

Standard Parts / Inch Fasteners

FNHA-1-B-345.00

Hex Jam Nuts, Grade 2, Zn Cr Plated, Fine Threads

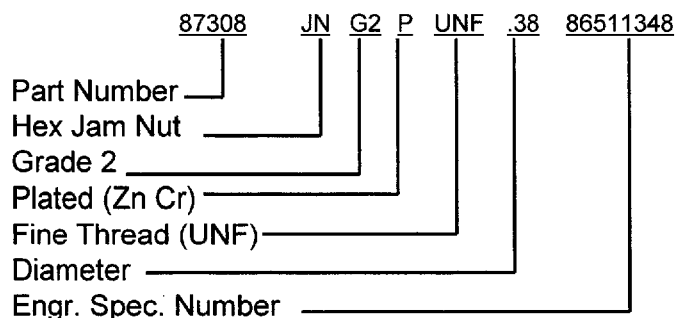
1. SCOPE

1.1 The fasteners defined by this specification are gold zinc chromate (Zn Cr) plated Grade 2 Hex Jam Nut with fine threads (UNF).

1.2 The Hex Jam Nut Grade 2 UNF Zn Cr plated is to be used in applications where additional security is needed to keep a fastener from coming loose, in critical and high strength applications, and for adjustment accuracy.

2. DESIGNATION

2.1 Typical call out on a drawing shall be:



NOTE: The above 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-D-005.00) - Assignment of Standard Part Numbers

ANSI/ASME B1.1 - Unified Inch Screw Threads

ANSI/ASME B18.2.2 - Square and Hex Nuts

SAE J995 - Mechanical and Material Requirements for Steel Nuts

SAE J122 - Surface Discontinuities on Nuts

4. REQUIREMENTS

4.1 MATERIAL

4.1.1 Grade 2 according to SAE J995 - Steel with the following chemical composition: max. of .47% Carbon, max. of .12% Phosphorus, and max. of .15% Sulfur.

4.1.2 Grade 2 nuts are not required to be marked for grade identification.

4.2 PLATING

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

					NAME	STD JN G2 UNF ZNCR		
					 NEW HOLLAND	ENGINEERING SPECIFICATION		
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ALL	C	BJF	110258	6/97				
ALL	B	BJF	108139	7/96				
ALL	A	RE	104739	1/95				
FRAME NO.	REV	BY	ECN NO.	DATE		PART NUMBER		
APP.	DRAWN		BJFJR	11/93		36511348		
KHH 12/93	CHECKED					Documents		

Standard Parts / Inch Fasteners**FNHA-1-B-345.00****4.3 MECHANICAL REQUIREMENTS**

Grade	Nut Size Diameter	Proof Load Stress	Hardness *
	Inch	PSI	Rockwell
2	1/4" thru 1-1/2"	90000	C32 max.

* Hardness shall be determined on the top or bottom of the Nut

4.4 MECHANICAL DIMENSIONS

The Hex Jam Nut thread geometry shall conform to UNF-2B 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 Nuts per 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 Material Engineering activity. Test data, test samples and a new identification code are to be submitted with the request.

	NAME			PART NUMBER	
	STD JN G2 UNF ZNCR			86511348	
ENGINEERING SPECIFICATION			REV. D	FRAME 2	OF 4