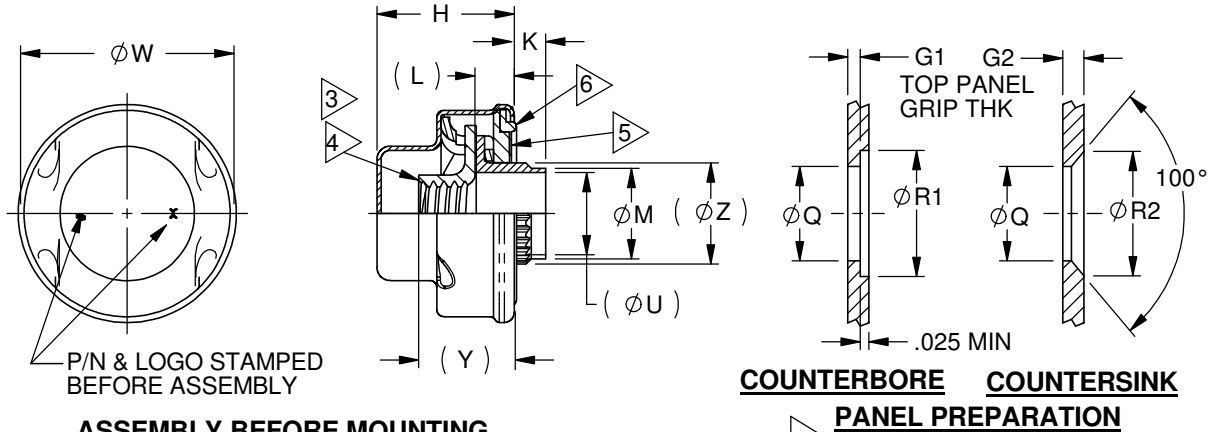




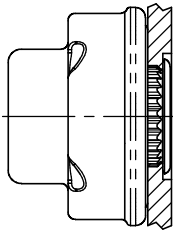
Arconic Fastening Systems and Rings
Tucson Operations
3724 East Columbia Street
Tucson, Arizona 85714 USA
Phone (520) 519-7400
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NUTPLATE ENGINEERING STANDARD



ASSEMBLY BEFORE MOUNTING

**COUNTERBORE COUNTERSINK
PANEL PREPARATION**



**ASSEMBLY AFTER
MOUNTING**

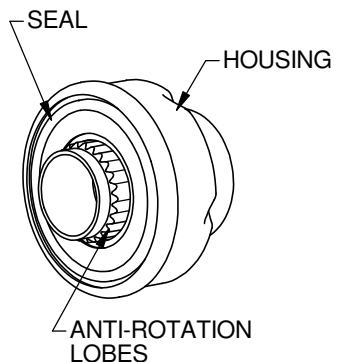
PART NO. CALLOUT SLP 6010 ()-()-()

MODEL

SERIES

THREAD SIZE CODE	H MAX	(L)	Ø M MAX	Ø Q		Ø R1 +.020 -.000	Ø R2 ±.010	(Ø U)	Ø W MAX	Y ±.025	(Ø Z)
				SOFT	HARD						
4, 4F, 6, 6F, M3, M3.5	.405	.127	.217	.218	.218	.312	.307	.192	.592	.241	.228
8, 8F, 10, 10C, 10F, M4, M5	.425	.136	.270	.272	.281	.375	.370	.245	.687	.277	.294
12, 12C, 12F, M6	.560	.162	.335	.339	.348	.515	.437	.310	.812	.352	.363

GRIP CODE	G1 TOP PANEL GRIP THICKNESS	G2 TOP PANEL GRIP THICKNESS	K ±.025
AA	N/A	.055 -.073	.073
A	.031-.062	.074 -.106	.099
B	.063 -.094	.107 -.133	.130
C	.095 -.125	.134 -.165	.161
D	.126 -.156	.166 -.196	.192
E	.157 -.187	.197 -.227	.223
F	.188 -.218	.228 -.258	.254
G	.219 -.250	.259 -.289	.285
H	.251 -.281	.290 -.320	.316
J	.282 -.312	.321 -.351	.347
K	.313 -.343	.352 -.382	.378
L	.344 -.374	.383 -.413	.409



THREAD SIZE CODE	THREAD SIZE	LEAD	THREAD SIZE CODE	THREAD SIZE	LEAD
4	.112-40 UNJC-3B	SINGLE	8F	.164-32 UNJC-3B	QUAD
6	.138-32 UNJC-3B		10F	.190-32 UNJF-3B	
8	.164-32 UNJC-3B		12F	.250-28 UNJF-3B	
10	.190-32 UNJF-3B		M3	MJ3 x 0.5-4h6h	METRIC
12	.250-28 UNJF-3B		M3.5	MJ3.5 x 0.6-4h6h	
10C	.190-24 UNJC-3B	SINGLE (COARSE)	M4	MJ4 x 0.7-4h6h	
12C	.250-20 UNJC-3B		M5	MJ5 x 0.8-4h6h	
4F	.112-40 UNJC-3B	DOUBLE	M6	MJ6 x 1.0-4h6h	
6F	.138-32 UNJC-3B				

CODE	NUT TYPE
L	LOCKING
NL	NON-LOCKING

H	PER ECN 13773, Changed installation tools on sheet 2	Current Design Activity CAGE Code OHDW7	TOLERANCE UNLESS OTHERWISE NOTED: .X = ±.05 .XX = ±.02 .XXX = ±.015 ANGLES ±0.5°	DRAWN BY C. MARTINEZ
	ISSUED 10/20/2005	SELF-SEALING NUTPLATE, STANDARD, 250° STEEL, RIVETLESS, LOW PROFILE	DIMENSIONS IN INCHES	CHECKED BY SIGNATURE ON FILE
	REVISED 06-07-2017			SLP6010
	PAGE 1 OF 2			S-2947

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NUTPLATE

ENGINEERING STANDARD

MATERIAL:

BRACKET: 1050 CARBON STEEL PER AMS 5085, HEAT TREAT TO HRC 42-47
HOUSING: 300 SERIES CRES PER AMS 5514
NUT: 1050 CARBON STEEL PER AMS 5085, HEAT TREAT TO
160 KSI MIN ULTIMATE TENSILE STRENGTH
SLEEVE: CRES PER AMS 5639 (304) OR AMS 5514 (305)
SEAL: BUNA-N PER MIL-R-6855, CLASS 1 & 2, GRADE 60

FINISH CODE:

BRACKET, SLEEVE & NUT: CAD PLATE PER AMS QQ-P-416, TYPE II, CLASS 2
HOUSING: PASSIVATE PER AMS2700
NUT: DRI-FILM LUBE PER AS5272
SEAL: NONE

NOTES:

- 1 "AA" GRIP RECOMMENDED PANEL PREPARATION
SIZE 12, 12C, 12F & M6: NOT RECOMMENDED FOR LESS THAN .060 THICKNESS
SIZES 8, 8F, 10, 10C, 10F, M4 & M5: "ØQ DIMENSION IS .276/.281, "ØR2 DIMENSION IS .343
SIZES 4, 4F, 6, 6F, M3 & M3.5: "ØR2 DIMENSION IS .275
- 2 SOFT: DIMENSIONS FOR SOFT ALUMINUM ALLOYS AND PLASTICS
HARD: DIMENSIONS FOR HARD ALUMINUM ALLOYS AND STEEL
- 3 A MINIMUM OF TWO THREADS ARE DEFORMED TO PRODUCE SELF-LOCKING ACTION
PER NASM25027 WHEN LOCKING FEATURE IS DESIRED.
- 4 NUT ELEMENT HAS .060 TOTAL RADIAL FLOAT FOR GRIP LENGTHS 'AA' THRU 'C';
.046 MIN FOR GRIPS GREATER THAN 'C'.
- 5 NUT ELEMENT DOT IDENTIFICATION COLOR CODE:
YELLOW FOR COARSE THREADS
ORANGE FOR FAST LEAD THREADS
GREEN FOR NON-LOCKING STANDARD THREADS
BLUE FOR METRIC LOCKING/NON-LOCKING THREADS
NONE FOR LOCKING STANDARD THREADS
- 6 SEALING PERFORMANCE MEETS OR EXCEEDS NAS 1473 STD. FOR TEST INFORMATION SEE
REPORT C-10724
- 7 FOR HIGH VOLUME INSTALLATION RATES, ALTERNATIVE POWER TOOLING IS AVAILABLE:
CONTACT FACTORY FOR ADDITIONAL INFORMATION.
- 8 CLASS -3B "J" THREADS PER SAE-AS-8879. METRIC "J" THREADS PER ASME B1.21M.
- 9 "K" IS MEASURED FROM THE BOTTOM OF THE ROLLED-OVER HOUSING.

7 HAND INSTALLATION TOOLS () = THREAD SIZE CODE

C'BORE	C'SINK
DCBT8600 - ()	DCST8600 - ()

H	PER ECN 13773, Changed installation tools on sheet 2		Current Design Activity CAGE Code OHDW7	TOLERANCE UNLESS OTHERWISE NOTED: .X = ±.05 .XX = ±.02 .XXX = ±.015 ANGLES ±0.5°		DRAWN BY C. MARTINEZ	
					CHECKED BY	SIGNATURE ON FILE	
ISSUED	10/20/2005	SELF-SEALING NUTPLATE, STANDARD, 250° STEEL, RIVETLESS, LOW PROFILE			SLP6010		
REVISED	06-07-2017						
PAGE	2 OF 2				S-2947		
DIMENSIONS IN INCHES							

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