



# RETAINER, NUT - RIVETLESS, COMPOSITE APPLICATION

TABLE II

APPROX. WEIGHT = $W_t + (W_b \times L)$					
NAFCO PART NUMBER	NOM DIA	CLASS FIT	Wt (lb)	Wb (lb/in)	
NA2480-3	3/16	I	.618	1.581	
		II			1.617
		III			1.799
NA2480-4	1/4	I	.688	1.808	1.772
		II			1.808
		III			1.967

TABLE III

0.015 OVERSIZE DIMENSIONS AND WEIGHT					
NAFCO PART NUMBER	NOM DIA	CLASS FIT	ØB MAX	Wt (lb)	Wb (lb/in)
NA2480-3X	3/16	I	.325	.618	1.802
		II	.329		1.823
		III	.359		2.043
NA2480-4X	1/4	I	.375	.688	2.029
		II	.379		2.047
		III	.409		2.254

**MATERIAL :** RETAINER -- 304 CRES PER AMS-QQ-S-763.  
CLIP -- 17-7 CRES PER AMS5678.

**HEAT TREAT :** 304 CRES ANNEALED PER AMS-QQ-S-763.

**FINISH :** RETAINER -- PASSIVATE PER AMS2700.  
CLIP -- PASSIVATE PER AMS2700.

**LUBRICATION:** RETAINER: THE INTERNAL DIAMETER THAT COMES IN CONTACT WITH THE TOOLING MANDREL DURING INSTALLATION SHALL HAVE DRY FILM LUBRICANT THAT HAS UNDERGONE ANY REQUIRED ELEVATED TEMPERATURE (ABOVE ROOM TEMPERATURE) CURE AFTER PASSIVATION.

**CODING:** LETTER CODE FOLLOWING BASIC PART NUMBER DEFINES CLASS FIT PER TABLE I, TABLE III, AND TABLE IV.  
FIRST DASH NUMBER DESIGNATES NOMINAL THREAD SIZE PER TABLE I.  
SECOND DASH NUMBER DESIGNATES GRIP IN .010 INCREMENTS. **[1]**  
LETTER "X" REPLACING DASH BETWEEN FIRST AND SECOND DASH NUMBER DESIGNATES .015 OVERSIZE. **[3]**

TABLE IV

LETTER CODE TO CLASS NUMBER	
CODE A	CLASS I
CODE B	CLASS II
CODE C	CLASS III

CONFORMS TO:  
NASM25027  
AS8879

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

PART NUMBER  
**NA2480**  
FEDERAL SUPPLY CODE: 32387