

NAVISTAR, INC.		
Material, Parts, and Process Specifications (MPAPS)		NUMBER: MPAPS S-J-9.101-GS/PL
		Former Designation: ESP-J-9.101-GS
TITLE: Button Plugs – English Series (Noun Code 6200)	CURRENT REV No.: 1506	DATE: June 2015
WRITTEN/EDITED BY: Materials Engineering	APPROVED BY: Materials Engineering	SUPERSEDES: ESP-J-9.101-GS - August 2006
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<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, NPP.		

1.0 GENERAL: Button plugs should securely assemble into holes of the specified diameter and fit snugly without play.

2.0 MATERIAL: As designated by part number, parts will be furnished per MPAPS as listed below.

Steel (STL) -1010 or 1050, MPAPS A-0, Part 1.

Brass (BRS) - Commercial quality.

3.0 FINISH: As designated by part number, parts will be furnished plain, plated or coated in accordance with MPAPS and Class listed below.

Plain (PLN)

Zinc Trivalent (ZN6A) on steel – MPAPS G-20, Class 6A.

Zinc (ZN) on brass – MPAPS G-20, Class 1.

Phosphate (PHC) on steel – MPAPS G-1, Class B-1

Chrome Bright (CRB) on steel – CEMS G-19, Part III, Class 13 CRB

Chrome Bright (CRB) on brass – CEMS G-19, Part III, Class 5 CRB

Black Enamel (BLE) - Standard with Manufacturer

4.0 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.

5.0 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.

Sizes: Hole Diameter - 1/8 to 1"
 excluding 1/64" increments

Material: Steel (STL) 1010

Finish: Plain (PLN)
 Zinc Trivalent (ZN6A)
 Chrome Bright (CRB)

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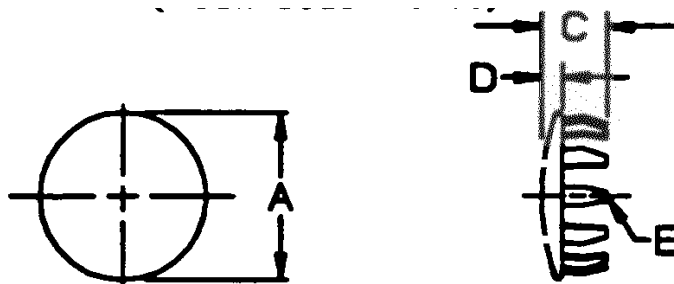
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6.0 TOLERANCES: For tolerances on material thickness see table below.

Material Thickness Range	Hole Diameter Tolerance
Up to .035, inclusive	+ .005, -.000
Over .035 to .093, inclusive	± .005
Over .093	±.010

7.0 WORKMANSHIP: Button plugs will be free from burrs, and all other defects that might affect their serviceability.

8.0 DIMENSIONS:



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