

ZMG SAE J429 Grade 8 Threaded Rod Requirements

ALL DIMENSIONS ARE IN INCHES

INTERPRET REQUIREMENTS IN ACCORDANCE WITH ANSI Y14.5

BREAK EDGES AND CORNERS .005-.015 UNLESS OTHERWISE SPECIFIED

ALL THREAD DIMENSIONS IN ACCORDANCE WITH UNC/UNF CLASS 2A FIT UNLESS OTHERWISE SPECIFIED

MATERIAL: THREADED RODS SHALL BE MADE OF STEEL CONFORMING TO THE CHEMICAL COMPOSITION REQUIREMENTS SHOWN IN TABLE 2 OF SAE J429(MAY 2014) FOR ALLOY STEEL.

NOTE 7 IN TABLE 2 OF SAE J429(MAY 2017) SHALL APPLY. HEAT TREAT (FULLY AUSTENITIZED), OIL QUENCH, AND TEMPERED AT A MINIMUM TEMPERING TEMPERATURE OF 800° F. ALLOY STEEL IN ACCORDANCE WITH SAE J429, Rc 33-39

BLACK OXIDE: APPLY STANDARD BLACK OXIDE FINISH. INTENDED ONLY FOR LIGHT RUST PREVENTION DURING TRANSIT AND INDOOR STORAGE

ELECTROPLATING: ZINC TRIVALENT YELLOW 5µm MIN, 36 HOURS TO WHITE RUST AND 72 HOURS TO RED RUST.

BAKING: REQUIRED ON ALL ELECTROPLATED PART NUMBERS. BAKE WITHIN 1 HOUR OF ZINC PLATING AT MINIMUM TEMPERATURE 428°F FOR MINIMUM OF 4 HOURS.

PACKAGING: PACK AND PALLETIZE BY SIZE AND THREAD PITCH. DO NOT MIX DIAMETERS, THREAD PITCHES, OR LENGTHS AMONG CARTONS ON PALLET.

MATERIAL TEST REPORTS ARE REQUIRED WITH EACH SHIPMENT AND MUST INCLUDE:

MATERIAL LOT #

MANUFACTURING HEAT #

PART #

QUANTITY SHIPPING

WEIGHT PERCENTAGES OF CHROMIUM, MOLYBDENUM, CARBON, MANGENESE, SILICON, SULFUR, AND PHOSPHORUS

TOLERANCES:

STRAIGHTNESS:

LENGTH EQUAL TO 6" OR LESS: $\pm .007 * \text{LENGTH}$

LENGTH OVER 6": $\pm .01 * \text{LENGTH}$

LENGTH:

LENGTH LESS THAN 6": -0.0 / + 0.2

LENGTH EQUAL TO 6" AND LESS THAN 36": -0.0 / + 0.5

LENGTH EQUAL TO 36" THRU 72": -0.0 / + 1.0

