

Cap Screw Flange Head, Underserrated, Zn Cr Plated, Coarse Threads

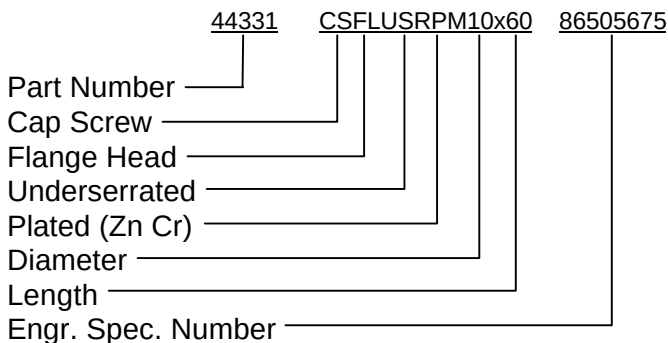
1. SCOPE

1.1 The fasteners defined by this specification are gold zinc chromate (Zn Cr) plated underserrated Cap Screws Flange Headed with coarse threads.

1.2 The Underserrated Cap Screw Flange Head Zn Cr plated fastener is to be used in joint applications which require integrity when tightened and do not come loose when subject 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 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 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

SAE J403—Chemical Compositions of SAE Steels
ISO 965/II—ISO General Purpose Metric Screw

Threads—Tolerances—Part 2: Limits of Sizes for General Purpose Bolt and Nut Threads—Medium Quality

DIN 6921—Hexagon Flange Bolts (Metric)

SAE J123—Surface Discontinuities on Bolts, Screws, and Studs

Tensilok® - BN73—Hex Flange (Serrated) Screws

3.2 This standard replaces the following company standard:

Versatile (Partial)

1-M-012

4. REQUIREMENTS

4.1 MATERIAL

4.1.1 Low carbon steel with the following chemical composition: .18% to .23% Carbon, .70% to 1.00% Manganese, max .040% Phosphorus, and max. .050% Sulfur. If Boron steel is used, boron content should be min. .0005.

					NAME	STD CS FLG USR ZNCR		
					 NEW HOLLAND	ENGINEERING SPECIFICATION		
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4.1.2 Heat Treatment:

Carburize and Direct Quench
 Total Case Depth of .002 to .006 inches
 Temper surface to 80 to 89 Rockwell 15N
 Core hardness to Rockwell C28 to C36*

*Take measurement at 1/2 radius of threaded transverse section at a distance of one diameter from the end of the product (average of four readings)

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 screws shall be able to withstand an 85,000 psi proof load.

4.4 MECHANICAL DIMENSIONS

The screw thread geometry shall be coarse pitch, tolerance class 6g (medium class) according to ISO 965/II before plating. 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.

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