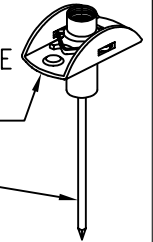


NUTPLATE CONFORMS TO AND MEETS THE STRENGTH REQUIREMENTS OF MIL-N-25027.

NUTPLATE ATTACHED BY MEANS OF ADHESIVE APPLIED TO THIS SURFACE

DISPOSABLE STEM ENGAGED BY INSTALLATION TOOL DURING SLEEVE FLARE OPERATION.



NOTE: ALL DIMENSIONS BEFORE PAINT.

PART NUMBER	THREAD T	A MAX	B MAX	D MAX	H MAX	R MIN
CB6109 () 3 () 1 () ()	.1900-32 UNJF-3B	.745	.454	.250	.240	.070
CB6109 () 3 () 2 () ()					.319	.125
CB6109 () 3 () 3 () ()					.382	.188
CB6109 () 3 () 4 () ()					.444	.250
CB6109 () 3 () 5 () ()					.516	.313
CB6109 () 3 () 6 () ()					.578	.375
CB6109 () 4 () 1 () ()	.2500-28 UNJF-3B	.948	.554	.312	.302	.070
CB6109 () 4 () 2 () ()					.361	.125
CB6109 () 4 () 3 () ()					.420	.188
CB6109 () 4 () 4 () ()					.486	.250
CB6109 () 4 () 5 () ()					.552	.313
CB6109 () 4 () 6 () ()					.615	.375
CB6109 () 5 () 1 () ()	.3125-24 UNJF-3B	1.042	.650	.375	.346	.070
CB6109 () 5 () 2 () ()					.403	.125
CB6109 () 5 () 3 () ()					.464	.188
CB6109 () 5 () 4 () ()					.539	.250
CB6109 () 5 () 5 () ()					.601	.313
CB6109 () 5 () 6 () ()					.664	.375
CB6109 () 6 () 1 () ()	.3750-24 UNJF-3B	1.182	.750	.437	.389	.070
CB6109 () 6 () 2 () ()					.439	.125

UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES AND TOLERANCES ARE AS SHOWN BELOW. DIMENSIONAL TOLERANCES AND SYMBOLS PER ANSI Y14.5M-1982.

PROPRIETARY PARTS SHOWN IN THIS DRAWING ARE THE SUBJECT OF ISSUED UNITED STATES AND FOREIGN PATENTS AND PATENTS PENDING. UNAUTHORIZED REPRODUCTION AND/OR DISTRIBUTION OF THIS DRAWING IS SPECIFICALLY PROHIBITED.

CLICK BOND

CARSON CITY
NEVADA 89706

CAD CB6109-1

APPROVALS	DATE
DRAWN RGP	12FEB96
CHECKED DAC	12FEB96
RELEASED CGH	14FEB96
REVISED RGP	12FEB96

TITLE			
NUTPLATE, TWO LUG, FLARE SLEEVE			
SIZE	CAGE CODE	DWG. NO.	REV.
A	66530	CB6109	3
SCALE	2/1 12FEB96		SHEET 1 OF 3

TABLE 2 INSTALLATION HOLE SIZE AND REPLACEMENT COMPONENT PART NUMBERS

THD SIZE CODE	U		V		NUT PART NO *	CLIP PART NO
	MIN	MAX	MIN	MAX		
3	.255	.262	.335	.345	CB6001()3-()	CB6002-3
4	.317	.324	.397	.407	CB6001()4-()	CB6002-4
5	.380	.387	.460	.470	CB6001()5-()	CB6002-5
6	.442	.449	.522	.532	CB6001()6-()	CB6002-6

- * () FIRST BRACKET - DESIGNATES NUT MATERIAL CODE.
 CR = A-286 CRES, PASSIVATE, DRI FILM LUBE
 CRC = A-286 CRES, CADMIUM PLATING, DRI FILM LUBE.
- () SECOND BRACKET - DESIGNATES NUTPLATE COUNTERBORE DEPTH CODE.

BASEPLATE MATERIAL AND FINISH DATA

CODE	MATERIAL	SPECIFICATION	FINISH	SPECIFICATION
A	ALUMINUM	QQ-A-250	NONE	
AA	ALUMINUM	QQ-A-250	ANODIZE	MIL-A-8625, TY 1
CR	A-286 CRES	AMS 5525	PASSIVATE	QQ-P-35

NUT MATERIAL AND FINISH

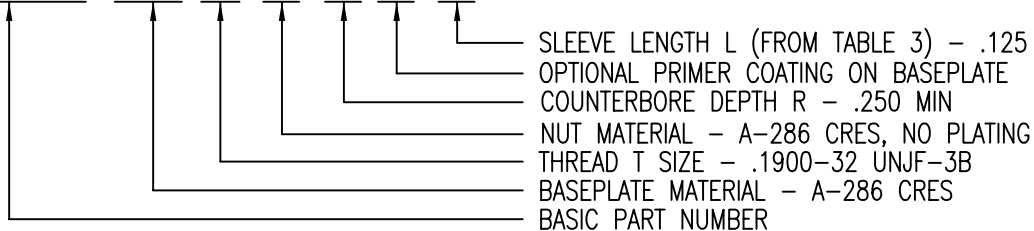
CODE	MATERIAL	FINISH
-	A-286 CRES	NO PLATING
CRC	A-286 CRES	CADMIUM PLATING

- MATERIAL: NUT ELEMENT: A-286 CRES (SEE CB6001)
 CLIP: 302 CRES OR ARMC0 18-2 MN CRES (SEE CB6002)
 SLEEVE: 304 OR 305 CRES PER AMS 5639 OR 5514
- FINISH: NUT ELEMENT: PASSIVATE, PLATE, AND DRI-FILM LUBE (SEE CB6001)
 CLIP: PASSIVATE PER QQ-P-35 (SEE CB6002)
 SLEEVE: PASSIVATE PER QQ-P-35

OPTIONAL PRIMER COATING ON BASEPLATE: EPOXY PRIMER PER MIL-P-85582.

EXAMPLE PART NUMBER

CB6109 CR 3 - 4 P 4



UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES AND TOLERANCES ARE AS SHOWN BELOW. DIMENSIONAL TOLERANCES AND SYMBOLS PER ANSI Y14.5M-1982.

PROPRIETARY PARTS SHOWN IN THIS DRAWING ARE THE SUBJECT OF ISSUED UNITED STATES AND FOREIGN PATENTS AND PATENTS PENDING. UNAUTHORIZED REPRODUCTION AND/OR DISTRIBUTION OF THIS DRAWING IS SPECIFICALLY PROHIBITED.

GLICK BOND

CARSON CITY
NEVADA 89706

CAD CB6109-2		APPROVALS		DATE		TITLE			
ANGLES ±1°		DRAWN	RGP	14FEB96		NUTPLATE, TWO LUG, FLARE SLEEVE			
.XX	±.03	CHECKED	DAC	14FEB96		SIZE	CAGE CODE	DWG. NO.	REV.
.XXX	±.010	RELEASED	CGH	14FEB96		A	66530	CB6109	3
.XXXX	±.001	REVISED	RGP	14FEB96		SCALE	2/1 12FEB96		SHEET 2 OF 3

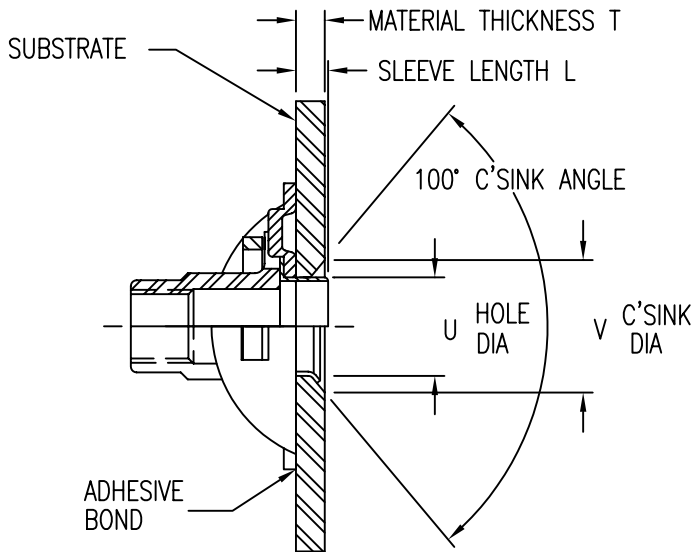
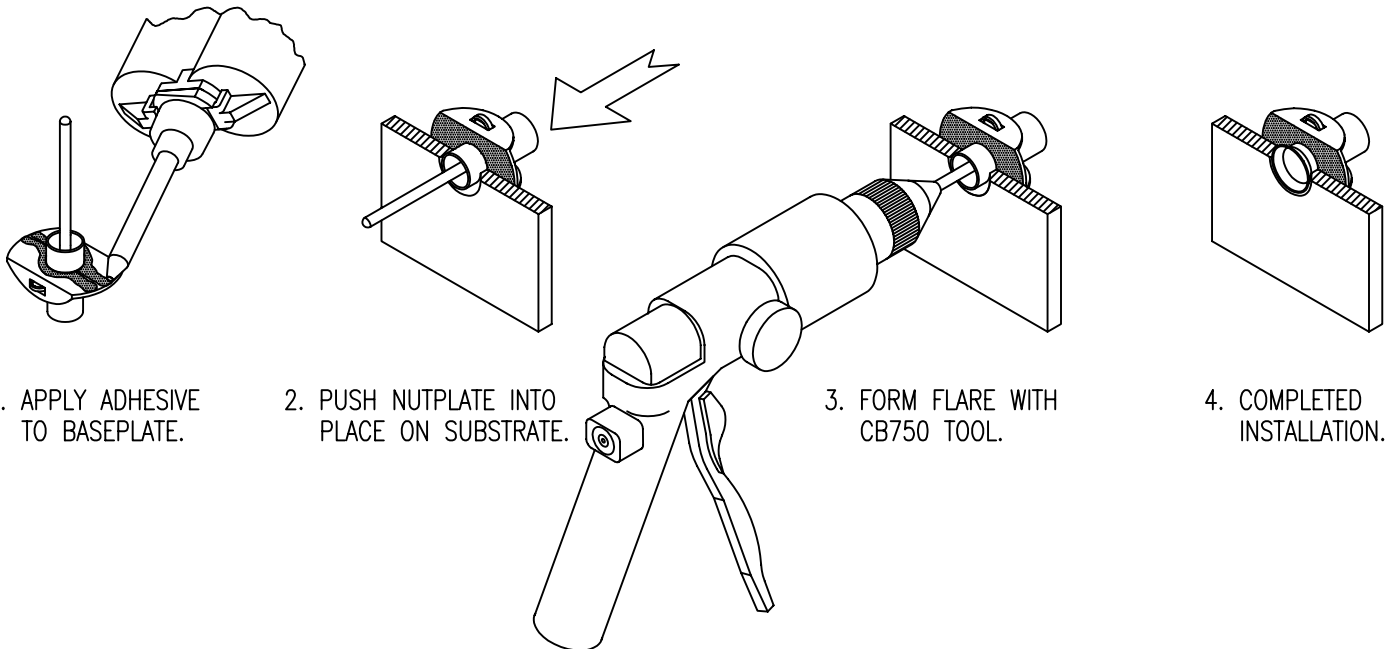


TABLE 3 SLEEVE LENGTH SELECTION DATA

SLEEVE LENGTH CODE	SLEEVE LENGTH L ± .010	MATL THICK T	
		MIN	MAX
2	.062	.046	.077
3	.093	.078	.108
4	.125	.109	.139
5	.156	.140	.170
6	.187	.171	.202
7	.218	.203	.233
8	.250	.234	.264
9	.281	.265	.295
10	.312	.296	.327
11	.343	.328	.358
12	.375	.359	.389
13	.406	.390	.420
14	.437	.421	.452
15	.468	.453	.483
16	.500	.484	.514

TYPICAL INSTALLATION SEQUENCE



UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES AND TOLERANCES ARE AS SHOWN BELOW. DIMENSIONAL TOLERANCES AND SYMBOLS PER ANSI Y14.5M-1982.

PROPRIETARY PARTS SHOWN IN THIS DRAWING ARE THE SUBJECT OF ISSUED UNITED STATES AND FOREIGN PATENTS AND PATENTS PENDING. UNAUTHORIZED REPRODUCTION AND/OR DISTRIBUTION OF THIS DRAWING IS SPECIFICALLY PROHIBITED.

CLICK BOND

CARSON CITY
NEVADA 89706

CAD CB6109-3	
ANGLES	±1°
.XX	±.03
.XXX	±.010
.XXXX	±.001

APPROVALS		DATE
DRAWN	RGP	12FEB96
CHECKED	DAC	12FEB96
RELEASED	CGH	14FEB96
REVISED	RGP	12FEB96

TITLE NUTPLATE, TWO LUG, FLARE SLEEVE			
SIZE	CAGE CODE	DWG. NO.	REV.
A	66530	CB6109	3
SCALE	2/1	12FEB96	SHEET 3 OF 3