

CHART 2 ENCAPSULATION MATERIAL
DEKALB FLAT DESIGN
PROFAX: 8523-XP23182 YUNGSOX PP 3015: WITH UV STABILIZERS LS326 & LS770 BLACK
HYLAR 460/: PVDF (POLYVINYLIDENEFLOURIDE) KYNAR 460 BLUE

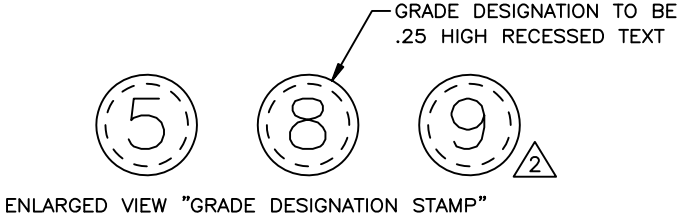

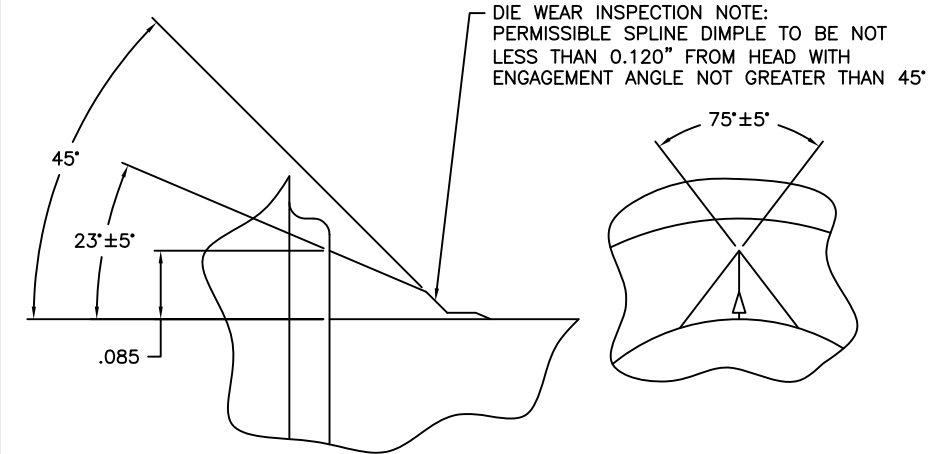
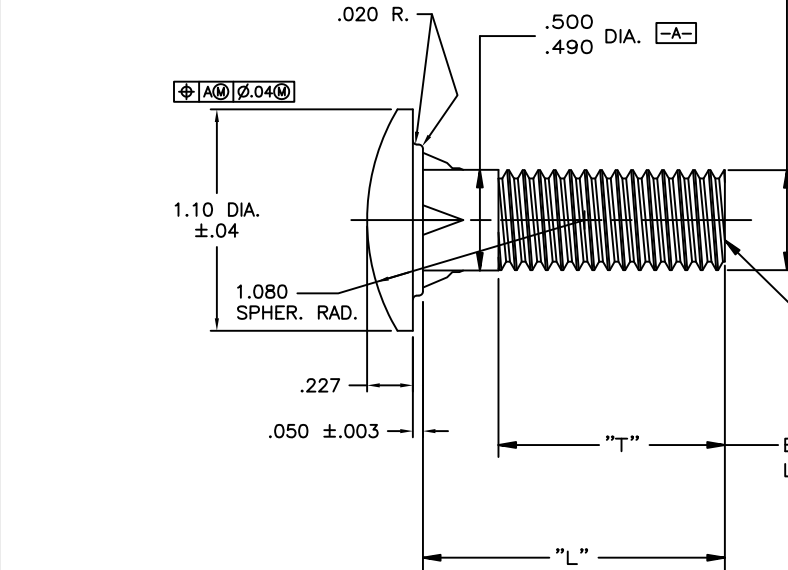
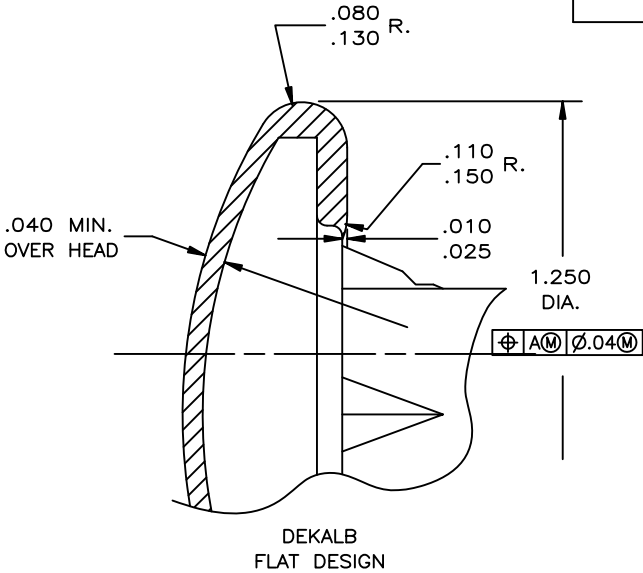
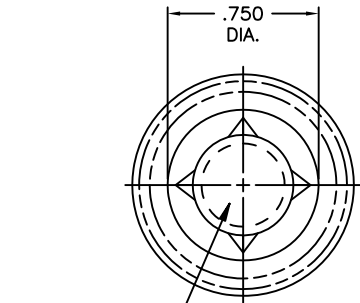


CHART 1 MATERIAL AND GRADE				
MATERIAL SPECIFICATIONS	2	5	8	 9
TENSILE STRENGTH	74 KSI MIN	120 KSI MIN	150 KSI MIN	180 KSI MIN
PROOF LOAD	-	85 KSI MIN	120 KSI	150 KSI
HARDNESS	80-100 HRB	25-34 RC	32-37 HRC	38-43 HRC
SPECIAL NOTATION	SAE J429, GRADE 2 AND ASTM A307, GRADE A WITH EXCEPTIONS AND ADDITIONAL REQUIREMENTS DEFINED HEREIN.	SAE J429, GRADE 5 AND ASTM A325 WITH EXCEPTIONS AND ADDITIONAL REQUIREMENTS DEFINED HEREIN.	SAE J429, GRADE 8 AND ASTM A490 WITH EXCEPTIONS AND ADDITIONAL REQUIREMENTS DEFINED HEREIN.	SAE J429, GRADE 9 AND ASTM A490 WITH EXCEPTIONS AND ADDITIONAL REQUIREMENTS DEFINED HEREIN.

THREAD SPECIFICATION:  
1/2-13UNC-2A SPECIAL PITCH DIAMETER.  
BEFORE FINISH COATING:  
MAJOR DIA. .4965-.4856  
PITCH DIA. .4465-.4415  
AFTER FINISH COATING:  
THREADS SHALL FIT A 0.4565 RING GAGE.



ENLARGED VIEW OF SPLINE



DEKALB  
FLAT DESIGN

IDENTIFICATION NOTES, DEKALB AND PARSONS OPERATIONS:

1. THREADED END SHALL BE MARKED WITH GRADE DESIGNATION FOR GRADE 5 AND 8 MATERIAL AS SHOWN IN THE ENLARGED VIEW "GRADE DESIGNATION STAMP". MARKING SHALL BE RECESSED.

FINISH COATING NOTES, DEKALB AND PARSONS OPERATIONS:

1. ZINC MECHANICALLY DEPOSITED PER THE LATEST REVISION OF ASTM B695, CLASS 50, TYPE 1. BOLTS SHALL BE TESTED FOR ABSENCE OF HYDROGEN EMBRITTLEMENT PER CST SPEC 10-23002. THE SIGNIFICANT SURFACE IS THE TIP OF THE THREADED END.
2. THE USE OF THIS COATING MAY POSSIBLY REQUIRE ALTERATION OF THE INTERNAL THREADS OF THIS PART'S MATING COMPONENT.




ENCAPSULATION MOLDING NOTES, DEKALB OPERATIONS:

1. ENCAPSULATION OF BOLT HEAD SHALL BE BY INJECTION MOLDING PROCESS USING A TUNNEL GATE DIE IN WHICH THE GATE FALLS AT THE CENTER OF THE HEAD CROWN.
2. SIDE GATING SHALL NOT BE USED.
3. ENCAPSULATION MUST BE FREE OF VOIDS.

GENERAL NOTES:

1. BOLTS SHALL NOT BE REJECTED FOR LOW HARDNESS IF THEY MEET THE TENSILE STRENGTH REQUIREMENTS.
2. BOLTS SHALL BE FREE FROM SURFACE DISCONTINUITIES PER ASTM F788-92. THE REQUIREMENTS OF SUPPLEMENT SECTION S1.1 APPLY.
3. THIS PART MUST COMPLY WITH NSF/ANSI STANDARD 61. THE FORMULATION FOR THIS PART IS REGISTERED WITH NSF, THEREFORE, BEFORE MAKING ANY CHANGES TO THE FORMULATION OF THIS PART PRIOR APPROVAL FROM CST STORAGE MUST BE OBTAINED.
4. THIS PART MUST BE MANUFACTURED IN THE USA FROM DOMESTICALLY PRODUCED STEEL.

GENERAL AND DIMENSIONAL SPECIFICATIONS:  
ANSI/ASME B18.2.1 1981  
SEE CURRENT REVISION OF "FASTENER STANDARDS"  
AS PUBLISHED BY THE INDUSTRIAL FASTENERS INSTITUTE (IFI)

NO ENCAPSULATION	8	1.25	1.25	2.50	290260-908
	8	1.00	1.25	2.25	290260-907
	8	.75	1.25	2.00	290260-906
	8	.25	1.50	1.75	290260-905
	8	.75	1.00	1.75	290260-904
	8	.50	1.00	1.50	290260-903
	5	.37	.88	1.25	290260-902
HYLAR/KYNAR DEKALB FLAT DESIGN	5	.25	.75	1.00	290260-901
	8	1.25	1.25	2.50	290260-110
	8	.50	1.25	1.75	290260-109
	5	.25	1.00	1.25	290260-108
	8	1.00	1.25	2.25	290260-107
	8	.75	1.25	2.00	290260-106
	8	.25	1.50	1.75	290260-105
	8	.75	1.00	1.75	290260-104
	8	.50	1.00	1.50	290260-103
	5	.37	.88	1.25	290260-102
   PROFAX DEKALB FLAT DESIGN	9	1.00	1.25	2.25	290260-017
	9	.75	1.25	2.00	290260-016
	9	.75	1.00	1.75	290260-014
	8	1.25	1.25	2.50	290260-010
	8	.50	1.25	1.75	290260-009
	5	.25	1.00	1.25	290260-008
	8	1.00	1.25	2.25	290260-007
	8	.75	1.25	2.00	290260-006
	8	.25	1.50	1.75	290260-005
	8	.75	1.00	1.75	290260-004
	8	.50	1.00	1.50	290260-003
	5	.37	.88	1.25	290260-002
	5	.25	.75	1.00	290260-001
SEE CHART 2 ENCAPSULATION MATERIAL	SEE CHART 1 MATERIAL AND GRADE	"S" SHANK LENGTH REF.	"T" EFF. THREAD LENGTH	"L" BOLT LENGTH	PART NUMBER AFTER ENCAPSULATION

<p>WELDING NOTE: ALL WELDS SHOULD BE SAME AS THE THICKNESS OF THE THINNEST PLATE WELDED FILLET OR SQUARE, CONTINUOUS UNLESS OTHERWISE NOTED. USE 'MIG' FOR ALL MILD STEEL PLATES AND 'TIG' FOR STAINLESS STEEL PLATES.</p> <p>TOLERANCE NOTE: TOLERANCES ON DIMENSIONS ARE AS FOLLOWS EXCEPT FOR BASIC DIMENSIONS, MAT'L STOCK SIZES AND TOLERANCES SPECIFIED OTHERWISE MATERIAL STOCK SIZE TOLERANCES SHALL CONFORM TO APPLICABLE STANDARD MILL VALUES UNLESS COVERED WITHIN A SPECIFIED CST MATERIAL SPECIFICATION.</p> <p>ONE DECIMAL: +/-: 0.060 TWO DECIMALS: +/-: 0.030 THREE DECIMALS: +/-: 0.015 ANGULAR DIM'S: +/-: 1°</p>														
		2	ADDED GRADE 9 BOLT OPTION TO DRAWING (-014, -016, -017)					19015	DRT	MEK	MEK	1/25/19	BY: DCS DATE: 5/9/17 NEXT ASSY: --- ORDER NO.: -	
												CHKD: MEK DATE: 5/9/17 SUPERCEDES: -		
												APPR: MEK DATE: 5/9/17 DWG #: 290260 REV: 2		
												SCALE: NTS SHEET: OF		
REV.	REVISION DESCRIPTION					ECN.	BY	CHKD.	APPR.	DATE				