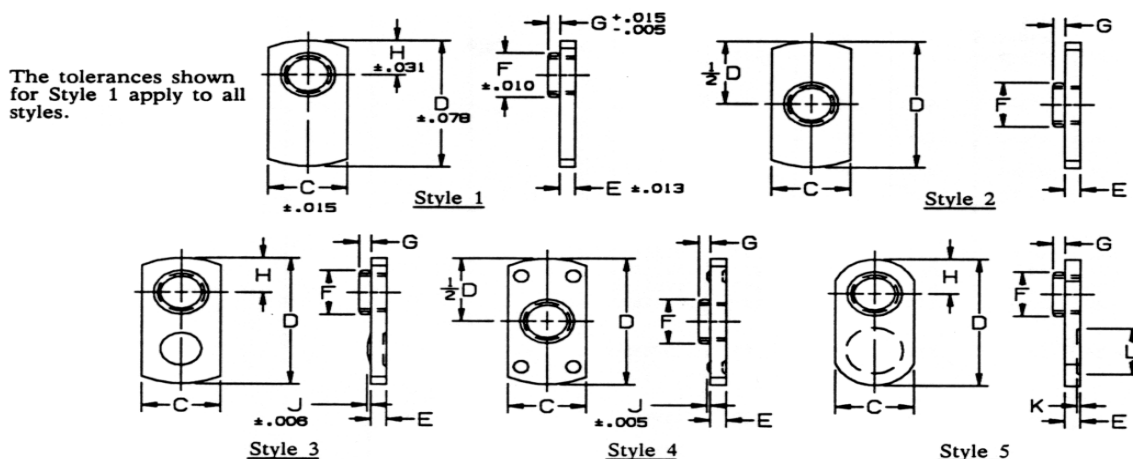


NAVISTAR, INC.		
Material, Parts, and Process Specifications (MPAPS)		NUMBER: MPAPS S-E-39.101-GS/PL
		Former Designation: ESP-E-39.101-GS
TITLE: Tab Weld Nuts – English Series (Noun Code 5780)	CURRENT REV No.: 1506	DATE: June 2015
WRITTEN/EDITED BY: Materials Engineering	APPROVED BY: Materials Engineering	SUPERSEDES: ESP-E-39.101-GS - August 2006
PRINTED COPIES OF THIS DOCUMENT MUST BE VERIFIED FOR CURRENT REVISION		
<i>This specification may involve hazardous materials, equipment, and procedures. This specification does not purport to address all of the safety issues associated with its use. The user is responsible to consult appropriate safety and health practices and to determine the applicability of regulatory limits prior to use.</i>		
Change Notice: Changed to New MPAPS format; Combined GS, PP.		

- 1.0 GENERAL:** Tab Weld Nuts are used on flat and tubular sections, confined corners, close spacing, flanges, and narrow channels in open and blind applications. Self-locating pilot style nuts speed positioning of parts assembly.
- 2.0 RESTRICTED CHEMICAL SUBSTANCES:** Effective January 1, 2007, all product supplied to the requirements of this specification must comply with the requirements of the MPAPS B-50 specification.
- 3.0 MATERIAL:** AISI 1008 or 1010 Steel (STL);
Mechanical Properties: Tensile Strength - 60,000 PSI
Yield Point - 30,000 PSI
Shearing Strength - 30,000 PSI
Elongation 2" - 30% Max
- 4.0 FINISH:** Plain (PLN)
- 5.0 THREAD:** Unified Series, Coarse, Class 2B.



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JUNE 2015

NUMBER: MPAPS S-E-39.101-GS/PL	TITLE: Tab Weld Nuts	REVISION: 1506
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Nominal Thread Size	G Pilot Height	H Hole Center to End		J Proj Height	K Target Depth	L Target Dia	Hole in Sheet	
Style No.	All	1 & 3	5	All	5	5	1,2, 3 & 4	5
8	.031	.188	.188	.020	.062	.250	.219	.219
10	.031	.188	.188	.020	.078	.281	.250	.250
1/4	.047	.250	.250	.025	.078	.281	.312	.297
5/16	.078	.344	.281	.030	.094	.344	.375	.375
3/8	.094	.344	.344	.030	.094	.406	.453	.453
1/2	.125	---	---	--	---	---	.609	---

For dimensions not shown, see section 6.0 and 7.0.

6.0 POLICY FOR SELECTING PARTS FOR NEW DESIGN: Approved parts are so designated to reduce variety of parts and assure maximum availability, interchangeability, and cost savings in volume buying.

For new design, parts shall be selected from "Approved" part list only.

7.0 PART LIST:

7.1 Approved:

Nominal Size-TPI	C-Width Style	D Length	E-Thick ness	F-Pilot Diam.	Part Number
8 - 32	.375-4	.625	.094	.203	27806R1
8 - 32	.438-1	.625	.094	.203	318864C1
10 - 24	.438-1	.625	.094	.234	338836C1
10 - 24	.438-3	.625	.094	.234	370544R1
1/4 - 20	.500-1	.812	.105	.297	629763R1
1/4 - 20	.500-2	1.062	.105	.297	252552C1
1/4 - 20	.500-4	.812	.105	.297	397216R1
5/16 - 18	.625-2	1.500	.135	.359	564266R1
5/16 - 18	.625-4	1.000	.135	.359	344724C1
3/8 - 16	.625-1	1.125	.135	.438	158878H1
3/8 - 16	.625-4	1.000	.135	.438	25564R1
1/2 -13	.812-4	1.250	.188	.594	25725R1
10 - 32	.375-4	.625	.086	.234	397631R1

8.0 TECHNICAL INFORMATION:

For further information related to the technical content of this specification, contact:	Suppliers may purchase controlled copies of this specification by contacting:
Materials Engineering and Technology Dept. 10400 W. North Avenue Melrose Park, IL 60160 E-mail: MaterialsEngineering@Navistar.com	IHS Global Inc. 15 Inverness Way East Englewood CO 80112-5776 Phone: 1-800-854-7179 E-mail: Automotive@IHS.com Website: http://global.ihs.com

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