

# STRESSNUT, FLOATING, EXPANDING, SAE REPLACABLE NUT ELEMENT, VARIABLE COUNTERBORE, STRESS RELIEVING FASTENER

**MATERIAL:**

NUT ELEMENT - CRES A286 (UNS S66286) PER AMS5525, AMS5732 OR AMS5737.

RETAINER - TITANIUM 6AL4V (UNS R56400) PER AMS4911  
OR 17-4 PH (H1025, UNS S17400) PER AMS5643.

RETAINING CLIP - XM-28 STAINLESS STEEL SPRING WIRE (UNS S24100) PER ASTM A313/A313M.

**FINISH:**

NUT ELEMENT - TYPE A286 CRES (450°F): PASSIVATE PER AMS2700 PLUS DRY FILM LUBRICANT PER AS5272.  
TYPE A286 CRES (800°F): PASSIVATE PER AMS2700 PLUS SILVER PLATE PER AMS2410.

RETAINER - PASSIVATE PER AMS2700.

RETAINING CLIP - PASSIVATE PER AMS2700.

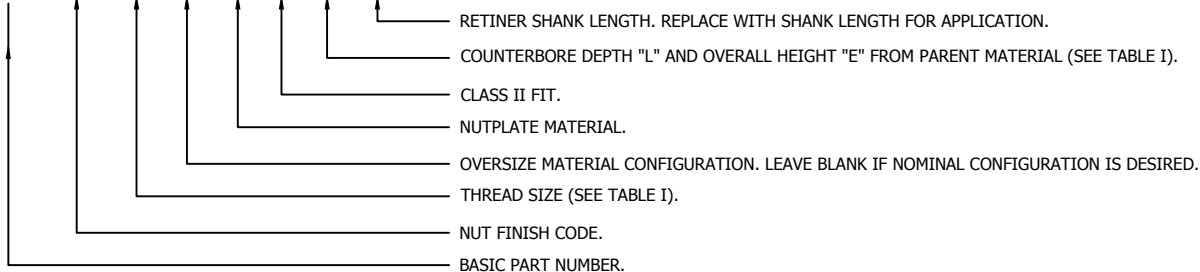
**CODE:**

NUT FINISH:  
"M" FOLLOWING BASE PART NUMBER INDICATES DRY FILM LUBRICANT ON NUT.  
"S" FOLLOWING BASE PART NUMBER INDICATES SILVER PLATE ON NUT.

RETAINER MATERIAL:  
"S" REPLACE "T" IN PART NUMBER TO INDICATE 17-4 PH RETAINER MATERIAL.

## EXAMPLE CALLOUT:

NA2397 M - 032 OS - I - II - 4 - ( )



- NOTES:**
1. ALL DIMENSIONS ARE IN INCHES AND APPLY AFTER FINISH AND PRIOR TO THE APPLICATION OF LUBRICANT UNLESS OTHERWISE SPECIFIED.
  - /2/ MINIMUM ID OF NUT RETAINER AFTER ASSEMBLY.
  - /3/ FLOAT ON NUT ELEMENT SHALL NOT BE LESS THAN 0.030 RADIALLY FROM CENTERED POSITION. NUT ELEMENT SHALL BE CAPABLE OF ENGAGEMENT WITH A BOLT IN THE MAXIMUM MISALIGNED POSITION.
  - /4/ REPLACABLE COMPONENTS:
    - A. NUT ELEMENT
    - B. RETAINING CLIP
  5. THREADS SHALL BE IN ACCORDANCE WITH AS8879. THE UPPER PORTION OF THE NUT SHALL BE DEFORMED TO PRODUCE SELF-LOCKING FEATURE.
  6. THE INCLUSION OF LUBRICANT ON THE RETAINERS AND RETAINING CLIPS OF LUBRICATED NUTS IS OPTIONAL.
  - /7/ RETAINER SHALL BE MARKED WITH NAFCO USA, LLC MANUFACTURING MARK "N" AND WITH "T" FOR TITANIUM 6AL4V MATERIAL. MARKINGS SHALL BE RAISED OR DEPRESSED .010 INCH MAXIMUM. LOCATION OPTIONAL EXCEPT MUST BE VISIBLE AFTER ASSEMBLY.
  - /8/ RETAINER SHANK LENGTH. REPLACE WITH EXACT LENGTH OF APPLICATION THICKNESS. MANUFACTURED LENGTH WILL BE ADJUSTED BY NAFCO TO ACCOUNT FOR GROWTH DURING INSTALLATION (SEE SECTION 2.9).
  - /9/ AXIAL TENSILE STRENGTH, TORQUE-OUT AND PUSH-OUT VALUES SHALL BE TESTED IAW NASM25027 AND NAS1791.
  - /10/ SEE EXAMPLE CALLOUT FOR DESCRIPTION OF PART NUMBER AND HOW TO INDICATE OVERSIZE OR NOMINAL RETAINER CONFIGURATION.

CONFORMS TO:  
NASM25027

**NAFCO USA, LLC**  
CARSON CITY, NV 89706

PART NUMBER  
**NA2397**  
FEDERAL SUPPLY CODE: 32387