

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
CB6311 () 3 () 1 () ()	.1900-32 UNJF-3B	.745	.454	.194	.195	.285	.275	.070	.2010
CB6311 () 3 () 2 () ()							.337	.125	
CB6311 () 3 () 3 () ()							.400	.188	
CB6311 () 3 () 4 () ()							.463	.250	
CB6311 () 3 () 5 () ()							.527	.313	
CB6311 () 3 () 6 () ()							.589	.375	
CB6311 () 4 () 1 () ()	.2500-28 UNJF-3B	.948	.554	.254	.255	.360	.320	.070	.2570
CB6311 () 4 () 2 () ()							.382	.125	
CB6311 () 4 () 3 () ()							.444	.188	
CB6311 () 4 () 4 () ()							.506	.250	
CB6311 () 4 () 5 () ()							.568	.313	
CB6311 () 4 () 6 () ()							.630	.375	

EXAMPLE PART NUMBER

CB6311 CR 3 - 1 P 200

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

- OPTIONAL FINISH ON SLEEVE - PASSIVATE
- SLEEVE LENGTH L IN THOUSANDTHS - .200
- OPTIONAL PRIMER COATING ON BASEPLATE
- THREAD RELIEF R - .070 MIN
- NUT MATERIAL - A-286 CRES, DRI-FILM LUBE
- THREAD T SIZE - .1900-32 UNJF-3B
- BASEPLATE 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 CB6311-1

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GLICK BOND

CARSON CITY
NEVADA 89706

APPROVALS		DATE	TITLE			
DRAWN	DAC	17SEP01	NUTPLATE, ONE LUG, FLEX SLEEVE			
CHECKED	DAC	17SEP01	SIZE	CAGE CODE	DWG. NO.	REV.
RELEASED	CGH	10CT01	A	66530	CB6311	0
REVISED			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 ARMC0 SPEC. (SEE CB6002)

FINISH: PASSIVATE PER QQ-P-35. (SEE CB6002)

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FLEX FIT
CAD CB6311-2

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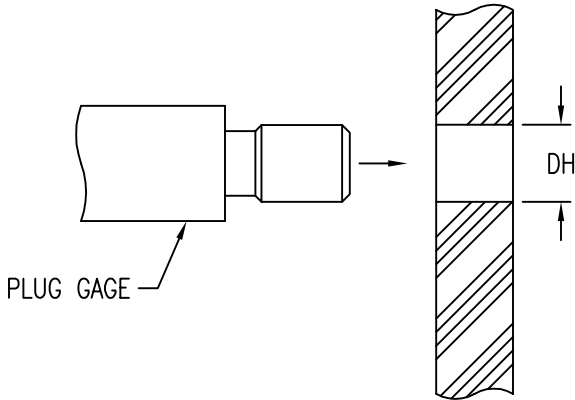
CARSON CITY
NEVADA 89706

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

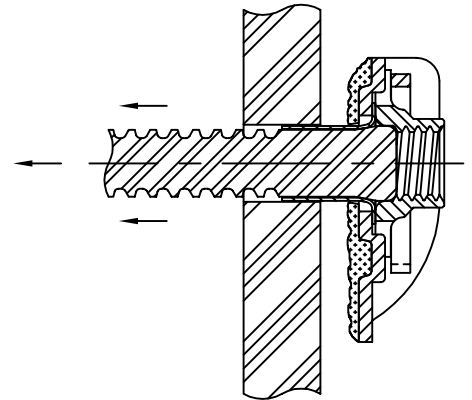
APPROVALS		DATE
DRAWN	DAC	17SEP01
CHECKED	DAC	17SEP01
RELEASED	CGH	10CT01
REVISED		

TITLE			
NUTPLATE, ONE LUG, FLEX SLEEVE			
SIZE	CAGE CODE	DWG. NO.	REV.
A	66530	CB6311	0
SCALE	2/1	17SEP01	SHEET 2 OF 3

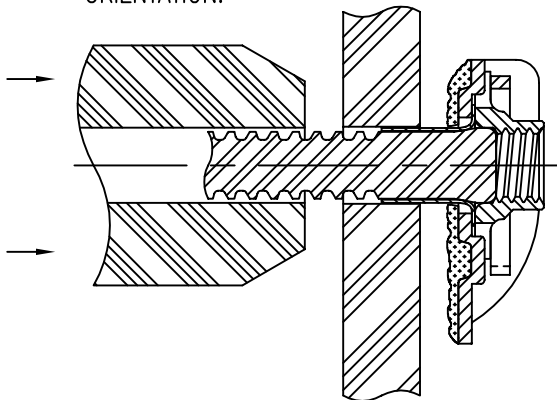
1. DRILL HOLE IN SUBSTRATE AND CHECK DH WITH PLUG GAGE.



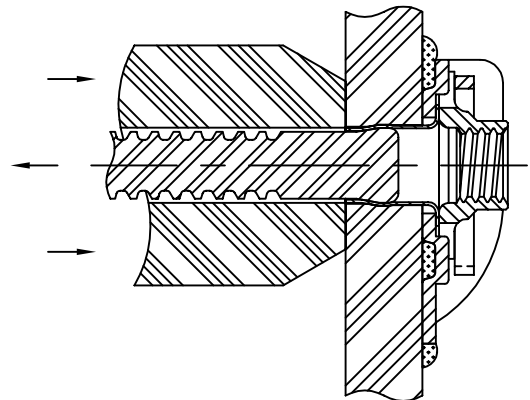
2. APPLY MIXED ADHESIVE TO NUTPLATE BASEPLATE AND PASS MANDREL THROUGH SUBSTRATE HOLE.



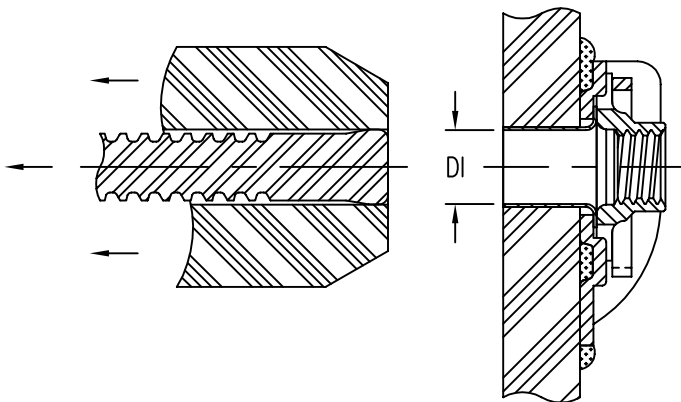
3. PLACE PULL TOOL OVER MANDREL AND ROTATE NUTPLATE TO DESIRED ORIENTATION.



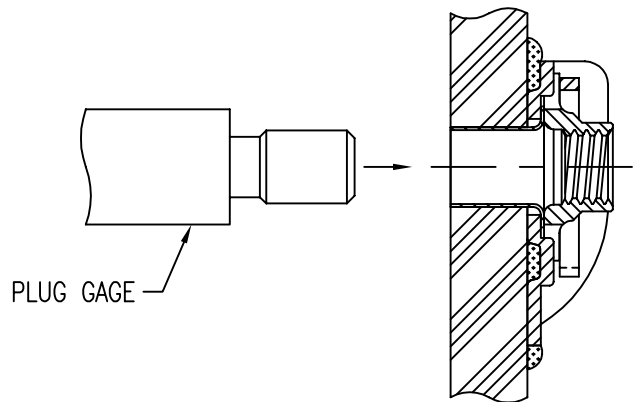
4. ACTUATE TOOL TO PULL MANDREL.



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



6. CHECK SLEEVE INSIDE DI WITH PLUG GAGE.



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FLEX FIT
CAD CB6311-3

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REVISED		

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NEVADA 89706

TITLE
NUTPLATE, ONE LUG, FLEX SLEEVE

SIZE	CAGE CODE	DWG. NO.	REV.
A	66530	CB6311	0

SCALE	DATE	SHEET	OF	TOTAL
2/1	17SEP01	3	OF	3