



STRESSNUT

FLOATING, VARIABLE COUNTERBORE, SAE REPLACEABLE NUT
ELEMENT, EXPANDING, STRESS RELIEVING FASTENER

PART NUMBER

NA2397

FEDERAL SUPPLY CODE 32387

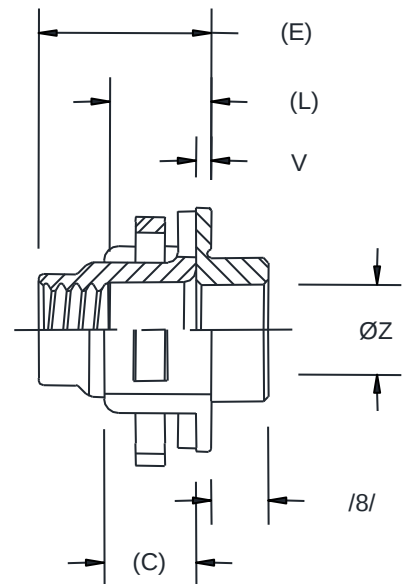
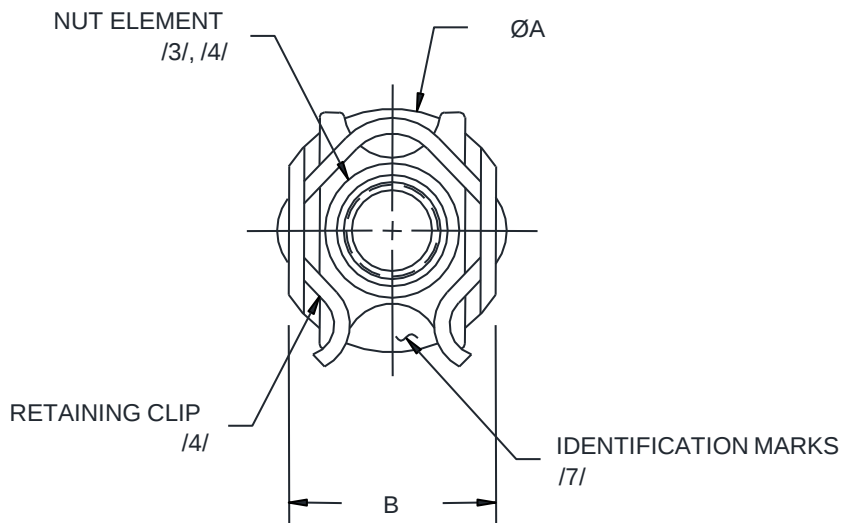


TABLE I – DIMENSIONS

NAFCO PART NUMBER /10/	THREAD (AS8879)	INSTALLATION HOLE SIZE				ØA MAX	B MAX	(C)	(E) MAX	(L) MIN	V ±.005	ØZ MIN /2/
		NOMINAL		OVERSIZE								
		MIN	MAX	MIN	MAX							
NA2397-032-T-II-1-()	.1900-32 UNJF-3B	.2969	.2984	.3125	.3140	.590	.490	.200	.260	.070	.050	.1935
NA2397-032-T-II-2-()									.325	.125		
NA2397-032-T-II-3-()									.385	.188		
NA2397-032-T-II-4-()									.450	.250		
NA2397-032-T-II-5-()									.510	.313		
NA2397-032-T-II-6-()									.575	.375		
NA2397-048-T-II-1-()	.2500-28 UNJF-3B	.3438	.3453	.3594	.3609	.705	.595	.200	.305	.070	.050	.2535
NA2397-048-T-II-2-()									.370	.125		
NA2397-048-T-II-3-()									.430	.188		
NA2397-048-T-II-4-()									.495	.250		
NA2397-048-T-II-5-()									.560	.313		
NA2397-048-T-II-6-()									.615	.375		
NA2397-054-T-II-1-()	.3125-24 UNJF-3B	.4063	.4083	.4219	.4239	.905	.685	.250	.350	.070	.050	.3160
NA2397-054-T-II-2-()									.405	.125		
NA2397-054-T-II-3-()									.465	.188		
NA2397-054-T-II-4-()									.530	.250		
NA2397-054-T-II-5-()									.590	.313		
NA2397-054-T-II-6-()									.650	.375		
NA2397-064-T-II-1-()	.3750-24 UNJF-3B	.4688	.4708	.4844	.4864	1.025	.870	.250	.380	.070	.060	.3785
NA2397-064-T-II-2-()									.430	.125		
NA2397-064-T-II-3-()									.495	.188		
NA2397-064-T-II-4-()									.560	.250		
NA2397-064-T-II-5-()									.635	.313		
NA2397-064-T-II-6-()									.690	.375		
NA2397-080-T-II-1-()	.5000-20 UNJF-3B	.5938	.5958	.6094	.6114	1.250	1.000	.250	.560	.070	.065	.5035

CONFORMS TO:
NASM25027
UNLESS OTHERWISE
SPECIFIED

NAFCO USA, LLC

CARSON CITY, NV 89706

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MATERIAL:

NUT - 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 - 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

NOTES:

- (1) DIMENSIONS IN INCHES AND APPLY AFTER FINISH AND PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- /2/ MINIMUM ID OF NUT RETAINER AFTER ASSEMBLY.
- /3/ FLOAT OF NUT ELEMENT SHALL NOT BE LESS THAN 0.030 RADIALY FROM CENTERED POSITION. NUT ELEMENT SHALL BE CAPABLE OF ENGAGEMENT WITH A BOLT IN THE MAXIMUM MISALIGNED POSITION.
- /4/ REPLACEABLE COMPONENTS:
 - a. NUT ELEMENT
 - b. RETAINING CLIP
- (5) THREADS SHALL BE IN ACCORDANCE WITH AS8879. THE UPPER THREADED PORTION OF THE NUT SHALL BE DEFORMED TO PROVIDE 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.

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.

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EXAMPLE CALLOUT:

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

RETAINER SHANK LENGTH. REPLACE WITH SHANK LENGTH FOR APPLICATION.

COUNTERBORE DEPTH "L" AND OVERALL HEIGHT "E" FROM PARENT MATERIAL (SEE TABLE I).

CLASS II FIT.

NUTPLATE MATERIAL.

OVERSIZE RETAINER CONFIGURATION. LEAVE BLANK IF NOMINAL CONFIGURATION IS DESIRED.

THREAD SIZE (SEE TABLE I).

NUT FINISH CODE.

BASE PART NUMBER.

DRAFT

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