

Standard Parts / Metric Fasteners

FNHA-1-A-390.00

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

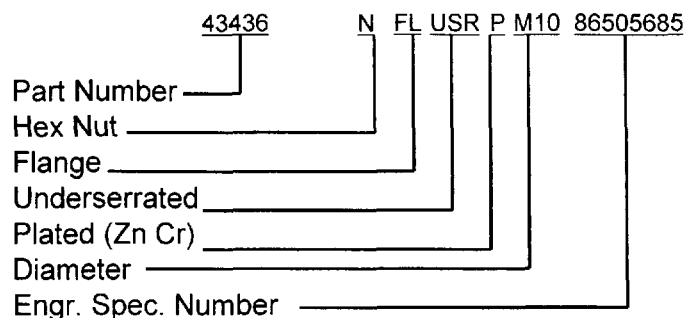
1. SCOPE

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

ANSI/ASME B18.2.4.4M - Metric Hex Flange Nuts

SAE J403 - Chemical Compositions of SAE Steels

SAE J122 - Surface Discontinuities on Nuts

3.2 This standard replaces the following company standards.

Versatile Standard (Partial) 1-M-046

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*

					NAME	STD LN FLG USR ZNCR	
ALL	E	BJF	111288	1/98	 NEW HOLLAND	ENGINEERING SPECIFICATION	
ALL	D	BJF	110082	5/97			
ALL	C	BJF	108139	7/96			
ALL	B	MI	106814	8/95			
ALL	A	RE	104739	1/95			
FRAME NO.	REV	BY	ECN NO.	DATE	THE INFORMATION HEREON IS THE CONFIDENTIAL AND PROPRIETARY PROPERTY OF NEW HOLLAND NORTH AMERICA, INC. AND/OR NEW HOLLAND CANADA, LTD. ANY USE, EXCEPT THAT FOR WHICH IT MAY BE LOANED, IS PROHIBITED.	FRAME 1	OF 4
APP. KHH 3/94	DRAWN		BJFJR	2/94		PART NUMBER	
	CHECKED					86505685	

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- * Core Hardness shall be determined after Case is removed.

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 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 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 USR ZNCR			86505685	
ENGINEERING SPECIFICATION			REV. E	FRAME 2	OF 4