

WE 962

Material and Performance of Steel Blind Anchor Nuts

1. SCOPE.

This standard covers the material and minimum performance requirements of steel round or hexagonal bodied blind anchor nuts in the range M4 to M10 inclusive.

1.1 REFERENCES.

WSD-M1A283-B1, B2, B3, B4, B43, B47, B48, B49 or B57 - Steel, cross reference for standard parts.

2. MATERIAL.

The material for blind anchor nuts shall be steel in accordance with WSD-M1A283 B1, B2, B3, B4, B43, B47, B48, B49 or B57.

3. PERFORMANCE.

When assembled in a panel of thickness equal to the maximum thickness recommended by the manufacturer for the blind anchor nut to be tested, using assembly equipment and settings approved by Ford, blind anchor nuts shall meet the requirements for Push Out, Torque to Turn, and Pull Out as specified in Table 1.

The direction of testing is shown in Figures 1, 2 and 3 as appropriate.

FIGURE 1

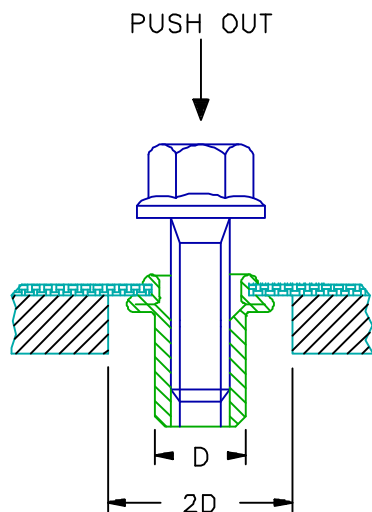


FIGURE 2

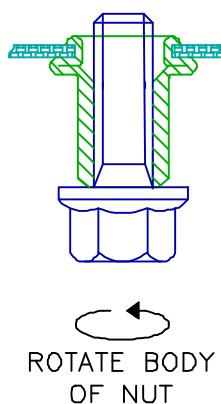
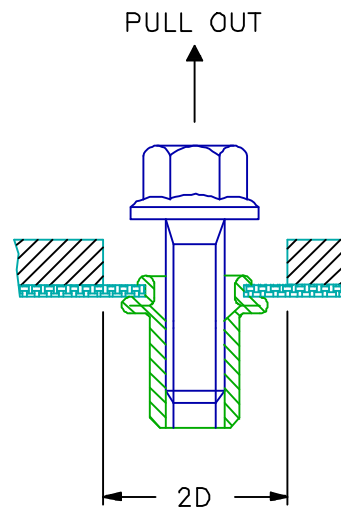


FIGURE 3



TEST BOLT / MANDREL
HEAD STYLE IS NOT
IMPORTANT



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Table 1. Nut type, material and performance

Nom Size	Type	Material	Push-Out Min (kN)	Torque to Turn Min (Nm)	Pull-Out Min (kN)
M4	Round	Steel	1	0.8	4.4
	Hex	Steel	0.9	2.2	4.4
M5	Round	Steel	1.4	1.4	7.1
	Hex	Steel	1.2	4.7	7.1
M6	Round	Steel	1.8	4	10
	Hex	Steel	1.7	7.9	10
M8	Round	Steel	1.8	4.5	18.3
	Hex	Steel	1.5	20	18.3
M10	Round	Steel	3	5.5	29
	Hex	Steel	2.6	41	29