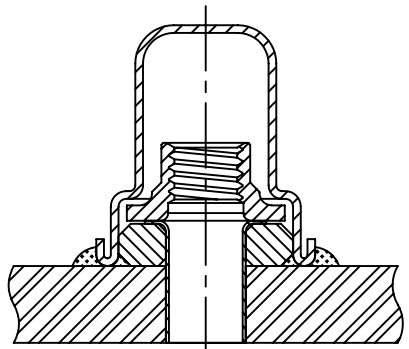
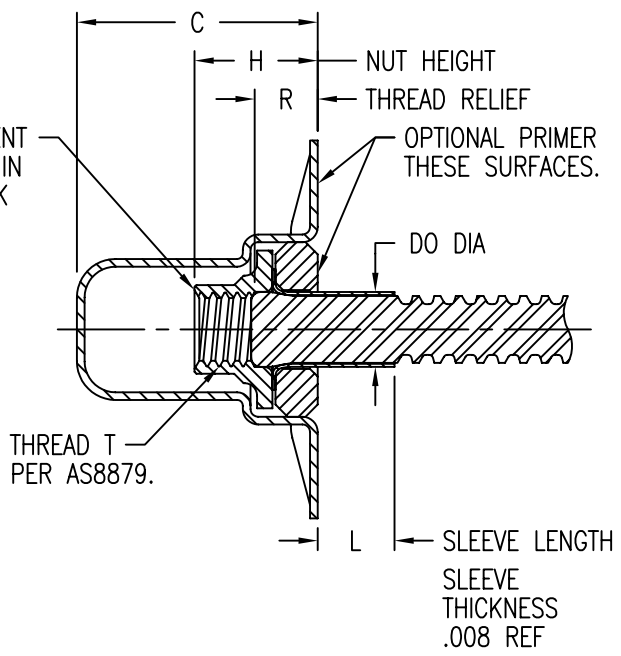
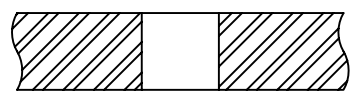


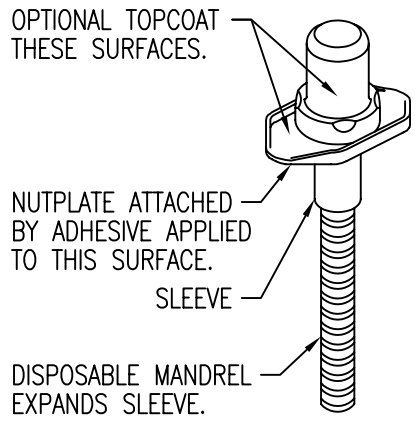
RADIAL FLOAT OF NUT ELEMENT
.020 MIN FROM CENTERLINE IN
ANY DIRECTION. THREAD LOCK
PER NASM25027.



TYPICAL COMPLETED INSTALLATION
DI INSIDE SLEEVE DIA AFTER EXPANSION



DH SUBSTRATE HOLE DIA



NUTPLATE MEETS STRENGTH REQUIREMENTS OF NASM25027.

EXAMPLE PART NUMBER

CB6310 CR 3 - 2 P F 200

- ↑ SLEEVE MATERIAL AND FINISH - A-286 CRES, PASSIVATE
- ↑ SLEEVE LENGTH L IN THOUSANDTHS - .200
- ↑ OPTIONAL TOPCOAT ON DOME
- ↑ OPTIONAL PRIMER ON BASEPLATE
- ↑ THREAD RELIEF R - .125 MIN
- ↑ NUT MATERIAL - A-286 CRES, DRI-FILM LUBE
- ↑ THREAD T SIZE - .1900-32 UNJF-3B
- ↑ DOME AND WASHER MATERIAL - A-286 CRES
- ↑ BASIC PART NUMBER

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 CB6310-1

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

APPROVALS		DATE
DRAWN	DAC	21MAR05
CHECKED	DAC	21MAR05
RELEASED	CGH	21MAR05
REVISED	DAC	21MAR05

TITLE NUTPLATE, SEALED, FLEX SLEEVE			
SIZE	CAGE CODE	DWG. NO.	REV.
A	66530	CB6310	2
SCALE	2/1 21MAR05		SHEET 1 OF 3

THREAD AND DIMENSION DATA (ALL DIMENSIONS BEFORE PAINT)

PART NUMBER	THREAD T	A MAX	B MAX	C MAX	DH	DI	DO REF	F MAX	H MAX	R MIN
CB6310()3-2() ()	.1900-32 UNJF-3B	.995	.580	.637	.2010	.194 .190	.195	.800	.335	.125
CB6310()3-3() ()				.700					.398	.187
CB6310()3-4() ()				.762					.460	.250
CB6310()3-5() ()				.825					.523	.312
CB6310()3-6() ()				.887					.585	.375
CB6310()3-7() ()				.950					.648	.437
CB6310()3-8() ()				1.012					.710	.500
CB6310()4-2() ()	.2500-28 UNJF-3B	1.100	.725	.706	.2570	.254 .250	.255	.950	.380	.125
CB6310()4-3() ()				.769					.443	.187
CB6310()4-4() ()				.831					.505	.250
CB6310()4-5() ()				.894					.568	.312
CB6310()4-6() ()				.956					.630	.375
CB6310()4-7() ()				1.019					.693	.437
CB6310()4-8() ()				1.081					.755	.500

NUT MATERIAL AND FINISH DATA

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

DOMES MATERIAL AND FINISH DATA

CODE	MATERIAL	SPEC.	PASSIVATE
CR	A-286 CRES	AMS 5525, 5726, 5731, 5732, 5737	AMS-QQ-P-35
ACR			

WASHER MATERIAL AND FINISH DATA

CODE	MATERIAL	SPEC.	FINISH	SPEC.
CR	A-286 CRES	AMS 5726, 5731, 5732, 5737	PASSIVATE	AMS-QQ-P-35
ACR	2024 OR 6061 ALUMINUM	AMS-QQ-A-200 OR AMS-QQ-A-225	ANODIZE	MIL-A-8625

SLEEVE MATERIAL AND FINISH DATA

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

OPTIONAL BASEPLATE PRIMER

CODE	MATERIAL SPEC.
P	MIL-PRF-85582

OPTIONAL TOPCOAT

CODE	MATERIAL SPEC.
F	AMS-C-27725A TYPE 2

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FLEX FIT
CAD CB6310-2

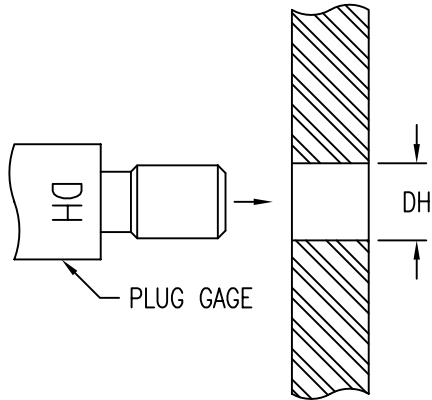
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GLICK BOND

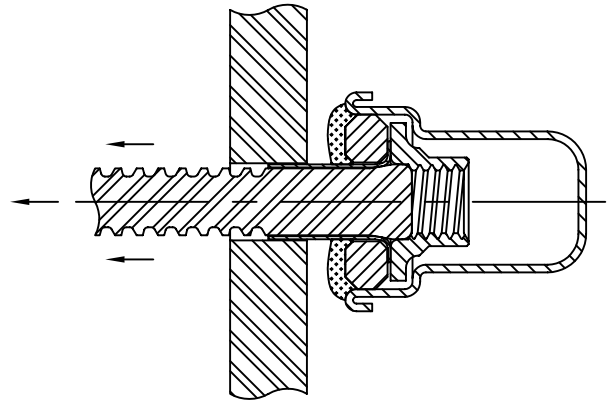
CARSON CITY
NEVADA 89706

APPROVALS		DATE	TITLE				
ANGLES	±1°	DRAWN <i>DAC</i>	21MAR05	NUTPLATE, SEALED, FLEX SLEEVE			
.XX	±.03	CHECKED <i>DOC/mtm</i>	21MAR05	SIZE	CAGE CODE	DWG. NO.	REV.
.XXX	±.010	RELEASED <i>CGH</i>	21MAR05	A	66530	CB6310	2
.XXXX	±.001	REVISED <i>DAC</i>	21MAR05	SCALE	2/1	21MAR05	SHEET 2 OF 3

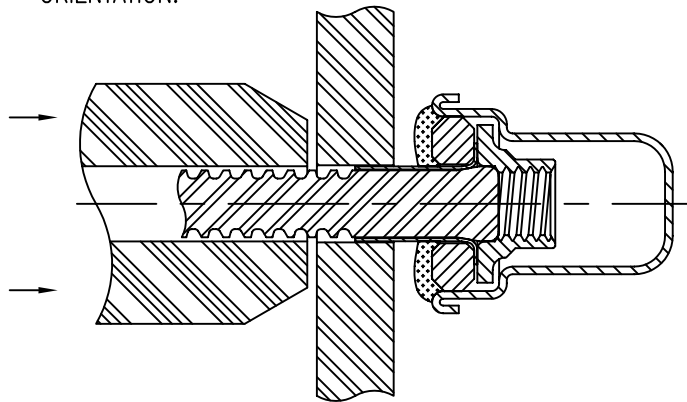
1. DRILL HOLE IN SUBSTRATE AND CHECK DIAMETER DH WITH PLUG GAGE.



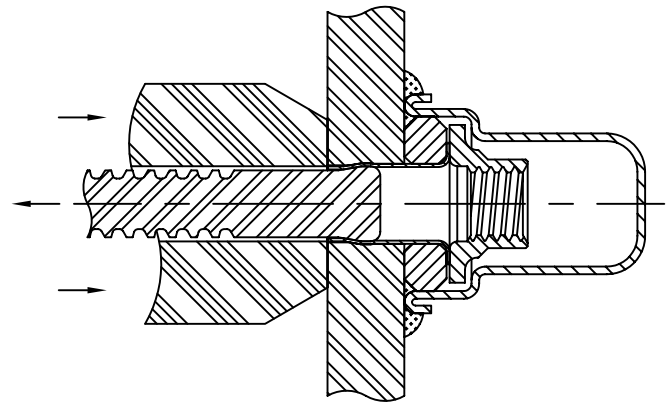
2. APPLY MIXED ADHESIVE TO NUTPLATE BASEPLATE AND PASS MANDREL THROUGH SUBSTRATE HOLE.



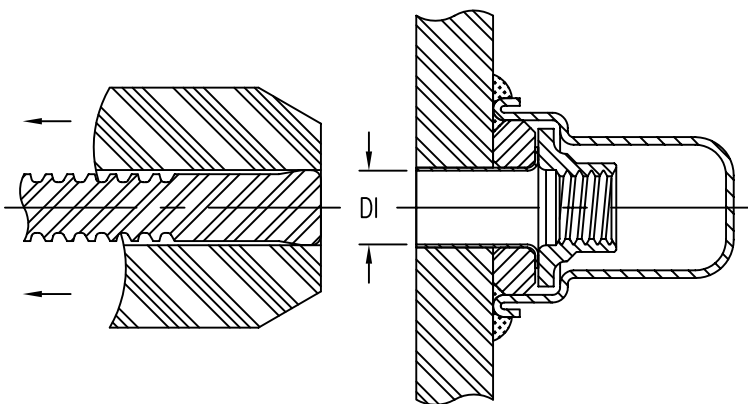
3. PLACE PULL TOOL OVER MANDREL AND ROTATE NUTPLATE TO DESIRED ORIENTATION.



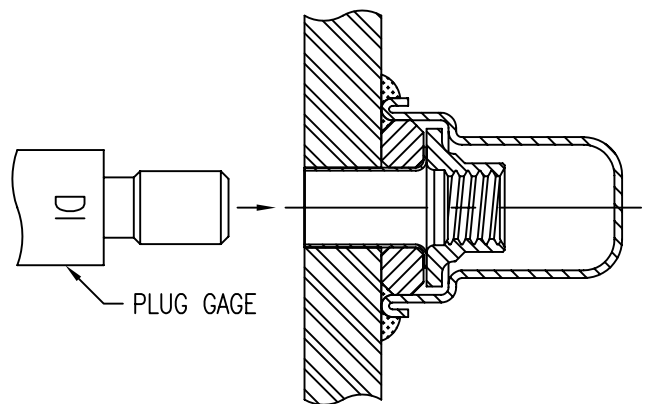
4. ACTUATE TOOL TO PULL MANDREL.



5. MANDREL PULLS THROUGH SLEEVE EXPANDING SLEEVE AND SUBSTRATE HOLE PLACING SUBSTRATE MATERIAL IN COMPRESSION.



6. CHECK SLEEVE INSIDE DIAMETER DI WITH PLUG GAGE.



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FLEX FIT
CAD CB6310-3

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CLICK BOND

CARSON CITY
NEVADA 89706

APPROVALS		DATE
DRAWN	DAC	21MAR05
CHECKED	DAC/mtm	21MAR05
RELEASED	CGH	21MAR05
REVISED	DAC	21MAR05

TITLE			
NUTPLATE, SEALED, FLEX SLEEVE			
SIZE	CAGE CODE	DWG. NO.	REV.
A	66530	CB6310	2
SCALE	2/1		21MAR05
			SHEET 3 OF 3