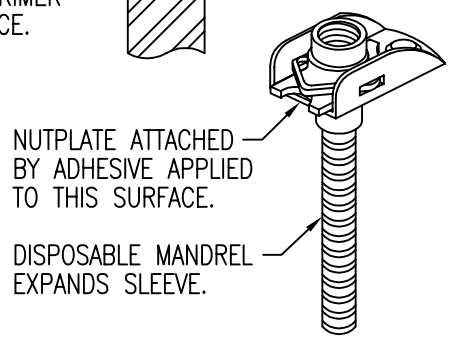


DI INSIDE SLEEVE DIA AFTER EXPANSION
TYPICAL COMPLETED INSTALLATION

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



NUTPLATE DIMENSIONS

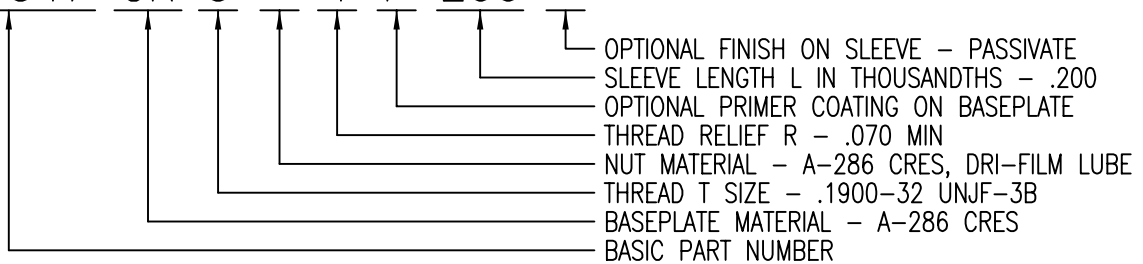
SLEEVE EXPANSION (DI FINAL) BASED ON HIGH STRENGTH ALUMINUM SUBSTRATE.

PART NUMBER	THREAD T	A MAX	B MAX	DI	DO REF	E MAX	H MAX	R MIN	DH
CB6347 () 3 () 1 () ()	.1900-32 UNJF-3B	.652	.454	.194	.214	.187	.275	.070	.2165
CB6347 () 3 () 2 () ()							.337	.125	
CB6347 () 3 () 3 () ()							.400	.188	
CB6347 () 3 () 4 () ()							.463	.250	
CB6347 () 3 () 5 () ()							.527	.313	
CB6347 () 3 () 6 () ()							.589	.375	
CB6347 () 4 () 1 () ()	.2500-28 UNJF-3B	.810	.554	.254	.270	.218	.320	.070	.2720
CB6347 () 4 () 2 () ()							.382	.125	
CB6347 () 4 () 3 () ()							.444	.188	
CB6347 () 4 () 4 () ()							.506	.250	
CB6347 () 4 () 5 () ()							.568	.313	
CB6347 () 4 () 6 () ()							.630	.375	

EXAMPLE PART NUMBER

CB6347 CR 3 - 1 P 200

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



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.



CARSON CITY NEVADA 89706

FLEX FIT
CAD CB6347-1

ANGLES	±1°
.XX	±.03
.XXX	±.010
.XXXX	±.001

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

TITLE NUTPLATE, CORNER, FLEX SLEEVE			
SIZE A	CAGE CODE 66530	DWG. NO. CB6347	REV. 0
SCALE 2/1	17SEP01		SHEET 1 OF 3

REPLACEMENT COMPONENT PART NUMBERS

THREAD SIZE CODE	NUT PART NO *	CLIP PART NO
3	CB6001 () 3-()	CB6002-3
4	CB6001 () 4-()	CB6002-4

* 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

CODE	MATERIAL	SPEC.	FINISH	SPEC.
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

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

NUT MATERIAL AND FINISH DATA (SEE CB6001)

CODE	MATERIAL	FINISH	SPEC.	LUBRICATION	SPEC.
-	A-286 CRES	PASSIVATE	QQ-P-35	DRI-FILM LUBE	MIL-L-46010, TY 1
CRC	A-286 CRES	CADMIUM PLATING	QQ-P-416	DRI-FILM LUBE	MIL-L-46010, TY 1
CRS	A-286 CRES	SILVER PLATING	AMS 2410	NONE	

SLEEVE MATERIAL AND FINISH DATA

CODE	MATERIAL	SPEC.	FINISH	SPEC.
NONE	A-286 CRES	AMS 5525 OR 5639	PASSIVATE	QQ-P-35
A	A-286 CRES	AMS 5525 OR 5639	IVD ALUMINUM	MIL-DTL-83488
C	A-286 CRES	AMS 5525 OR 5639	CAD PLATE	QQ-P-416

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)

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FLEX FIT
CAD CB6347-2

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GLICK BOND

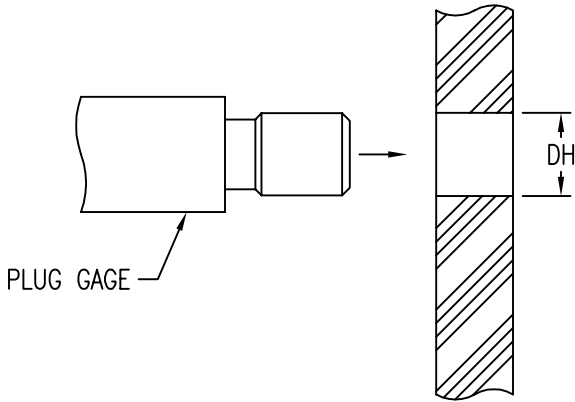
CARSON CITY
NEVADA 89706

ANGLES	±1°
.XX	±.03
.XXX	±.010
.XXXX	±.001

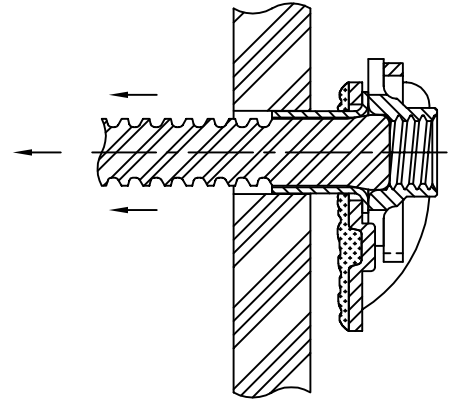
APPROVALS		DATE
DRAWN	DAC	17SEP01
CHECKED	DAC	17SEP01
RELEASED	CGH	10CT01
REVISED		

TITLE			
NUTPLATE, CORNER, FLEX SLEEVE			
SIZE	CAGE CODE	DWG. NO.	REV.
A	66530	CB6347	0
SCALE	2/1	17SEP01	SHEET 2 OF 3

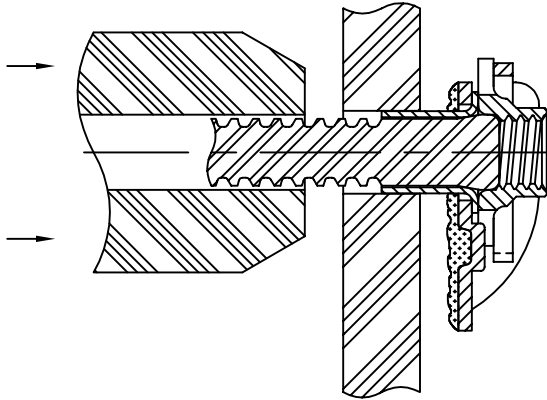
1. DRILL HOLE IN SUBSTRATE AND CHECK DH WITH PLUG GAGE.



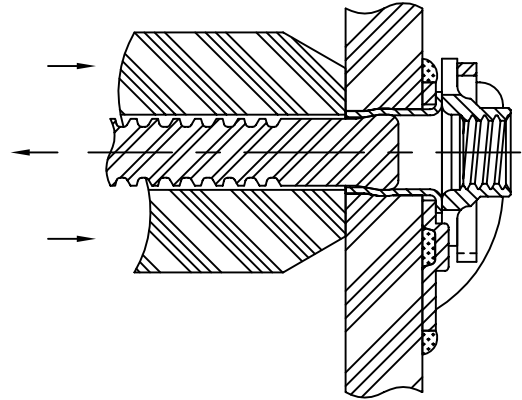
2. APPLY MIXED ADHESIVE TO NUTPLATE BASEPLATE AND PASS MANDREL THROUGH SUBSTRATE HOLE.



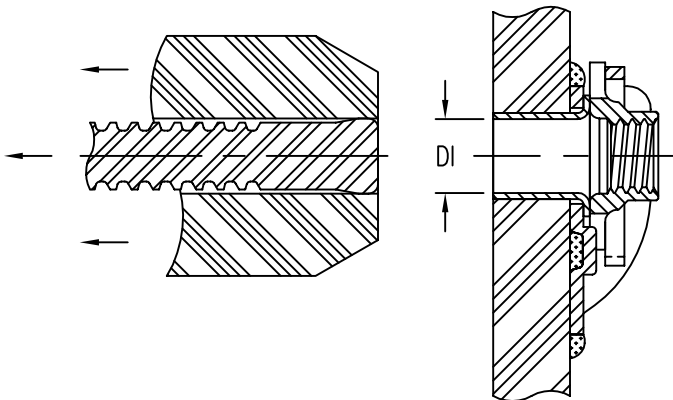
3. PLACE PULL TOOL OVER MANDREL AND ROTATE NUTPLATE TO DESIRED ORIENTATION.



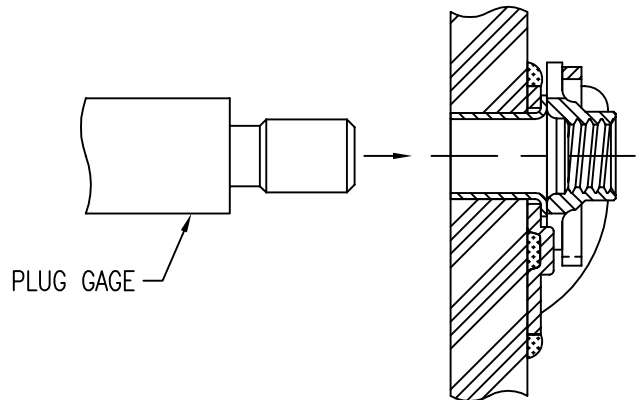
4. ACTUATE TOOL TO PULL MANDREL.



5. MANDREL PULLS THROUGH SLEEVE EXPANDING SLEEVE AND SUBSTRATE HOLE.



6. CHECK SLEEVE INSIDE DI WITH PLUG GAGE.



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

FLEX FIT
CAD CB6347-3

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

GLICK BOND

CARSON CITY
NEVADA 89706

TITLE
NUTPLATE, CORNER, FLEX SLEEVE

SIZE	CAGE CODE	DWG. NO.	REV.
A	66530	CB6347	0

SCALE	2/1	17SEP01	SHEET 3 OF 3
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