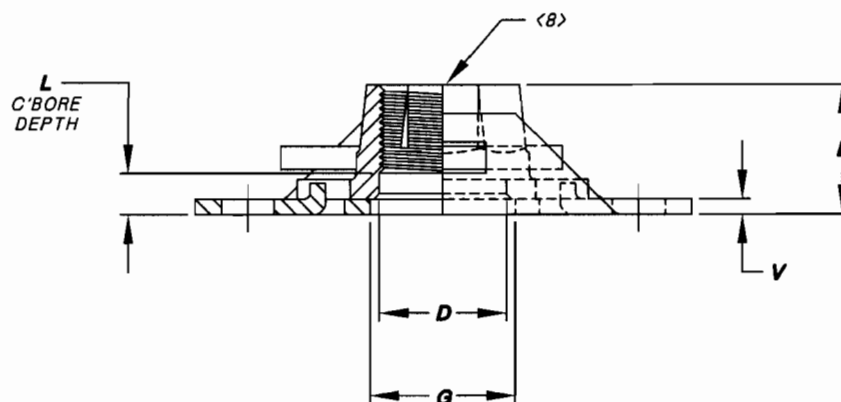
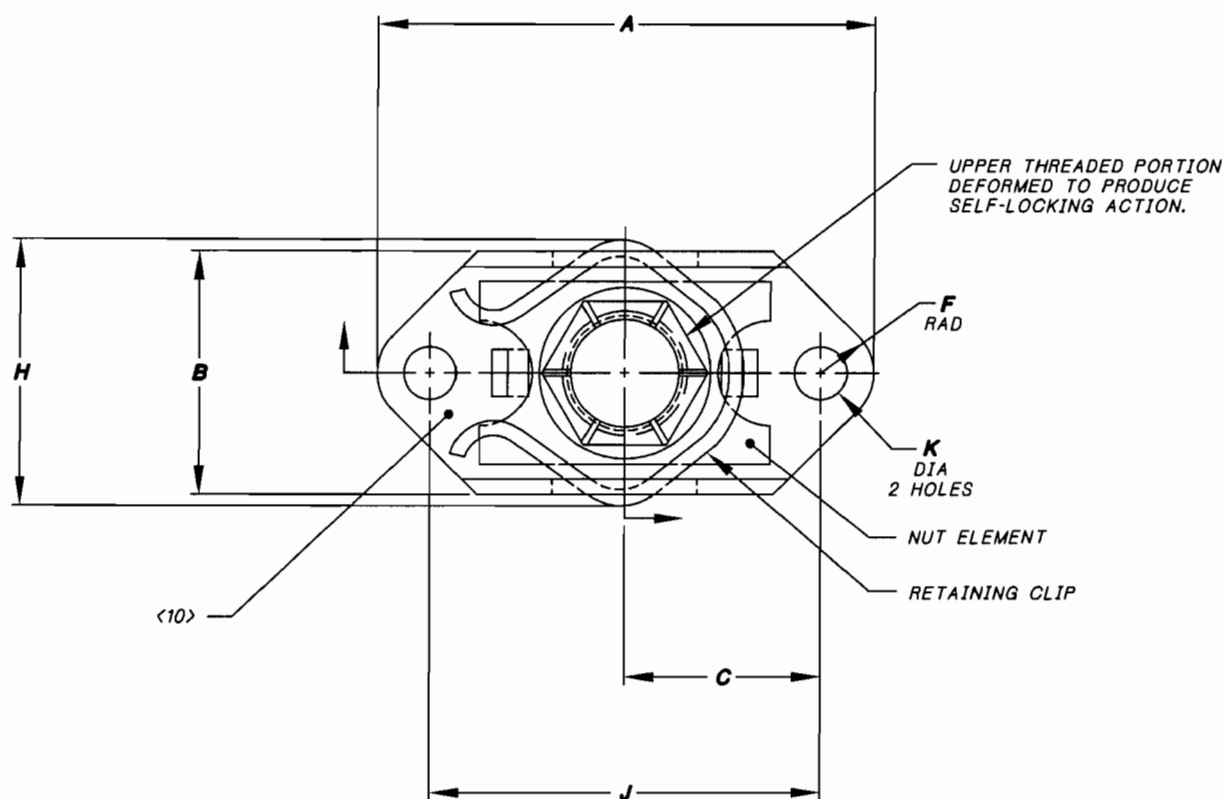


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INTERIM DOCUMENT REVISION		
Rev.	Date	DAF #
H1	10/21/10	94301

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REV. LETTER AND DATE

H 2 MAR 09

DAF NUMBER

DAF 07220

CURRENT DESIGN ACTIVITY:

**Alcoa
Fastening
Systems**VOI-SHAN PRODUCTS
3000 W. LOMITA BLVD.
TORRANCE, CA 90505

TITLE:

**NUT PLATE
FLAT BEAM LOCK, CLIP-IN,
250 CYCLE, ALLOY STEEL NUT,
CRES CAGE, 2 LUG**UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES &
ASME Y14.5M TOLERANCES:ANGLES = * 3°
DECIMALS .XX = * .02
.XXX = * .010

CURRENT DESIGN ACTIVITY:

CAGE CODE:

SALES DRAWING NO.

FBL10040-()-()

SHEET 1 OF 3

S22056

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Camloc . Delron . Deutsch . Huck . K-Fast . Kaynar . Microdot . RAM . Rosan . Screwcorp . Tridair . Voi-Shan

TABLE 1

DASH NUMBER	THREAD (8)	A MAX	B MAX	C ±.005	D DIA REF	E MAX REF (10)	F MIN	G DIA MIN REF
-08-1	.1640-32 UNJF-38	.948	.454	.344	.194	.250	.100	.250
-08-2						.312		
-08-3						.375		
-08-4						.438		
-08-5						.500		
-08-6						.562		
-3-1	.1900-32 UNJF-38	.948	.454	.344	.194	.250	.100	.250
-3-2						.312		
-3-3						.375		
-3-4						.438		
-3-5						.500		
-3-6						.562		
-4-1	.2500-28 UNJF-38	1.292	.554	.500	.254	.295	.125	.310
-4-2						.357		
-4-3						.419		
-4-4						.481		
-4-5						.543		
-4-6						.605		
-5-1	.3125-24 UNJF-38	1.292	.650	.500	.317	.344	.125	.373
-5-2						.400		
-5-3						.461		
-5-4						.524		
-5-5						.586		
-5-6						.649		

TABLE 1 CON'T

DASH NUMBER	THREAD (8)	H MAX	J ±.002	K DIA ±.005 -.000	L C'BORE MIN REF	V ±.005	MAX WEIGHT LBS/100
-08-1	.1640-32 UNJF-38	.484	.688	.098	.070	.032	-
-08-2					.125		-
-08-3					.188		-
-08-4					.250		-
-08-5					.313		-
-08-6					.375		-
-3-1	.1900-32 UNJF-38	.484	.688	.098	.070	.032	.67
-3-2					.125		.74
-3-3					.188		.79
-3-4					.250		.84
-3-5					.313		.89
-3-6					.375		.94
-4-1	.2500-28 UNJF-38	.584	1.000	.098	.070	.032	1.17
-4-2					.125		1.27
-4-3					.188		1.36
-4-4					.250		1.44
-4-5					.313		1.54
-4-6					.375		1.62
-5-1	.3125-24 UNJF-38	.720	1.000	.130	.070	.040	1.92
-5-2					.125		1.97
-5-3					.188		2.10
-5-4					.250		2.21
-5-5					.313		2.32
-5-6					.375		2.43

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NUT PLATE
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GRES CAGE, 2 LUGUNLESS OTHERWISE SPECIFIED
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DECIMALS .XX = ± .02
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SALES DRAWING NO.

FBL10040-()-()

SHEET 2 OF 3

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TABLE 2

PART NUMBER	SEATING TORQUE (MAX)	AXIAL TENSILE STRENGTH (POUNDS MIN)	PUSHOUT STRENGTH (LBS.MINIMUM)	TORQUE-OUT STRENGTH (IN/LBS MINIMUM)
FBL10040-08-()	26.0 IN/LBS	1,950	200	45
FBL10040-3-()	36.0 IN/LBS	2,825	200	90
FBL10040-4-()	60.0 IN/LBS	5,060	225	160
FBL10040-5-()	120.0 IN/LBS	8,000	250	280

NOTES; UNLESS OTHERWISE SPECIFIED:

2. MATERIAL:
- 2.1 NUT: 4140 OR 8740 ALLOY STEEL PER AMS6382 OR AMS6322.
- 2.2 CAGE: C1050 CARBON STEEL PER AMS5085 OR QQ-S-635.
- 2.3 CLIP: 302 CRES STEEL PER AMS5688 OR 18-2MN CRES, OR XM-28 PER CHEMISTRY OF ASTM A313.
3. HEAT TREAT:
- 3.1 NUT: HEAT TREATED.
- 3.2 CAGE: HEAT TREATED.
4. FINISH:
- 4.1 NUT: CADMIUM PLATE PER AMS-QQ-P-416, TYPE I, CLASS 2, EMBRITTLEMENT RELIEF BAKE TO BE 23 HOURS MINIMUM. AFTER PLATING.
- 4.2 CAGE: CADMIUM PLATED PER AMS-QQ-P-416, TYPE II, CLASS 2.
- 4.3 CLIP: PASSIVATE PER AMS2700.
5. LUBRICATION:
- 5.1 CAGE - NONE
- 5.2 CLIP - NONE
- 5.3 NUT - MOLYBDENUM DISULFIDE DRY FILM COATED PER AS5272, TYPE I.
6. FLOATABILITY:
- 6.1 .030 MINIMUM RADIALLY FROM CENTERED POSITION.
7. 1. AXIAL TENSILE STRENGTH, PUSHOUT AND TORQUE-OUT AS TABULATED IN TABLE 2.
- 7.1 2. LOCKING TORQUE CAPABLE OF 250 REUSABLE CYCLES, SEATED TO THE VALUES AS TABULATED.
- 7.2 3. TEST BOLT MATERIAL TO BE ALLOY STEEL, CADMIUM PLATED WITH A MINIMUM STRENGTH
- 7.3 OF 160,000 PSI.
- <8> THREADS PER AS8879, PRIOR TO LUBRICATION AND FORMING SELF-LOCKING ACTION.
9. ANTI-SEIZE COMPOUND PER MIL-PRF-907 APPLIED TO INTERNAL THREADS.
- <10> CAGE SHALL BE IDENTIFIED WITH MANUFACTURER'S IDENTIFICATION. RAISED OR DEPRESSED .010 MAXIMUM. LOCATION OPTIONAL EXCEPT SHALL BE VISIBLE AFTER ASSEMBLY.
11. PART CALLOUT EXAMPLE:
- 11.1 FBL10040-4-2
- SECOND DASH NUMBER INDICATES
"L" COUNTERBORE DEPTH (.125 SHOWN)
- FIRST DASH NUMBER INDICATES BASIC
SIZE IN SIXTEENTHS OF AN INCH
(.2500-28UNJF SHOWN)
- BASIC PART NUMBER

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CURRENT DESIGN ACTIVITY:

Alcoa
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VOI-SHAN PRODUCTS
3000 W. LOMITA BLVD.
TORRANCE, CA 90505

TITLE:

NUT PLATE
FLAT BEAM LOCK, CLIP-IN,
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