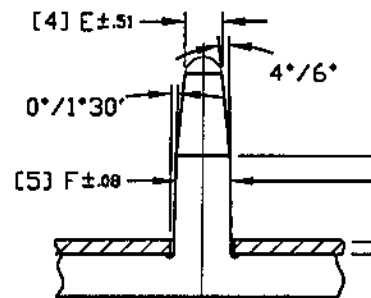


DIE CAST STUD

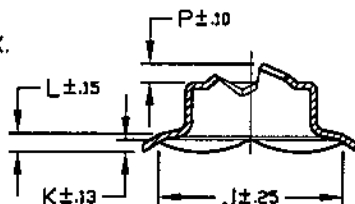
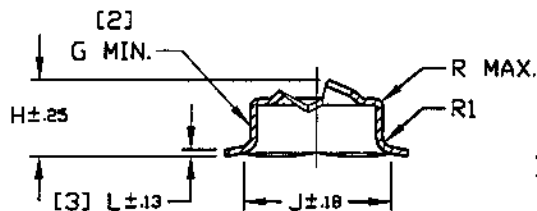


PANEL THICKNESS 'T'

UNCONTROLLED

MAY 23 2002

Controlled copy must be in Red



- (4) ROUND END OPTIONAL.
- (5) DIA. OF STUD INCLUDING PLATING AT HT. 'B'.
- 6. TO ASSURE ADEQUATE STUD PROJECTION AND PROPER INITIAL THREADING, INCREASE LENGTH 'C' BY THE AMOUNT REQUIRED FOR UNCOMPRESSED GASKETS OR ANTICIPATED MISMATCH OF TRIM CONTOURS.
- 7. DIE CAST STUDS: NICKEL-CHROMIUM PLATING MUST NOT EXCEED .08 THICK ALONG STUD.
- 8. STUDS FABRICATED FROM WIRE: SURFACE HARDNESS MUST NOT EXCEED ROCKWELL B 80.
- 9. STEEL STUDS: NICKEL, CHROMIUM, OR OTHER HARD FINISHES ARE NOT RECOMMENDED.
- 10. WHEN NUT FINISH IS PHOSPHATE AND DIC, MINIMUM TIGHTENING TORQUE WILL BE 850F FIGURES.

- (1) FORMED HOLE M, N, D (M, D PERPENDICULAR TO HEX FLATS, N AT TIPS OF TEETH)
- (2) FLAT HEIGHT AT CENTER OF HEX. MAX TAPER 1° PER SIDE.
- (3) TOTAL DISH HEIGHT TO BASE RADIUS.

* CONDITIONS OF ASSEMBLY PERFORMANCE:

NUT TORQUED BY HAND ON PLAIN, COLD DRAWN STEEL STUD HARDNESS R30T 74-82) AGAINST PLAIN STEEL WASHER HARDNESS R30T 78-82).

NOMINAL STUD SIZE "P"	PALNUT PART NO.	CUSTOMER PART NO.	DESIGN NO.	HEX					WASHER				H	M	N	D	P	Q	STEEL THICK.	STUD DIMENSIONS			* ASSEMBLY PERFORMANCE ON COLD DRAWN STEEL			
				V	A	G	R	RI	D	J	K	L								B	C Min.	E	HEALTHY TORQUE In	TIGHTENING TORQUE In	MIN CLAMPING In	MIN ULTIMATE TORQUE In
6.0	SF060015		1	11.00/10.77	12.70/12.26	2.31	1.09	0.91	15.00	13.50	-	0.45	6.35	5.41/5.31	5.52/5.33	5.79/5.63	1.26	9.58/9.07	0.53	T+6.1	T+8.9	3.76	2.48	9.70	1271	11.9
6.0	SF060018		2	11.00/10.77	12.70/12.26	2.40	1.09	0.91	18.00	14.73	1.00	1.12	7.18	5.41/5.31	5.52/5.33	5.79/5.63	1.26	9.58/9.07	0.53	T+6.6	T+9.4	3.76	2.48	10.20	1271	12.1
6.3	SF630015		1	11.00/10.77	12.70/12.26	2.31	1.09	0.91	15.00	13.50	-	0.45	6.40	5.77/5.66	5.84/5.74	6.15/5.99	1.52	9.58/9.07	0.53	T+6.1	T+8.9	4.06	2.60	10.20	1335	12.5
6.3	SF630018		2	11.00/10.77	12.70/12.26	2.40	1.09	0.91	18.00	14.73	1.00	1.12	7.06	5.77/5.66	5.84/5.74	6.15/5.99	1.52	9.58/9.07	0.53	T+6.6	T+9.4	4.06	2.60	10.70	1335	12.7
6.3	SF630021		2	11.00/10.77	12.70/12.26	2.49	1.09	0.91	21.00	17.11	1.16	1.53	7.64	5.77/5.66	5.84/5.74	6.15/5.99	1.52	9.58/9.07	0.53	T+7.1	T+9.9	4.06	2.60	11.30	1335	13.0
6.3	SF630024		2	11.00/10.77	12.70/12.26	2.58	1.09	0.91	24.00	19.53	1.34	1.93	8.12	5.77/5.66	5.84/5.74	6.15/5.99	1.52	9.58/9.07	0.53	T+7.4	T+10.0	4.06	2.60	11.30	1335	13.0
8.0	SF080020		2	13.00/12.80	15.02/14.50	2.75	1.14	0.96	20.00	16.30	0.71	1.17	7.85	7.34/7.19	7.34/7.16	7.98/7.72	1.65	10.06/9.55	0.58	T+7.3	T+10.0	5.60	5.65	11.30	1335	11.86
8.0	SF080032		2	13.00/12.80	15.02/14.50	2.75	1.14	0.96	32.00	26.10	1.78	2.79	9.04	7.34/7.19	7.36/7.18	8.00/7.77	1.65	10.31/9.25	0.58	T+8.3	T+11.1	5.60	5.65	17.00	1113	22.6

DATE	REV	DESCRIPTION	BY
8/1/00	A	REDRAWN TO AUTOCAD 2000	M.S.
7/30/99		MOVED 'P' LOCATION TO LDW TOOTH REMOVED 'P' NOTE 1.52 (P) DIM WAS 1.14 PER ECC0022	K.J.D.
6/4/98		.71 WAS 1.09 (SF080020) PER EC #1890	B.A.D.
6/12/95		REDRAWN TO CAD; NO CHANGES	B.A.D.
5/22/88		12.70/12.26 WAS 12/70/12.76	W.S.
1/18/88		RELEASED SF080020 RELEASE #1161	W.S.
5/7/86		ADDED SF080032 FROM DWG.8-28/75 SUPERCEDED	J.L.
10/21/82		'M' WAS 5.57/5.89, 'N' WAS 5.58/5.77, 'D' WAS 6.17/6.35 ON SF630015, SF630018, SF630021 & SF630024	B.A.D.
4/6/81		ADDED PART #SF060015	J.T.
6/7/79		CORRECTED M,N,D DIMS ON SF060018; ADDED NONRELEASED PART SF060020	E.R.N.
12/3/78		ADDED SF060018	R.S.
5/5/78		REDRAWN-REPLACES COPY DATED 11/23/77	J.M.K.

TINNERMAN PALNUT
ENGINEERED PRODUCTS, LLC

MATERIAL:
50 CARBON SPRING STEEL

HARDNESS: ROCKWELL 30N 60-70

TOLERANCES, UNLESS SPECIFIED:
mm ±.25 in ±.010

PAL® PALNUT® ON SERT® PUSHNUT®

TITLE
PALNUT SELF THREADING NUTS,
WASHER TYPE
STYLE 'SF' METRIC

DRAWN: JMK	RELEASED	SCALE
DATE: 5/15/78	PART No: VARIOUS	NONE
CHECKED: <i>CWAS</i>	DWG No.	SF-METRIC
APPROVED: <i>10/9/00</i>		