



Preferred Parts

Number:	C-001
Date Issued:	B-OCT06

ELECTRONIC DOCUMENT IN THE VIEWER IS CONTROLLED. PRINTED COPY IS AN UNCONTROLLED DOCUMENT.

MACHINE SCREWS (SUPERSEDED)

This standard has been superseded by CNH Standard Parts, STPC110 (87366932), Machine Screws Inch.

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The superseded standard remains available for viewing following this page if needed.

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MACHINE SCREWS (SUPERSEDED)

GENERAL SPECIFICATIONS

GENERAL: This standard conforms with the American National Standard B-18.6.3 for various types of slotted and recessed head machine screws.

Truss Head, Round Head, Fillister Head, and Binding Head Machine Screws are not preferred for new design and should be replaced in new design by Pan Head Machine Screws.

Refer to CNH Standard, STPA020 Abbreviations for Fastener Finishes and Material Specifications.

PREFERRED PARTS POLICY: Preferred parts are so designated to reduce variety of parts and assure maximum availability, interchangeability, and cost savings in volume buying.

Material: Carbon Steel (CST)
Head Types: Flat, Oval, Pan, Hex, Hex Washer
Drive: Cross Recess, ANSI Type 1 (Phillips) and Hex
Diameters: 6, 8, 10, 1/4, 5/16, 3/8
Threads: Coarse
Finishes: Zinc with Chromate (ZND), Phosphate Coated (PHC)
Lengths: As show below:

Nominal Size

LENGTH	6	8	10	.250	.312	.375
.250	X	X	X			
.375	X	X	X			
.500	X	X	X	X	X	
.625	X	X	X	X	X	
.750	X	X	X	X	X	X
.875	X	X	X	X	X	X
1.000	X	X	X	X	X	X
1.250	X	X	X	X	X	X
1.500		X	X	X	X	X
1.750			X	X	X	X
2.000				X	X	X
2.250				X	X	X
2.500					X	X
3.000					X	X

SERVICE PARTS SUBSTITUTION POLICY: In the event that Engineering does not indicate a "Do Not Substitute" in Engineering Specifications, the following substitutions may be implemented in service.

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Flat Head Machine Screws

<u>To Be Replaced</u>	<u>Service Replacement</u>
Slotted or cross recess, plain (PLN) finish	Zinc with chromate (ZND) cross recess or (ZND) slotted (if cross recess is not set up for service)
Slotted, phosphate coated (PHC) finish	Cross recess, phosphate coated (PHC) finish
Slotted, zinc with chromate (ZND) finish	Cross recess, zinc with chromate (ZND) finish

Pan Head Machine Screws

<u>To Be Replaced</u>	<u>Service Replacement</u>
Slotted or cross recess, plain (PLN) finish	Zinc with chromate (ZND) cross recess or (ZND) slotted (if cross recess is not set up for service)
Slotted, phosphate coated (PHC) finish	Cross recess, phosphate coated (PHC) finish
Slotted, zinc with chromate (ZND) finish	Cross recess, zinc with chromate (ZND) finish

Round Head Machine Screws

<u>To Be Replaced</u>	<u>Service Replacement</u>
Slotted, plain or zinc (ZND) finish	Pan head, cross recess, zinc dichromate (ZND) finish or slotted (if cross recess is not set up for service)
Cross recess, plain or zinc (ZND) finish	Pan head, cross recess, zinc (ZND) finish

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MACHINE SCREWS (SUPERSEDED)

DIMENSIONS: All dimensions in this Standard are in inches. All unspecified detail shall conform to ANSI B-18.6.3.

THREADS: Threads shall be Unified Standard, Class 2A, UNC or UNF series or UNRC or UNRF series with radius root, optional with manufacturer. Class 2A limits shall apply to plain finish (unplated or uncoated) screws and to plated or coated screws before plating or coating.

LENGTH OF THREAD: Screws of size No. 5 and smaller, up to and including nominal lengths of 1.125 inch, shall be threaded full length. Screws of longer nominal lengths shall have a minimum length of full form thread of 1.00 inch.

Screws of size No. 6 and larger, up to and including nominal lengths of 2.00 inch, shall be threaded full length. Screws of longer nominal lengths shall have a minimum of full form thread of 1.50 inch.

Short Length Screws: Flat or oval countersunk head machine screws having lengths equal to or less than the length listed below shall have head undercut by an amount which reduces the head height to 70 percent of the normal head height shown in dimensional tables. A corresponding reduction shall also apply to slot or recess depths.

Nominal Screw Size	These Lengths or Shorter are Undercut	Nominal Screw Size	These Lengths or Shorter are Undercut
0	.125	10	.312
1	.125	12	.375
2	.125	.250	.438
3	.125	.312	.500
4	.187	.375	.562
5	.187	.438	.625
6	.187	.500	.750
8	.250		

MATERIAL: Carbon steel (CST) SAE Grade 60M with minimum tensile strength of 60,000 p.s.i., 70-100 HRB. Steel (5) SAE Grade 120M with minimum tensile strength of 120,000 p.s.i., 25-38 HRC.

Brass (BRS) SAE CA360 alloy or equivalent, hard temper.

Stainless steel (SST) Type 410. This is a magnetic general purpose stainless with good corrosion resistance and excellent strength properties. Stainless steel screws shall be passivated to ensure a clean surface, free from iron bearing contaminants which cause rusting and adversely affect appearance.

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FINISHES: Machine screws shall be furnished plain (PLN), plated, or coated in appearance with Case Engineering Materials Specifications:

Phosphate Coating (PHC)	-	MS 91
Zinc with Chromate (ZND)	-	MS 201
Cadmium (CAD)	-	MS 206 *Not Recommended
Black Teflon (PTF)	-	MS 61
Black Zinc (BZN)	-	MS 203
Black Cadmium (BKC)	-	MS 208 *Not Recommended

WORKMANSHIP: Machine screws shall be free from burrs, seams, laps, loose scale, irregular surfaces, and any defects affecting their serviceability.

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