

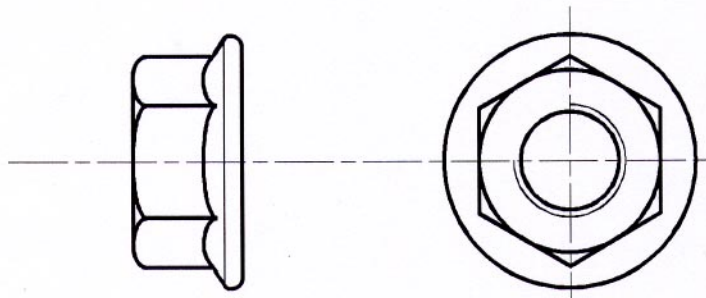
**HEXAGON FLANGED NUTS
PAINT CLEARING**

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NO USE RESTRICTION*This is a translation, the French original shall be used in all cases of litigation**Date of translation :15/11/2004***FUNCTIONAL NORME REQUIRING APPROVAL OF SUPPLIES****FOREWORD**

In view of the variety of paint deposits and their method of application, it is recommended to carry out tests in production conditions, specifically to determine the tightening torques which are compatible with all the supplies of nuts already approved.

At the date of issue of this document, there is no French or international standard dealing with the same subject.

**1. OBJECT AND FIELD OF APPLICATION**

This norme specifies the characteristics of paint clearing hexagon flanged nuts of metric dimensions, with a thread diameter 5 to 10 mm inclusive, produced in product grade A.

2. INSTRUCTIONS FOR USE

The use of these nuts may be considered only when the hexagon flanged nuts in norme C21 3312 are not suitable; their use is mostly reserved for assembly to weld screws on the body before painting.

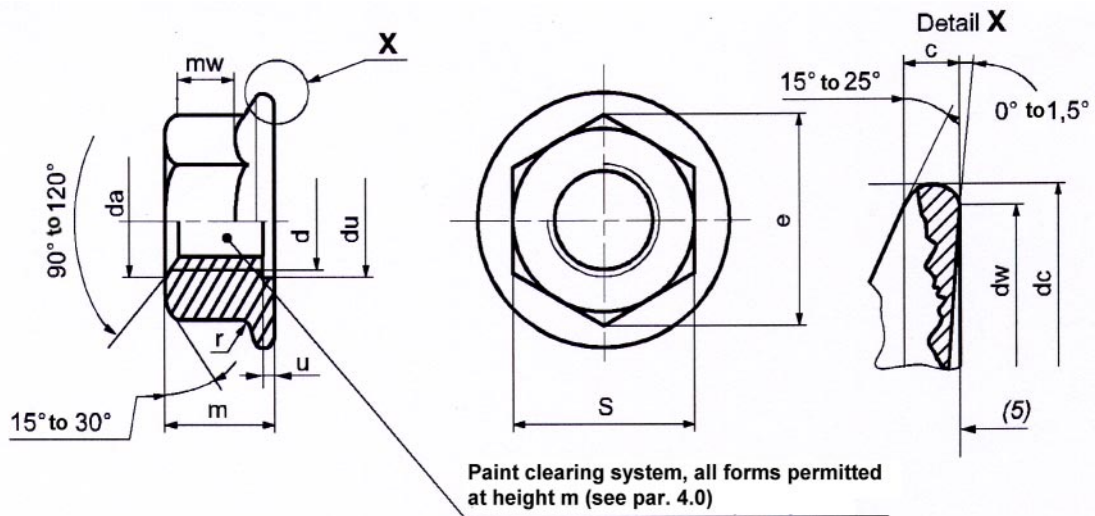
CHOICE OF NUTS

Nuts with numbers shown in the table of § 6 Functional preferred numbers (fictitious) are to be adopted unless it is technically impossible. If the use of another quality class, another coating or other dimensions is essential, contact the local "**Standard fasteners representative**" (**Représentant Standardisation Pièces Répétitives**) available on each Engineering plant, to obtain the part number.

OVERALL DIMENSIONS FOR TIGHTENING TOOLS

Refer to norme B11 1200.

3. NUT DIMENSIONS



NOMINAL DIAMETER "d"	PITCH	dc	Dw	e	m		S		c	da (1)	r (2)	mw (3)	du (4)	u
		max.	min.	min.	min.	max.	min.	max.	min.	max.		min.	max.	max.
5	0,80	11,8	9,8	8,71	4,7	5	7,78	8	1,0	5,75	0,30	2,2	7,0	0,25
6	1,00	14,2	12,2	10,95	5,7	6	9,78	10	1,1	6,75	0,36	3,1	7,4	0,30
8	1,25	17,9	15,8	14,25	7,6	8	12,73	13	1,2	8,75	0,48	4,5	9,5	0,40

- (1) da min. = d nominal (form permitted also on flange side).
 (2) The radius r applies both to across corners and across flats of the hexagon.
 (3) Height of wrench engagement, approximate value.
 (4) du min = d nominal.
 (5) No cutting burr on the surface of the flange.

4. SPECIFICATIONS

MATERIAL

Nuts defined in this norme are produced in steel.

MECHANICAL CHARACTERISTICS

Quality classe 8 according to norme C20 0020.

THREAD

ISO metric thread.

Tolerance class 6H according to norme B11 3110 unless otherwise stated.

PAINT CLEARING SYSTEM

The paint clearing system is left to the discretion of the supplier providing that it meets the general characteristics of norme C20 0070.

The dimensional limits of this system must be within those of the table in § 3 Nut dimensions while at the same time retaining the characteristics of the quality class.

MANUFACTURING TOLERANCES

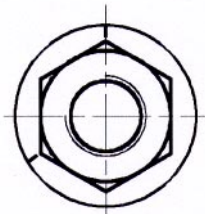
Nuts must be produced to product grade A, their manufacturing tolerances are given in norme C20 0220.

QUALITY CLASS MARKING

The quality class marking must conform to the details of norme C20 0020.

However, the marking code (clock face system) is allowed on top of the flange.

Example :



PROTECTION

Nuts are supplied zinc plated according to the requirements of norme B15 4102.

Electrolytic zinc plating, according to norme B15 4100 and B15 4101, is tolerated until 01/07/2006.

Any change to the coating must be validated by the relevant PSA departments.

Those supplied copper plated must meet the requirements of norme B15 4120.

5. SUPPLY OF NUTS

The general requirements concerning the supply of nuts are given in norme B20 0110.

6. FUNCTIONAL PREFERRED NUMBERS (FICTITIOUS)

Nuts of quality class 8, coating Z5FJR

(Assembly with screws or studs of quality class ≤ 8.8 .)

Designation : **ECROU H EMB NETTOY M6x100 AC8 Z5FJR**

d x p	"FICTITIOUS" NUMBERS
M5 x 0,80	79 03 233 028
M6 x 1,00	79 03 233 029
M8 x 1,25	79 03 233 030
M10 x 1,50	79 03 233 064

Note 1 : Each corresponding approved supply is officialised by the Engineering Departments which allocate an origin code 96 to the drawing and to the supply.

The relationship between the functional number (fictitious) and the numbers of approved supplies is dealt with by the Engineering Information System (SCE).

Note 2 : Parts numbers quoted in the above table are not necessarily bought out parts. These may only be quoted in a Basic Parts List (NEN).

7. RECORDS AND REFERENCE DOCUMENTS

7.1. RECORDS

7.1.1. CREATION

- OR : 01/12/1986 – CREATION OF THE NORME.

7.1.2. SUBJECT OF THE MODIFICATION

- G : 04/06/2004 – Modification to the § Protection.
- F : 13/04/1999 – ADDITION OF THE REFERENCE NUMBER 79 03 233 064.

7.2 REFERENCE DOCUMENTS

7.2.1. PSA DOCUMENTS

7.2.1.1 Normes

B11 1200	TIGHTENING OF SCREWS AND NUTS ACCESSIBILITY AND CLEARANCE REQUIRED FOR THE OPERATION
B11 3110	ISO METRIC THREAD FOR GENERAL USE
B15 4101	COATINGS ELECTROLYTIC ZINC DEPOSITS AND ASSOCIATED FINISHES
B15 4120	COATINGS ELECTROLYTIC COPPER PLATING, NICKEL PLATING AND CHROMIUM PLATING
B20 0110	SUPPLY OF PRODUCTS – GENERAL REQUIREMENTS
C20 0020	NUTS CLASSIFICATION AND CHARACTERISTICS
C20 0070	CHARACTERISTICS OF PAINT CLEARING NUTS
C20 0220	TOLERANCES FOR NUT FASTENERS
C21 3312	HEXAGON FLANGED NUTS PRODUCT GRADE A

7.2.1.2. Others

7.2.2. EXTERNAL DOCUMENTS

7.3. EQUIVALENT TO :

7.4. CONFORMS TO :

7.5. KEY-WORDS

AUTONETTOYEURS, ECROUS, EMB, EMBASE, H, HEXAGONAUX, NETTOY
(*Paint clearing, Nuts, Flange, H, Hexagon*)