CB6001 NUT ELEMENT FLOATS .020 MIN FROM CENTER.

THREAD T PER MIL-S-8879. THREAD LOCK BY ELLIPTICAL DEFORMATION PER NASM25027.

CB6002 CLIP CAN BE REMOVED WITH PLIERS TO REPLACE NUT.
BASEPLATE

NUTPLATE MEETS THE STRENGTH REQUIREMENTS OF NASM25027.
NOTE: ALL DIMENSIONS BEFORE PAINT.

DI INSIDE SLEEVE DIA AFTER EXPANSION

TYPICAL COMPLETED INSTALLATION

NUTPLATE DIMENSIONS

<table>
<thead>
<tr>
<th>PART NUMBER</th>
<th>THREAD T</th>
<th>A MAX</th>
<th>B MAX</th>
<th>DI</th>
<th>DO REF</th>
<th>E MAX</th>
<th>H MAX</th>
<th>R MIN</th>
<th>DH</th>
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</thead>
<tbody>
<tr>
<td>CB6307 () 3 () 1 () ()</td>
<td>.1900–32 UNJF-3B</td>
<td>.652</td>
<td>.454</td>
<td>.194</td>
<td>.190</td>
<td>.187</td>
<td>.275</td>
<td>.070</td>
<td>.337</td>
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<tr>
<td>CB6307 () 3 () 2 () ()</td>
<td>.2500–28 UNJF-3B</td>
<td>.810</td>
<td>.554</td>
<td>.254</td>
<td>.250</td>
<td>.218</td>
<td>.444</td>
<td>.188</td>
<td>.506</td>
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</table>

EXAMPLE PART NUMBER
CB6307 CR 3 - 1 P 200

"NL" SUFIX TO PART NUMBER INDICATES NON-LOCKING NUT ELEMENT.

OPTIONAL FINISH ON SLEEVE – PASSIVATE
SLEEVE LENGTH L IN THOUSANDS – .200
OPTIONAL PRIMER COATING ON BASEPLATE
THREAD RELIEF R – .070 MIN
NUT MATERIAL – A-286 CRES, DRI-FILM LUBE
THREAD T SIZE – .1900–32 UNJF-39
BASEPLATE MATERIAL – A-286 CRES

BASIC PART NUMBER

CARSON CITY NEVADA 89706

FLEX FIT CAD CB6307-1

APPROVALS

DRAWN DAC 17SEP01
CHECKED DAC 17SEP01
RELEASED CGH 10CT01
REVISED

SCALE 2/1 17SEP01
### Replacement Component Part Numbers

<table>
<thead>
<tr>
<th>Thread Size Code</th>
<th>Nut Part No</th>
<th>Clip Part No</th>
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<tr>
<td>3</td>
<td>CB6001 (    ) 3—( )</td>
<td>CB6002—3</td>
</tr>
<tr>
<td>4</td>
<td>CB6001 (    ) 4—( )</td>
<td>CB6002—4</td>
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</tbody>
</table>

* First ( ) designates nut material code.
  - CR = A-286 CRES, PASSIVATE, DRI—FILM LUBE.
  - CRC = A-286 CRES, CADMIUM PLATING, DRI—FILM LUBE.
  - CRS = A-286 CRES, SILVER PLATING.

* Second ( ) designates nutplate thread relief (nut c’bore) code.
  - "NL" suffix to nut part no. indicates non—locking nut element.

### Baseplate Material and Finish Data

<table>
<thead>
<tr>
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<th></th>
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<tbody>
<tr>
<td>A</td>
<td>ALUMINUM</td>
<td>QQ—A—250</td>
<td>NONE</td>
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<tr>
<td>AA</td>
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<td>QQ—A—250</td>
<td>ANODIZE</td>
<td>MIL—A—8625, TY 1</td>
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<td>A—286 CRES</td>
<td>AMS 5525</td>
<td>PASSIVATE</td>
<td>QQ—P—35</td>
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</tbody>
</table>

Optional primer coating on baseplate: epoxy primer per MIL—P—85582.

### Nut Material and Finish Data (See CB6001)

<table>
<thead>
<tr>
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<tr>
<td>—</td>
<td>A—286 CRES</td>
<td>PASSIVATE</td>
<td>QQ—P—35</td>
<td>DRI—FILM LUBE</td>
<td>MIL—L—46010, TY 1</td>
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<tr>
<td>CRC</td>
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<td>CADMIUM PLATING</td>
<td>QQ—P—416</td>
<td>DRI—FILM LUBE</td>
<td>MIL—L—46010, TY 1</td>
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<td>CRS</td>
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<td>SILVER PLATING</td>
<td>AMS 2410</td>
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</table>

### Sleeve Material and Finish Data

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<tbody>
<tr>
<td>NONE</td>
<td>A—286 CRES</td>
<td>AMS 5525 OR 5639</td>
<td>PASSIVATE</td>
<td>QQ—P—35</td>
</tr>
<tr>
<td>A</td>
<td>A—286 CRES</td>
<td>AMS 5525 OR 5639</td>
<td>IVD ALUMINUM</td>
<td>MIL—DL—83488</td>
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<tr>
<td>C</td>
<td>A—286 CRES</td>
<td>AMS 5525 OR 5639</td>
<td>CAD PLATE</td>
<td>QQ—P—416</td>
</tr>
</tbody>
</table>

### Clip Material and Finish Data:

**Material:** 302 CRES PER AMS 5688 OR 5866, OR 18—2 MN CRES PER ARMCO SPEC. (SEE CB6002)

**Finish:** PASSIVATE PER QQ—P—35. (SEE CB6002)
1. Drill hole in substrate and check DH with plug gage.

2. Apply mixed adhesive to nutplate baseplate and pass mandrel through substrate hole.

3. Place pull tool over mandrel and rotate nutplate to desired orientation.

4. Actuate tool to pull mandrel.

5. Mandrel pulls through sleeve expanding sleeve and substrate hole.

6. Check sleeve inside diameter DI with plug gage.

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

FLEX FIT
CAD CB6307-3

APPROVALS: DAC 17SEP01
CHECKED: DAC 17SEP01
RELEASED: CGH 10CT01
REVISION: 

TITLE: NUTPLATE, CORNER, FLEX SLEEVE

SIZE: A 66530 CB6307

SCALE: 2/1 17SEP01

SHEET 3 OF 3