

NUT, BIHEXAGONAL, SELF-LOCKING
Inco718, 1550 MPA , ISO MJ,
LUBRICATED

BA1580

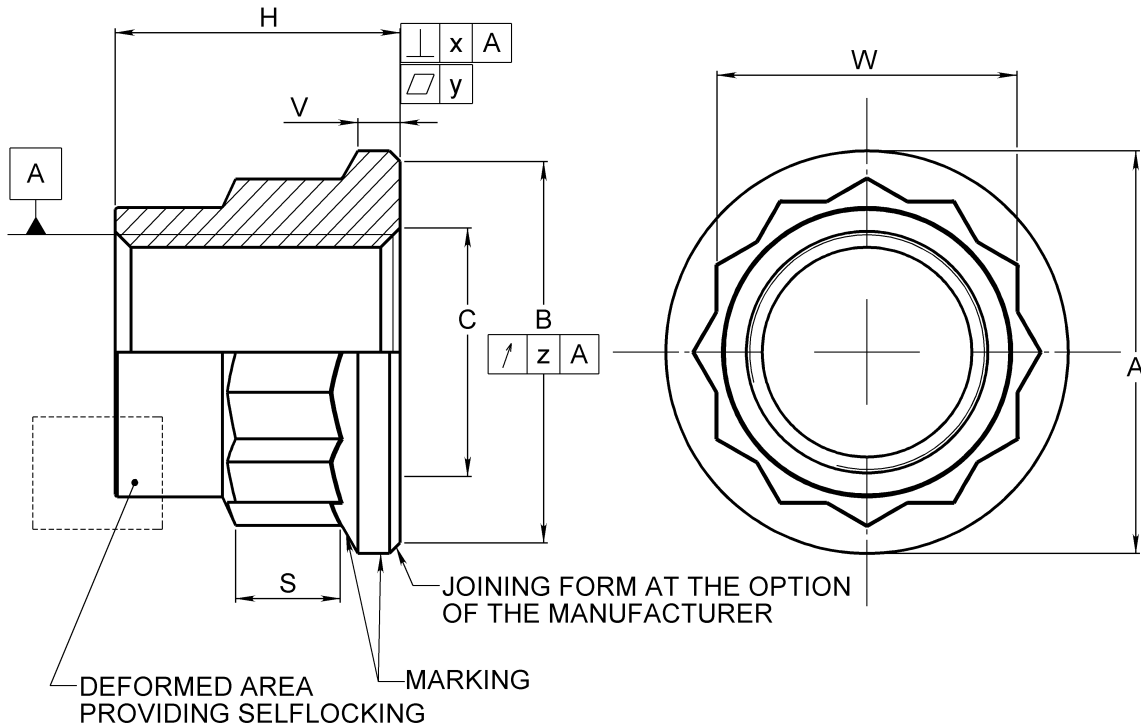


FIGURE 1



GENERAL NOTE:

UNLESS OTHERWISE SPECIFIED

- i) **Units:** Dimensions and tolerances are in millimeters. Dimensions apply after finish.
- ii) **Surface Texture :** $Ra3.2\sqrt{\text{---}}$ per ASME B46.1
- iii) **Break sharp edges:** 0.05mm/0.2mm.
- iv) **Fillets :** R 0.2mm / 0.4mm
- v) **Thread:** ISO MJ as per ISO5855-1 and ISO5855-2

Technical Center	Drawn by	Signature	Date	Approved by	Signature	Date	Revision
PAGE 1/4	D. FRIOT		2023-02-23	J. GOYER		2023-02-23	E

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1. Nut definition

Configuration- Dimensions- Tolerances- Masses

See figure 1 and table 1

DIA	Threads per	A	B	C	H	V	S	W per ISO4095	x	y	z	Mass
DASH NO.	ISO5855-1 & ISO5855-2	0 -0,25	MIN	± 0,20	0 -0,2	MIN	MIN		TOL	TOL	TOL	kg/1000pcs REF
5	MJ5X0,8 4H6H	9,1	8,3	5,7	7	1,2	2	7	0,10	0,05	0,2	1,7
6	MJ6X1 4H5H	10,6	9,8	7	8,1	1,,2	2,3	8				2,4
8	MJ8X1 4H5H	13,6	12,8	9	10,4	1,2	2,8	10				4,4
10	MJ10X1,25 4H5H	16,8	15,8	11	13	1,2	3,1	12	0,13		0,3	7,8
12	MJ12X1,25 4H5H	19,9	18,8	13	15	1,4	3,5	14				14
14	MJ14X1,50 4H5H	23	21,9	15,1	17,5	1,7	4	17	0,15		0,4	20
16	MJ16X1,50 4H5H	26	24,9	17,1	20	1,9	4,7	19				28
18	MJ18X1,50 4H5H	29,1	28	19,1	22,5	1,9	5,6	22				44
20	MJ20X1,50 4H5H	32,3	31,2	21,1	25	2,1	6,8	24				53

TABLE 1: DIMENSIONS, NOMINAL SIZE

Material

NICKEL ALLOY 718 per AMS5662 or AMS5962

Surface Treatment

CODE L : Passivated per AMS2700 and Molybdenum disulfide coating per AS1701 class III
CODE T : Passivated per AMS2700 and Molybdenum disulfide coating per AS1701 class VI
CODE A : Passivated per AMS2700 and HiKote®4N/C per EN4473

Service Temperature Limit

425°C

2. Designation

Example: **BA1580 L 6**

Dia Dash Code

Finish Code

Basic part number

3. Marking

Per EN2424 style A

4. Technical Specification

Per EN4048 except for:

- Tightening torques (also called Seating torques) for measuring locking (also called self-locking) and breakaway torques
- Wrenching feature torque As per Table 2.

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Ø code	TORQUES (Nm)	
	Tightening	Wrenching feature
5	6,7	9,5
6	15,5	19,5
7	28	38
8	41	56,5
10	74	89,5
12	125	148
14	167	225
16	217	300
18	293	420
20	448	595

TABLE 2: TIGHTENING AND WRENCHING FEATURE TORQUES

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Revision Date	Name	Modifications	Justification
A JUNE 29, 2009	Y.DOUCARD	New document	-
B AUGUST 11, 2009	Y.DOUCARD	General note v), page1: Replace ISO5558-2 by ISO5855-1 and ISO5855-2	-
		Table 1, page 2: Replace ISO5558-2 by ISO5855-2	-
		Table 1, page 2: Change tolerance class 4H6H to 4H5H from diameter MJ6 to MJ20.	In line with ISO5855-2 requirements.
		Section 4, page 2: Replace technical specification EN4047 by EN4048.	EN4047 only valid for silver plated nuts.
C OCTOBER, 28 th 2011	M.RICHARD	Section 4, page 2: Replace "EN4048 except seating torque per ISO8642" by "EN4048 except for tightening and wrenching feature torques, as per Table 2"	ISO8642 was a typo, and was instead of ISO8641. It gives test methods and not values. Now, ISO8641 has been revised and so, is no longer applicable for this standard.
		Section4, page 3: Add Table 2: Tightening and wrenching feature torques	Idem
D NOVEMBER, 04 TH 2011	M.RICHARD	Typo error in TABLE 2 (page 3): Tightening torque for Ø code 7 → 25 replaced by 28.	-
E FEBRUARY 23 rd 2023	D. FRIOT	Surface treatment code T added (AS1701 Class VI)	-

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