

Machine Screw Flat Head 90 Degrees, Zn Cr Plated, Coarse Threads

1. SCOPE

1.1. The fasteners defined by this specification are gold zinc chromate (Zn Cr) plated Flat Headed 90o Machine Screws with coarse threads.

1.2. The Flat Headed Machine Screw Zn Cr plated fastener is to be used for countersunk applications where material flows over the head and for appearance purposes like in a cab application.

2. DESIGNATION

2.1 Typical call-out on a drawing shall be:

Dutch	86512463	VS	FH90 G	M6x25	86505677
English	86512463	MS	FH90 P	M6x25	86505677
Part Number	86512463				
Machine Screw		MS			
Flat Head 90°			FH90		
Plated (Zn Cr) (G-Gal Zn 5)				G	
Diameter				M6	
Length					25
Standard Part Number	86512463				86505677

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

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

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

ISO 898/I—Mechanical Properties of Fasteners—Part I: Bolts, Screws, and Studs

ISO 965/II—ISO General Purpose Metric Screw Threads—Tolerances—Part 2: Limits of Sizes for General Purpose Bolt and Nut Threads—Medium Quality

ISO 4757—Cross Recesses for Screws

DIN 965A—Flat Head Machine Screws

SAE J1061—Surface Discontinuities on General Application Bolts, Screws, and Studs

3.2 This standard replaces the following company standards:

New Holland	ES12.06
Versatile (Partial)	1-M-020

4. REQUIREMENTS

4.1 MATERIAL

Class 4.8 according to ISO 898/I—low or medium carbon steel with the following chemical composition of max. .55% Carbon, max. .05% Phosphorus, and max. .06% Sulfur.

					NAME	STD MS FH90 ZNCR		
					 NEW HOLLAND		ENGINEERING SPECIFICATION	
ALL	H	BJF	120060	04DEC02	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
FRAME NO.	REV.	BY	ECN NO.	DATE			PART NUMBER	
APP.	DRAWN		BJFJR	1/94			86505677	
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4.2 PLATING

The plating shall be gold Zinc Chromate (Zn Cr) Electroplate 86508316 (FNHA-2-H-500.25) per standard 86508305 (FNHA-2-H-500.00). Baking is not required for hydrogen embrittlement relief.

4.3 HEAD DRIVE TYPE

The standard Phillips drive type is Type H according to ISO 4757.

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. All other dimensions shall be according to DIN 965.

4.5 SURFACE DISCONTINUITIES

All products under this specification shall meet the Surface Discontinuities on General Application Bolts, Screws, and Studs per SAE J1061 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.

 NEW HOLLAND	NAME				PART NUMBER	
	STD MS FH90 ZNCR				86505677	
ENGINEERING SPECIFICATION		REV. H	FRAME 2	OF 4		