

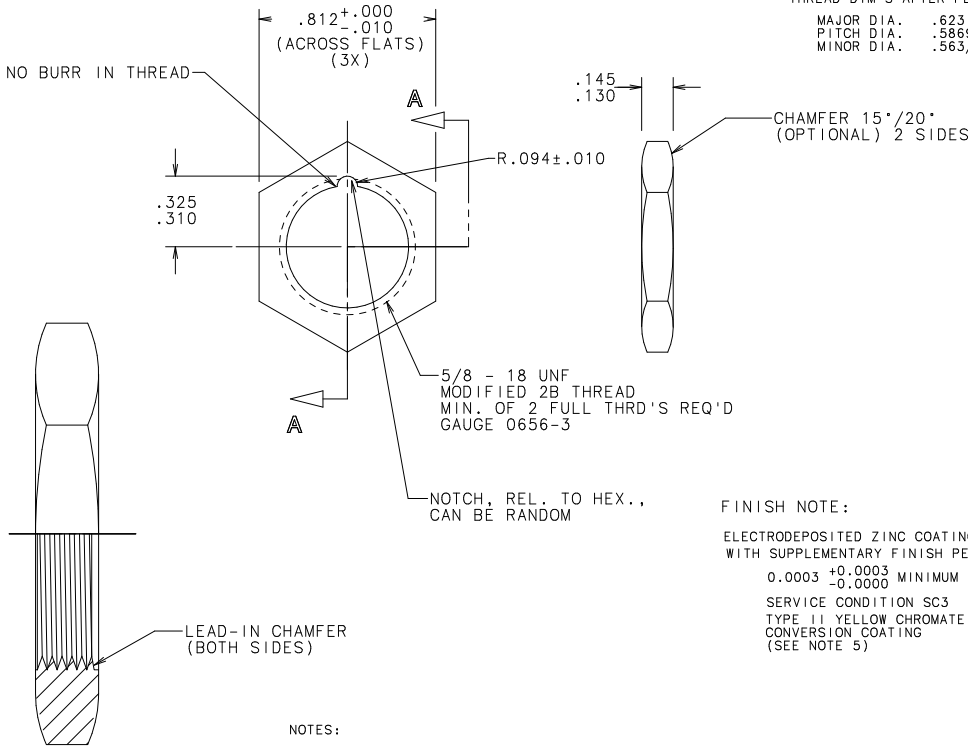
PART NO.	PLATING	HEX NUT
903-048	SEE FINISH NOTE	903-048-1
903-048-1	PLAIN	N/A

THREAD DIM'S BEFORE PLATING:

MAJOR DIA. .625 MIN.
 PITCH DIA. .5889/.5949
 MINOR DIA. .565/.570

THREAD DIM'S AFTER PLATING:

MAJOR DIA. .623 MIN.
 PITCH DIA. .5869/.5929
 MINOR DIA. .563/.568



SECTION A-A
 SCALE 4:1

NOTES:

1. AXIS OF THREAD TO BE ⊥ WITHIN 2° TO FACE OF NUT.
2. ESSENTRICITY OF P.D. & MAJOR DIA. NOT TO EXCEED .010 T.I.R.
3. ECCENTRICITY OF MIN. DIA. TO FLATS NOT TO EXCEED .010 T.I.R.
4. UNPLATED PARTS TO BE PROTECTED AGAINST OXIDATION UNTIL PLATED. PLATING TO BE DONE AS SOON AS POSSIBLE AFTER FABRICATION.
5. PLATED PARTS SHALL MEET THE SALT SPRAY REQUIREMENTS OF ASTM-B117 96 HR. SALT SPRAY TEST (CERTIFICATION REQUIRED).

FINISH NOTE:

ELECTRODEPOSITED ZINC COATING
 WITH SUPPLEMENTARY FINISH PER:
 0.0003 +0.0003 MINIMUM ZINC PLATING
 -0.0000
 SERVICE CONDITION SC3
 TYPE II YELLOW CHROMATE
 CONVERSION COATING
 (SEE NOTE 5)

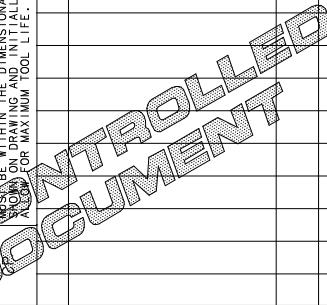
SEE CHART	HEX NUT	DESCRIPTION	EA	U/M
NO	COMPONENT NO		1000	QTY/M

BILL OF MATERIAL

MATERIAL SPEC		FINISH		SCALE	
M.P.I.F. F-00006-85 (MIN. DEN.)		SEE FINISH NOTE & NOTE 5		FULL	
COPIES TO	DRW	DATE	DATE	DATE	LBS/M
1	KAM	12/18/97			
2	CHK				
3	APPD				
4					
5					
6					
7					
8					
TOLERANCE UNLESS OTHERWISE SPECIFIED					
TWO PLACE DEC ±.01 FRACTION ±					
THREE PLACE DEC ±.005 ANGULAR ±1°					
TITLE					
HEX NUT-SINTERED					

LTR	REVISION	CHK	APD
S	39046C-REVISE & REDRAWN IN NEW STRUCTURE 3/30/98	KAM	
T	80518C - ADD FINISH NOTE, CHG. NOTE 5, ADD CHART,		
-	REMOVE FROM B/M ZINC ANODE 4/4/2000	BJJ	
U	81992B-DLT. "ASTM" ADD TOL FOR PLATING 4/3/02	PJM	
V	821420-CHG F00005-20 TO -00006.69 MIN. DEN. 5/22/02	PJM	

UNLESS OTHERWISE SPECIFIED, DIMENSIONS DO NOT INCLUDE PLATING.
 DENOTES CRITICAL CHARACTERISTICS.
 DENOTES CPK DIMENSIONS.-MINIMUM CPK VALUE
 DENOTES A CHARACTERISTIC THAT PROVIDES AN INDICATION OF PROCESS PERFORMANCE. PROCEDURE FOR MEASUREMENT (ST) AND TRACKING TO BE DEFINED IN TAPES INSPECTION INSTRUCTIONS.
 DIMENSIONS OF DIMENSIONS.-MINIMUM CP VALUE FROM DRAWING AND FINALLY LOCATED TO ALLOW FOR MAXIMUM TOOL LIFE.



REVISION	DRWG. NO.	SERIES
V	903-048	

DES PLAINES, ILLINOIS 60016

