

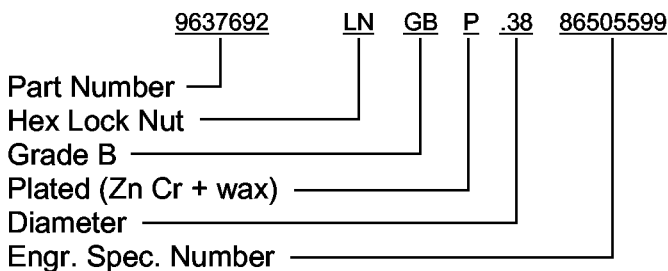
Hex Lock Nuts, Grade B, All-Metal, Zn Cr Plated, Coarse Threads**1. SCOPE**

1.1 The fasteners defined by this specification are gold zinc chromate (Zn Cr) plated plus wax Grade B Hex Lock Nuts with coarse threads.

1.2 The Hex Lock Nut Grade B Zn Cr plus wax is preferred item to be used in joint applications which require integrity when tightened and do not loosen when subjected to vibration.

2. DESIGNATION

2.1 Typical call-out on a drawing shall be:



NOTE: The above description is required for use in all company-wide computer generated documents. The description on hand drawn assembly drawings should follow the same practice.

2.2 Table 2 contains the Preferred part numbers to be used in future designs. Table 3 lists the Non-Preferred part numbers which should be avoided in future designs.

2.3 When requesting a new part number, refer to the instructions in standard 86505922 (FNHA-3-A-005.00).

3. RELATED SPECIFICATIONS**3.1 REFERENCE STANDARDS**

86508305(FNHA-2-H-500.00)—Zinc Electroplating on Ferrous Surfaces

86505922(FNHA-3-A-005.00)—Assignment of Standard Part Numbers

ANSI/ASME B1.1—Unified Inch Screw Threads

IFI 100—Prevailing-Torque Type Steel Hex and Hex Flange Nuts

ASTM F812—Surface Discontinuities on Nuts

3.2 This standard replaces the following company standards:

New Holland (Partial)
Versatile (Partial)

NA2.01.3
1-A-020

4. REQUIREMENTS**4.1 MATERIAL**

Grade B according to IFI 100. Steel with the following chemical composition: max. of .55% carbon, min. of .30% Manganese, max. of .05 Phosphorus, and max. of .15% Sulfur.

4.2 MARKING

Grade B nuts shall be marked with three equally spaced identical symbols (dot, line, letter, or other character), 120 degrees apart on the chamfered surface of the nut. Manufacturer's mark shall also be present per IFI 100.

					NAME	STD LN GB UNC ZNCR		
					 NEW HOLLAND		ENGINEERING SPECIFICATION	
ALL	J	BJF	115653	28FEB01	THE INFORMATION HEREON IS THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF NEW HOLLAND N. V. AND/OR ITS SUBSIDIARIES. ANY USE, EXCEPT THAT FOR WHICH IT MAY BE LOANED, IS PROHIBITED.		FRAME 1	OF 4
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4.3 PLATING

The plating shall be gold Zinc Chromate (Zn Cr) Electroplate plus wax per 86508332 (FNHA-2-H-500.75). Baking is not required for hydrogen embrittlement relief.

4.4 MECHANICAL REQUIREMENTS

Grade	Nut Size Diameter	Proof Load Stress	Hardness *
	Inch	PSI	Rockwell
B	#4 thru 1"	120000	C28 max.
	1" thru 1 1/2"	105000	C28 max

* Hardness shall be determined on the top of the Nut

4.5 MECHANICAL DIMENSIONS

The Hex Lock Nut thread geometry shall conform to UNC-2B per ANSI/ASME B1.1. The general dimensions shall meet the requirements in Table 1. All other dimensions shall be according to IFI 100.

4.6 SURFACE DISCONTINUITIES

All products under this specification shall meet the Surface Discontinuities on Nuts per ASTM F812.

5. SUPPLIER RESPONSIBILITY

5.1 Suppliers shall perform the necessary test for sample approval for initial lots. After this approval, suppliers are not required to perform the specific tests, but ascertain that their product will conform to the specification limits. These specified requirements will be used to reconcile any disputed values.

5.2 All materials supplied to this specification shall be equivalent in all characteristics to the material upon which approval was originally granted. Prior to making of any changes in the properties, composition, construction, color, dimensions, processing or labeling of the material originally approved under this specification, the supplier shall notify Purchasing and the affected Materials Engineering activity of the proposed changes and obtain the written acknowledgement of the Material Engineering activity. Test data, test samples and a new identification code are to be submitted with the request.

	NAME				PART NUMBER	
	STD LN GB UNC ZNCR				86505599	
ENGINEERING SPECIFICATION				REV. J	FRAME 2	OF 4