

MATERIAL AND FINISH DATA

NOTE: ALL DIMENSIONS BEFORE PAINT.

CODE	NUT MATERIAL	SPEC.	PASSIVATE	DRI-FILM LUBE
CR	A-286 CRES	AMS 5525, 5726, 5731, 5732, OR 5737	QQ-P-35	MIL-PRF-46010 TY 1

CODE	WASHER MATERIAL	SPEC.	PASSIVATE	DOME MATERIAL	SPEC.	PASSIVATE
CR	A-286 CRES	AMS 5731	AMS-QQ-P-35	A-286 CRES	AMS 5525	AMS-QQ-P-35

THREAD DATA (THREAD LOCK PER NASM25027)

CODE	THREAD T	SPEC.
3	.1900-32 UNJF-3B	AS8879

NUT HEIGHT AND C'BORE DATA

CODE	R MIN	H MAX	COLOR CODE
NONE	.125	.325	NONE
3	.187	.383	RED
4	.250	.445	GREEN
5	.312	.508	BLACK
6	.375	.570	BLUE
7	.437	.633	ORANGE

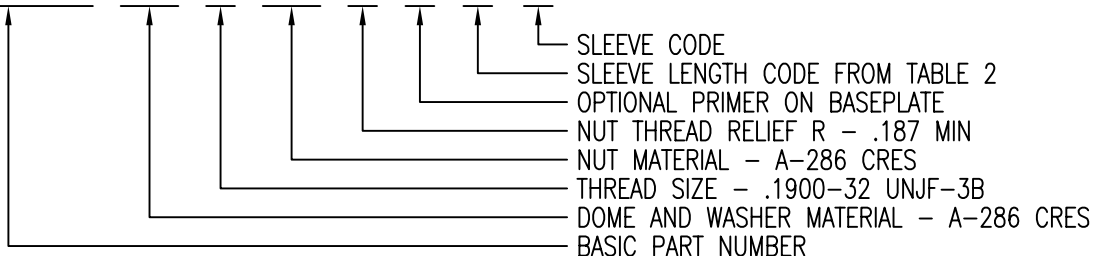
SLEEVE MATERIAL: A-286 CRES PER AMS 5525
 CONDITION AND FINISH: ANNEALED PASSIVATE PER AMS-QQ-P-35
 DRI-FILM LUBE SLEEVE ID ONLY PER MIL-PRF-46010

OPTIONAL PRIMER

CODE	BASEPLATE PRIMER	SPEC.
P	EPOXY PRIMER	MIL-PRF-85582

EXAMPLE PART NUMBER

CB9530 CR 3 CR 3 P 8



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.

GLICK BOND

CARSON CITY
NEVADA 89706

CAD CB9530-1		APPROVALS	DATE
ANGLES	±1°	DRAWN DAC	16JUL04
.XX	±.03	CHECKED <i>[Signature]</i>	16JUL04
.XXX	±.010	RELEASED CGH	17JUL04
.XXXX	±.001	REVISED	

TITLE			
NUTPLATE, EXTENDED FLOAT, SEALED, FLARE SLEEVE			
SIZE	CAGE CODE	DWG. NO.	REV.
A	66530	CB9530	0
SCALE	2/1	16JUL04	SHEET 1 OF 4

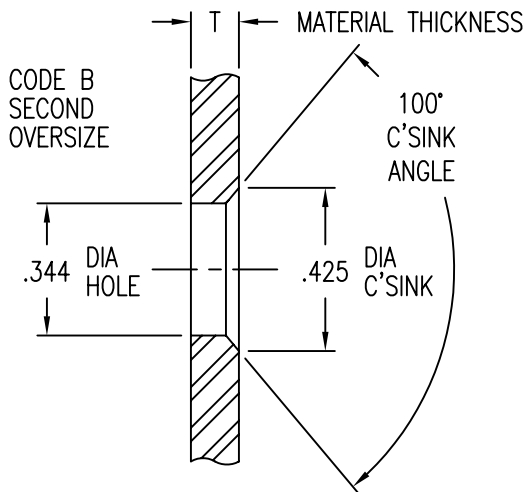
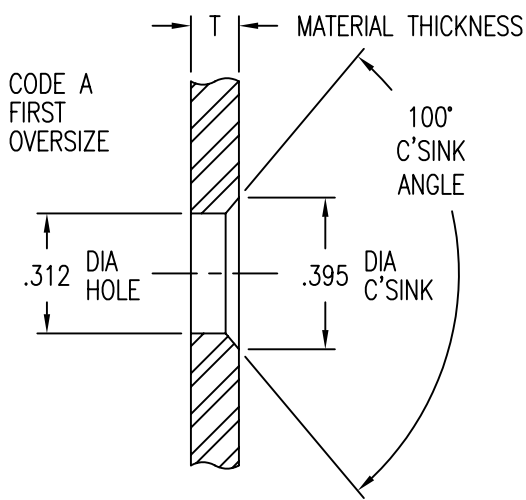
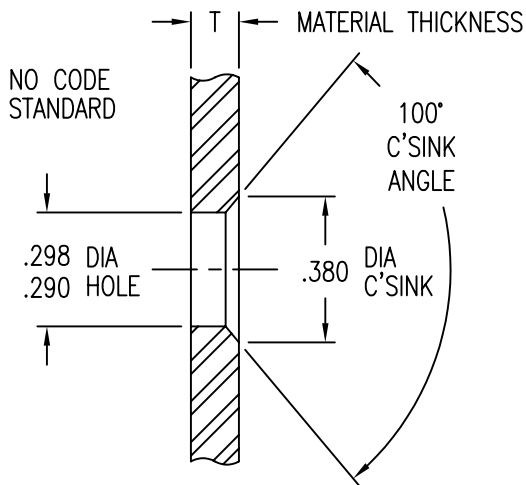


TABLE 2: SLEEVE LENGTH SELECTION DATA

LENGTH CODE	SLEEVE L	MATERIAL THICKNESS T	
		MIN	MAX
4	.062	.048	.063
5	.077	.064	.078
6	.093	.079	.094
7	.108	.095	.109
8	.124	.110	.125
9	.140	.126	.141
10	.155	.142	.156
11	.171	.157	.172
12	.187	.173	.188
13	.202	.189	.203
14	.218	.204	.219
15	.233	.220	.234
16	.249	.235	.250
17	.265	.251	.266
18	.280	.267	.281
19	.296	.282	.297
20	.312	.298	.313
21	.327	.314	.328
22	.343	.329	.344
23	.358	.345	.359
24	.374	.360	.375
25	.390	.376	.391
26	.405	.392	.406
27	.421	.407	.422
28	.437	.423	.438
29	.452	.439	.453
30	.468	.454	.469
31	.483	.470	.484
32	.499	.485	.500

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.

GLICK BOND

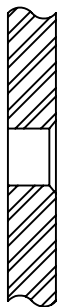
CARSON CITY
NEVADA 89706

CAD CB9530-2	
ANGLES	±1°
.XX	±.03
.XXX	±.010
.XXXX	±.001

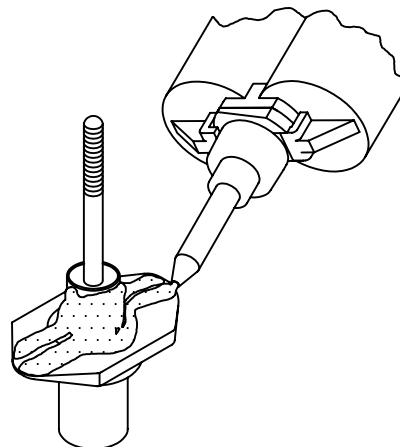
APPROVALS	DATE
DRAWN <i>DAC</i>	16JUL04
CHECKED <i>DOC/mtm</i>	16JUL04
RELEASED <i>CGH</i>	17JUL04
REVISED	

TITLE NUTPLATE, EXTENDED FLOAT, SEALED, FLARE SLEEVE			
SIZE A	CAGE CODE 66530	DWG. NO. CB9530	REV. 0
SCALE 2/1	17JUL04		SHEET 2 OF 4

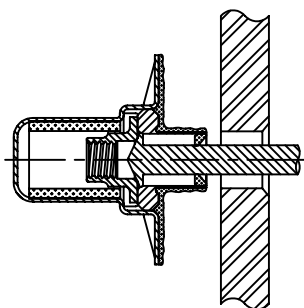
1. PREPARE HOLE IN SUBSTRATE.



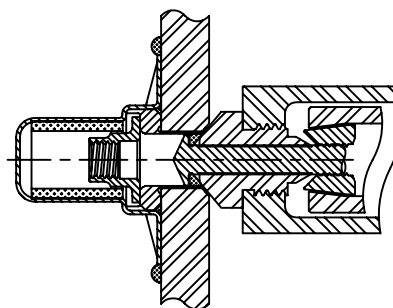
2. APPLY MIXED ADHESIVE TO BASEPLATE AND OUTSIDE OF SLEEVE.



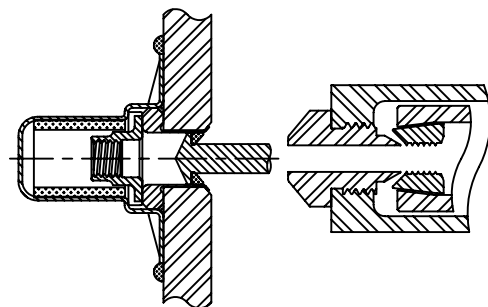
3. INSERT ASSEMBLY THROUGH SUBSTRATE HOLE AND SEAT AGAINST SUBSTRATE SURFACE.



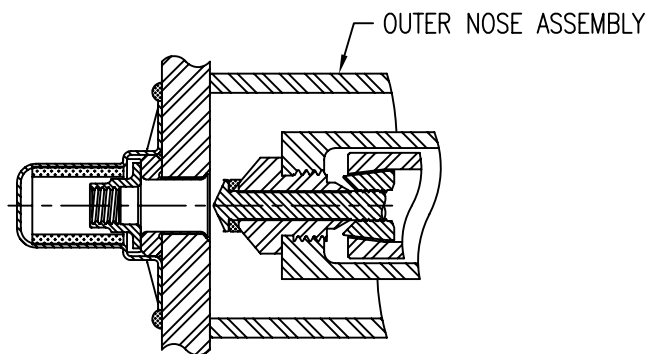
4. PLACE NOSE OF PULL TOOL OVER STEM (MAKE SURE TOOL HAS BEEN RELEASED). ACTUATE TOOL TO PULL STEM AND FLARE SLEEVE



5. WHEN FLARING IS COMPLETE RELEASE STEM AND REMOVE PULL TOOL. WIPE EXCESS ADHESIVE FROM FLARED SLEEVE SUBSTRATE AREA AND TOOL NOSE.



6. INSERT OUTER NOSE ON PULL TOOL THEN PLACE OVER STEM AND PULL STEM AWAY FROM ASSEMBLY.



7. EJECT STEM FROM PULL TOOL. FLARING OPERATION IS COMPLETE.

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.

CLICK BOND

CARSON CITY
NEVADA 89706

CAD CB9530-3

APPROVALS

DATE

TITLE

ANGLES ±1°

DRAWN DAC

16JUL04

NUTPLATE, EXTENDED FLOAT, SEALED, FLARE SLEEVE

.XX ±.03

CHECKED DAC/ctm

16JUL04

SIZE A CAGE CODE 66530 DWG. NO. CB9530 REV. 0

.XXX ±.010

RELEASED CGH

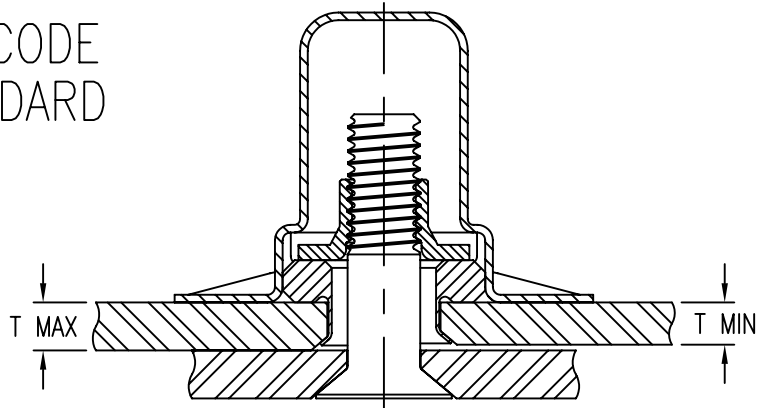
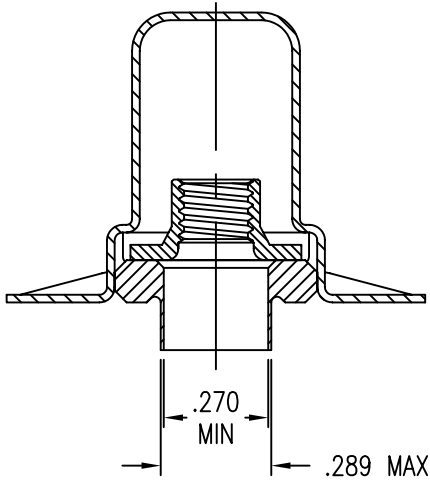
17JUL04

.XXXX ±.001

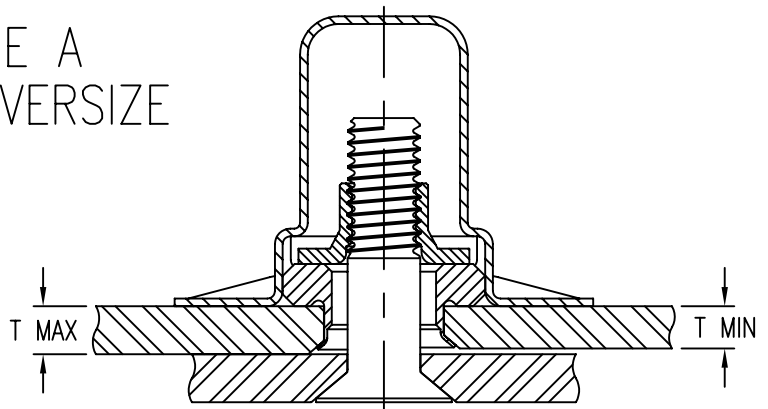
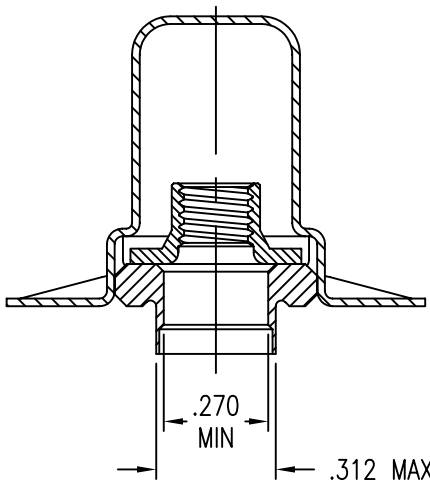
REVISED

SCALE 1/1 16JUL04 SHEET 3 OF 4

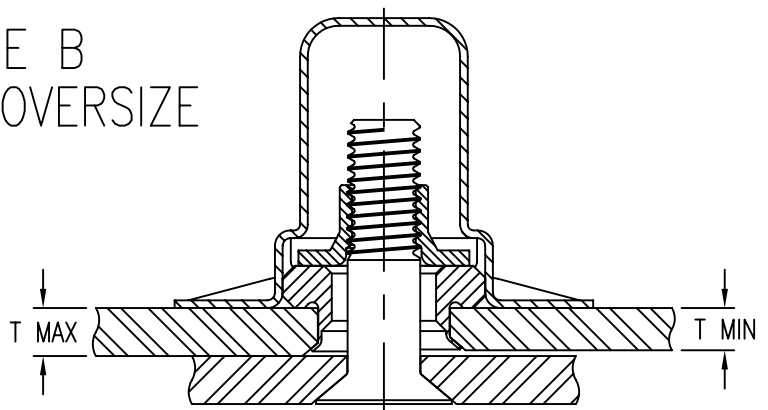
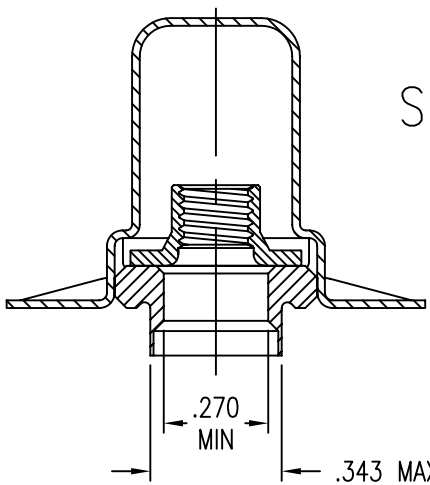
NO CODE
STANDARD



CODE A
FIRST OVERSIZE



CODE B
SECOND OVERSIZE



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.

CLICK BOND

CARSON CITY
NEVADA 89706

CAD CB9530-4

APPROVALS	DATE
DRAWN <i>DAC</i>	16JUL04
CHECKED <i>DOC/mtm</i>	16JUL04
RELEASED <i>CGH</i>	17JUL04
REVISED	

TITLE			
NUTPLATE, EXTENDED FLOAT, SEALED, FLARE SLEEVE			
SIZE	CAGE CODE	DWG. NO.	REV.
A	66530	CB9530	0
SCALE	2/1	16JUL04	SHEET 4 OF 4