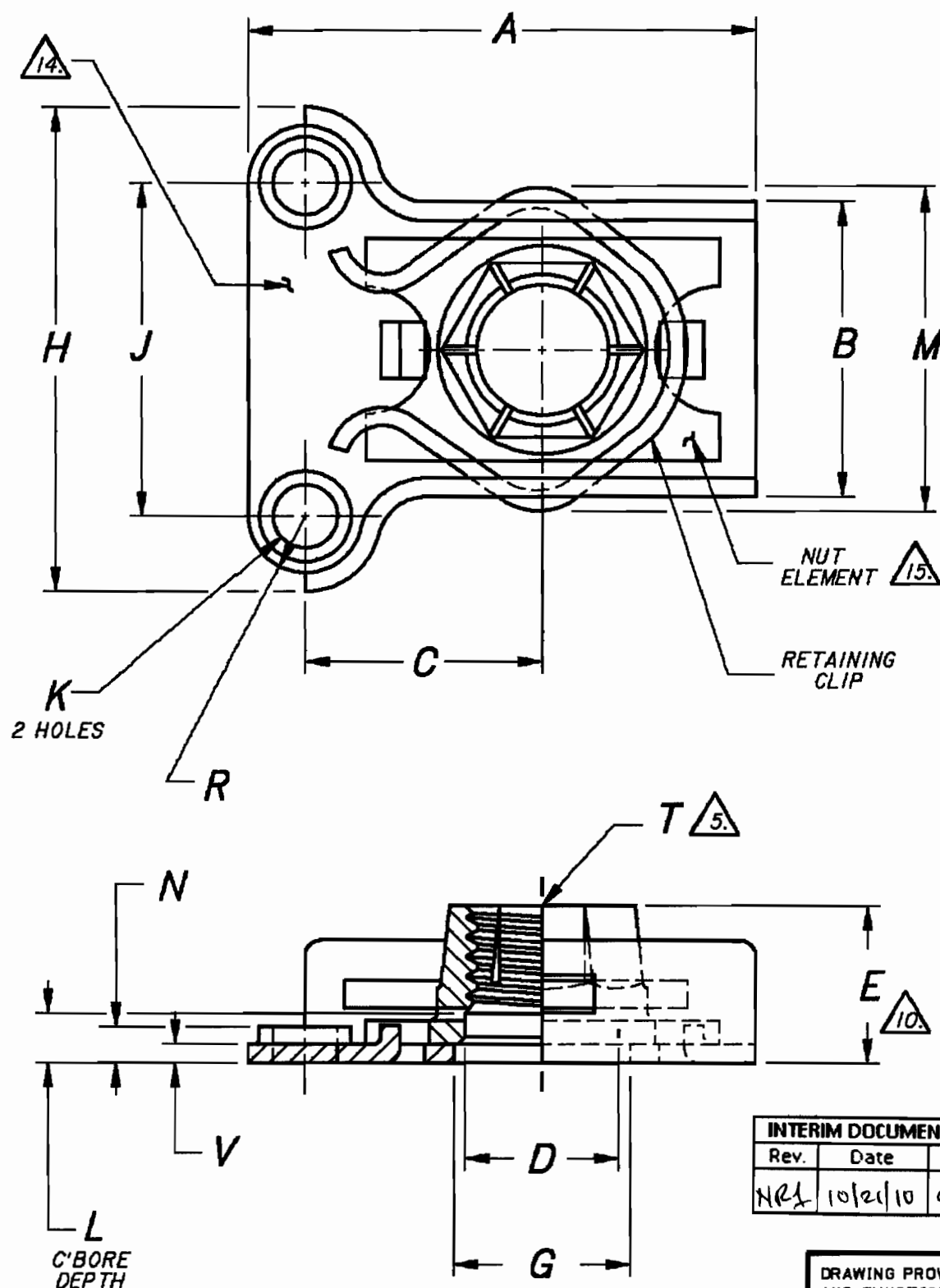




DRAWN BY: BLA	DATE 4-25-89
MFG. ENGRS. J.K.	DATE 6-13-89
APPROVED BY: G. E. R. N.	DATE 5/27/89
APPROVED BY:	DATE
PROJECT NUMBER	89-167

TITLE: NUT PLATE FLAT BEAM LOCK, CLIP-IN, 250 CYCLE, ALLOY STEEL, CORNER TYPE
UNLESS OTHERWISE SPECIFIED: TOLERANCES: DECIMALS: .XX ±.02 .XXX ±.010 ANGLES: ±.5°
MILLIMETERS ± 0.30 ± 0.25
SURFACE FINISH 125 MICROINCHES

Tridair fasteners
REXNORD SPECIALTY FASTENER DIVISION 3000 W. LOMITA BOULEVARD TORRANCE, CA. 90505
FBL10076-()-()
FSC: 29372 SHEET 1 OF 4

REVISION NR1 10-21-10 94301
BLA NR1 10-21-10 94301
FSC 29372 4-25-89

TABLE I

DASH NUMBER	THREAD 	A MAX.	B MAX.	C ±.005	D DIA. (REF)	E MAX. (REF) 	G DIA. MIN. (REF)	H MAX.	J ±.002
-3-1	.1900-32 UNJF-3B	.750	.454	.335	.194	.250	.250	.830	.486
-3-2						.312			
-3-3						.375			
-3-4						.438			
-3-5						.500			
-3-6						.562			
-4-1	.2500-28 UNJF-3B	.900	.554	.375	.254	.295	.310	1.050	.707
-4-2						.357			
-4-3						.419			
-4-4						.481			
-4-5						.543			
-4-6						.605			
-5-1	.3125-24 UNJF-3B	1.050	.650	.480	.317	.344	.373	1.100	.707
-5-2						.400			
-5-3						.461			
-5-4						.524			
-5-5						.586			
-5-6						.649			

DASH NUMBER	THREAD 	K DIA. +.005 -.000	L C'BORE MIN. (REF)	M MAX.	N ±.010	R (REF)	V ±.005	MAX. WEIGHT LBS/100
-3-1	.1900-32 UNJF-3B	.098	.070	.484	.077	.120	.032	.83
-3-2			.125					.90
-3-3			.188					.94
-3-4			.250					.99
-3-5			.313					1.04
-3-6			.375					1.09
-4-1	.2500-28 UNJF-3B	.098	.070	.584	.077	.120	.032	1.44
-4-2			.125					1.53
-4-3			.188					1.62
-4-4			.250					1.69
-4-5			.313					1.79
-4-6			.375					1.89
-5-1	.3125-24 UNJF-3B	.130	.070	.720	.100	.140	.040	2.27
-5-2			.125					2.33
-5-3			.188					2.43
-5-4			.250					2.55
-5-5			.313					2.65
-5-6			.375					2.74

DRAWING PROVIDES FORM, FIT
AND FUNCTION DATA. DO NOT
ATTEMPT TO MANUFACTURE
PRODUCT USING THIS DRAWING.

DRAWN BY: BLA	DATE 4-25-89
MFG. ENGRS. J.K.	DATE 6-13-89
APPROVED BY: GENSEN	DATE 5/22/89
APPROVED BY:	DATE
PROJECT NUMBER	89-167

TITLE: NUT PLATE FLAT BEAM LOCK, CLIP-IN, 250 CYCLE, ALLOY STEEL, CORNER TYPE	
UNLESS OTHERWISE SPECIFIED:	
TOLERANCES:	
DECIMALS:	.XX ±.02 .XXX ±.010 ANGLES: 2°
MILLIMETERS	± 0.50 ± 0.25
SURFACE FINISH	125 MICROINCHES

Tridair fasteners
REXNORD SPECIALTY FASTENER DIVISION 3000 W. LONITA BOULEVARD TORRANCE, CA 90505
FBL10076-()-()
FSC: 29372 SHEET 2 OF 4

INTERIM DOCUMENT REVISION		
Rev.	Date	DAF #
202	10/21/10	94301

TABLE II

PART NUMBER	SEATING TORQUE (MAX)	INSTALLATION OR REMOVAL TORQUE (MAX)	BREAKAWAY TORQUE (MIN)	AXIAL TENSILE STRENGTH (POUNDS MIN.)
FBL10076-3-()	36.0 IN/LBS.	18.0 IN/LBS.	2.0 IN/LBS.	2,825
FBL10076-4-()	60.0 IN/LBS.	30.0 IN/LBS.	3.5 IN/LBS.	5,060
FBL10076-5-()	120.0 IN/LBS.	60.0 IN/LBS.	6.5 IN/LBS.	8,000

PART NUMBER	PUSHOUT STRENGTH (LBS.MIN.)	TORQUE-OUT STRENGTH (IN/LBS.MIN)
FBL10076-3-()	100	60
FBL10076-4-()	125	100
FBL10076-5-()	125	160

NOTES: (UNLESS OTHERWISE SPECIFIED.)

2. MATERIAL:

- 2.1. NUT: 4140 OR 8740 ALLOY STEEL PER MIL-S-5626 OR MIL-S-6049.
 2.2. CAGE: STEEL PER AMS5085 OR QQ-S-635.
 2.3. CLIP: 302 CRES STEEL PER AMS5688 OR ARMCO 18-2MN CRES.

3. HEAT TREAT:

- 3.1. NUT: 180 KSI MIN. ULTIMATE TENSILE STRENGTH PER MIL-H-6875.
 3.2. CAGE: 160 KSI MIN. ULTIMATE TENSILE STRENGTH PER MIL-H-6875.

4. FINISH:

- 4.1. NUT: CADMIUM PLATE PER QQ-P-416, TYPE I, CLASS 2, WITH 23 HOUR BAKE TO RELIEVE HYDROGEN EMBRITTLEMENT, AND DRY FILM LUBE PER MIL-L-8937
 4.2. CAGE: CADMIUM PLATE PER QQ-P-416, TYPE II, CLASS 2.
 4.3. CLIP: PASSIVATE PER QQ-P-35.



5. THREADS PER MIL-S-8879 EXCEPT IN LOCKING AREA AND PRIOR TO LUBRICATION.

6. ANTI-SEIZE COMPOUND PER MIL-A-907 APPLIED TO INTERNAL THREADS.

7. FLOAT OF NUT PORTION OF ASSEMBLY SHALL BE .030 MINIMUM RADially FROM CENTERED POSITION. NUT BODY SHALL BE CAPABLE OF ENGAGEMENT WITH A BOLT IN THE MAXIMUM MISALIGNED POSITION.

8. PUSHOUT, TORQUE-OUT AND AXIAL TENSILE STRENGTH OF NUT PLATE SHALL BE AS SPECIFIED IN TABLE II.

9. LOCKING TORQUE:

THE SELF LOCKING FEATURE SHALL BE A FLAT BEAM TYPE CAPABLE OF 250 SEATED USEABLE CYCLES WHEN TESTED WITH A 160 KSI MINIMUM ULTIMATE TENSILE STRENGTH, CADMIUM PLATED, ALLOY STEEL BOLT. LOCKING TORQUE LIMITS SHALL BE AS SPECIFIED IN TABLE II.



10. MINIMUM "E" NOT SPECIFIED, LIMITED ONLY BY STRENGTH REQUIREMENTS.

11. THE ASSEMBLY SHALL PROVIDE A BEARING SURFACE FOR THE NUT WITHIN THE CAGE.

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REVISION SEE SHEET 1

INTERIM DOCUMENT REVISION	Rev	Date	DAF #
NR1	10/21/10	94301	

DRAWN BY: BLA		DATE: 4-25-89	TITLE: NUT PLATE FLAT BEAM LOCK, CLIP-IN, 250 CYCLE, ALLOY STEEL, CORNER TYPE		 REXNORD SPECIALTY FASTENER DIVISION 3000 N. LOMITA BOULEVARD TORRANCE, CA. 90505
MFG. ENGRS: J.K.		DATE: 6-13-89			
APPROVED BY: (Signature)		DATE: 5/22/89			
APPROVED BY:		DATE:			
PROJECT NUMBER: 89-167	UNLESS OTHERWISE SPECIFIED:		TOLERANCES:	MILLIMETERS	SURFACE FINISH
	DECIMALS: .XX ±.02			± 0.50	125 MICROINCHES
	ANGLES: .XXX ±.010			± 0.25	
				FBL10076-()-()	
				FSC: 29372	
				SHEET 3 OF 4	

12. SHAPE WITHIN ENVELOPE SHOWN OPTIONAL.

13. NUT PLATES ARE SIMILIAR TO THE DIMENSIONAL ENVELOPE SPECIFIED IN NAS1793.



14. CAGE SHALL BE IDENTIFIED WITH MANUFACTURER'S IDENTIFICATION, RAISED OR DEPRESSED .010 MAXIMUM. LOCATION OPTIONAL EXCEPT SHALL BE VISIBLE AFTER ASSEMBLY.



15. TOP OF NUT FLANGE SHALL BE IDENTIFIED WITH MANUFACTURER'S IDENTIFICATION AND SECOND DASH NUMBER OF ASSEMBLY TO INDICATE "L" COUNTERBORE DEPTH. MARKING SHALL BE RAISED OR DEPRESSED .010 MAXIMUM. LOCATION OPTIONAL.

16. NUT ELEMENT IS REMOVABLE AND REPLACEABLE, SEE BELOW FOR PART NUMBERS:

ASSEMBLY P/N	NUT ELEMENT P/N	RETAINING CLIP P/N
FBL10076-3-()	FBL10041-3-()	FBL10059-3R
FBL10076-4-()	FBL10041-4-()	FBL10059-4R
FBL10076-5-()	FBL10041-5-()	FBL10059-5R

17. PART CALLOUT EXAMPLE:

FBL10076-4-2

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.

INTERIM DOCUMENT REVISION

Rev	Date	LIAP #
NR1	10/21/10	94301

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DRAWN BY: BLA MFG. ENGRS. J.K. APPROVED BY: G. J. J. J. PROJECT NUMBER 89-167	DATE 4-25-89 DATE 6-13-89 DATE 7/27/89 DATE DATE	TITLE: NUT PLATE FLAT BEAM LOCK, CLIP-IN, 250 CYCLE, ALLOY STEEL, CORNER TYPE	Tridair fasteners REKORD SPECIALTY FASTENER DIVISION 3000 W. LOMITA BOULEVARD TORRANCE, CA. 90505
UNLESS OTHERWISE SPECIFIED: TOLERANCES: DECIMALS: .XX ±.02 .XXX ±.010 ANGLES: ±2°		MILLIMETERS ± 0.50 ± 0.25	SURFACE FINISH 125 MICROINCHES
FBL10076-()-() FSC: 29372		SHEET 4 OF 4	

FBL.SALES.FBL10076-X-X

SEE SHEET 1

REVISION

SCANNED