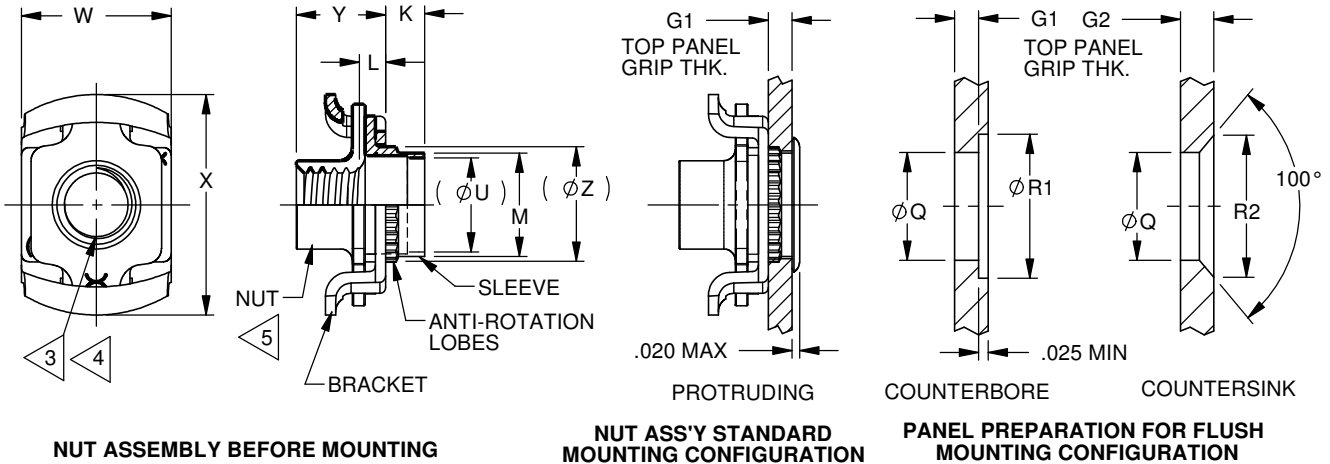


THIS DRAWING, THE STRUCTURAL DESIGN DISCLOSED THEREIN AND THE TECHNICAL DATA AND ENGINEERING SERVICE REPRESENTED THEREBY ARE THE EXCLUSIVE PROPERTY OF HUCK INTERNATIONAL, INC.



THREAD SIZE CODE	(L)	Ø M MAX	Ø Q		Ø R1 +.020 -.000	Ø R2 ±.005	(Ø U)	W	X	Y ±.025	(Z)
			SOFT	HARD							
2, 4, 4F, 6, 6F, M3, M3.5	.062	.217	.218	.218	.312	.307	.192	.295	.420	.189	.228
8, 8F, 10, 10C, 10F, M4, M5	.068	.270	.272	.281	.375	.370	.245	.390	.572	.245	.294
12, 12C, 12F, M6	.089	.335	.339	.348	.515	.437	.310	.450	.650	.300	.363

PART NUMBER CALLOUT

FFC 6010 () - () - ()

MODEL

SERIES

CODE	NUT TYPE
L	LOCKING
NL	NONLOCKING

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

THREAD SIZE CODE	THREAD SIZE PER SAE-AS-8879	LEAD	THREAD SIZE CODE	THREAD SIZE PER SAE-AS-8879	LEAD	THREAD SIZE CODE	THREAD SIZE PER ASME B1.21M	LEAD
2	.086-56 UNJC-3B	SINGLE	4F	.112-40 UNJC-3B	DOUBLE	M3	MJ3 x 0.5-4H6H	METRIC
4	.112-40 UNJC-3B		6F	.138-32 UNJC-3B	QUAD	M3.5	MJ3.5 x 0.6-4H6H	
6	.138-32 UNJC-3B		8F	.164-32 UNJC-3B		M4	MJ4 x 0.7-4H6H	
8	.164-32 UNJC-3B		10F	.190-32 UNJC-3B	M5	MJ5 x 0.8-4H6H		
10	.190-32 UNJC-3B		12F	.250-28 UNJC-3B	M6	MJ6 x 1.0-4H6H		
12	.250-28 UNJC-3B							
10C	.190-24 UNJC-3B	SINGLE						
12C	.250-20 UNJC-3B	(COARSE)						

W

PER DCN 13165, CHANGED FORMAT

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

DRAWN BY J. SCHLOBOHM
CHECKED BY SIGNATURE ON FILE

ISSUED 7/7/2006
REVISED 7/28/2015
PAGE 1 OF 2

NUT PLATE, 450° F, RIVETLESS,
CRES NUT ELEMENT, FLOAT ING, ALL SIZES

DIMENSIONS IN INCHES

FFC6010
S-0996



MATERIAL:

NUT: A-286 CRES PER AMS 5525, HEAT TREAT TO 160 KSI MIN. ULTIMATE TENSILE STRENGTH

BRACKET: 1050 CARBON STEEL PER AMS 5085, HEAT TREAT TO HRC 42-47

SLEEVE: 304 CRES PER AMS 5639 OR AMS-QQ-S-763 OR 305 CRES PER AMS 5514

FINISH CODE:

BRACKET& SLEEVE: CAD PLATE PER AMS QQ-P-416, TYPE II, CLASS 2.

NUT: PASSIVATE PER AMS2700 AND DRI-FILM LUBE PER AS5272

NOTES:

- 1 "AA" GRIP RECOMMENDED PANEL PREPARATION:
SIZES 2, 4, 4F, 6, 6F, M3 & M3.5 C'SINK: "Ø R2" DIMENSION IS .275
SIZE 8, 8F, 10, 10C, 10F, M4 & M5 C'SINK: "Ø Q" DIMENSION IS .276/.281; "Ø R2" DIMENSION IS .343
SIZE 12, 12C, 12F, M6: NOT RECOMMENDED FOR LESS THAN .060 PANEL THICKNESS
- 2 SOFT: DIMENSIONS FOR SOFT ALUMINUM ALLOYS AND PLASTICS
HARD: DIMENSIONS FOR HARD ALUMINUM ALLOYS AND STEEL
- 3 A MINIMUM OF TWO THREADS ARE DEFORMED TO PRODUCE SELF-LOCKING ACTION PER NASM25027 WHEN LOCKING FEATURE IS DESIRED.
- 4 NUT ELEMENT HAS .060 TOTAL RADIAL FLOAT FOR GRIP LENGTHS "AA" THRU "C" AND .046 MINIMUM FOR GRIP LENGTHS GREATER THAN "C".
- 5 FOR NUT ELEMENT REPLACEMENT PART NUMBER, SEE DRAWING S-0877.
- 6 NUT ELEMENT REMOVAL TOOL AVAILABLE, PART NUMBER RB 6527.
- 7 THREAD SIZE CODE
- 8 FOR HIGH VOLUME INSTALLATION RATES, ALTERNATIVE POWER TOOLING IS AVAILABLE:
CONTACT ALCOA FASTENING SYSTEMS SALES DEPT.
- 9 TOOLING TYPE:
"N" DESIGNATES COUNTERBORE
"S" DESIGNATES COUNTERSINK
- 10 NUT ELEMENT COLOR CODE:
NONE: LOCKING STANDARD THREADS
GREEN: NON-LOCKING STANDARD THREADS
YELLOW: COARSE THREADS
ORANGE: FAST LEAD THREADS
BLUE: METRIC THREADS
- 11 J THREADS PER SAE-AS-8879; MJ THREADS PER ASME B1.21M.

HAND INSTALLATION TOOL SELECTION TABLE:

ARBOR PRESS TOOL: HW 9 7659-(7)		COMPLETE HAND TOOL ASSEMBLY (INCLUDES:NOSE PIECE, PULLER & HANDLE) C'BORE: DCBT8600-(7) , C'SINK: DCST8600-(7)	
ANVIL: HW 9 7658-(7)		NOSE PIECE: C'BORE: DCBN86130-(7) , C'SINK: DCSN86130-(7)	
FORMER: HW 9 7657-(7)		PULLER: DTP86230-(7) HANDLE ASS'Y: TA7533	

W	PER DCN 13165, CHANGED FORMAT		TOLERANCE UNLESS OTHERWISE NOTED: .X = ±.05 .XX = ±.02 .XXX = ±.015 ANGLES ±0.5°	DRAWN BY	J. SCHLOBOHM
	ISSUED	7/7/2006		CHECKED BY	SIGNATURE ON FILE
REVISED	7/28/2015	NUT PLATE, 450° F, RIVETLESS, CRES NUT ELEMENT, FLOAT ING, ALL SIZES		FFC6010	
PAGE	2 OF 2				
			DIMENSIONS IN INCHES		

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

This drawing/documentation is controlled by either the Department of State, International Traffic In Arms Regulations or the Department of Commerce, Export Administration Regulations and may require an export license/exception prior to being transferred to a foreign national, inside or outside of the United States. EAR/ECCN EAR99. These commodities, technology or software were exported from the United States in accordance with the Export Administration Regulations. Diversion contrary to U.S. law prohibited.