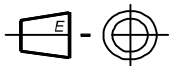
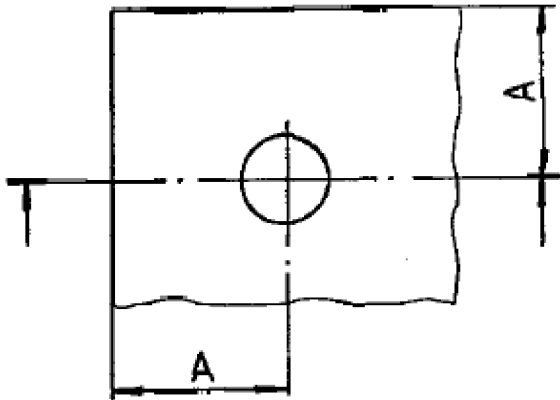
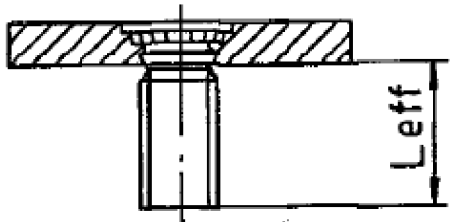
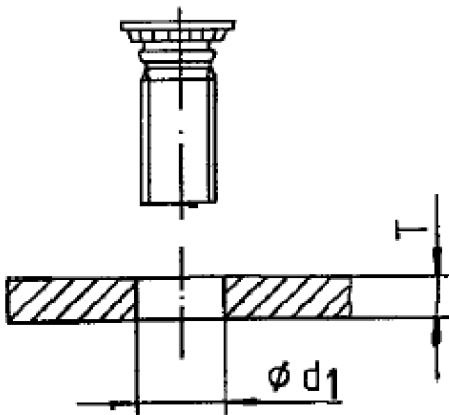
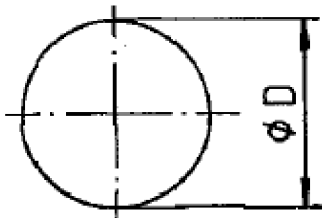
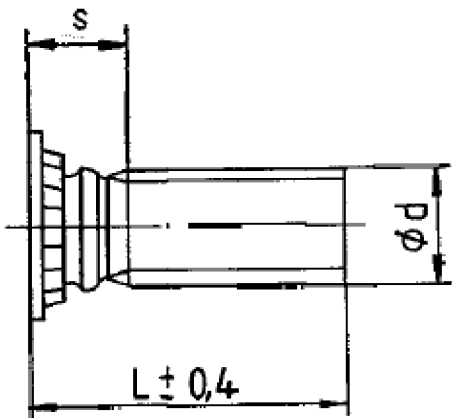


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SCREW



$L\text{ eff} = L - T$

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1 GENERAL

This product specification includes screw studs type SBA 519.

2 APPLICATION

This product specification shall be applied for choice, purchase, manufactu-
ring and inspection.
In case of difference between this product specification and the purchase
order, the purchase order shall apply.

3 DESIGN

Self Clinching Studs. Squeeze lockable studs.

Thread: ISO metric screw threads. Coarse pitch.
Material: Steel or stainless steel AISI 400 according to product list.

4 CORRESPONDING STANDARD

Design and dimensions according to Ericsson instruction.
Material according to Ericsson instruction.
Surface treatment according to Ericsson instruction.

5 USE

The screw studs made of steel is suitable for use in sheets of steel, brass, copper
or aluminium of hardness HRB 80 or less.
The screw studs made of stainless steel is suitable for use in stainless steel
sheets of hardness HRB 70 or less.

6 TECHNICAL DATA

6.1 Steel studs

Dimension	M2	M3	M4	M5	M6	M8
Pitch	0.4	0.5	0.7	0.8	1.0	1.25
D	3.5	4.5	5.5	6.5	8.0	9.9
d1 max	2.03	3.05	4.04	5.06	6.05	8.05
d1 min	1.96	2.97	3.96	4.98	5.97	7.97
T min	1.0	1.0	1.0	1.0	1.5	2.0
A min	4.8	5.5	7.0	7.0	8.0	9.5

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6.1 Stainless steel studs

Dimension	M3	M4	M5	M6
Pitch	0.5	0.7	0.8	1.0
D	4.6	5.9	6.5	8.2
d1 max	3.08	4.08	5.08	6.08
d1 min	2.92	3.92	4.92	5.92
T min	1.0	1.0	1.0	3.0
T max	2.4	2.4	2.4	1.6
A min	5.5	7.0	7.0	8.0

7 TOLERANCES

Tolerances except as stated see: ISO 965.

Burrs: The products shall have full surfaces and edges
and all burrs removed that can cause injury to person or product.

8 TREATMENTS

Zinc electroplating and conversion coating according to MZY 510 15/31.

The thickness on zinc layer and bright chromate coating according to ISO 4042:1999 table 2.

9 UNIT

Quantity shall be given in pieces.

10 MOUNTING

See the figure 1. To mount the stud, squeeze the stud into a punched or drilled hole, this action will allow the displaced material around the hole's edge to flow and lock the stud.

11 PACKING

See 1055-108 Uen.

12 INSPECTION

Inspection according to ISO 3269:2000.

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13 REFERENCES

1003-101 Uen	STAKO classes, instruction
105 63-2031 Uen	General quality requirements on components.
105 86-MZY 510 15 Uen	Quality requirement colorless conversion coating
ISO 261:1998	ISO general-purpose metric screw threads.
ISO 965-1:1998	Tolerances – Part 1:Principles and basic data.
ISO 1101-1983	Technical drawings - Geometrical tolerance - tolerance of form, orientation, location and run-out – Generalities, definitions, symbols, indications on drawing.
ISO 2768-1	General tolerances – Part 1:Tolerances for linear and angular dimensions without individual tolerance indications.
ISO 3269:2000	Fasteners – Acceptance inspection.
ISO 4042:1999	Fasteners – Electroplated coatings.
ISO 4759	Tolerances for fasteners.

14 PRODUCT LIST

14.1 ZINC ELECTROPLATED AND YELLOW CHROMATED SCREWS*

*This coating is not available. Use 78/SBA 519 xx/xxxx in table below.

Product number	Thread	L	Treatment
03/SBA 519 020/0080	M 2	8	MZY 510 15/31
03/SBA 519 030/0060	M 3	6	MZY 510 15/31
03/SBA 519 030/0080	M 3	8	MZY 510 15/31
03/SBA 519 030/0100	M 3	10	MZY 510 15/31
03/SBA 519 030/0120	M 3	12	MZY 510 15/31
03/SBA 519 030/0200	M 3	20	MZY 510 15/31
03/SBA 519 040/0080	M 4	8	MZY 510 15/31
03/SBA 519 040/0100	M 4	10	MZY 510 15/31
03/SBA 519 040/0120	M 4	12	MZY 510 15/31
03/SBA 519 040/0140	M 4	14	MZY 510 15/31
03/SBA 519 040/0200	M 4	20	MZY 510 15/31
03/SBA 519 040/0250	M 4	25	MZY 510 15/31
03/SBA 519 050/0100	M 5	10	MZY 510 15/31
03/SBA 519 050/0120	M 5	12	MZY 510 15/31
03/SBA 519 050/0180	M 5	18	MZY 510 15/31
03/SBA 519 050/0200	M 5	20	MZY 510 15/31
03/SBA 519 060/0100	M 6	10	MZY 510 15/31
03/SBA 519 060/0120	M 6	12	MZY 510 15/31
03/SBA 519 060/0140	M 6	14	MZY 510 15/31
03/SBA 519 060/0200	M 6	20	MZY 510 15/31
03/SBA 519 060/0250	M 6	25	MZY 510 15/31
03/SBA 519 060/0300	M 6	30	MZY 510 15/31

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03/SBA 519 080/0160	M 8	16	MZY 510 15/31
03/SBA 519 080/0200	M 8	20	MZY 510 15/31
03/SBA 519 080/0250	M 8	25	MZY 510 15/31

14.2 ZINC ELECTROPLATED WITH
CONVERSION COATING MZY 510 15/31

78/SBA 519 020/0080	M 2	8	MZY 510 15/31
78/SBA 519 030/0060	M 3	6	MZY 510 15/31
78/SBA 519 030/0080	M 3	8	MZY 510 15/31
78/SBA 519 030/0100	M 3	10	MZY 510 15/31
78/SBA 519 030/0120	M 3	12	MZY 510 15/31
78/SBA 519 030/0200	M 3	20	MZY 510 15/31
78/SBA 519 040/0080	M 4	8	MZY 510 15/31
78/SBA 519 040/0100	M 4	10	MZY 510 15/31
78/SBA 519 040/0120	M 4	12	MZY 510 15/31
78/SBA 519 040/0140	M 4	14	MZY 510 15/31
78/SBA 519 040/0160	M 4	16	MZY 510 15/31
78/SBA 519 040/0180	M 4	18	MZY 510 15/31
78/SBA 519 040/0200	M 4	20	MZY 510 15/31
78/SBA 519 040/0250	M 4	25	MZY 510 15/31
78/SBA 519 050/0100	M 5	10	MZY 510 15/31
78/SBA 519 050/0120	M 5	12	MZY 510 15/31
78/SBA 519 050/0140	M 5	14	MZY 510 15/31
78/SBA 519 050/0180	M 5	18	MZY 510 15/31
78/SBA 519 050/0200	M 5	20	MZY 510 15/31
78/SBA 519 050/0250	M 5	25	MZY 510 15/31
78/SBA 519 050/0300	M 5	30	MZY 510 15/31
78/SBA 519 060/0100	M 6	10	MZY 510 15/31
78/SBA 519 060/0120	M 6	12	MZY 510 15/31
78/SBA 519 060/0140	M 6	14	MZY 510 15/31
78/SBA 519 060/0150	M 6	15	MZY 510 15/31
78/SBA 519 060/0160	M 6	16	MZY 510 15/31
78/SBA 519 060/0180	M 6	18	MZY 510 15/31
78/SBA 519 060/0200	M 6	20	MZY 510 15/31
78/SBA 519 060/0250	M 6	25	MZY 510 15/31
78/SBA 519 060/0300	M 6	30	MZY 510 15/31
78 SBA 519 060/0350	M 6	35	MZY 510 15/31
78/SBA 519 080/0150	M 8	15	MZY 510 15/31
78/SBA 519 080/0160	M 8	16	MZY 510 15/31
78/SBA 519 080/0200	M 8	20	MZY 510 15/31
78/SBA 519 080/0250	M 8	25	MZY 510 15/31
78/SBA 519 080/0300	M 8	30	MZY 510 15/31
78/SBA 519 080/0350	M 8	35	MZY 510 15/31

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14.2 STAINLESS STEEL SCREW

Product number	Thread	L	Treatment
SBA 519 030/0080	M 3	8	No treatment
SBA 519 030/0100	M 3	10	No treatment
SBA 519 060/0150	M 6	15	No treatment

15 DOCUMENT REVISION INFORMATION

Revision	Description
E	SBA 519 060/0150 added to product list
F	78/SBA 519 040/0080 added to product list.
G	SBA 519 030/0080 added to product list.
H	78/SBA 519 080/0150, 78/SBA 519 020/0080, 78/SBA 519 030/0060, 78/SBA 519 030/0120, 78/SBA 519 050/0200, 78/SBA 519 060/0250 and 78/SBA 519 060/0300 added to product list. Changed 14.1 and 14.2 headings because of new conversion coating.
J	Added SBA 519 030/0100