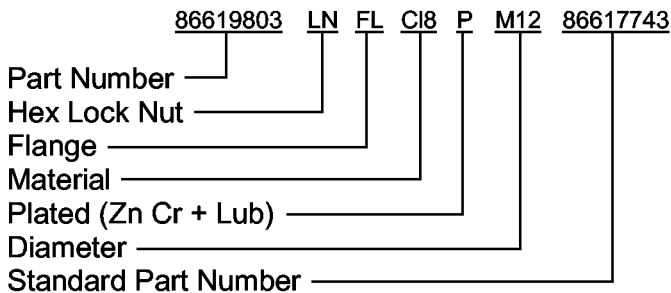


Flanged Lock Nuts, Class 8, All Metal, Zn Cr Plated, Coarse Threads**1. SCOPE**

1.1 The fasteners defined by this specification are gold zinc chromate (Zn Cr) plated with supplemental lubricant Class 8 Hex Flanged Lock Nuts with coarse threads.

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 part numbers to 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 898/2—Mechanical Properties of Fasteners—Part 2: Nuts with Specified Proof Load Values

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

ISO 2320—Prevailing Torque Type Steel Hexagon Nuts—Mechanical and Performance Properties

ISO 7044—Prevailing Torque Type All-Metal Hexagon Nuts with Flange—Product Grades A and B

ASTM F812—Surface Discontinuities on Nuts

4. REQUIREMENTS**4.1 MATERIAL**

4.1.1 Class 8 according to ISO 2320.

4.1.2 Nuts of diameter M5 and larger shall be marked legibly to identify property class and manufacturer. Property class identification symbols shall conform to ISO 898 Part 2.

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4.3 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) plus supplemental lubricant. Baking is not required for hydrogen embrittlement relief.

4.4 MECHANICAL REQUIREMENTS PER ISO 2320

Class	Nut Size Diameter	Proof Load Stress	Hardness *
	mm	N/mm ² (min.)	Rockwell
8	thru 4	800	C30 max.
	over 4 thru 7	855	C30 max.
	over 7 thru 10	870	C30 max.
	over 10 thru 16	880	C30 max.
	over 16 thru 24	920	C36 max.

* Hardness shall be determined on the top of the nut

4.4 MECHANICAL DIMENSIONS

The Hex Flange Lock Nut thread geometry shall be coarse threads, tolerance class 6H (medium grade) according to ISO 965/2. The general dimensions shall meet the requirements in Table 1. All other dimensions shall be according to ISO 7044.

4.5 SURFACE DISCONTINUITIES

All products under this specification shall meet the Surface Discontinuities on Nuts per ASTM F812.

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.

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