

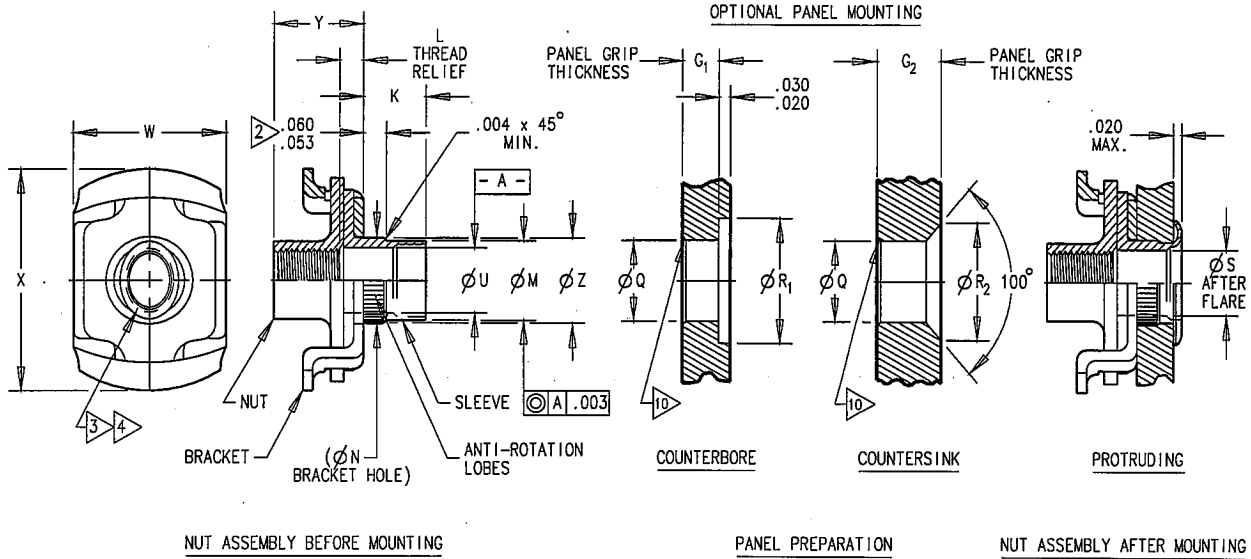
S-3320

1 OF 2

HUCK LAKEWOOD
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PARTS AND INSTALLATION PROCEDURES COVERED BY PATENT NUMBERS 3,695,324 AND 3,765,078. PLUS OTHERS PENDING.



PART NUMBER CALLOUT

GHFCT 6010 L -10-()-()
 MODEL
 SERIES

CODE	(L)	± .025	Y
1	.068	.230	
2	.113	.295	
3	.176	.357	
4	.239	.420	

ØM	(ØN)	ØQ	ØR1	ØR2	ØS	ØU	W	X	(ØZ)
MAX.	MIN.	+.0030	+.020	±.005	+.0030	MAX.	MIN.		
.246	.242	-.0000	-.000		-.0000	.204	.201	.390	.572

GRIP CODE	SUB-PANEL GRIP THICKNESS		K
	G1	G2	
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
M	.375-.405	.414-.444	.440
N	.406-.436	.445-.475	.471
P	.437-.467	.476-.506	.502
R	.468-.498	.507-.537	.533
S	.499-.529	.538-.568	.564
T	.530-.560	.569-.599	.595
U	.561-.591	.600-.630	.626
V	.592-.622	.631-.661	.657
W	.623-.653	.662-.692	.688
X	.654-.684	.693-.723	.719
Y	.685-.715	.724-.754	.750

THREAD SIZE PER MIL-S-8879	LBS./100
1,2	3
.190-32 UNJF-3B	.38 .42 .45

CODE	NUT TYPE
L	SELF-LOCKING

MATERIAL:

NUT: (A-286) CRES PER AMS 5525 HEAT TREAT TO 160 KSI MINIMUM ULTIMATE TENSILE STRENGTH.
 SLEEVE: (304) CRES PER AMS 5639 OR AMS 5514 (305) OR EQUIV.
 BRACKET: (17-7 PH) CRES PER AMS 5528 HEAT TREAT TO 180 KSI MINIMUM ULTIMATE TENSILE STRENGTH.

FINISH:

SLEEVE: CAD PLATE PER QQ-P-416, TYPE II CLASS 2, OVER PASSIVATE PER QQ-P-35. DYED BLUE FOR COLOR CODING.
 BRACKET: CAD PLATE PER QQ-P-416, TYPE II CLASS 2, OVER PASSIVATE PER QQ-P-35.

NUT: PASSIVATE PER QQ-P-35 & DRI-FILM LUBRICANT PER MIL-L-46010.

NOTES:

- "R2" DIMENSION FOR "AA" GRIP LENGTH IS: .315
- .023/.030 LOBES HEIGHT FOR "AA" & "A" GRIPS.
- A MINIMUM OF TWO THREADS ARE DEFORMED TO PRODUCED SELF-LOCKING ACTION PER MIL-N-25027.
- NUT ELEMENT HAS .060 TOTAL FLOAT WITHIN THE BRACKET.
- FOR NUT ELEMENT REPLACEMENT P/N, SEE DWG. S-0877.
- NUT ELEMENT REMOVAL TOOL AVAILABLE, P/N RB6527.
- NUT ELEMENT COLOR CODE PER PCD: 160147.
SELF-LOCKING NUTS: NATURAL DARK GRAY (DRI-FILM)
- FOR HIGH VOLUME INSTALLATION RATES, ALTERNATE POWER TOOLING IS AVAILABLE. SEE SHEET 2 OF 2 FOR INSTALLATION TOOLS.
- TO OBTAIN ADDITIONAL WEIGHTS ADD INCREMENTS OF .020 PER LETTER CODE.
- .010 x 45° CHAMFER REQUIRED FOR INSTALLATION IN 7075 AND 7050 ALUMINUM ALLOYS.
- SEE SHEET 2 OF 2 FOR INSTALLATION TOOLS.

TOLERANCE DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED FRACTIONS ± 1/32 ANGLES ± 2° 2 PLACE DECIMALS ± .02 3 PLACE DECIMALS ± .015				HUCK THIRD ANGLE COMPANY	Huck International, Inc. - Lakewood Operations - Aerospace Fastener Division 3969 Paramount Blvd. Lakewood, CA 90712	
PREPARED IN ACCORDANCE WITH ANSI Y14.5M					DATE: 03/21/91	NUT PLATE RIVETLESS, SPECIAL SLEEVE DIAMETER, (45° F), CLOSE TOLERANCE
NC1	5663	9/11/95	JR	DR. BY: <i>[Signature]</i>	SIZE	CODE IDENT NO.
NC	EDR#5311	03/21/91	JR	CHK. BY: <i>[Signature]</i>	A	97928
REV	E.O. NO.	DATE	BY	APPD. BY: <i>[Signature]</i>	PART NO.	GHFCT 6010L
REVISION				SCALE NONE	DWG NO.	S-3320
				DATE: 03/25/91	SHEET 1 OF 2	

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PNEUMATIC TOOL

ASSEMBLY PART NUMBER	INSTALLATION	FORMER ASSEMBLY	USE ON
PTRM7503CB-()	C'BORE	FRMB-()	GHFCT6010 L -()-()-()
PTRM7503CS-()	C'SINK	FRMS-()	

HAND TOOL

ASSEMBLY PART NUMBER	INSTALLATION	NOSE PIECE ASSEMBLY	USE ON
DCBT8604()-()-()	C'BORE	DCBN86134-()	GHFCT6010 L -()-()-()
DCST8604()-()-()	C'SINK	DCSN86134-()	

ARBOR PRESS TOOL


ASSEMBLY PART NUMBER	INSTALLATION	USE ON
MCT7659CB-()	C'BORE	GHFCT6010 L -()-()
MCT7659CS-()	C'SINK	

AIR HYDRAULIC TOOL

ASSEMBLY PART NUMBER	INSTALLATION	NOSE PIECE ASSEMBLY	USE ON
DT()3004CB-()	C'BORE	DT3014CB-()	GHFCT6010 L -()-()
DT()3004CS-()	C'SINK	DT3014CS-()	

EXAMPLE: DT()3004CS-()

CODE	TYPE OF INSTALLATION POWER UNIT
I	INLINE MOTOR INTEGRATED WITH BOOSTER
P	PISTOL GRIP MOTOR WITH REMOTE BOOSTER
R	REMOTE CYLINDER FOR LIMITED ACCESS

				TOLERANCE DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED FRACTIONS ± 1/32 ANGLES ± 2° 2 PLACE DECIMALS ± .02 3 PLACE DECIMALS ± .015		 <small>THIRD ANGLE COPYING</small>		Huck International, Inc. - Lakewood Operations - <small>Aerospace Fastener Division 3969 Paramount Blvd. Lakewood, CA 90712</small>	
NC1	5663	9/11/95	JR	JA	PREPARED IN ACCORDANCE WITH ANSI Y14.5M	DATE:	03/21/91	NUT PLATE RIVETLESS, SPECIAL SLEEVE DIAMETER, (450° F), CLOSE TOLERANCE	
NC	EDR#5311	03/21/91	JR	JB	THIRD ANGLE PROJECTION DUAL DIMENSIONING IN MM. TOL. MM	DR. BY:	<i>CR</i>	SIZE	CODE IDENT NO.
REV	E.O. NO.	DATE	BY	APPD	SCALE NONE	CHK. BY:	<i>Colin Krugilla</i>	A	97928
REVISION					SCALE NONE	APPD. BY:	<i>[Signature]</i>		
					DATE:	03/25/91			
									PART NO. GHFCT 6010L DWG NO. S-3320 SHEET 2 OF 2