DESIGNATION	INSTALLATION TOOL	PULLING HEAD
M8	G84	H84C-404NP

- ⑨ FLOAT OF NUT ELEMENT OF ASSEMBLY SHALL NOT BE LESS THAN 0,73mm (.029 INCH) RADIALLY FROM CENTERED POSITION. NUT ELEMENT SHALL BE CAPABLE OF ENGAGEMENT WITH BOLT IN THE MAXIMUM MISALIGNED POSITION.
- 10. ALL DIMENSIONS ARE IN MILLIMETERS (INCHES).
- ⑪ "N" CODE PARTS HAVE FREE-RUNNING NUT ELEMENTS (WITHOUT CRIMP) WHICH MEET ONLY AXIAL TENSILE PERFORMANCE OF LN65016.
- ⑫ "NO CODE" DESIGNATION USES A COPPER FREE NUT..
- ⑬ OPTIONAL: LUBE MAY BE APPLIED TO MANDREL FOR PERFORMANCE.
- ⑭ FINISH CODES WITH THE PREFIX "G" INDICATE REACH COMPLIANT COATING.

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EXAMPLE OF CHERRY PART NUMBER:



SHEET 5 OF 5		PART NUMBER
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STANDARDS PAGE REVISION LOG

CNP25

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
D	7-08-15	14-1288	<ul style="list-style-type: none">• ADDED REACH COMPLIANT COATING GCC AND GN• ADDED NOTE 14• GENERAL CLEANUP AND STANDARDIZATION	MC