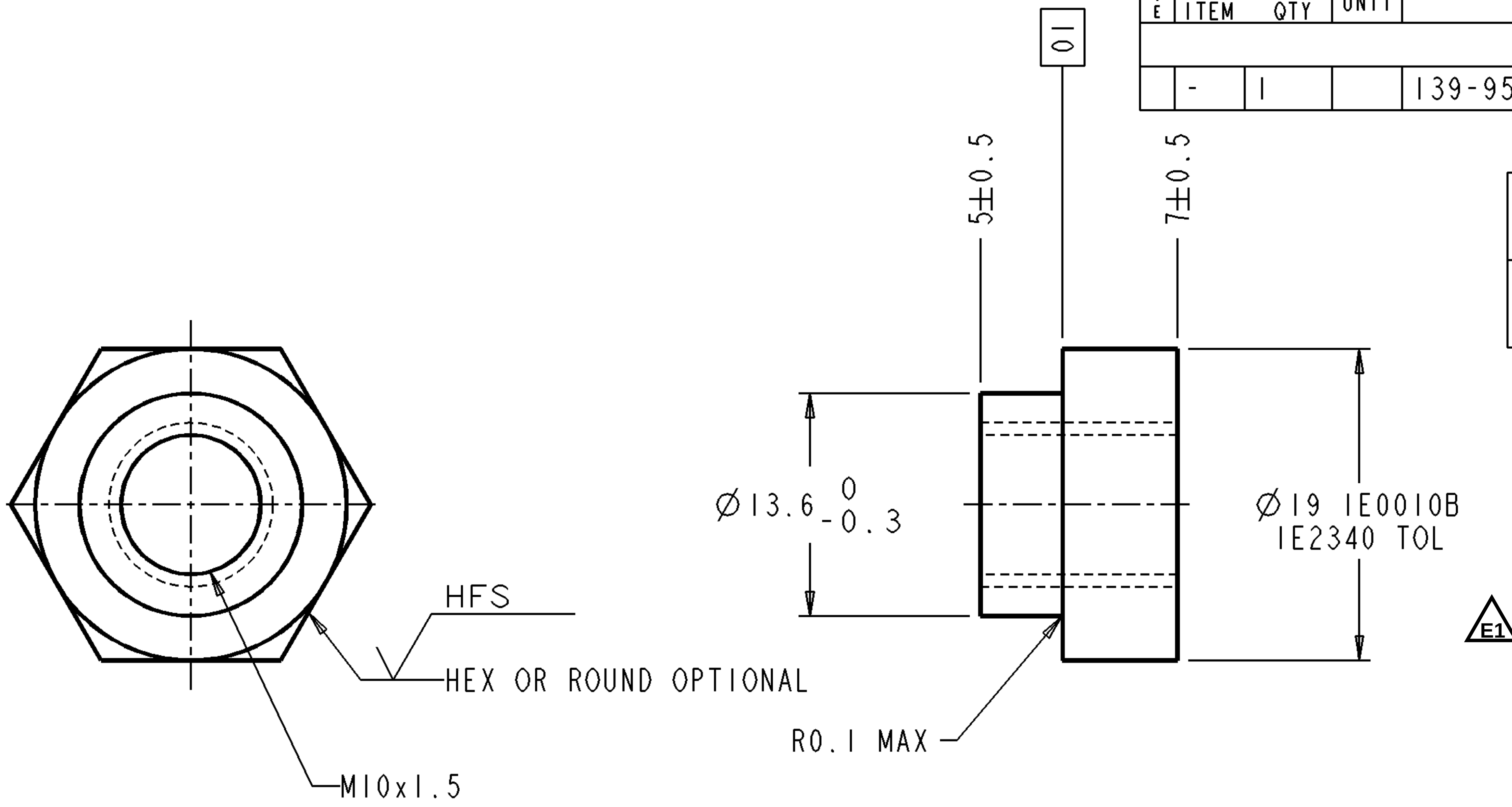
METRIC 315-4131

NOTE	ITEM	QTY	MEAS UNIT	PART NO.	NAME
					SERVICE REPLT
	-	1		139-9599	NUT-WELD



MATL	A	1E2340	STL & PROC
HT TR			
		1E5167A	INT-PROP
		1E2722A	DRAWING
		1E2644	DIM.
		1E2122	SURF. TEX
		1E1675J	COATING
		1E0198R	BRAND MARKINGS
		1E0013G	CONFIDENTIALITY
		1E0012A	INTERPRETATION
		1E0010B	CONVERSION
NOTE		1E0011	INTPR & TOL
		Caterpillar: Confidential Green	

PROD. X OTHER

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN mm DIMENSIONS W/O TOL ARE BASIC | VERSION TYPE | PRIMARY X | SECONDARY

THIRD ANGLE PROJECTION | SHEET 1 OF 1 | DWG CONTROL A717

CATERPILLAR

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NUT-WELD
(M10X1.5)(LONG PILOT)
315-4131 | VER - | CHG 02 | B

NOTE A: PROOF LOAD - 54.5 kN MIN (ISO 898-2 CLASS 9).
TEST ON A PLATE WITH A CLEARANCE HOLE OF DIA 11.
ORIENT PILOT AWAY FROM THE PLATE.
APPLY LOAD USING A 6g THREADED MANDREL OR BOLT
OF ISO 898-1 CLASS 10.9 OR HIGHER STRENGTH.
MANDREL OR BOLT SHALL EXTEND 3 PITCHES
THROUGH THE WELD NUT. AFTER HOLDING PROOF
LOAD FOR 15 SECOND MIN, THE NUT SHALL BE REMOVABLE
BY FINGERS FROM THE UNLOADED MANDREL OR BOLT

REF: PILOT CLEARANCE HOLE Ø13.8

REF: INSTALLATION - ARC WELD WITH MILD STEEL LOW H FILLER

CHANGE

A1	1018 CF MATERIAL WAS 1215 (HR, CF) MATERIAL MJS, 7/16/12, PCR# 65816
B1	CORRECTED THREAD CALLOUT AMS 9/29/14 PCR 70003
C1	THREAD CALLOUT WAS INCORRECT WAS M10 X 1.5-6G AMS 08/21/15 PCR# 71003
D1	REMOVED HFS SYMBOL NO PHYSICAL CHANGE TO PART AMS 07/30/18 PCR 75601
E1	REMOVED SPECIFICATIONS 1E0013Y, 1E0357, 1E2650, & 1E2722B. ADDED SPECIFICATIONS 1E0010B, 1E0012A, 1E0013G 1E0198R, 1E1675J, 1E2122, 1E2340, 1E2644, 1E2722A, AND 1E5167A. ADDED NOTE A. SAH 2/12/2020 CCR #5817
F1	ADDED NOTE #3 SAH 5/6/2025 PCR #87675

F1 3. QUOTE ROUND OPTION IF POSSIBLE USING Ø 3/4" BAR

2. PART TO BE RUST, SLAG AND SCALE FREE.

1. REMOVE ALL BURRS AND SHARP EDGES.

bluebeam

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P.O. BOX 151 MAYVILLE, WI, 53050

MATERIAL - MIL TOLERANCES APPLY UNLESS NOTED
PURCHASE PER PRINT

CUSTOMER	CUST NO	CUST. REV.
CATERPILLAR	315-4131	02

TITLE
NUT-WELD (LONG PILOT) M10 X 1.5 THD

SYMS USED ON

DRAWN	MJS	DATE	1/03/06
APPROVED	SAH	DATE	2/12/2020

SIMILIAR TO

SCALE

SIZE	PART NO	SHEETS
C	41-9910-02	1 OF 1