

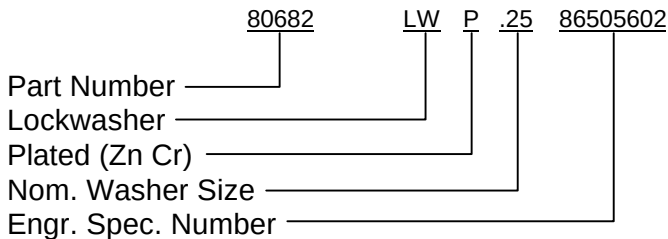
Lock Washer Helical Spring Zn Cr Plated**1. SCOPE**

1.1 The fasteners defined by this specification are gold zinc chromate (Zn Cr) plated Helical Spring Lockwashers.

1.2 The Helical Spring Lockwasher Zn Cr plated is washer to provide protection against looseness resulting from vibration. The preferred lockwasher is the Belleville Spring Lockwasher 86505666 (FNHA-1-A-540.00)

2. DESIGNATION

2.1 Typical call out on a drawing shall be:



NOTE: The above typical 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 list of non preferred part numbers should not be used 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**

86580475 (FNHA-2-H-505.00)—Zinc Mechanical Coating on Ferrous Surfaces
86505922 (FNHA-3-D-005.00)—Assignment of Standard Part Numbers
86505666 (FNHA-1-A-540.00)—Lockwasher, Belleville Spring Type, Zn Cr
ANSI/ASME B18.21.1—Lockwashers

3.2 This standard replaces the following company standards.

New Holland Standard	NA2.03.3
Versatile Standard (Partial)	1-A-024

4. REQUIREMENTS**4.1 MATERIAL**

Lockwashers shall be made from carbon steel lock washer wire meeting the following limits for decarburization:

Diameter of Round Wire or Sections of Equivalent Area	Max. Depth of Free Ferrite	Max. Total Affected Depth (Free ferrite plus partial decarburization)
Up to .140, incl	.002	.006
Over .140 to .250, incl	.003	.010
Over .250 to .375, incl	.004	.008
Over .375 to .500, incl	.006	.015

Also, lockwashers shall be heat treated to a hardness of Rockwell C38 to 46 or equivalent.

					NAME	STD LW HELICAL ZNCR		
					 NEW HOLLAND		ENGINEERING SPECIFICATION	
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4.2 PLATING

The plating shall be gold Zinc Chromate (Zn Cr) Mechanical per 86580485(FNHA-2-H-505.25).

4.3 MECHANICAL DIMENSIONS

The general dimensions shall meet the requirements in Table 1 according to Regular Helical Spring Lockwashers of ANSI/ASME B18.21.1.

4.4 WASHER SECTION

The section of finished washers shall be slightly trapezoidal in shape with thickness at the inner periphery greater than the thickness at the outer periphery by an amount varying from a minimum of .0005 in. to a maximum of .001 in per .0156 in. of the minimum section width.

4.4.1 Corners. The corners at the outer and inner peripheries of washer shall be rounded sufficiently to avoid checks. However the radius at corners shall not exceed the equivalent of 15 percent of the minimum width of the washer section and need not necessarily be tangent to the face of the washer section.

4.5 COILING

Washers shall be coiled so that height is approximately equivalent to twice the thickness of the washer thickness. The gap and relationship of severed ends shall be such as to prevent washers tangling and ensure that washers will compress flat.

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.

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