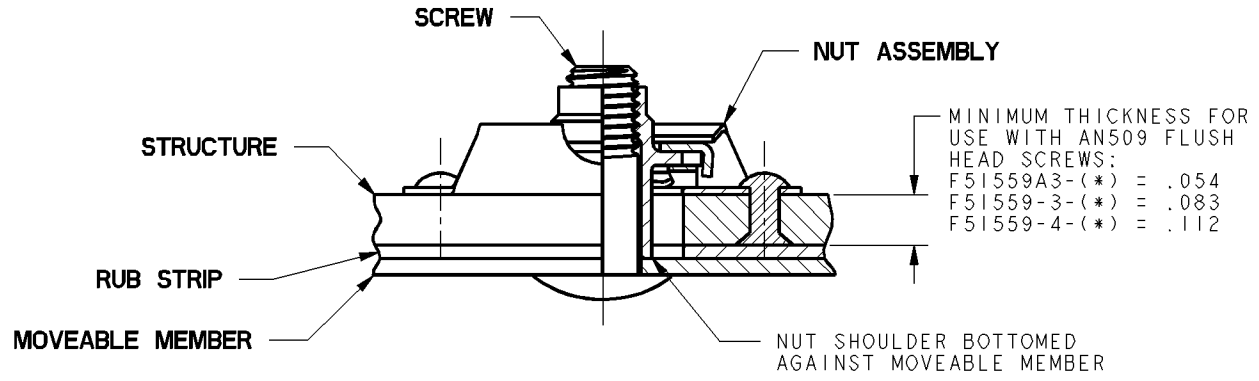
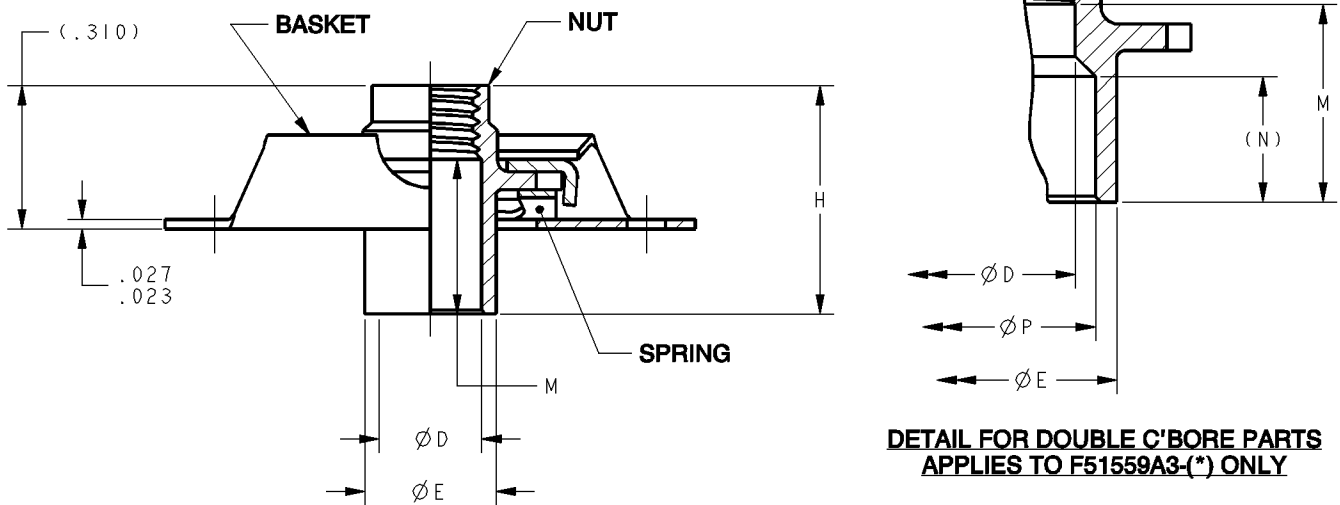
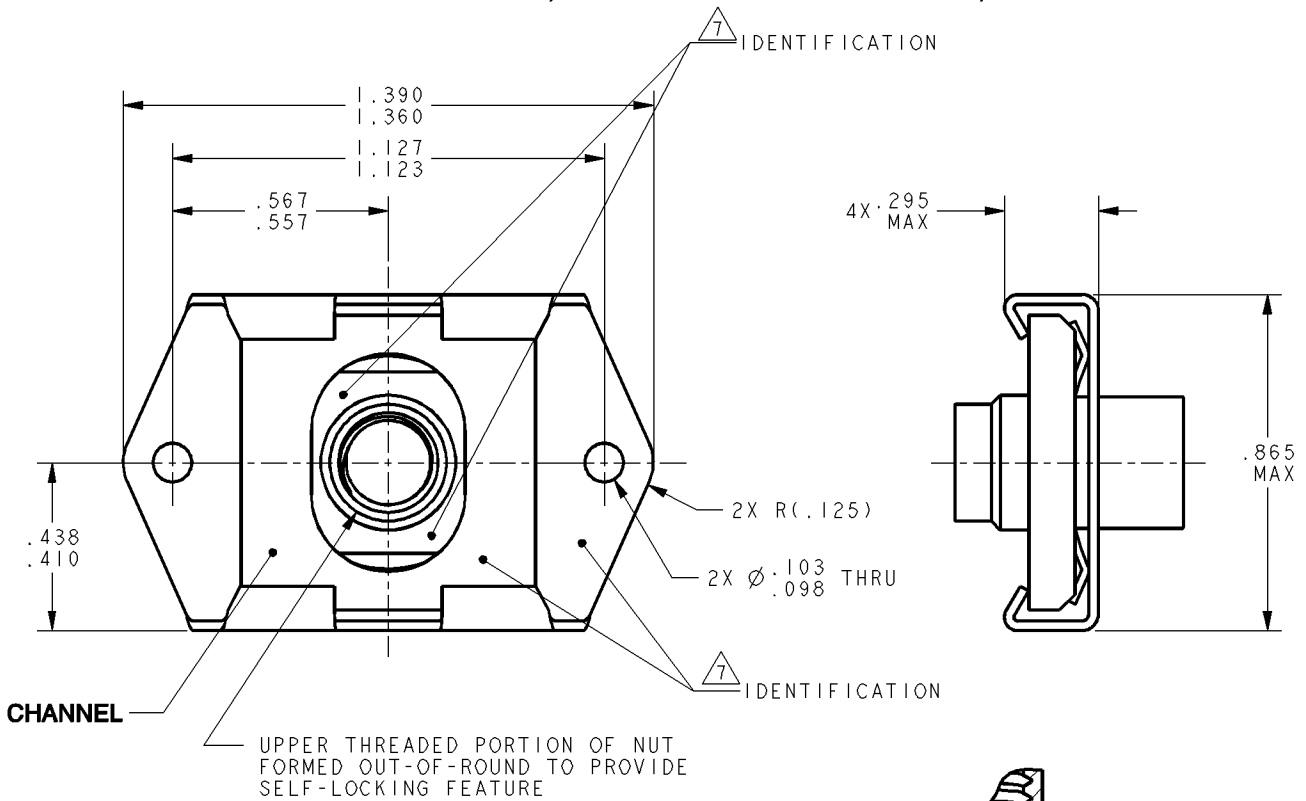


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THIRD ANGLE PROJECTION


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FILE STORED AS: S.F51559	APPROVED DATE 24OCT1979	CURRENT DESIGN ACTIVITY:	TITLE: <b>NUT - ANCHOR, 2 LUG, FLOATING, SELF-LOCKING, SPRING LOADED, ASSEMBLY</b>	CURRENT DESIGN ACTIVITY: <b>CAGE CODE: 15653</b>
	REV. LETTER AND DATE <b>B</b> 12OCT2017	<b>ARCONIC</b> Arconic Fastening Systems and Rings Fullerton Operations 800 S State College Boulevard Fullerton, California, 92831	UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES & ASME Y14.5-2009 TOLERANCES: DECIMALS = ±.015; ANGLES = ±2°	<b>SALES DRAWING No.</b>
	CUSTOMER:			<b>F51559-(*)-(*)</b>


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AFSR PRODUCTS PART NO.	THREADS PER AS8879	STRUCTURE THICKNESS +.004 -.005	ØD	E	H MAX	M ±.005	SHANK LENGTH DASH NO. ▲
F51559-3-	9	.1900-32UNJF-3B		.200 .195	.255 .250	.173	1
	0					.178	
	10					.183	2
	11					.193	3
	1					.195	
	2					.203	4
	3					.213	5
	12					.223	6
	4					.226	
	13					.233	7
	14					.243	8
	15					.253	9
	16					.263	10
	6					.271	
	17					.273	11
	18					.283	12
	19					.293	13
	20					.303	20
	21					.313	21
	7					.318	
	22					.323	22
	23					.333	23
	24					.343	24
	25					.353	25
	26					.363	26
	27					.373	27
	28					.383	28
	29					.393	29
	31					.413	31
	32					.423	32
	33					.433	33
	34					.443	34
	35					.453	35
	36					.463	36
	37					.473	37
	38					.483	38
	39					.493	39
	40					.503	40
	41					.513	41
	42					.523	42
	43					.533	43

THIRD ANGLE PROJECTION 

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	REV. LETTER AND DATE <b>B</b> 12OCT2017		UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES & ASME Y14.5-2009 TOLERANCES: DECIMALS = ±.015; ANGLES = ±2°	<b>SALES DRAWING No.</b>
	CUSTOMER:			<b>F51559-(*)-(*)</b>

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AFSR PRODUCTS PART NO.	THREADS PER AS8879	STRUCTURE THICKNESS +.004 -.005	ØD	E	H	M	(N)	ØP	SHANK LENGTH DASH NO. ▲	
					MAX	±.005				
F51559A3-	9	.1900-32UNJF-3B	.035	.200 .195	.345 .340	.313	.173	.048	.270 .265	1
	0		.040			.318	.178	.053		
	10		.045			.323	.183	.058		2
	11		.055			.333	.193	.068		3
	1		.057			.335	.195	.063		
	2		.065			.343	.203	.078		4
	3		.075			.353	.213	.088		5
	12		.085			.363	.223	.098		6
	4		.088			.366	.226	.103		
	13		.095			.373	.233	.108		7
	14		.105			.383	.243	.118		8
	15		.115			.393	.253	.128		9
	16		.125			.403	.263	.138		10
	6		.133			.411	.271	.143		
	17		.135			.413	.273	.148		11
	18		.145			.423	.283	.158		12
	19		.155			.433	.293	.168		13
	20		.165			.443	.303	.178		20
	21		.175			.453	.313	.188		21
	7		.180			.458	.318	.193		
	22		.185			.463	.323	.198		22
	23		.195			.473	.333	.208		23
	24		.205			.483	.343	.218		24
	25		.215			.493	.353	.228		25
	26		.225			.503	.363	.238		26
	27		.235			.513	.373	.248		27
	28		.245			.523	.383	.258		28
	29		.255			.533	.393	.268		29
	31		.275			.553	.413	.288		31
	32		.285			.563	.423	.298		32
	33		.295			.573	.433	.308		33
	34		.305			.583	.443	.318		34
	35		.315			.593	.453	.328		35
	36		.325			.603	.463	.338		36
	37		.335			.613	.473	.348		37
	38		.345			.623	.483	.358		38
	39		.355			.633	.493	.368		39
	40		.365			.643	.503	.378		40
	41		.375			.653	.513	.388		41
	42		.385			.663	.523	.398		42
	43		.395			.673	.533	.408		43


THIRD ANGLE PROJECTION EAR EXPORT CONTROLLED TECHNICAL DATA: DISTRIBUTION LIMITED TO U.S. PERSONS OR THOSE NON-U.S. PERSONS COVERED BY AN APPROPRIATE EXPORT LICENSE OR ALLOWED FOR BY THE APPROPRIATE REGULATIONS. ECCN: EAR99.

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	CUSTOMER:			<b>F51559-(*)-(*)</b>

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					MAX	±.005		
F51559-4-	09	.2500-28UNJF-3B	.035	.270 .265	.345 .340	.313	.173	1
	10		.045			.323	.183	2
	11		.055			.333	.193	3
	1		.057			.335	.195	
	2		.065			.343	.203	4
	3		.075			.353	.213	5
	12		.085			.363	.223	6
	4		.088			.366	.226	
	13		.095			.373	.233	7
	14		.105			.383	.243	8
	15		.115			.393	.253	9
	16		.125			.403	.263	10
	17		.135			.413	.273	11
	18		.145			.423	.283	12
	9		.150			.428	.278	
	19		.155			.433	.293	13
	20		.165			.443	.303	20
	21		.175			.453	.313	21
	22		.185			.463	.323	22
	23		.195			.473	.333	23
	24		.205			.483	.343	24
	25		.215			.493	.353	25
	26		.225			.503	.363	26
	27		.235			.513	.373	27
	28		.245			.523	.383	28
	29		.255			.533	.393	29
	31		.275			.553	.413	31
	32		.285			.563	.423	32
	33		.295			.573	.433	33
	34		.305			.583	.443	34
	35		.315			.593	.453	35
	36		.325			.603	.463	36
	37		.335			.613	.473	37
	38		.345			.623	.483	38
	39		.355			.633	.493	39
	40		.365			.643	.503	40
	41		.375			.653	.513	41
	42		.385			.663	.523	42
	43		.395			.673	.533	43

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MATERIAL: NUT -- 4130 ALLOY STEEL PER AMS6370 (UNS G41300), HEAT TREATED, OR 8740 ALLOY STEEL PER AMS6322 (UNS G87400), HEAT TREATED.  
 BASKET, CHANNEL & SPRING -- 17-7PH CORROSION RESISTANT STEEL PER AMS5528 (UNS S17700).

FINISH: F51559-3-(\*), F51559A3-(\* ) & F51559-4-(\*):  
 NUT -- CADMIUM PLATED PER AMS-QQ-P-416, TYPE II, CLASS 2, PLUS DRY FILM LUBRICANT COAT PER AS5272, TYPE I.  
 EMBRITTLEMENT TEST PER AMS-QQ-P-416 DOES NOT APPLY.  
 BASKET, CHANNEL & SPRING -- PASSIVATE PER AMS2700 AND DRY FILM LUBRICANT COAT PER AS5272, TYPE I.  
 F51559-3-(\* )C, F51559A3-(\* )C & F51559-4-(\* )C:  
 NUT, BASKET & CHANNEL -- CADMIUM PLATED PER AMS-QQ-P-416, TYPE II, CLASS 2, PLUS DRY FILM LUBRICANT COAT PER AS5272, TYPE I.  
 EMBRITTLEMENT TEST PER AMS-QQ-P-416 DOES NOT APPLY.  
 SPRING -- PASSIVATE PER AMS2700 AND DRY FILM LUBRICANT COAT PER AS5272, TYPE I.  
 DRY FILM LUBRICANT TO MEET HYDRAULIC FLUID RESISTANCE WHEN TESTED PER ASTM D2510, USING ASI241 PHOSPHATE ESTER HYDRAULIC FLUIDS.

PERFORMANCE: NASM25027 FOR REGULAR NUTS, EXCEPT AS FOLLOWS:  
 A) TORQUE OUT REQUIREMENTS OF NASM25027 NOT APPLICABLE.  
 B) AXIAL TENSILE STRENGTH OF NUT ASSEMBLY 700 lbf MINIMUM.  
 C) NASM25027 AXIAL TENSILE VALUES APPLY TO NUT ELEMENT ONLY.

- NOTES: 1. FLOATABILITY: RADIALLY FROM CENTERED POSITION:  
 F51559-3-(\* ) = .150 MINIMUM.  
 F51559A3-(\* ) = .100 MINIMUM.  
 F51559-4-(\* ) = .100 MINIMUM.
2. SPRING LOAD SHALL BE 25 lb ± 3 lb, WHEN THE NUT ELEMENT SHANK PROTRUDES FROM THE BEARING SURFACE OF THE BASKET AT A DISTANCE EQUAL TO THE NOMINAL STRUCTURE THICKNESS. ADDITIONAL PROTRUSION OF .013 ± .007 WILL CAUSE THE NUT ELEMENT FLANGE TO BOTTOM OUT.
4. IN A TYPICAL INSTALLATION, PRELOAD IS OBTAINED AND LIMITED BY DRAWING THE SHOULDER OF THE NUT UP TO THE SURFACE OF THE MOVEABLE MEMBER. WITH THE SCREW REMOVED, THE SPRING MUST HOLD THE NUT IN POSITION WITHIN LIMITS OF THE FLOAT TO PERMIT THE ALIGNMENT OF THE NUT AND SCREW.
5. WITH THE SCREW REMOVED, SPRING MUST HOLD NUT IN ANY SELECTED POSITION WITHIN LIMITS OF THE FLOAT TO PERMIT ALIGNMENT OF NUT AND SCREW DURING REASSEMBLY.
6. PRELOAD IS OBTAINED AND LIMITED BY PULLING THE SHOULDER OF THE NUT UP TO THE SURFACE OF THE MOVEABLE MEMBER CONTROLLING INITIAL COMPRESSION OF THE SPRING.


IDENTIFICATION, MARK AS FOLLOWS:  
 F51559-(\* )-(\* ) -- MARK "NAS1803" ON TOP OF CHANNEL OR BASKET, PLUS MANUFACTURER'S TRADEMARK, AND SHANK LENGTH DASH NO. AS TABULATED ▲ ON TOP OF NUT OR BASKET.  
 F51559-(\* )-(\* )C - MARK "NAS1803" ON TOP OF CHANNEL OR BASKET, PLUS MANUFACTURER'S TRADEMARK, AND SHANK LENGTH DASH NO. AS TABULATED ▲ AND LETTER "C" ON TOP OF NUT OR BASKET.

ALL MARKINGS INDENTED .010 MAXIMUM, ORIENTATION OPTIONAL.

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