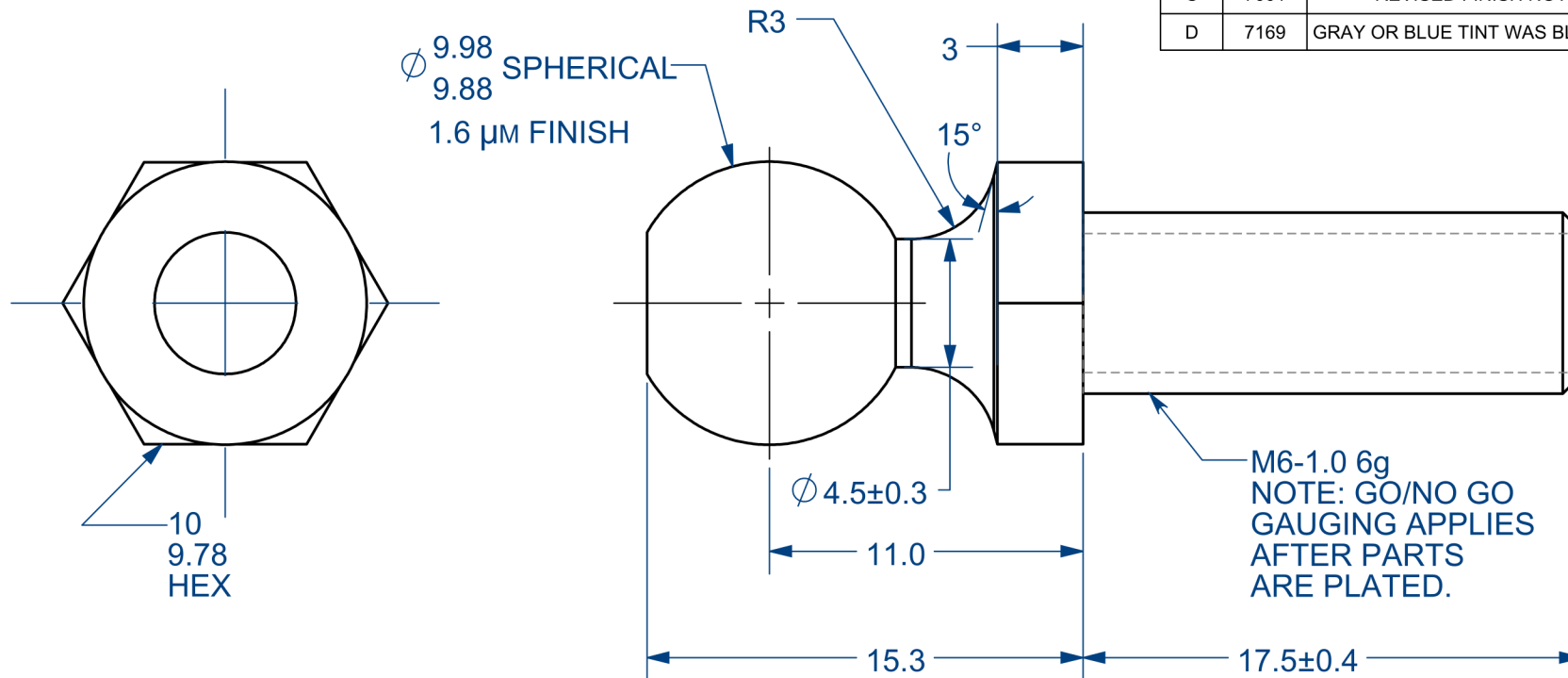


| REV | ECR  | DESCRIPTION                     | REV BY | CHK BY | REV DATE  |
|-----|------|---------------------------------|--------|--------|-----------|
| A   |      | REVISION "A" NOT RELEASED       |        |        |           |
| B   | 5973 | RELEASED FOR PRODUCTION         | RCD    | DEW    | 9/19/2014 |
| C   | 7001 | REVISED FINISH NOTE.            | RCD    | DEW    | 7/19/2017 |
| D   | 7169 | GRAY OR BLUE TINT WAS BLUE TINT | RCD    | DEW    | 1/11/2018 |



## NOTES

1. MATERIAL: 1215 STEEL OR ENGINEERING APPROVED EQUIVALENT.
2. FINISH: 0.0002 MINIMUM ZINC NICKEL (10-15%) TRIVALENT BARREL + BAKE.  
NOTICE: PARTS WILL HAVE A GRAY OR BLUE TINT. MUST WITHSTAND 720 HOURS MINIMUM SALT SPRAY.
3. HARDENED MIN 55 HRC CASE HARDENED TO .127mm/.381mm DEEP.
4. PART TO BE FREE FROM BURRS, SHARP EDGES, AND OTHER DEFECTS WHICH MAY LESSEN THE USEABILITY.
5. THE BALL STUDS SHALL HAVE COMPLETE SURFACES AND CORNERS.
6. SURFACE ROUGHNESS UNLESS OTHERWISE STATED Ra MAX 6.3µm.

材料: 1215 钢

表面处理: 镀层要求: 5-8微米环保灰色或者蓝色锌镍合金 (Zinc Nickel)

720 小时的最低盐雾测试

热处理与硬度: 表面硬化 (渗碳): 最小硬度 HRC 55.

硬化深度: 渗碳深度为 0.127mm 至 0.381mm

外观要求: 零件必须无毛刺、锐边或其他影响使用性的缺陷。

球头螺柱必须有完整的表面和圆角。

表面粗糙度: 除非另有规定, 表面粗糙度 (Ra) 最大为 6.3µm。

数量: 10万件

SCALE: 4:1 SHEET NUMBER: 1 OF 1 MODEL: H18107

PART NO.:

METRIC  
ALL DIMENSIONS IN mm  
TOLERANCES UNLESS  
OTHERWISE SPECIFIED:

DECIMAL X. ±0.5  
DECIMAL .X ±0.25  
DECIMAL .XX ±0.13  
DECIMAL .XXX ±0.05  
ANGULAR ±0.5°

DESCRIPTION:

BALL STUD, 10mm

DRAWN BY:

RCD

DATE:

9/19/2014

CHECKED BY:

DEW

DATE:

9/19/2014

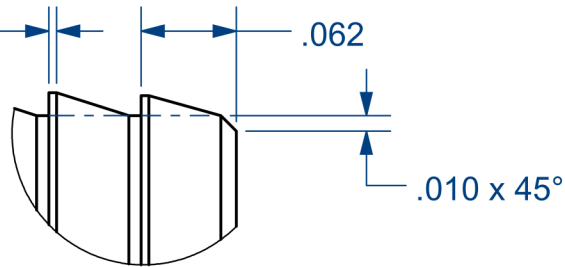
DRW NO:

H18107

DRW REV:

D

.005 MAX  
FLAT 3X



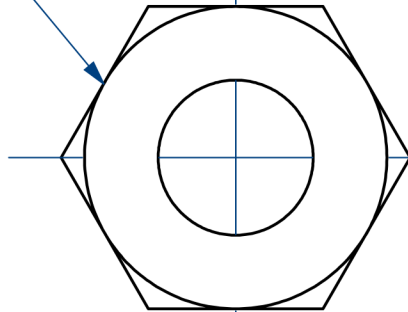
DETAIL A  
SCALE 8 : 1

**CONFIDENTIAL**

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| REV | ECR  | DESCRIPTION             | REV BY | CHK BY | REV DATE   |
|-----|------|-------------------------|--------|--------|------------|
| A   | 6615 | RELEASED FOR PRODUCTION | RCD    | DEW    | 11/22/2016 |
| B   | 7001 | REVISED FINISH NOTE     | RCD    | DEW    | 7/19/2017  |
| C   | 7098 | REVISE & REDRAW         | RCD    | DEW    | 10/20/2017 |

10  
9.78 mm  
HEX



材料: 1215 钢 或工程认可的同等级材料。  
表面处理: 镀层要求: 0.0002英寸最低厚度的  
锌镍合金 (10-15%) ,  
采用三价铬钝化 + 烘烤工艺。  
盐雾测试: 零件有灰色或蓝色镀层。  
必须能够经受至少 720 小时的最低盐雾测试  
热处理与硬度: 表面硬化 (渗碳): 最小硬度 HRC 55。  
硬化深度: 渗碳深度为 0.127mm 至 0.381mm。  
外观要求: 零件必须无毛刺、锐边或  
其他影响使用性的缺陷。  
球头螺柱必须有完整的表面和圆角。  
表面粗糙度: 除非另有规定, 表面粗糙度 (Ra) 最大为 6.3μm。

数量: 10000PCS

**NOTES**

1. MATERIAL: 1215 STEEL OR ENGINEERING APPROVED EQUIVALENT.
2. FINISH: 0.0002 MINIMUM ZINC NICKEL (10-15%) TRIVALENT BARREL + BAKE. (B)  
NOTICE: PARTS WILL HAVE A GRAY OR BLUE TINT. MUST WITHSTAND 720 HOURS  
MINIMUM SALT SPRAY.
3. HARDENED MIN 55 HRC CASE HARDENED TO .127mm/.381mm DEEP.
4. PART TO BE FREE FROM BURRS, SHARP EDGES, AND OTHER DEFECTS WHICH  
MAY LESSEN THE USEABILITY.
5. THE BALL STUDS SHALL HAVE COMPLETE SURFACES AND CORNERS.
6. SURFACE ROUGHNESS UNLESS OTHERWISE STATED Ra MAX 6.3μm.

Ø 9.98  
9.88 mm  
1.6 μM FINISH

Ø .260

R.115

.453

R.010

.220

.181

.122

Ø .240  
TYP

Ø .266±.002

Ø .270±.002

Ø .270±.002

.050

.381

.550

SCALE: 4:1 SHEET NUMBER: 1 OF 1 DRW SIZE: A MODEL: H18427

PRT NO: X

ALL DIMENSIONS IN INCHES  
TOLERANCES UNLESS  
OTHERWISE SPECIFIED:  
DECIMAL X. PLC. ±.020  
DECIMAL .X PLC. ±.010  
DECIMAL .XX PLC. ±.010  
DECIMAL .XXX PLC. ±.005  
FRACTIONAL ±1/64  
ANGULAR ±0.5°

DESCRIPTION:

BALL STUD, 10mm

DRAWN BY:

RCD

DATE:

11/22/2016

CHECKED BY:

DEW

DATE:

11/22/2016

DRW NO.:  
H18427

DRW REV:  
C