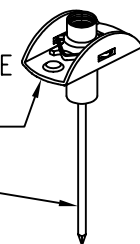


NUTPLATE CONFORMS TO AND MEETS THE STRENGTH REQUIREMENTS OF MIL-N-25027.

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.

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**GLICK BOND**

CARSON CITY  
NEVADA 89706

CAD CB6109-1

APPROVALS DATE

TITLE  
NUTPLATE, TWO LUG, FLARE SLEEVE

ANGLES ±1°

DRAWN RGP 12FEB96

SIZE A CAGE CODE 66530 DWG. NO. CB6109 REV. 3

.XX ±.03

CHECKED DAC 12FEB96

.XXX ±.010

RELEASED CGH 14FEB96

.XXXX ±.001

REVISED RGP 12FEB96

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

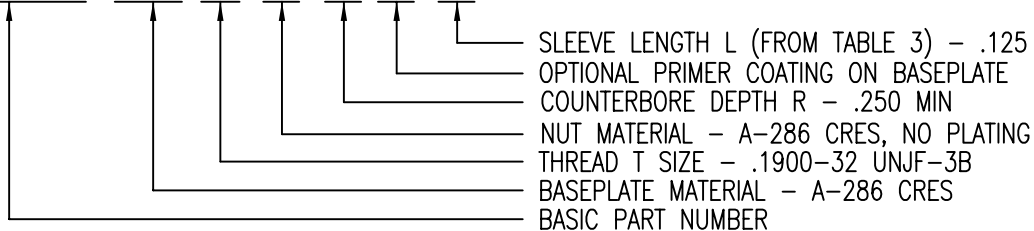
CODE	MATERIAL	FINISH
-	A-286 CRES	NO PLATING
CRC	A-286 CRES	CADMIUM PLATING

- 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



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**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
.XXX ±.010		RELEASED	CGH	14FEB96		A	66530
.XXXX ±.001		REVISED	RGP	14FEB96		DWG. NO.	CB6109
				SCALE	2/1	12FEB96	REV. 3
						SHEET	2 OF 3

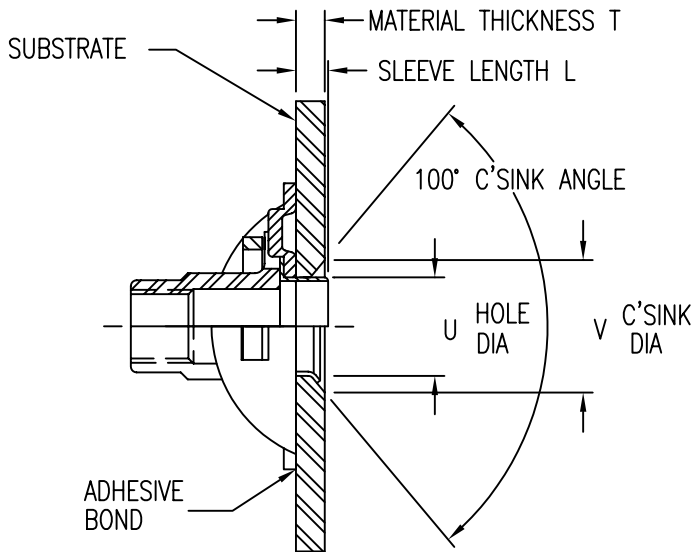
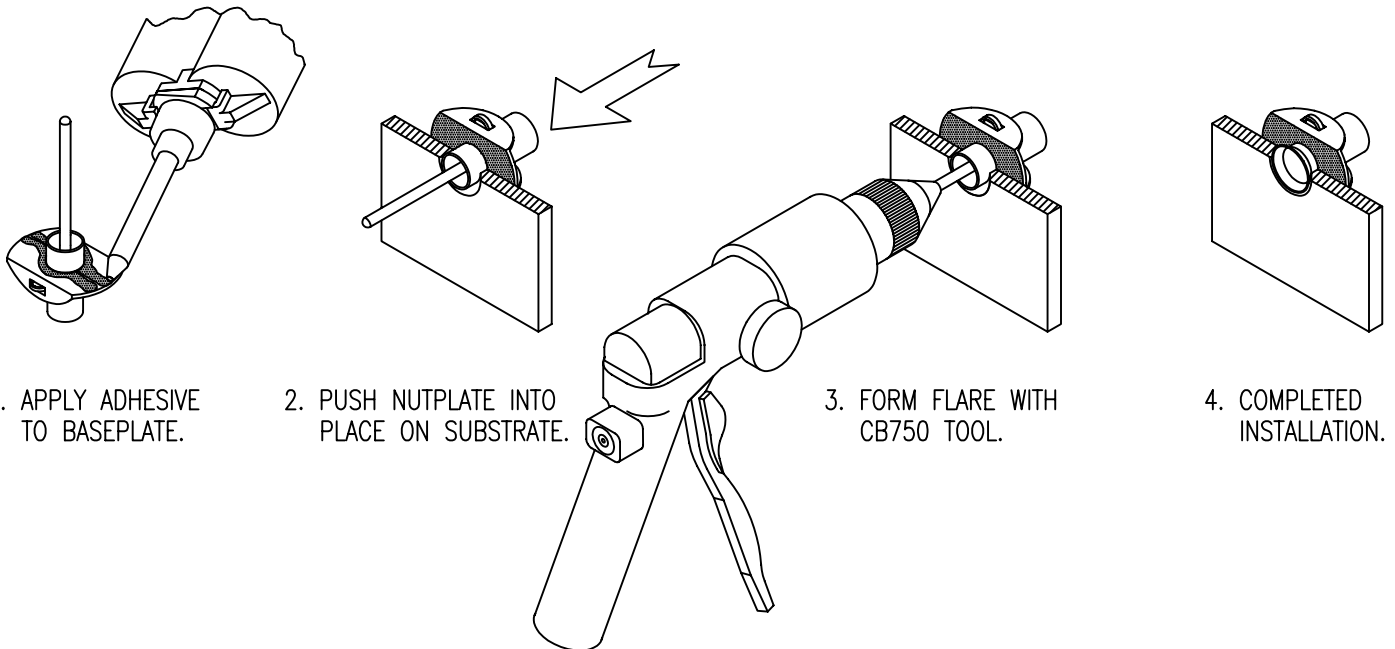


TABLE 3 SLEEVE LENGTH SELECTION DATA

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



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**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