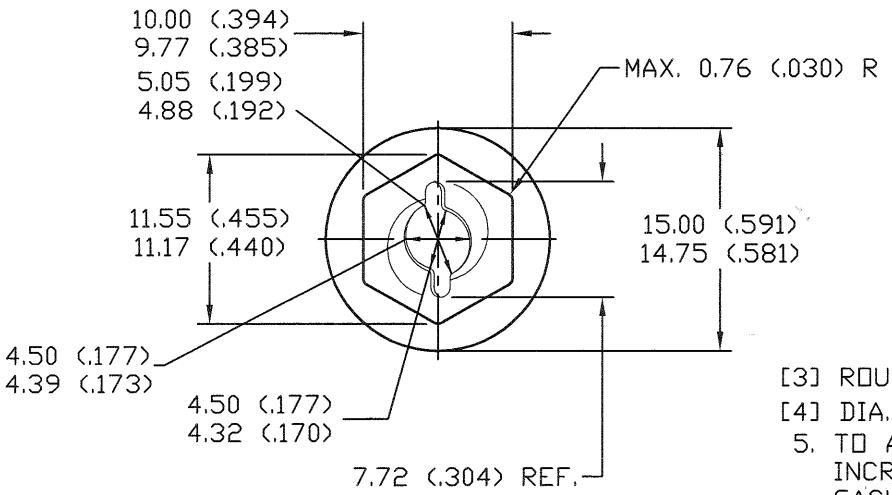
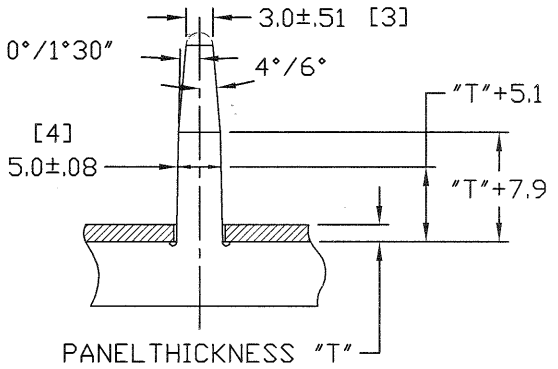
DWG

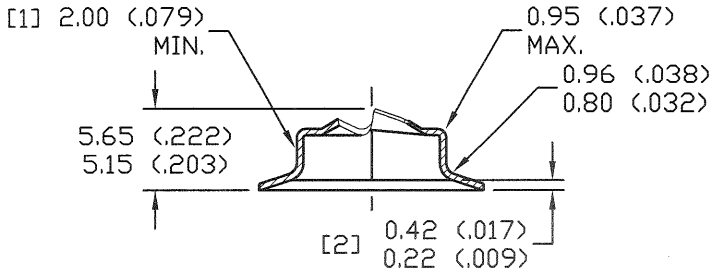
SD050015

ASSEMBLY EFFICIENCY DEPENDS ON ADHERENCE TO THESE STUD SPECIFICATIONS.



DIE CAST STUD





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

[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.

Controlled copy must be in Red

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)	CRO
9/7/00	B	REDRAWN TO AUTOCAD 2000	MS
1/17/00	A	CREATED "CONTROLLED" DRAWING PER ECO#0095	KJD

TINNERMAN connection engineering

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: TM	DWG No.	
APPROVED: TM	SD050015	