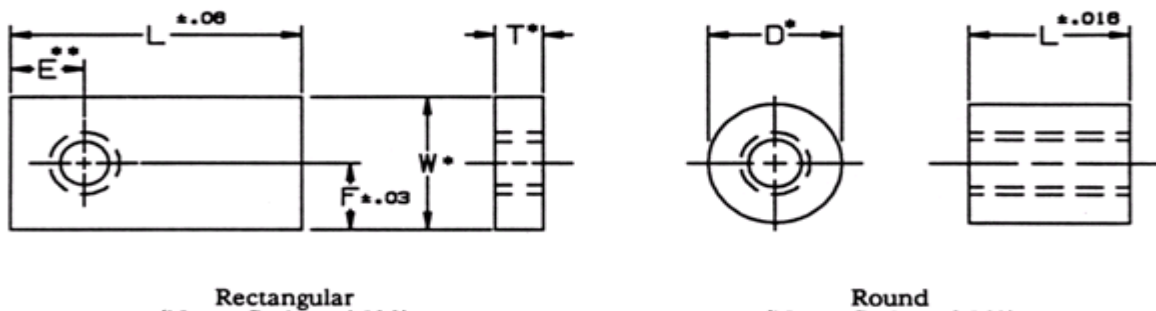


NAVISTAR, INC.		
Material, Parts, and Process Specifications (MPAPS)		NUMBER: MPAPS S-E-42.101-GS/PL
		Former Designation: ESP-E-42.101-GS
TITLE: Tapping Bosses– English Series (Noun Code 0865)	CURRENT REV No.: 1506	DATE: June 2015
WRITTEN/EDITED BY: Materials Engineering	APPROVED BY: Materials Engineering	SUPERSEDES: ESP-E-42.101-GS - September 2007
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: This standard consists of weldable round and rectangular parts containing a single through tapped hole.

The following design parameters must be adhered to:

- | | |
|---|--|
| Rectangular Parts | - F dimensions must be on center line.
Length (L) must not exceed five times width (W). |
| Round Parts | - Thickness (L) must not exceed 2 times outside diameter (D) . |
| Threads | - Coarse Only |
| Nominal Thread Sizes | - 1/4, 5/16, 3/8, 1/2, 5/8, 3/4, and 1 inch. |
| Length (L), Width (W), and Diameter (D) | - 1/4 inch increments only |
| Thickness (T) | - 1/8 inch increments only |
| Center of Drilled Hole (E) | - 1/16 inch increments only |



* Mill Tolerance - 0-202W, MPAPS A-0, Part II, use AISI hot rolled bar tolerance, or 2-202W, MPAPS A-0, Part II, use cold drawn bar tolerance.

** Drilled Hole to be located a distance of nominal L minus E.

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JUNE 2015

NUMBER: MPAPS S-E-42.101-GS/PL	TITLE: <i>Tapping Bosses</i>	REVISION: 1506
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- 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 EDGES:** A breakout of 15% thickness permissible with sheared edges.
- 4.0 TOLERANCES:** (Round Parts)
Diameter (D) must be concentric with the axis of threaded hole within $\pm .04$.
Both ends (L) dimension must be square with the axis of threaded hole within $\pm .016$.
- 5.0 THREADS:** Unified Series, Class 2B.
- 6.0 MATERIAL:** As designated by part number, Code 0-202W or 2-202W steel per MPAPS A-0, Part II.
- 7.0 FINISH:** Plain (PLN).
- 8.0 DESIGN GUIDANCE DATA:** Where Type 5 torques are required, the following chart indicates minimum thickness required.

Nominal Size	T Min
1 /4	.375
5 /16	.500
3 /8	.625
1 /2	.750
5/8	1.000
3/4	1.250
1	1.500

- 9.0 DEFECTS:** Bosses must be free from all defects which might affect their serviceability.

10.0 PART LIST - TAPPING BOSSES – ROUNDED:

10.1 Approved:

Nominal Size -TPI	L Length	D O.D.	Material	Part Number
3/8 -16	.62	1.00	0-202W	612866C1

11.0 TECHNICAL INFORMATION:

For further information related to the technical content of this specification, contact:	Suppliers may purchase controlled copies of this specification by contacting:
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