

NAVISTAR, INC.		
Material, Parts, and Process Specifications (MPAPS)		NUMBER: MPAPS S-E-69.101-GS/PL
		Former Designation: ESP-E-69.101-GS
TITLE: Push on Spring 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-69.101-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:** Push on spring nuts (Stud Receivers) have a "Boss" or impression that allows the fastener to be forced down on a stud and lock in place. Back pressure against the fastener causes the prongs to bite into the stud.
- 2.0 APPLICATION AND DESIGN:** All nuts in section 10.0 may be used on either round or "D" shaped studs, except the heavy series nuts having the boss design variation. These nuts are used on round studs only. Nuts are used on round studs in applications where the assembly is permanent; "D" shaped studs where disassembly is a consideration. Recommended stud design data is specified at the following page.
- 3.0 DIMENSIONAL TOLERANCE:** Tolerance on dimensions in the tables will be plus or minus .010 inch unless otherwise specified. Tolerance on the thickness of material will be plus or minus .001 inch.
- 4.0 BOSS:** Size and formation of boss and other detail will be such as to assemble readily and function satisfactorily with the specified stud.
- 5.0 MATERIAL:** Spring steel, 1050 thru 1065 per MPAPS A-0, Part I, suitably processed to meet the performance requirements of the specification.
- 6.0 FINISH:** Two standard finishes "Phosphate Coated", and "Rustproof." "Phosphate Coating" will comply with Class B-2 per MPAPS G-1, which requires phosphate coating with subsequent oil coating to meet a 48 hour salt spray requirement. "Rustproof" requires phosphate coating, with two subsequent coats of hex-free zinc chromate paint requirements (or paint standard with manufacturer) to meet 72 hour salt spray requirement
- 7.0 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.

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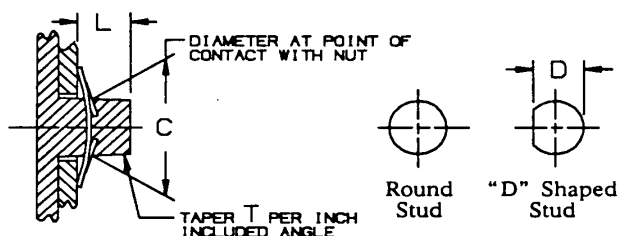
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8.0 HARDNESS:

Material Thickness	Rockwell Scale	Dial Reading	Conversion to Rockwell C Scale
Up to .016	15N	82.5 - 85.5	44 - 50
.017-.024	30N	63.0 - 68.5	44 - 50

9.0 SURFACE DISCONTINUITIES: Allowable limits defined in MPAPS F-31, Part II.



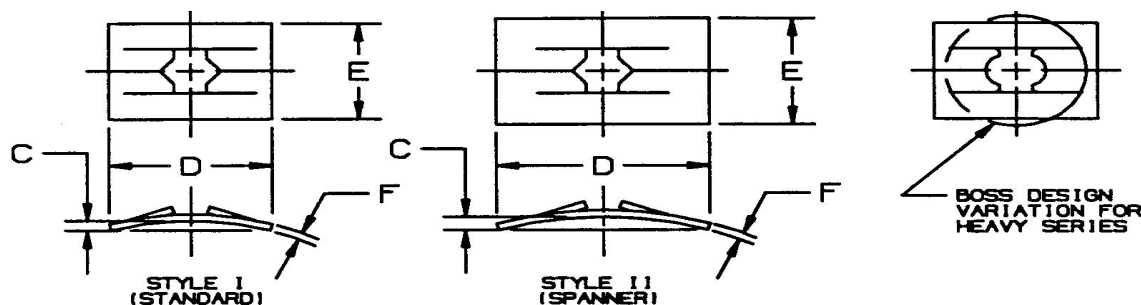
RECOMMENDED STUD DESIGN DATA

Dimensions in inches

C	D	L	T
Stud Diameter ±.005	Stud Width	Exposed Stud Length	Maximum Taper
1/16	.049	3/16	.052
3/32	.074	3/16	.052
1/8	.100	3/16	.052
5/32	.125	1/4	.040
3/16	.150	1/4	.040
7/32	.175	1/4	.040
1/4	.200	1/4	.040
5/16	.250	5/16	.033
3/8	.300	5/16	.033

10.0 PART LIST:

10.1 Approved:



Stud Diameter	Style	Series	D Length	E Width	C		F Thick-ness	PART NUMBERS	
					Arch			STEEL	
					Max	Min		Phosphate Coated	Rustproof
3/16	I	Medium	5/8	3/8	.060	.030	.017	-	445207
1/4	I	Medium	5/8	7/16	.050	.020	.017	-	445213

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