

Hex Flange Nut, Underserrated, Zn Cr Plated, Coarse Threads

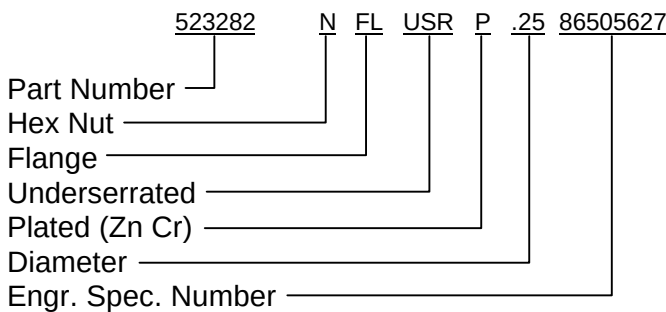
1. SCOPE

1.1 The fasteners defined by this specification are gold zinc chromate (Zn Cr) plated Hex Flange Nuts Underserrated with coarse threads.

1.2 The Underserrated Hex Flange Nut Zn Cr plated fastener is to be used in joint applications which require integrity when tightened and does not loosen when subjected to vibration.

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 not be used in future designs.

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

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

SAE J403—Chemical Compositions of SAE Steels

SAE J122—Surface Discontinuities on Nuts

3.2 This standard replaces the following company standards.

New Holland (Partial)

2.02.5

Versatile (Partial)

1-A-032

4. REQUIREMENTS

4.1 MATERIAL

4.1.1 AISI 1010 according to SAE J403—low carbon steel with the following chemical composition: .08% to .13% Carbon, .30% to .60% Manganese, max. .04% Phosphorus, and max. .05% Sulfur.

4.1.2 Heat Treatment

Carburize and Direct Quench

Effective Case Depth .003 to .012 inches

Temper Surface to 78 to 90 Rockwell 15N

Core Hardness to Rockwell b80 to b95*

* Core Hardness shall be determined after Case is removed.

					NAME	STD LN FLG URS ZNCR		
ALL	E	BJF	117333	24JAN02	 NEW HOLLAND	ENGINEERING SPECIFICATION		
ALL	D	BJF	111422	2/98				
ALL	C	BJF	110258	6/97				
ALL	B	BJF	108139	7/96				
ALL	A	RE	104739	3/94				
FRAME NO.	REV	BY	ECN NO.	DATE	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	PART NUMBER
APP. KHH 2/94	DRAWN	BJFJR	2/94					
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4.2 PLATING

The plating shall be gold Zinc Chromate (Zn Cr) Electroplate per 86508316 (FNHA-2-H-500.25). Baking (86512106) per 86508305 (FNHA-2-H-500.00) is required for hydrogen embrittlement relief.

4.3 MECHANICAL REQUIREMENTS

The nuts shall be able to withstand a 120,000 psi Proof Load.

4.4 MECHANICAL DIMENSIONS

The nut thread geometry shall conform to UNC-2B according to 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 Nuts according to SAE J122.

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.

 NEW HOLLAND	NAME				PART NUMBER	
	STD LN FLG URS ZNCR				86505627	
ENGINEERING SPECIFICATION				REV. E	FRAME 2	OF 4