

Cap Screw, Hex Socket Head, Plain

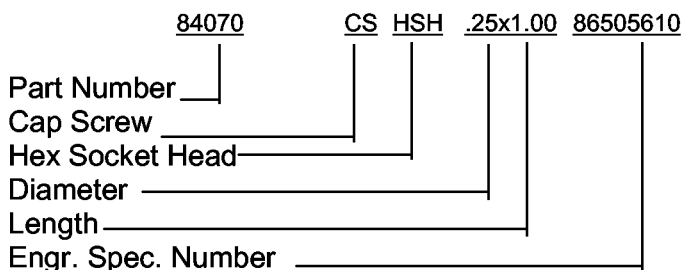
1. SCOPE

1.1. The fasteners defined by this specification are plain Cap Screws Hex Socket Headed with UNRC-3A coarse threads.

1.2. The Cap Screw Hex Socket Head plain fastener is to be used in applications where head is to be recessed into hole or square and in tight areas that will not allow room for wrenching a hex head.

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 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

86505922(FNHA-3-A-005.00) - Assignment of Standard Part Numbers
 ANSI/ASME B1.1 - Unified Inch Screw Threads
 ANSI/ASME B18.3 - Socket Head Cap Screws
 ASTM A574 - Alloy Steel Socket Head Cap Screws
 SAE J123 - Surface Discontinuities on Bolts, Screws, and Studs

3.2 This standard replaces the following company standards.

Versatile Standard (Partial) 1-A-003

4. REQUIREMENTS

4.1 MATERIAL

4.1.1 Alloy steel shall be according to ASTM A574 with the following chemical composition: min. .31% of Carbon, max. .045% of Phosphorus, and max. .045% of Sulfur with one or more of the following alloying elements: chromium, nickel, molybdenum or vanadium present in sufficient quantity to assure that the specified strength properties are met after oil quenching and tempering.

4.1.2 Screws shall be heat treated by oil quenching from above the transformation temperature and then tempering at a temperature not lower than 650°F.

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ALL	K	BJF	115070	08SEP00			FRAME 1	OF 4
ALL	J	BJF	111875	4/98				
ALL	H	BJF	111422	2/98				
FRAME NO.	REV	BY	ECN NO.	DATE			PART NUMBER	
APP.	DRAWN		BJFJR	12/93	 36505610 Documents Document Sharing			
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4.1.3 The hardness of finished screws shall be Rockwell C39 to C45 for 1/2 inch diameter and smaller screws and Rockwell C37 to C45 for 5/8 inch diameter and larger screws. Core hardness to be measured at 1/2 radius of the threaded transverse section at a distance of 1 diameter from the end of the product (average of 4 readings).

4.2 PLATING

These parts are not plated.

4.3 MECHANICAL DIMENSIONS

The screw thread geometry shall conform to UNRC-3A per ANSI/ASME B1.1. The general dimensions shall meet the requirements in Table 1.

4.5 SURFACE DISCONTINUITIES

All products under this specification shall meet the Surface Discontinuities on Bolts, Screws, and Studs per SAE J123 requirements.

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 Materials Engineering activity. Test data, test samples and a new identification code are to be submitted with the request.

	NAME				PART NUMBER	
	STD CS HSH UNRC				86505610	
ENGINEERING SPECIFICATION				REV. K	FRAME 2	OF 4