

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

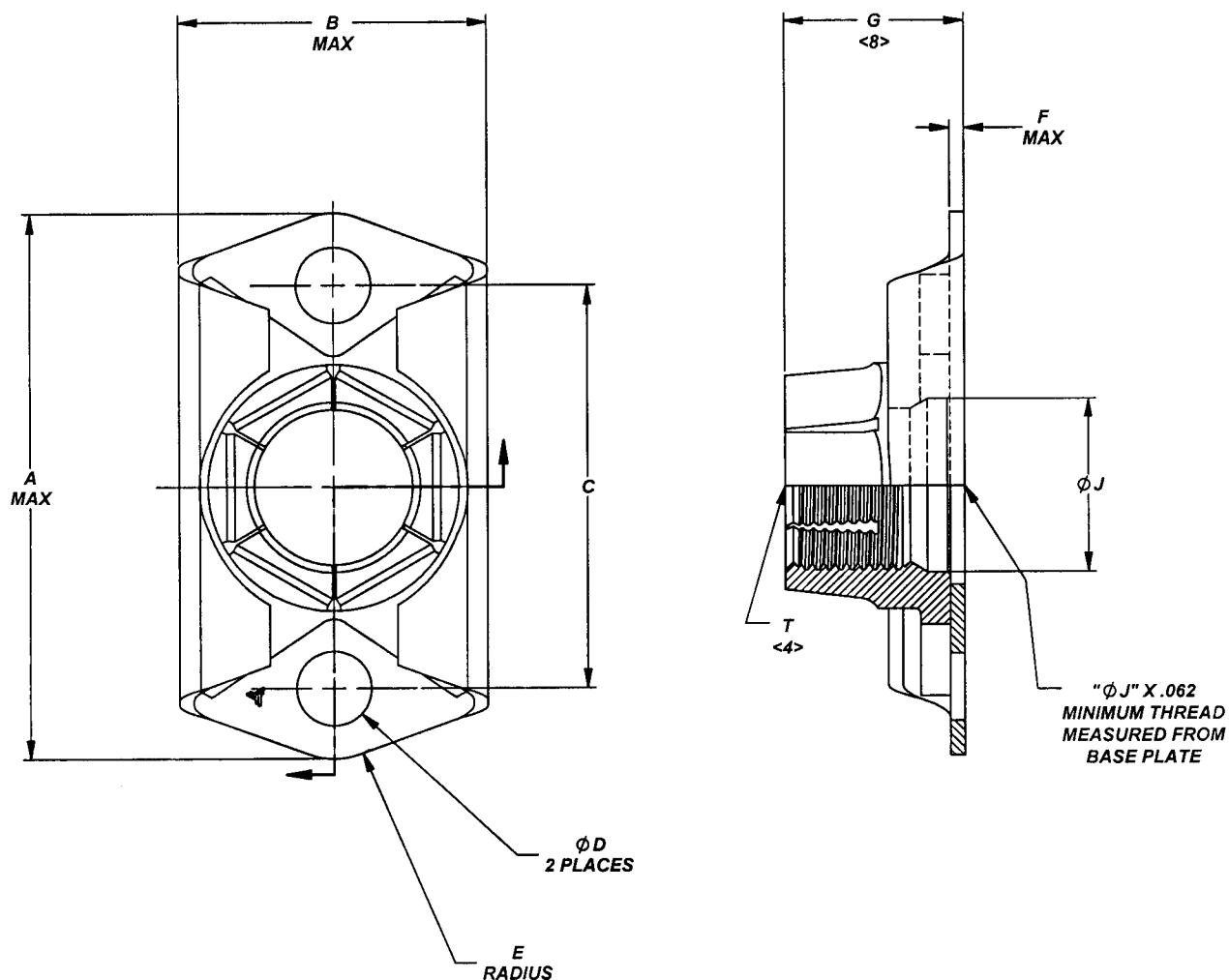
MANUFACTURE OF THE PROPRIETARY PARTS SHOWN HERE WITHOUT WRITTEN
CONSENT OF ALCOA FASTENING SYSTEMS IS ABSOLUTELY PROHIBITED.THIS DRAWING EMBODIES A CONFIDENTIAL, PROPRIETARY DESIGN & ALL DESIGN, MANUFACTURING
PRODUCTION, USE & SALE RIGHTS REGARDING SAME ARE EXPRESSLY RESERVED.

TABLE 1

DASH NUMBER	T THREAD SIZE	A MAX	B MAX	C ±.002	D +.005 -.000	E MIN	F MAX	G MAX	Φ J MIN	WEIGHT LBS.100 MAXIMUM	AXIAL STRENGTH MINIMUM LBS	SEATING TORQUE MAXIMUM IN-LBS
- 5	.3125-24UNJF-3B	1.010	.581	.718	.130	.117	.045	.328	.317	1.10	7,000	120.0

APPROVED DATE
11 AUG 03REV. LETTER AND DATE
A 2 AUG 16DAF NUMBER
DAF 114625

CURRENT DESIGN ACTIVITY:

Alcoa
Fastening
Systems & Rings

CAMLOC PRODUCTS
 3012 W. LOMITA BLVD.
 TORRANCE, CA. 90505

TITLE:

NUT PLATE
FLOATING, FLAT BEAM LOCK,
50 CYCLES, TWO LUG, REDUCED RIVET
SPACING, A286 CRES, 450°

 UNLESS OTHERWISE SPECIFIED
 DIMENSIONS ARE IN INCHES &
 ASME Y14.5M TOLERANCES:

 ANGLES
 DECIMALS
 .XX = ±.02
 .XXX = ±.010

CURRENT DESIGN ACTIVITY:

CAGE CODE: 71286

SALES DRAWING NO.

FBL10147C-5

SHEET 1 OF 2

S45075

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

NOTES; UNLESS OTHERWISE SPECIFIED:

1. MATERIAL:

- 1.1 NUT: A286 CRES STEEL PER AMS5731, AMS5732, AMS5734 OR AMS5737.
- 1.2 CAGE: 300 SERIES CRES PER AMS5517 OR AMS5515.

2. HEAT TREAT:

- 2.1 NUT: 160 KSI MINIMUM PER AMS-H-6875 OR AMS2759.

3. FINISH:

- 3.1 NUT: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. MOLYBDENUM DISULFIDE DRY FILM COAT PER AS5272.
- 3.2 CAGE: CADMIUM PLATE PER AMS-QQ-P-416, TYPE II, CLASS 2. <SEE NOTE 3.2.1>.
- 3.2.1 THE CAGE COMPONENT IS DEFORMED AFTER CADMIUM PLATING AS PART OF THE ASSEMBLY PROCESS. PLATING THICKNESS IS WAIVED ON THE DEFORMED AREAS AND LOCALIZED BARE AREAS ARE ACCEPTABLE AT THE CONTACT LOCATIONS IN THE DEFORMED ZONES.

<4> THREADS PER AS8879 EXCEPT IN LOCKING AREA AND PRIOR TO LUBRICATION.

- 5. ANTI-SEIZE COMPOUND PER MIL-DTL-907 ADDED TO INTERNAL THREAD.

6. LOCKING TORQUE:

- 6.1 THE SELF-LOCKING FEATURE SHALL BE A FLAT BEAM TYPE CAPABLE OF 50 SEATED USEABLE CYCLES WHEN TESTED WITH A 160,000 PSI MINIMUM ULTIMATE TENSILE STRENGTH BOLT. SEATING TORQUE SHALL BE AS SPECIFIED IN TABLE 1 LOCKING TORQUE LIMITS SHALL BE AS SPECIFIED IN NASM25027 TABLE III.
- 7. FLOAT OF NUT PORTION OF ASSEMBLY SHALL BE .020 MINIMUM RADIALLY FROM CENTERED POSITION. NUT BODY SHALL BE CAPABLE OF ENGAGEMENT WITH A BOLT IN THE MAXIMUM MISALIGNED POSITION.

<8> MINIMUM "G" NOT SPECIFIED. LIMITED ONLY BY STRENGTH REQUIREMENTS.

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

10. NUT PUSHOUT AND TORQUE-OUT SHALL BE AS SPECIFIED IN NASM25027.

11. NUT PLATES ARE SIMILAR TO THE DIMENSIONAL ENVELOPE SPECIFIED IN NAS1068 AND MS21075.

12. PART CALLOUT EXAMPLE:

- 12.1 FBL10147 C - 5
 - .3125-24UNJF-3B THREAD SIZE
 - "C" AFTER BASIC PART NUMBER DESIGNATES CADMIUM PLATED CAGE
 - BASIC PART NUMBER

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SHEET 2 OF 2