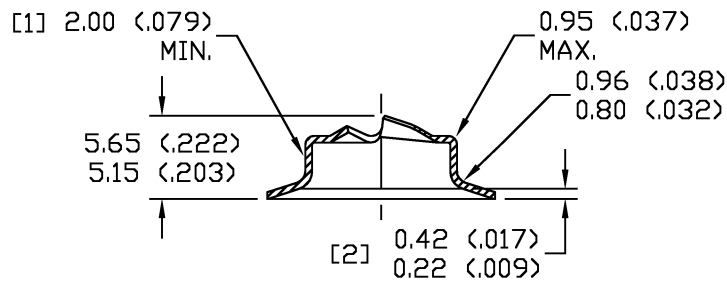
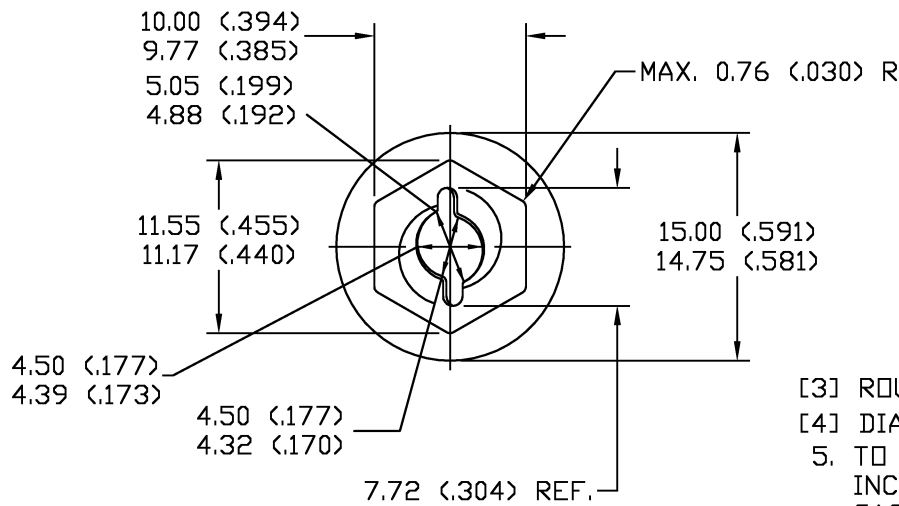


DWG

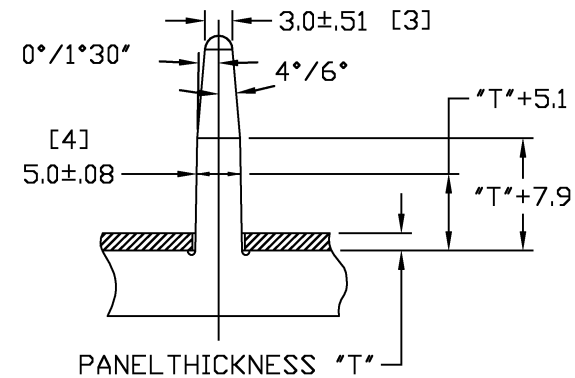
SD050015

ASSEMBLY EFFICIENCY DEPENDS ON ADHERENCE TO THESE STUD SPECIFICATIONS.



- [1] MIN. FLAT HEIGHT AT CENTER OF HEX,
MAX TAPER 1° PER SIDE.
[2] TOTAL DISH HEIGHT TO BASE RADIUS.

DIE CAST STUD



- [3] ROUND END OPTIONAL.
[4] DIA. OF STUD INCLUDING PLATING AT "T"+5.1
5. TO ASSURE ADEQUATE STUD PROJECTION AND PROPER INITIAL THREADING, INCREASE LENGTH OF STUD BY THE AMOUNT REQUIRED FOR UNCOMPRESSED GASKETS OR ANTICIPATED MISMATCH OF TRIM CONTOURS.
6. DIE CAST STUDS: NICKEL-CHROMIUM PLATING MUST NOT EXCEED .08 THICKNESS ALONG STUD.
7. STUDS FABRICATED FROM WIRE: SURFACE HARDNESS MUST NOT EXCEED ROCKWELL B-80.
8. STEEL STUDS: NICKEL, CHROMIUM OR OTHER HARD FINISHES ARE NOT RECOMMENDED.
9. ASSEMBLY PERFORMANCE ON COLD DRAW STEEL:
MAX. THREADING TORQUE: 1.90Nm TIGHTENING TORQUE: 6.90Nm
MIN. CLAMPING: 1157N MIN. ULTIMATE TORQUE: 8.60
10. CONDITIONS OF ASSEMBLY PERFORMANCE:
NUT TORQUED BY HAND ON PLAIN COLD DRAWN STEEL STUD (HARDNESS R30T 74-82) AGAINST PLAIN STEEL WASHER (HARDNESS R30T 74-82).
11. WHEN NUT FINISHED IS PHOSPHATE AND OIL, MINIMUM TIGHTENING TORQUE WILL BE 85% OF FIGURES SHOWN ABOVE.

DATE	REV	DESCRIPTION	BY
18JUN07	D	NOTE 9. MIN. CLAMPING 1157N WAS 11.57N	NR
26FEB07	C	7.72 REF DIMENSION WAS 7.98/7.47 (ECO #1012)	CRD
9/7/00	B	REDRAWN TO AUTOCAD 2000	MS
1/17/00	A	CREATED "CONTROLLED" DRAWING PER ECO#0095	KJD



MATERIAL:
SPRING STEEL-0.43(.017)-SAE1050

HARDNESS: ROCKWELL 30N 60-70

TOLERANCES, UNLESS SPECIFIED:

mm ±.38 in ±.015

PAL®	PALNUT®	ON SERT®	PUSHNUT®
TITLE			
5 x 10 x 15 PALNUT SELF THREADING NUT WASHER TYPE METRIC STYLE "SD"			
DRAWN:	CMB	RELEASED	SCALE
DATE:	10/26/93	PART No: SD 050015	NONE
CHECKED:	DWG No.		
APPROVED:	SD050015		