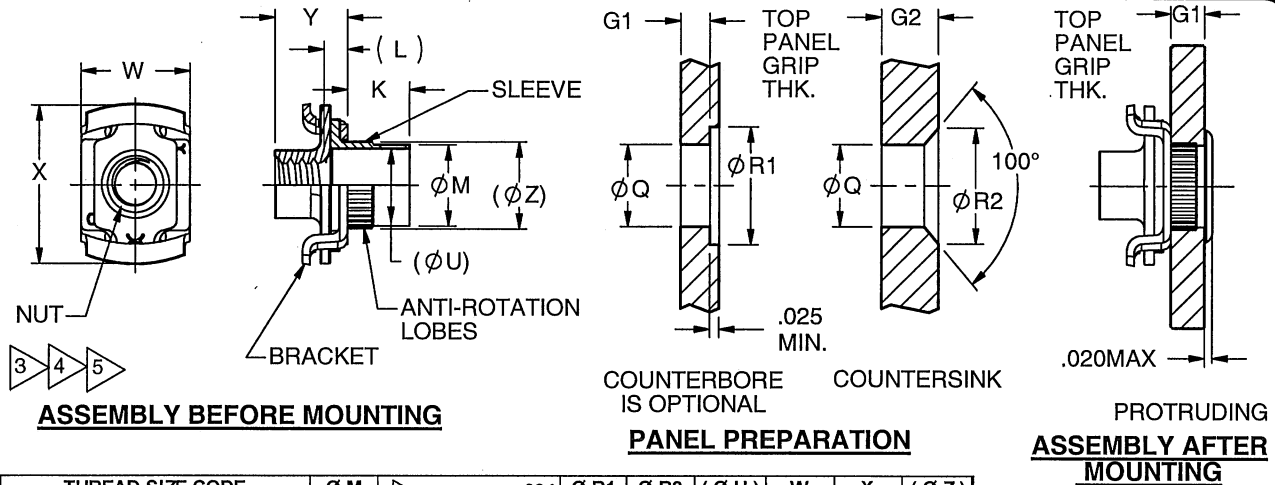


REV **W**  
**S-1216**  
 DRAWING NO.



THREAD SIZE CODE	Ø M MAX	Ø Q		Ø R1	Ø R2	(Ø U)	W	X	(Ø Z)
		SOFT	HARD	+ .004 - .001	+ .020 ± .005 - .000				
4, 4F, 6, 6F, M3, M3.5	.217	.218	.218	.312	.307	.192	.295	.420	.228
8, 8F, 10, 10C, 10F, M4, M5	.270	.272	.281	.375	.370	.245	.390	.572	.294
12, 12C, 12F, M6	.335	.339	.348	.515	.437	.310	.450	.650	.363

**PART NUMBER CALLOUT**  
**GFP 6010 ( ) ( ) ( ) ( )**

MODEL  
 SERIES

NUT HEIGHT CODE	(L)			Y ± .025		
	4, 4F, 6, 6F, M3, M3.5	8, 8F, 10, 10C, 10F, M4, M5	12, 12C, 12F, M6	4, 4F, 6, 6F, M3, M3.5	8, 8F, 10, 10C, 10F, M4, M5	12, 12C, 12F, M6
NONE	.062	.068	.089	.189	.230	.303
2	.109	.113	.174	.254	.295	.366
3	.172	.176	.237	.317	.357	.428
4	.234	.239	.300	.380	.420	.490

GRIP CODE	G1	G2	K ±.010	GRIP CODE	G1	G2	K ±.010
AA	N/A	.055 - .073	.073	F	.188 - .218	.228 - .258	.254
A	.031 - .062	.074 - .106	.099	G	.219 - .250	.259 - .289	.285
B	.063 - .094	.107 - .133	.130	H	.251 - .281	.290 - .320	.316
C	.095 - .125	.134 - .165	.161	J	.282 - .312	.321 - .351	.347
D	.126 - .156	.166 - .196	.192	K	.313 - .343	.352 - .382	.378
E	.157 - .187	.197 - .227	.223	L	.344 - .374	.383 - .413	.409

CODE	NUT TYPE
L	LOCKING
NL	NONLOCKING

THREAD SIZE CODE	THREAD SIZE PER SAE-AS-8879	LEAD	LB/100				THREAD SIZE CODE	THREAD SIZE PER SAE-AS-8879; ASME B1.21M FOR METRIC	LEAD	LB/100			
			1, 2	3	4	7				1, 2	3	4	7
4	.112-40 UNJC-3B	SINGLE	.131	.151	.171	8F	.164-32 UNJC-3B	QUAD	.365	.405	.445		
6	.138-32 UNJC-3B		.140	.161	.201	10F	.190-32 UNJF-3B		.370	.415	.455		
8	.164-32 UNJC-3B		.365	.405	.445	12F	.250-28 UNJF-3B		.682	.742	.802		
10	.190-32 UNJF-3B		.370	.415	.455	M3	MJ3 x 0.5-4H6H		.131	.151	.171		
12	.250-28 UNJF-3B	SINGLE (COARSE)	.682	.742	.802	M3.5	MJ3.5 x 0.6-4H6H	METRIC	.140	.161	.201		
10C	.190-24 UNJC-3B		.370	.415	.455	M4	MJ4 x 0.7-4H6H		.365	.405	.445		
12C	.250-20 UNJC-3B		.682	.742	.802	M5	MJ5 x 0.8-4H6H		.370	.415	.455		
4F	.112-40 UNJC-3B		DOUBLE	.131	.151	.171	M6		MJ6 x 1.0-4H6H	.682	.742	.802	
6F	.138-32 UNJC-3B	.140		.161	.201								
8D	.164-32 UNJF-3B	.365		.405	.445								

W DCN 3654 10-13-05  
 REV DESCRIPTION/EC NO. DATE

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS IN INCHES

TOLERANCE UNLESS OTHERWISE NOTED:  
 .X = ±.05 ANGLES ±0.5°  
 .XX = ±.02  
 .XXX = ±.015

**ALCOA** Alcoa Fastening Systems

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

TITLE  
**NUT PLATE, RIVETLESS, 450° F, FLOATING, ALL CRES, STANDARD DIAMETER SLEEVE, ALL SIZES**

DATE 10/13/2005 PART NO. **GFP6010**  
 DRAWN JLS DRAWING NO. **S-1216**  
 CHECK [Signature] CAGE CODE 0HDW7 REV **W**  
 APPROVE [Signature] SCALE: 2:1 SHEET 1 OF 2

THIS DRAWING, THE STRUCTURAL DESIGN DISCLOSED THEREIN, THE TECHNICAL DATA AND ENGINEERING SERVICE REPRESENTED THEREBY ARE THE EXCLUSIVE PROPERTY OF HUCK INTERNATIONAL, INC.

REV **W**

**S-1216**

DRAWING NO.

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 5525 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 - "ØQ" DIMENSION .276-.281, "ØR2" DIMENSION .343  
 SIZES 4, 4F, 6, 6F, M3, M3.5 - "ØR2" 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 .046 MIN. FOR GRIP LENGTHS GREATER THAN "C".
- 5 FOR NUT ELEMENT REPLACEMENT P/N SEE DWG. S-0877.
- 6 NUT ELEMENT REMOVAL TOOL AVAILABLE, P/N 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				
COMPLETE HAND TOOL ASSEMBLY		PULLER	NOSE PIECE	
C'BORE	C'SINK		C'BORE	C'SINK
DCBT8600(-)	DCST8600(-)	DTP86230(-)	DCBN86130(-)	DCSN86130(-)

INSTALLATION TOOLS:

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

( ) = THREAD SIZE CODE  
 \* "N" DESIGNATES C'BORE  
 "S" DESIGNATES C'SINK

HAND INSTALLATION TOOLS:   
 NOSE PIECE  
 PULLER  
 HANDLE ASSEMBLY TA7533


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W	DCN 3654	10-13-05
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TITLE <b>NUT PLATE, RIVETLESS, 450° F, FLOATING, ALL CRES, STANDARD DIAMETER SLEEVE, ALL SIZES</b>	
DATE 10/13/2005	PART NO. <b>GFP6010</b>
DRAWN JLS	DRAWING NO. <b>S-1216</b>
CHECK 	CAGE CODE <b>0HDW7</b> REV <b>W</b>
APPROVE	SCALE: 2:1 SHEET 2 OF 2