



Preferred Parts

Number:	B-015
Date Issued:	A-DEC05

PREVAILING TORQUE HEXAGON HEAD BOLTS (Superseded)

This standard has been superseded by CNH Standard Parts, STPB230 (87366882), Prevailing Torque Hex Head Bolts - Inch - Non-Preferred.

The controlled versions of CNH specifications and standards are published on the CNH Intranet site.

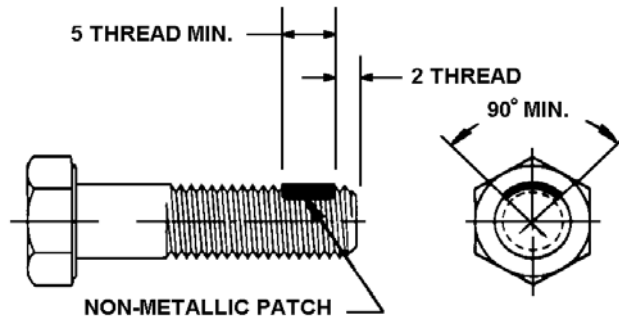
The documents are also available on the CNH electronic viewing system (e.g. eViewer). Suppliers are able to access these documents on CSCN (CNH Supplier Communications Network).

The superseded standard remains available for viewing following this page if needed.

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PREVAILING TORQUE HEXAGON HEAD BOLTS
(Superseded)

GENERAL SPECIFICATIONS



GENERAL: The threaded fasteners covered by this standard are prevailing-torque hexagon head bolts with a non-metallic plastic patch bonded to a specified portion of the threads to provide a prevailing torque feature. These bolts are applications where temperatures will not exceed 120°C (250°F).

BASIC BOLT: The bolt must comply in all respects with the General Specifications for Hexagon Head Bolts, Section B-001.

PREVAILING-TORQUE FEATURE: The location and size of the non-metallic plastic patch must comply with the illustration shown above. Bolts shall assemble a minimum of one full turn by hand into any mating internally threaded component that is accepted by a properly selected GO thread plug gage.

The prevailing-torque feature shall be free from visible porosity, voids and cracks, and shall be uniform in color without streaks, dark areas or other indicators of contamination or degradation. It shall be firmly attached to the bolt and shall not loosen under normal handling. It shall be chemically inert to the following fluids:

<u>FLUID</u>	<u>CASE MATERIAL SPEC</u>
Diesel Engine Lubricating Oil, Multi-Viscosity	MS 1120-1
Combination Hydraulic, Transmission Wet Brake Fluid	MS 1207
Transmission, Converter and Hydraulic Fluid (TCH)	MS 1210
Gear Oil, SAE 85W-140, EP	MS 1316
Anti-Freeze, Single Phase, Ethylene Glycol Base, Low Silicate	MS 1710



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PREVAILING-TORQUE PERFORMANCE REQUIREMENTS: Volume of non-metallic patch material must be sufficient to meet the following prevailing-torque requirements when tested in accordance with IFI-124 standard.

The prevailing torque of bolts, occurring during any installation or removal, shall not exceed the maximum prevailing torque specified. In addition, the maximum prevailing torque developed by bolt during first and fifth removals shall not be less than the minimum removal torques specified.

CLASS 2A UNC AND UNF SERIES THREADS

Nominal Size of Bolt	Prevailing Torque Maximum		First Removal Minimum	Fifth Removal Minimum
	In. Lbs.	Ft. Lbs.	Inch Lbs.	Inch Lbs.
1/4 0.250	40.0	3.3	5.0	3.0
5/16 0.312	85.0	7.1	8.0	5.0
3/8 0.375	110.0	9.2	14.0	9.0
7/16 0.438	150.0	12.5	20.0	12.0
1/2 0.500	220.0	18.3	26.0	16.0
9/16 0.562	270.0	22.5	35.0	22.0
5/8 0.625	350.0	29.2	45.0	30.0
3/4 0.750	460.0	38.3	60.0	45.0
7/8 0.875	700.0	58.3	95.0	65.0
1 1.000	900.0	75.0	130.0	85.0

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