Live Lock
CA2000 Series.

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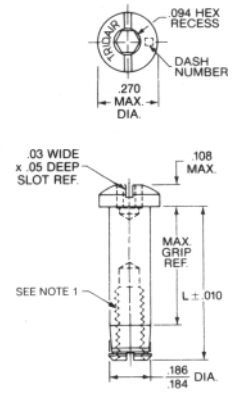
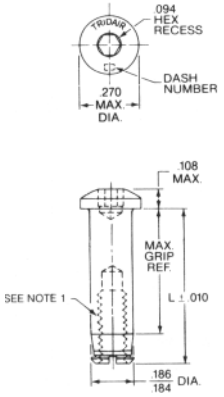
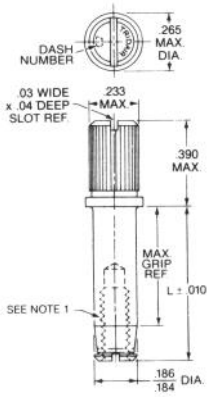
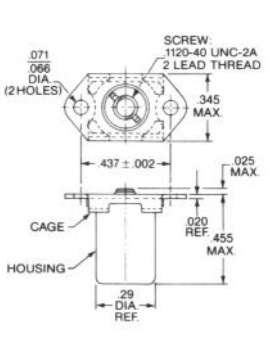
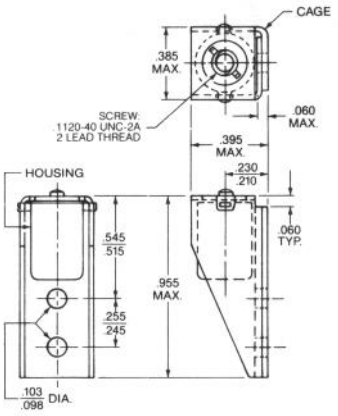
	Protruding Head		
	 **Pan Head Hex Recess Slotted**	 **Pan Head Hex Recess**	 **Knurled Head Slotted**
Material	Part No.	Part No.	Part No.
Material: 300 Series CRES Finish: Passivated per QQ-P-35	CA2021-( )	CA2022-( )	CA2024-( )
Material: A-286 CRES Finish: Passivated per QQ-P-35	--	CA20043T-( )	--

Live Lock
CA2000 Series.

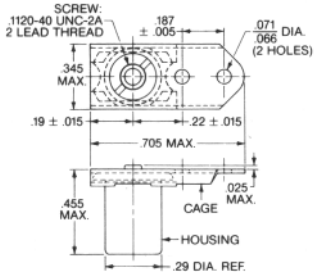
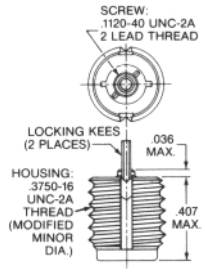
Receptacles.



2-Lug
.020 Radial Float



Right Angle Mount
.020 Radial Float

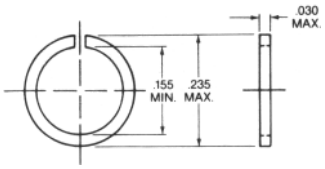
Material	Part No.	Approx. Weight lbs./ea.	Part No.	Approx. Weight lbs./ea.
Cage: 300 Series CRES Screw: A-286 CRES Housing: 300 Series CRES Heat Treat: Screw: Per MIL-H-6875 Finish: Cage and Housing: Passivated per QQ-P-35 Screw: Dry Film Lubed	CA2010	.0059	Ca2014	.0106
Same as above except Cage Finish: Cadmium Plated per QQ-P-416, Type II, Class 2	CA2010C		—	—
	 **1-Lug** **.020 Radial Float**		 **LiveSert***	
Material	Part No.	Approx. Weight lbs./ea.	Part No.	Approx. Weight lbs./ea.
Cage: 300 Series CRES Screw: A-286 CRES Housing: 300 Series CRES Heat Treat: Screw: Per MIL-H-6875 Finish: Cage and Housing: Passivated per QQ-P-35 Screw: Dry Film Lubed	CA2044	.0062	--	--
Same as above except Cage Finish: Cadmium Plated per QQ-P-416, Type II, Class 2	CA2044C		--	--
Screw: A-286 CRES Housing: 300 Series CRES Heat Treat: Screw: Per MIL-H-6875 Finish: Housing: Passivated per QQ-P-35 Screw: Dry Film Lubed	--	--	CA2058	.0068

*LiveSerts with radial float are available; contact Technical Sales.

Live Lock
CA2000 Series.

Retaining Rings.

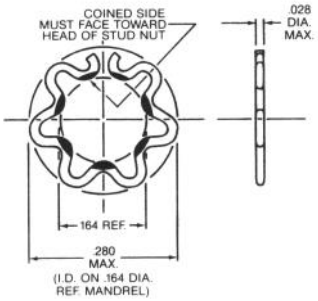
CA2025 Split Ring



Material	Part No.
17-7PH CRES Heat Treat: Per MIL-H-6875 Finish: Passivated per QQ-P-35	CA2025
Same as CA2025 except Finish: Black Oxide per MIL-C-13924	CA2025B
Same as CA2025 except Finish: Cadmium Plated per QQ-P-416, Type II , Class 2	CA2025C

Weight:
.0098 lbs. per hundred (approx.)

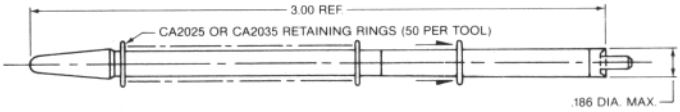
CA2035 Wire Form Ring



Material:
Elgiloy Wire
Heat Treat:
Stress relieved and spring tempered
Finish:
Passivated per QQ-P-35
Weight:
.0062 per hundred (approx.)

Notes:
1. Use CA2035 ring when through hole in substructure "T_2" exceeds .218 diameter. See hole preparation on Pages 6 and 7.
2. **IMPORTANT:** Coined side of ring must face torward head of stud nut.

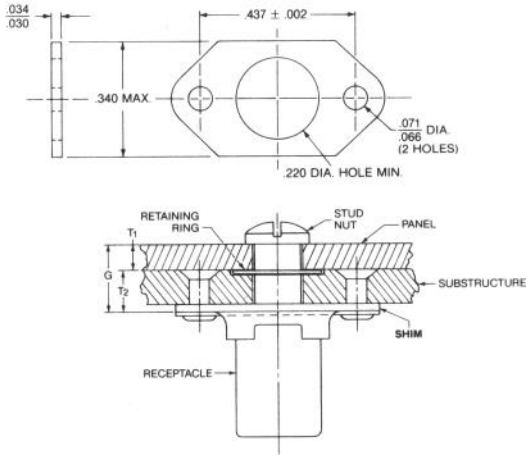
Installation Tool for CA2025 or CA2035 Retaining Rings



Note: Fifty (50) retaining rings are sold mounted on an installation tool to insure proper installation.

Shim.

CA2077



Typical Installation
Showing Proper Use of Shim

Material:
Aluminum per QQ-A-250
Finish:
Anodized per MIL-A-8625
Weight:
.0003 lbs. each (approx.)

Notes:
1. For use with CA2010 or CA2010C receptacle if required.
2. Shim is required when "G" Grip Range is less than min. grip of stud nut (see ordering information on Page 9).

Live Lock
CA2000 Series.

Panel/Substructure Preparation and Installation Data.

Panel:
Flush Head Stud Nuts

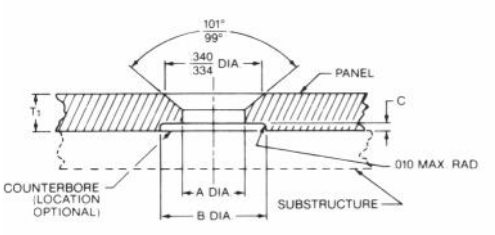


Table I

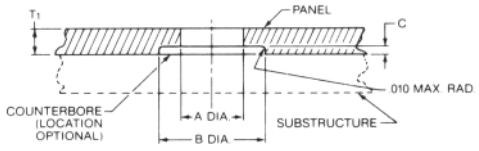
Basic Retaining Ring Part No.	A Dia.	B Dia.	C Depth
CA2025	.189 .187	.255 .245	.035 .030
CA2035		.317 .307	.025 .020

1. Locate and drill “A” diameter hole through panel.

2. Countersink $\frac{101°}{99°}$ to $\frac{.340}{.334}$ diameter.

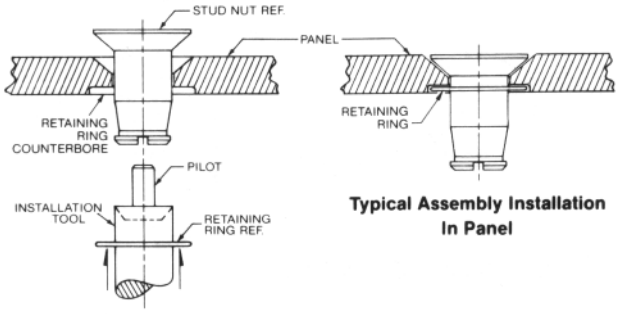
3. If “T_1” is greater than .090, counterbore panel to “B” diameter by “C” depth. Preferred location for counterbored retaining ring recess is in panel “T_1”.

Panel:
Protruding Head Stud Nuts



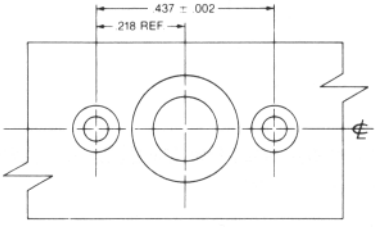
1. Refer to Table I above.
2. Locate and drill “A” diameter hole through panel.
3. If “T_1” is greater than .060, counterbore panel to “B” diameter by “C” depth. Preferred location for counterbored retaining ring recess is in panel “T_1”.

Retaining Ring Installation



To install CA2025 or CA2035 retaining ring on stud nut, insert pilot of tool completely into stud nut threads and slide the retaining ring onto the stud nut.

Substrucutre:
2-Lug Receptacle



Top View of Substructure

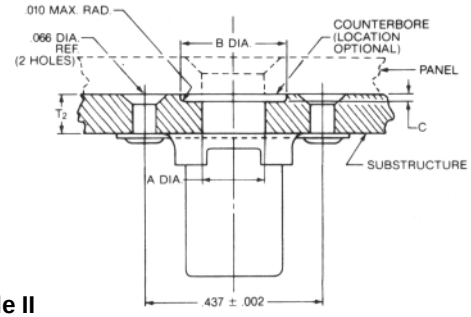


Table II

Application	A Dia.	B Dia.	C Depth	Basic Retaining Ring Part No.
Shear	.189 .187	.255 .245	.035 .030	CA2025
Allow for Panel misalignment	.210 Max.	.266 Min.		
Allow for maximum panel misalignment		.328 Min.	.025 .020	CA2035

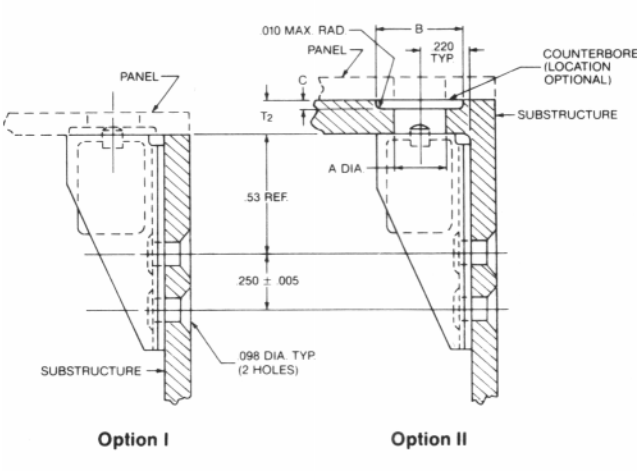
1. Locate and drill “A” diameter hole through substructure.
2. If required, counterbore to “B” diameter by “C” depth. (See flush head or protruding head, Note 3 on this page.)
3. Locate, drill and countersink two holes for flush mount rivets (not supplied). Holes must be symmetrical to “A” diameter.
4. Rivet receptacle in place.

Live Lock
CA2000 Series.

Panel/Substructure Preparation and Instllation Data (cont'd.).

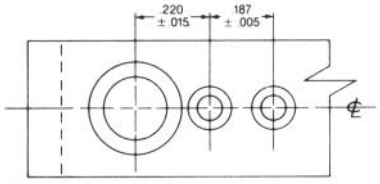
Substructure:
Right Angle Receptacle

Option I Installation:
1. Requires retaining ring counterbore recess to be in panel.
2. Locate and drill two holes for rivets (not supplied).
3. Rivet receptacle in place.

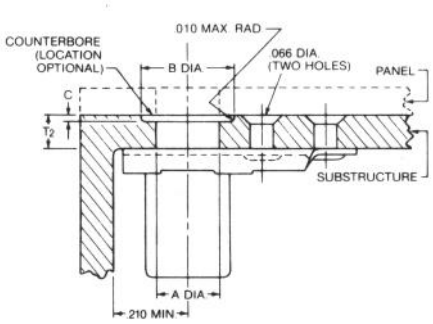


Option II Installation:
1. Refer to Table II on Page 6.
2. Locate and drill "A" diameter hole through substructure.
3. If required, counterbore to "B" diameter by "C" depth (see flush or protruding head, Note 3, Page 6).
4. Locate and drill two holes for rivets (not supplied).
5. Rivet receptacle in place.

Substructure:
1- Lug Receptacle



Top View of Substructure



Notes:
1. Refer to Table II on Page 6.
2. Locate and drill "A" diameter hole through substrucutre.
3. If required, counterbore to "B" diameter by "C" depth (see panel preparation for flush or protruding head, Page 6, Note 3.)
4. Locate, drill and countersink two holes for flush mount rivets (not supplied). Holes must be symmetrical to "A" diameter.
5. Rivet receptacle in place.

Live Lock
CA2000 Series.

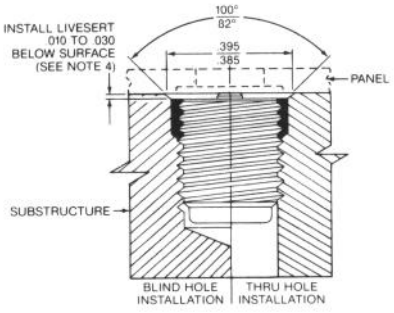
Panel/Substructure Preparation and Installation Data (cont'd.).

Substructure:
LiveSert Receptacle

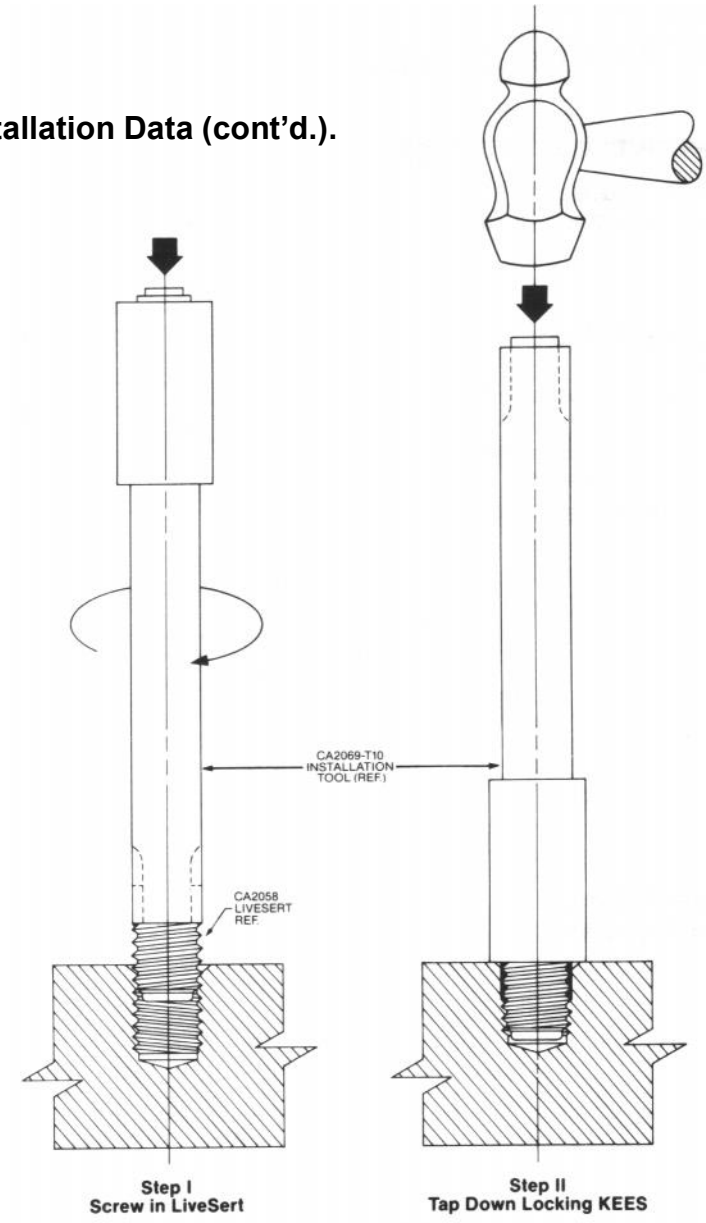
Notes:
1. Locate and drill $\frac{.336}{.331}$ diameter to .437 minimum depth.

2. Countersink $\frac{100^\circ}{82^\circ}$ to $\frac{.395}{.385}$ diameter.

3. Tap .375-16 UNC-2B thread, .388 minimum depth.
4. Install LiveSert with CA2069-T10 installation tool (Step I). Live Sert is designed to stop at the correct depth below the surface of the substructure.
5. Invert CA2069-T10 tool and drive in the kees (Step II).
6. Retaining ring counterbore recess must be in panel "T_1".
7. **Caution:** Always wear eye protection when striking tool with hammer.



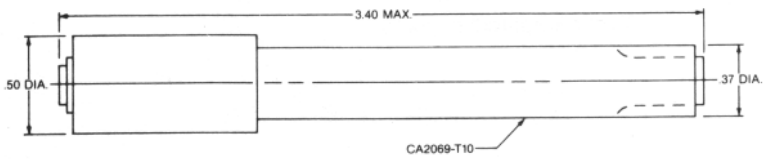
Shown With Locking KEES Installed



Step I
Screw in LiveSert

Step II
Tap Down Locking KEES

LiveSert Installation Tool
CA2069-T10



Material: Alloy Steel
Finish: Black Oxide

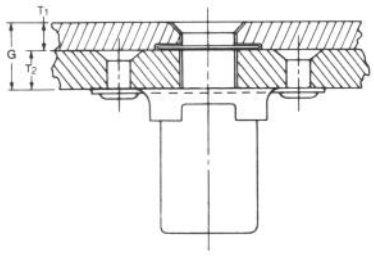
Note: Installation tool CA2069-T10 is required to install CA2058 LiveSert receptacle.

Live Lock
CA2000 Series.

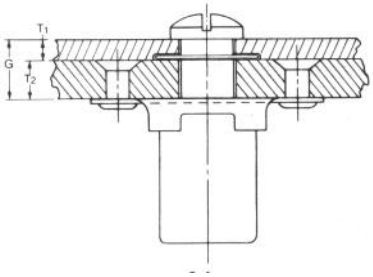
Ordering Information.

To Select Stud Nut Dash Number

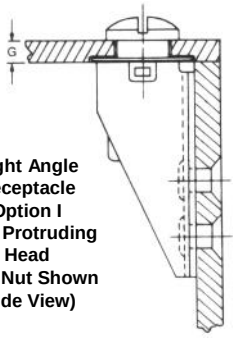
1. Determine “G” thickness:
   a. “G” = “T1”+”T2,” plus any compressed gasketing material, shim, paint or other finishes.
2. Locate “G” grip range in the table.
3. Find the corresponding stud nut dash number in the column designated for the selected stud nut.



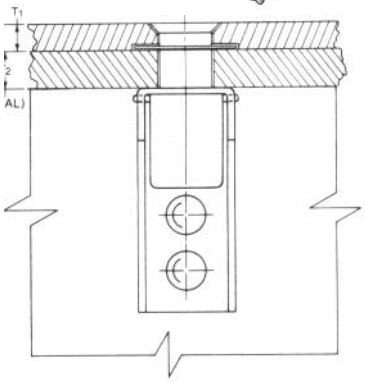
2-Lug Receptacle Flush Head Stud Nut Shown



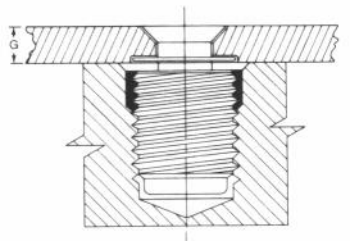
2-Lug Receptacle Protruding Head Stud Nut Shown



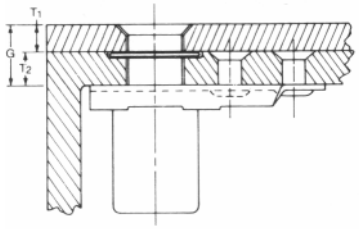
Right Angle Receptacle Option I With Protruding Head Stud Nut Shown (Side View)



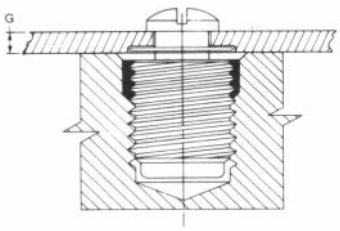
Right Angle Receptacle Option II With Flush Head Stud Nut Shown (Front View)



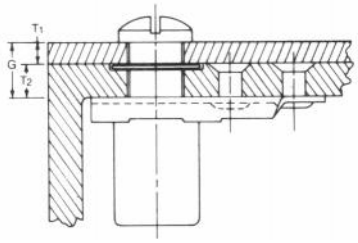
LiveSert Receptacle Flush Head Stud Nut Shown



1-Lug Receptacle Flush Head Stud Nut Shown



LiveSert Receptacle Protruding Head Stud Nut Shown



1-Lug Receptacle Protruding Head Stud Nut Shown

Stud Nut Dash Number Selection***											
L	"G" Grip Range**	CA2020/CA20000T		CA2021		CA2022/CA20043T		CA2023		CA2024*	
		Dash No.	Weight lbs./100	Dash No.	Weight lbs./100	Dash No.	Weight lbs./100	Dash No.	Weight lbs./100	Dash No.	Weight lbs./100
.250	.090-.124	N/A	--	-0	.23	-0	.24	N/A	--	-0	.25
.312	.125-.187	-1	.20	-1	.26	-1	.26	-1	.20	-1	.31
.375	.188-.250	-2	.24	-2	.29	-2	.29	-2	.24	-2	.38
.437	.251-.312	-3	.28	-3	.32	-3	.32	-3	.28	-3	.44
.500	.313-.375	-4	.32	-4	.34	-4	.34	-4	.32	-4	.50
.562	.376-.437	-5	.36	-5	.37	-5	.37	-5	.36	-5	.56
.625	.438-.500	-6	.40	-6	.40	-6	.40	-6	.40	-6	.62
.687	.501-.562	-7	.44	-7	.42	-7	.42	-7	.44	-7	.69

*For Dash Number “-0” minimum grip = .062 inch.
**For “G” grip range greater than grip shown, contact Technical Sales.
***If “G” is less than grip shown and CA2010 type receptacle is used, shim CA2077 is required (see Page 5 for typical shim installation).

Live Lock

Live Lock