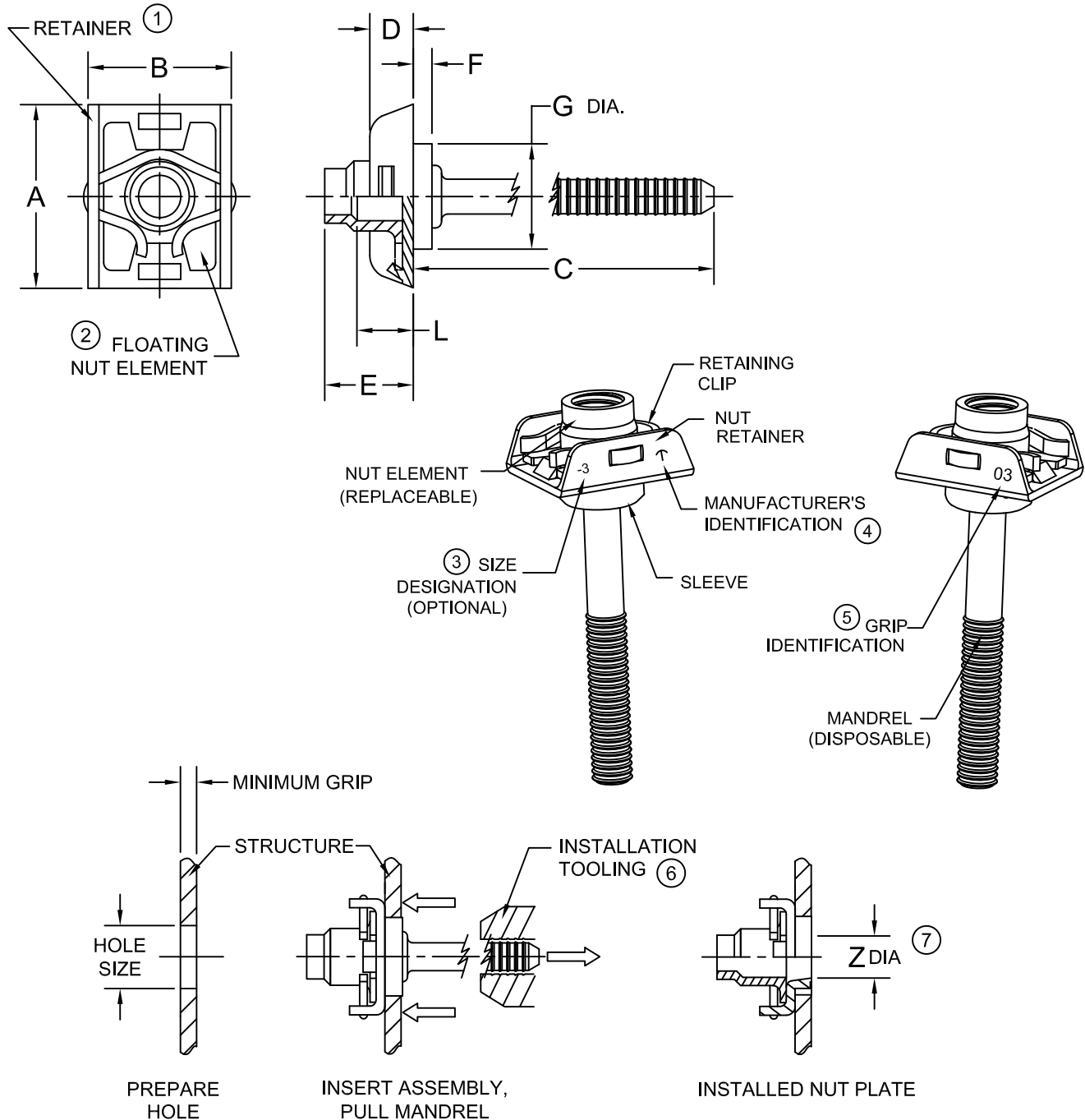




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NUT PLATE INSTALLATION SEQUENCE

SEE SHEET 2 FOR DIMENSIONS

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(11) NAS 523 CODE : ---	CHERRY® RIVETLESS NUT PLATE 0.060 INCH BOLT CLEARANCE FOR CARBON COMPOSITE APPLICATIONS	SHEET 1 OF 5		PART NUMBER
		ISSUE	6-13-08	<b>CNP51</b>
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**ASSEMBLY DIMENSIONS**

FASTENER DIAMETER DESIGNATION	THREAD SIZE (8)	C'BORE DASH NO.	L MIN	A MAX	B MAX	C REF MANDREL LENGTH		D REF	E MAX	G REF	Z (7) MIN	INSTALLATION HOLE SIZE	RETAINING CLIP
						STD	SHORT						
-3	.1900-32 UNJF-3B	-1	.076	.595	.490	1.450	1.100	.245	.258	.305	.248	.305/.308	NAS1795-3
		-2	.135						.320				
		-3	.198						.383				
		-4	.260						.446				
		-5	.323						.508				
-4	.2500-28 UNJF-3B	-1	.071	.740	.595	1.375	1.100	.265	.303	.368	.310	.368/.371	NAS1795-4
		-2	.135						.365				
		-3	.198						.427				
		-4	.260						.489				
		-5	.323						.551				

**NUTPLATE GRIP SELECTION**

GRIP DASH NO.	MINIMUM GRIP (in) (12)	F REF	MAXIMUM GRIP
-03	.125	.110	BASED ON CUSTOMER APPLICATION. CONSULT CHERRY FOR OPTIONS

**MECHANICAL PROPERTIES**

FASTENER DIAMETER DESIGNATION	THREAD SIZE (8)	AXIAL TENSILE STRENGTH OF ALLOY STEEL AND CRES AT ROOM TEMPERATURE (lbf, MINIMUM)	ASSEMBLY MECHANICAL PROPERTIES (9)	
			TORQUE-OUT (in-lbf, MINIMUM)	PUSH-OUT (lbf, MINIMUM)
-3	.1900-32UNJF-3B	2460	60	100
-4	.2500-28UNJF-3B	4580	100	125

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⑩ MATERIAL AND FINISH

BASIC PART NO.	NUT ⑪			
	MAT'L CODE	MATERIAL	FINISH CODE	FINISH
CNP51	C	A286 CRES PER AMS5525, AMS5732, OR AMS5737	NO CODE	PASSIVATE PER AMS2700, COPPER OR NICKEL STRIKE OPTIONAL, AND DRY FILM LUBE PER AS5272
			P	SILVER PLATE PER AMS2410 .0002 MIN THICKNESS

SLEEVE		RETAINER		MANDREL		RETAINING CLIP	
MATERIAL	FINISH	MATERIAL	FINISH	MATERIAL	FINISH ⑬	MATERIAL	FINISH
NICKEL 200 PER ASTM-B-160 OR ASTM-B-162 ⑪	TUMBLE POLISH	A286 CRES PER AMS5525	PASSIVATE PER AMS 2700	CRES OR STEEL	PARTIALLY COPPER COATED OR PASSIVATE PER AMS 2700	XM-28 PER ASTM- A -313	PASSIVATE PER AMS 2700

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**NOTES:**

- ① RETAINER BASE CONFIGURATION OPTIONAL WITHIN THE LIMITS OF DIMENSIONS "A" AND "B".
- ② 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.
- ③ FASTENER SIZE DESIGNATION STAMPED ON RETAINER AT MANUFACTURER'S OPTION.
- ④ MANUFACTURER'S IDENTIFICATION LETTER "T" STAMPED ON RETAINER.
- ⑤ FASTENER GRIP IDENTIFICATION 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:

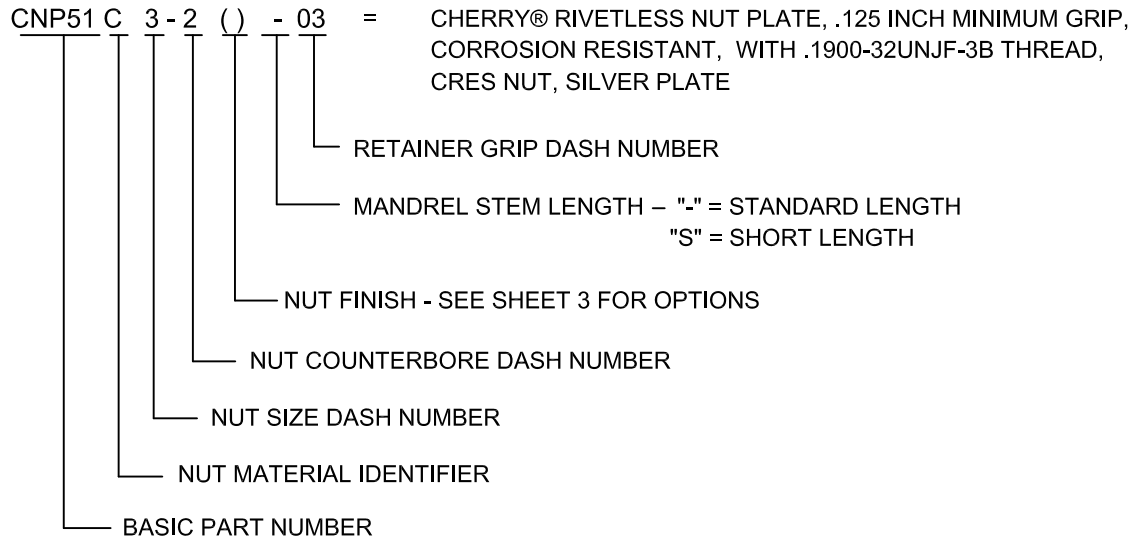
FASTENER DIAMETER DESIGNATION	INSTALLATION TOOL	PULLING HEAD
-3	G704B	H704-305NPC
	G800	
-4	G704B	H704-368NPC
	G800	

- 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 CARBON COMPOSITE MATERIAL.
- ⑩ MATERIAL DESIGNATION REFERS TO CHEMICAL COMPOSITION ONLY PER APPROPRIATE SPECIFICATION.
- ⑪ THE MAGNETIC PERMEABILITY OF THE SLEEVE SHALL BE LESS THAN 3.0 Mu (AIR = 1.0) FOR FIELD STRENGTH OF H = 200 OERSTEDS.
- ⑫ IN MINIMUM GRIP INSTALLATIONS, ANY BURRS WHICH EXTEND BEYOND THE BACKSIDE OF THE STRUCTURE MAY BE REMOVED BY DEBURRING.
- ⑬ OPTIONAL: LUBE MAY BE APPLIED TO MANDREL FOR PERFORMANCE.

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**PART NUMBER EXAMPLE:**



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STANDARDS PAGE REVISION LOG

REV LTR	DATE	DCR NUMBER	REVISION DESCRIPTION	COMP. BY
J	2-11-13	13-0124	ADDED NEW NOTE TO MATERIAL AND FINISH: MANDREL: FINISH - OPTIONAL: LUBE MAY BE APPLIED TO MANDREL FOR PERFORMANCE.	RW