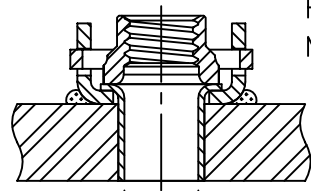


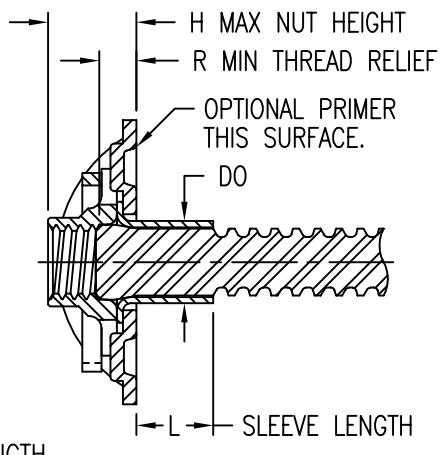
BASEPLATE  
 CB6001 NUT ELEMENT  
 FLOATS .020 MIN  
 FROM CENTER.  
 THREAD T  
 PER MIL-S-8879.  
 THREAD LOCK BY  
 ELLIPTICAL DEFORMATION  
 PER NASM25027.  
 CB6002 CLIP CAN BE  
 REMOVED WITH PLIERS  
 TO REPLACE NUT.

NUTPLATE MEETS THE STRENGTH  
 REQUIREMENTS OF NASM25027.  
 NOTE: ALL DIMENSIONS BEFORE PAINT.



DI INSIDE SLEEVE DIA AFTER EXPANSION

TYPICAL COMPLETED INSTALLATION

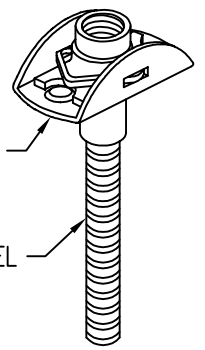


SLEEVE  
 THICKNESS  
 .016 REF.

SUBSTRATE  
 HOLE DIA

NUTPLATE ATTACHED BY  
 ADHESIVE APPLIED TO  
 THIS SURFACE.

DISPOSABLE MANDREL  
 EXPANDS SLEEVE.



NUTPLATE DIMENSIONS

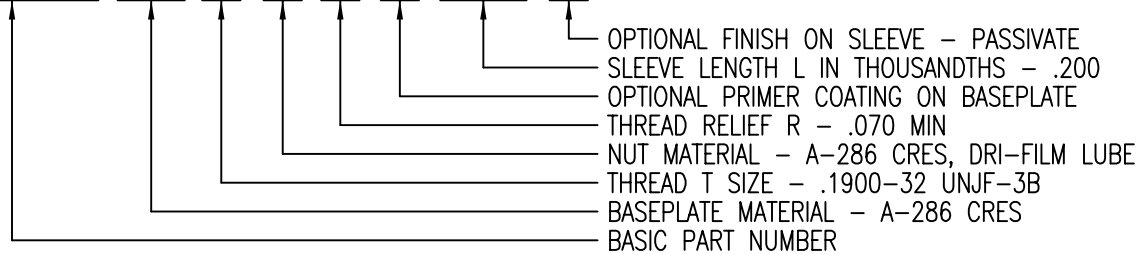
SLEEVE EXPANSION (DI FINAL) BASED ON HIGH STRENGTH ALUMINUM SUBSTRATE.

PART NUMBER	THREAD T	A MAX	B MAX	DI	DO REF	H MAX	R MIN	DH
CB6349 ( ) 3 ( ) 1 ( ) ( )	.1900-32 UNJF-3B	.745	.454	.194	.214	.275	.070	.2165
CB6349 ( ) 3 ( ) 2 ( ) ( )						.337	.125	
CB6349 ( ) 3 ( ) 3 ( ) ( )						.400	.188	
CB6349 ( ) 3 ( ) 4 ( ) ( )						.463	.250	
CB6349 ( ) 3 ( ) 5 ( ) ( )						.527	.313	
CB6349 ( ) 3 ( ) 6 ( ) ( )						.589	.375	
CB6349 ( ) 4 ( ) 1 ( ) ( )	.2500-28 UNJF-3B	.948	.554	.254	.270	.320	.070	.2720
CB6349 ( ) 4 ( ) 2 ( ) ( )						.382	.125	
CB6349 ( ) 4 ( ) 3 ( ) ( )						.444	.188	
CB6349 ( ) 4 ( ) 4 ( ) ( )						.506	.250	
CB6349 ( ) 4 ( ) 5 ( ) ( )						.568	.313	
CB6349 ( ) 4 ( ) 6 ( ) ( )						.630	.375	

EXAMPLE PART NUMBER

CB6349 CR 3 - 1 P 200

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



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.



CARSON CITY  
 NEVADA 89706

FLEX FIT  
 CAD CB6349-1

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

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

TITLE NUTPLATE, TWO LUG, FLEX SLEEVE			
SIZE A	CAGE CODE 66530	DWG. NO. CB6349	REV. 1
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)

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 CB6349-2

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**GLICK BOND**

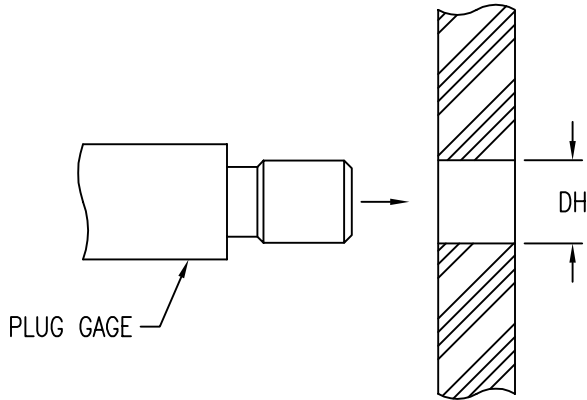
CARSON CITY  
NEVADA 89706

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

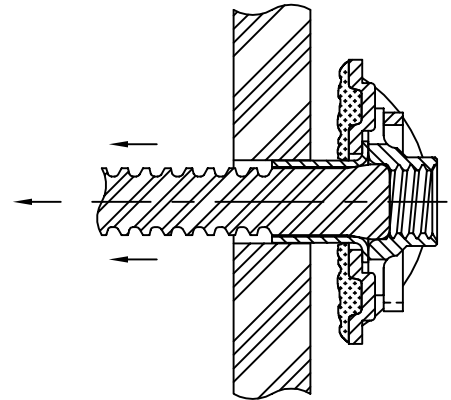
APPROVALS		DATE
DRAWN	DAC	17SEP01
CHECKED	DAC	17SEP01
RELEASED	CGH	10CT01
REVISED	DAC	17SEP01

TITLE			
NUTPLATE, TWO LUG, FLEX SLEEVE			
SIZE	CAGE CODE	DWG. NO.	REV.
A	66530	CB6349	1
SCALE	2/1	17SEP01	SHEET 2 OF 3

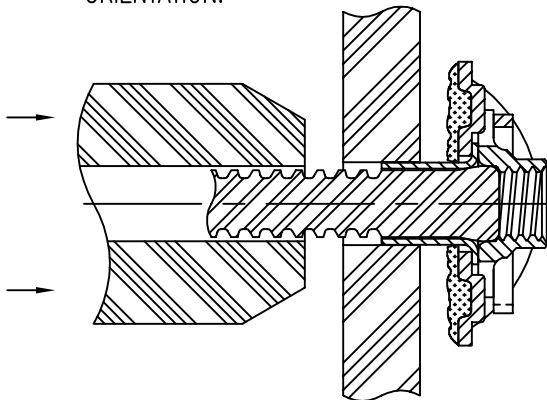
1. DRILL HOLE IN SUBSTRATE AND CHECK DH WITH PLUG GAGE.



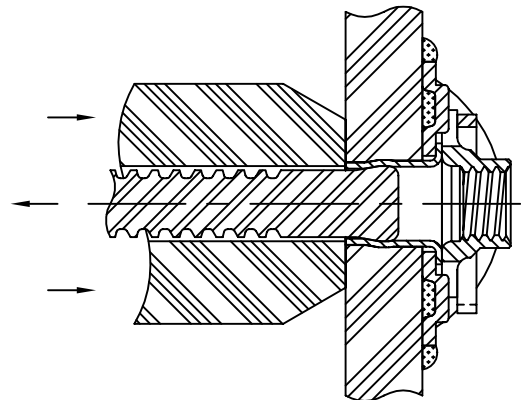
2. APPLY MIXED ADHESIVE TO NUTPLATE BASEPLATE AND PASS MANDREL THROUGH SUBSTRATE HOLE.



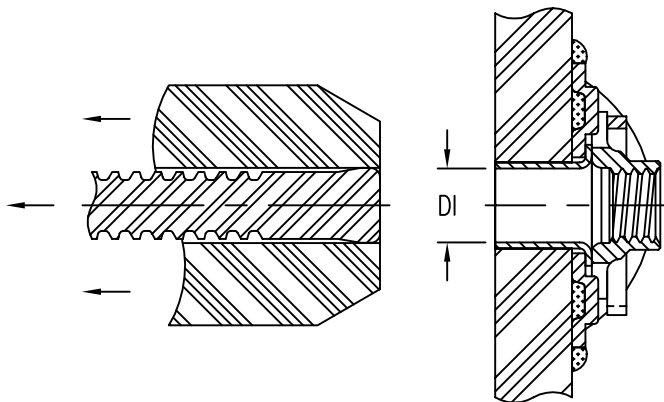
3. PLACE PULL TOOL OVER MANDREL AND ROTATE NUTPLATE TO DESIRED ORIENTATION.



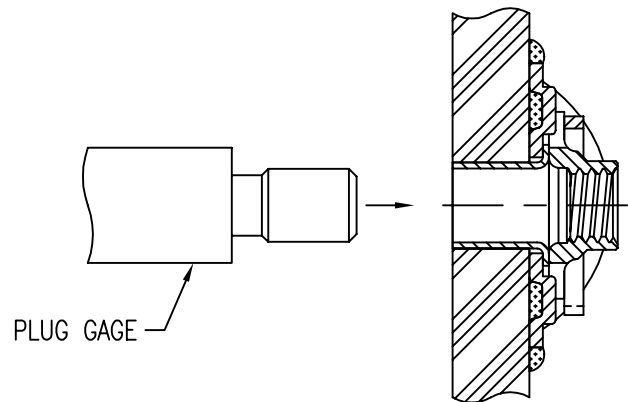
4. ACTUATE TOOL TO PULL MANDREL.



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



6. CHECK SLEEVE INSIDE DIAMETER DI WITH PLUG GAGE.



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FLEX FIT  
CAD CB6349-3

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**GLICK BOND**

CARSON CITY  
NEVADA 89706

APPROVALS		DATE	
DRAWN	DAC	17SEP01	
CHECKED	DAC	17SEP01	
RELEASED	CGH	10OCT01	
REVISED	DAC	17SEP01	

TITLE			
NUTPLATE, TWO LUG, FLEX SLEEVE			
SIZE	CAGE CODE	DWG. NO.	REV.
A	66530	CB6349	1
SCALE	2/1		17SEP01
SHEET 3 OF 3			