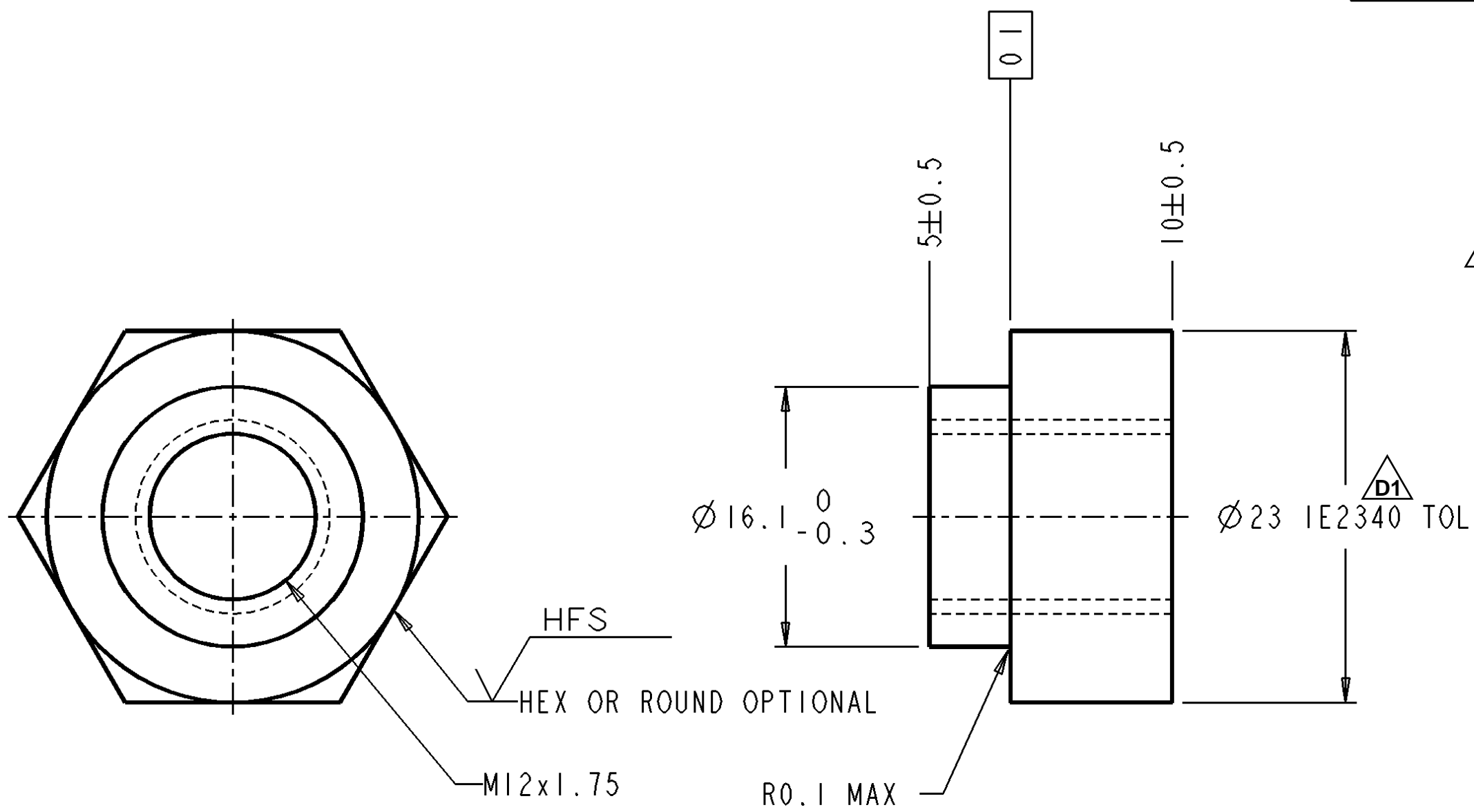


A B C D E F G

4 3 2 1

METRIC 323-1104



NOTE A: ISO 898-2 CLASS 9. PROOF LOAD 80.1 kN SHALL BE APPLIED BY A 6g THREADED MANDREL OR BOLT OF ISO 898-1 CLASS 10.9 OR HIGHER AND UPON A PLATE HRC 45 MIN AND WITH A CLEARANCE HOLE OF DIA 14. THE WELD PROJECTIONS SHALL FACE AWAY FROM THE PLATE DURING TEST AND TEST MANDREL OR BOLT SHALL EXTEND 3 PITCHES THROUGH THE WELD NUT. AFTER A 15 SECOND MIN LOAD DURATION, THE NUT SHALL BE ABLE TO BE REMOVED BY FINGERS FROM THE UNLOADED MANDREL OR BOLT.

REF: PILOT CLEARANCE HOLE \varnothing 16.75
 REF: WELD SPECIFICATION 1E0099R IS REQUIRED FOR WELDING

M A T L	A	1E2340	STL & PROC
H T R			
D1	1E5167A	INT-PROP	
	1E4246D	ROHS	
	1E2722A	DRAWING	
	1E2644	DIM.	
	1E2122	SURF. TEX	
	1E1675J	COATING	
	1E0198R	BRAND MARKINGS	
	1E0013G	CONFIDENTIALITY	
	1E0012A	INTERPRETATION	
	1E0011	INTPR & TOL	

NOTE
Caterpillar: Confidential Green

PROD.	<input checked="" type="checkbox"/>	OTHER	<input type="checkbox"/>
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN mm		VERSION TYPE	PRIMARY <input checked="" type="checkbox"/> SECONDARY
DIMENSIONS W/O TOL ARE BASIC		SHEET 1 OF 1	DWG CONTROL A717
CATERPILLAR			
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NUT-WELD (M12X1.75)(LONG PILOT)			
323-1104		VER -	CHG 01

CHANGE

A1	1018 CR MATERIAL WAS 1215 (HR, CF) MATERIAL MJS, 7/16/12, PCR# 65817
B1	THREAD CALLOUT WAS INCORRECT WAS M12 X 1.75-2B AMS 08/21/15 PCR 71003
C1	REMOVED HFS SYMBOL NO PHYSICAL CHANGE TO PART AMS 07/30/18 PCR 75601
D1	CUSTOMER REV 01 WAS REV 00 SPEC 1E0013Y WAS 1E0013G SPEC 1E2722A WAS 1E2722B SPEC 1E0357 WAS REMOVED SPEC 1E2650 WAS REMOVED SPEC 1E0012A WAS ADDED SPEC 1E0198R WAS ADDED SPEC 1E1675J WAS ADDED SPEC 1E4246D WAS ADDED SPEC 1E5167A WAS ADDED SPEC 1E2122 WAS ADDED SPEC 1E2340 WAS ADDED SPEC 1E2644 WAS ADDED NOTE A WAS ADDED \varnothing 23 1E2340 TOL WAS 23+/-1.5 REMOVED DEBURR-2 NOTE SAH 8/15/2023 CCR #6276

2 PART TO BE RUST, SLAG AND SCALE FREE.
 1 REMOVE ALL BURRS AND SHARP EDGES.

DRAWN APPROVED	MJS SAH	DATE DATE	1/03/06 8/15/2023	SIMILIAR TO SCALE	MATERIAL - MIL TOLERANCES APPLY UNLESS NOTED		
					PURCHASE PER PRINT		
				CUSTOMER	CUST NO	CUST. REV.	
				CATERPILLAR	323-1104	01	
				TITLE			
				NUT WELD (LONG PILOT) M12 X 1.75			
				SYMS USED ON			
				SIZE	PART NO	SHEETS	
				C	41-9912-01	1 OF 1	

A B C D E F G