ASSEMBLY BEFORE MOUNTING

COUNTERBORE IS OPTIONAL
COUNTERSINK

TOP PANEL GRIP .THK.

TOP PANEL GRIP .THK.

.025 MIN.

100°

ASSEMBLY AFTER MOUNTING

PART NUMBER CALLOUT

GFP 6010 ( ) ( ) ( )

MODEL

SERIES

THREADED SIZE CODE

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<tr>
<th>Ø M MAX</th>
<th>Ø Q</th>
<th>Ø R1</th>
<th>Ø R2</th>
<th>(Ø U)</th>
<th>W</th>
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GRIP CODE

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<td>B</td>
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<td>D</td>
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<td>E</td>
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THREAD SIZE CODE

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<td>.158-32 UNJC-3B</td>
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NUT PLATE, RIVETLESS, 450° F.
FLOATING, ALL CRES, STANDARD DIAMETER SLEEVE, ALL SIZES

Alcoa Fastening Systems
AEROSPACE FASTENER DIVISION
3724 EAST COLUMBIA STREET
TUCSON, ARIZONA 85714
PHONE 520 519-7400
FAX 520 519-7427
www.huckaerospace.com

S-1216
REV W

DCN 3654 10-13-05

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS IN INCHES
TOLERANCE UNLESS OTHERWISE NOTED:
X = ±.05 ANGLES ±.5°
XX = ±.02
XXX = ±.015

SCALE: 2:1 SHEET 1 OF 2
MATERIAL:
SLEEVE: CRES PER AMS 5639 (304) OR AMS 5514 (305)
BRACKET: 17-7 PH CRES PER AMS 5528, H.T. TO
180 KSI MIN ULTIMATE TENSILE STRENGTH
NUT: A-286 CRES PER AMS 5625 OR 5737, H.T. TO
160 KSI MIN ULTIMATE TENSILE STRENGTH
FINISH CODE:
BRACKET, NUT & SLEEVE: PASSIVATE PER AMS QQ-P-35
NUT: DRI-FILM LUBRICANT PER MIL-PRF-46010

NOTES:

1. "AA" GRIP RECOMMENDED PANEL PREPARATION:
   SIZES 12, 12C, 12F, M6 NOT RECOMMENDED FOR LESS THAN .060 PANEL THICKNESSES
   SIZES 8, 8F, 10, 10C, 10F, M4, M5 - "0" DIMENSION .276-.281, "0R2" DIMENSION .343
   SIZES 4, 4F, 6, 6F, M3, M3.5 - "0R2" DIMENSION .275

2. SOFT - DIMENSION FOR SOFT ALUMINUM ALLOYS & PLASTICS
   HARD - DIMENSION FOR HARD ALUMINUM ALLOYS & STEEL
   (SEE PCD 160012 FOR MORE DETAILS)

3. A MINIMUM OF TWO THREADS ARE DEFORMED TO PRODUCE SELF-LOCKING
   ACTION PER NASM25027, WHEN LOCKING FEATURE IS REQUIRED.

4. NUT ELEMENT HAS .060 TOTAL RADIAL FLOAT FOR GRIP LENGTHS "AA"
   THRU "C" AND .048 MIN. FOR GRIP LENGTHS GREATER THAN "C".

5. FOR NUT ELEMENT REPLACEMENT PN SEE DWG. S-0877.

6. NUT ELEMENT REMOVAL TOOL AVAILABLE, PN RB 6527.

7. TO OBTAIN ADDITIONAL WEIGHTS ADD INCREMENTS OF .010 LBS/100 PER LETTER CODE
   FOR SIZES 4, 4F, 6, 6F, M3, M3.5; .020 LBS/100 FOR SIZES 8, 8D, 8F, M4, 10, 10C, 10F, M5, 12, 12C, 12F, M6.

8. NUT ELEMENT COLOR CODE: (PCD 160147)
   NONE - LOCKING STANDARD THREADS
   GREEN - NONLOCKING STANDARD THREADS
   YELLOW - COARSE THREADS
   ORANGE - FAST LEAD THREADS
   BLUE - "MJ" METRIC THREADS.

9. COMPLETE TOOL ASSEMBLY INCLUDES NOSE PIECE, PULLER, & HANDLE. "N" DESIGNATES
   COUNTERBORE, "S" DESIGNATES COUNTERSINK.

10. FOR HIGH VOLUME INSTALLATION RATES, ALTERNATE POWER TOOLING IS AVAILABLE.
    PLEASE CONTACT AFS INSTALLATION SYSTEMS FOR MORE INFORMATION.

11. THREAD DIMENSIONS APPLY PRIOR TO APPLICATION OF DRI-FILM LUBRICANT. POSSIBLE THREAD
    TIGHTNESS DUE TO LUBE BUILDUP WILL DIMINISH FOLLOWING ENGAGEMENT OF MATING PART.

12. THREADS ARE CUT FOR THREAD SIZE CODES 8, 8F, M4, 10, 10C, 10F, M5, 12, 12C, 12F, M6.

13. LOCKING TORQUE VALUES OF SIZES 8, 8F, M4, 10, 10C, 10F, M5, 12, 12C, 12F, M6 ARE TO SATISFY
    SNECMA DT57-11.

### HAND INSTALLATION TOOL SELECTION TABLE

<table>
<thead>
<tr>
<th>COMPLETE HAND TOOL ASSEMBLY</th>
<th>PULLER</th>
<th>NOSE PIECE</th>
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<tbody>
<tr>
<td>CBORE</td>
<td>C'SINK</td>
<td>DTP86230-()</td>
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<td>DCBT86600-()</td>
<td>DCST8600-()</td>
<td>DCSN86130-()</td>
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</tbody>
</table>

### INSTALLATION TOOLS:

- ARBOR PRESS TOOL HW (* 7659-()
- ANVIL HW (* 7658-()
- FORMER HW (* 7657-()

### HAND INSTALLATION TOOLS:

- NOSE PIECE
- PULLER
- HANDLE ASSEMBLY TA7533

---

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**DATE:** 10/13/2005  **PART NO.:** GFP6010  **DRAWN:** JLS  **CHECK:**  **CAGE CODE:** 0HD7  **REV:** W  **SCALE:** 2:1  **SHEET 2 OF 2**