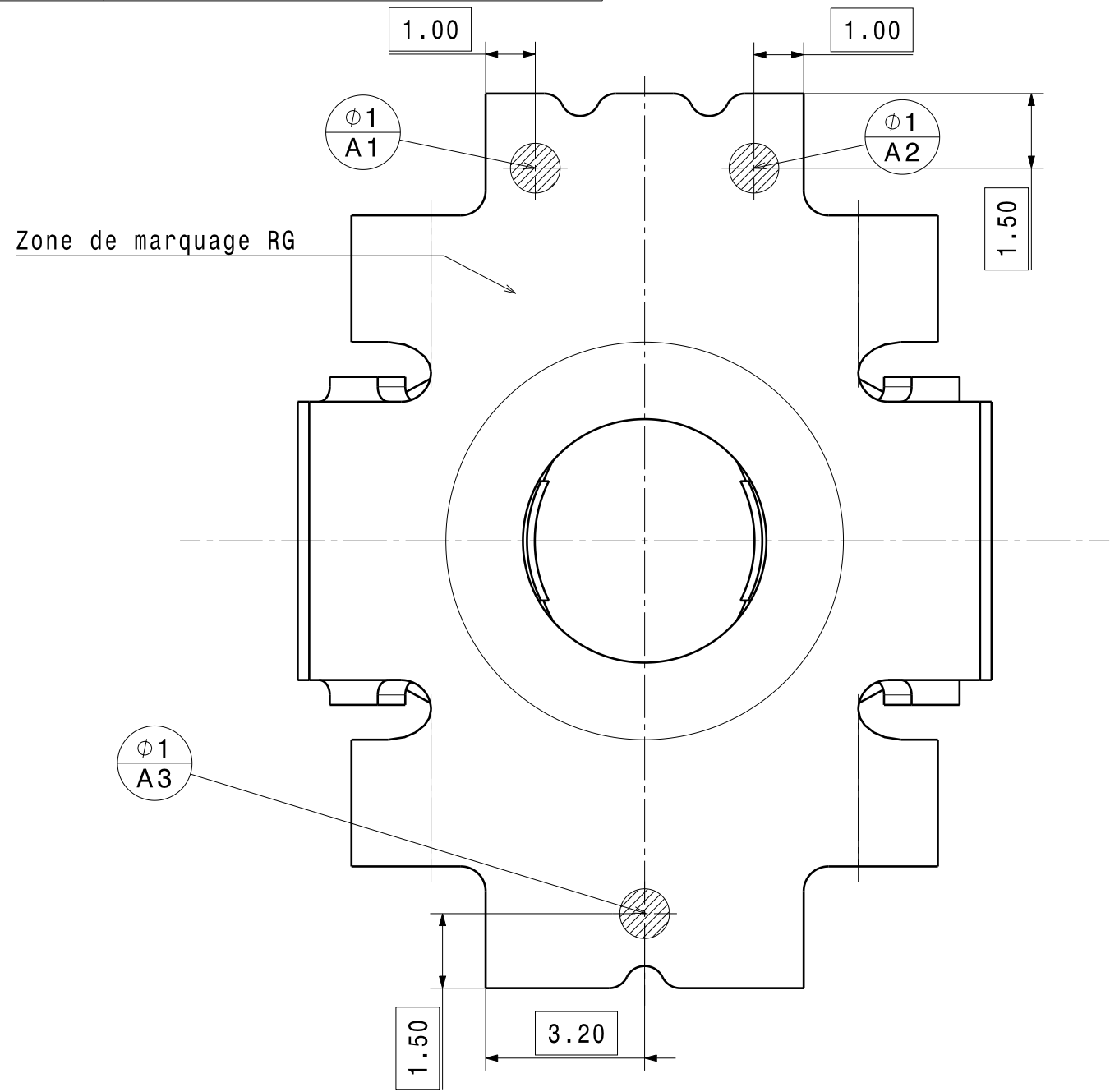
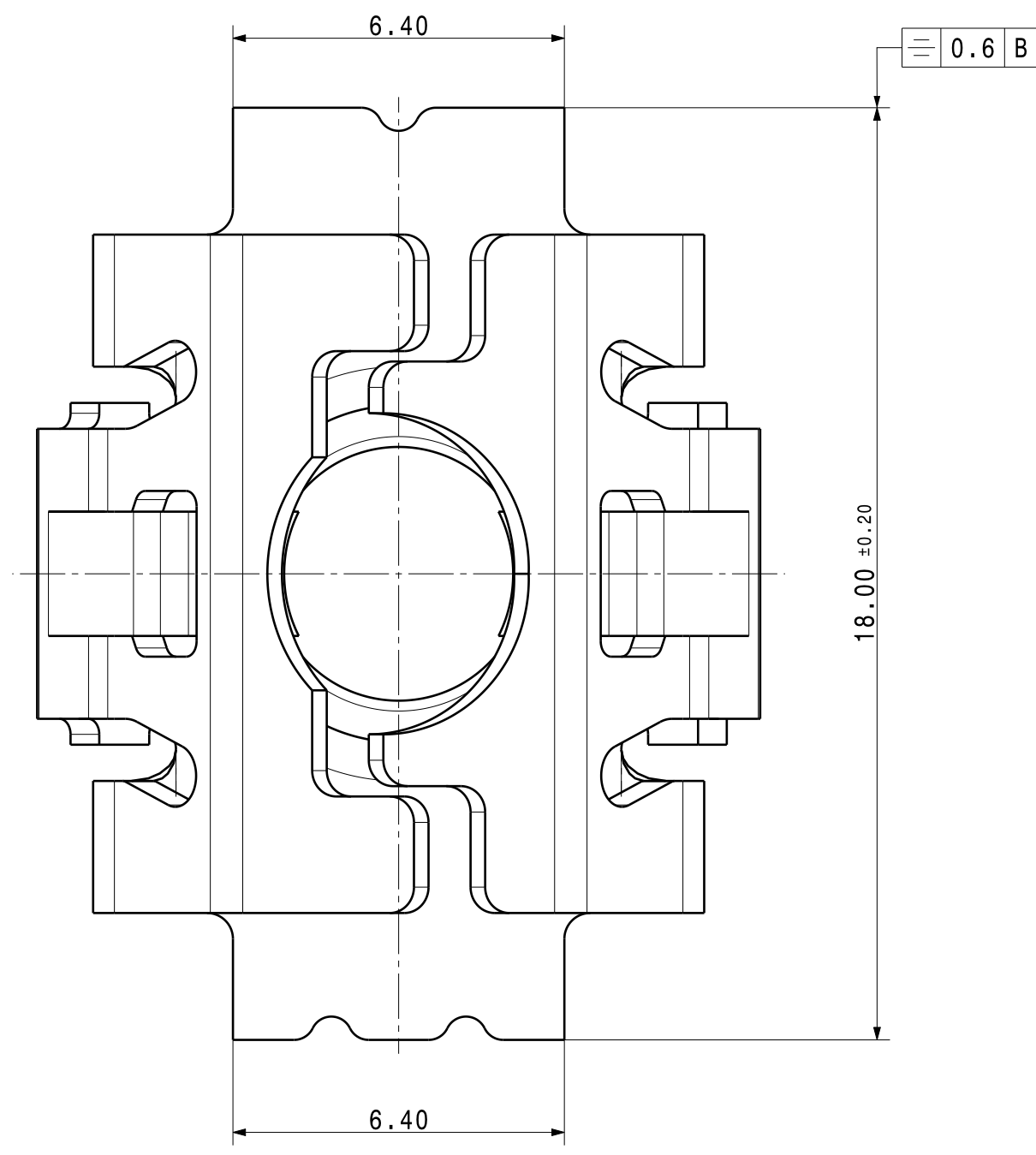
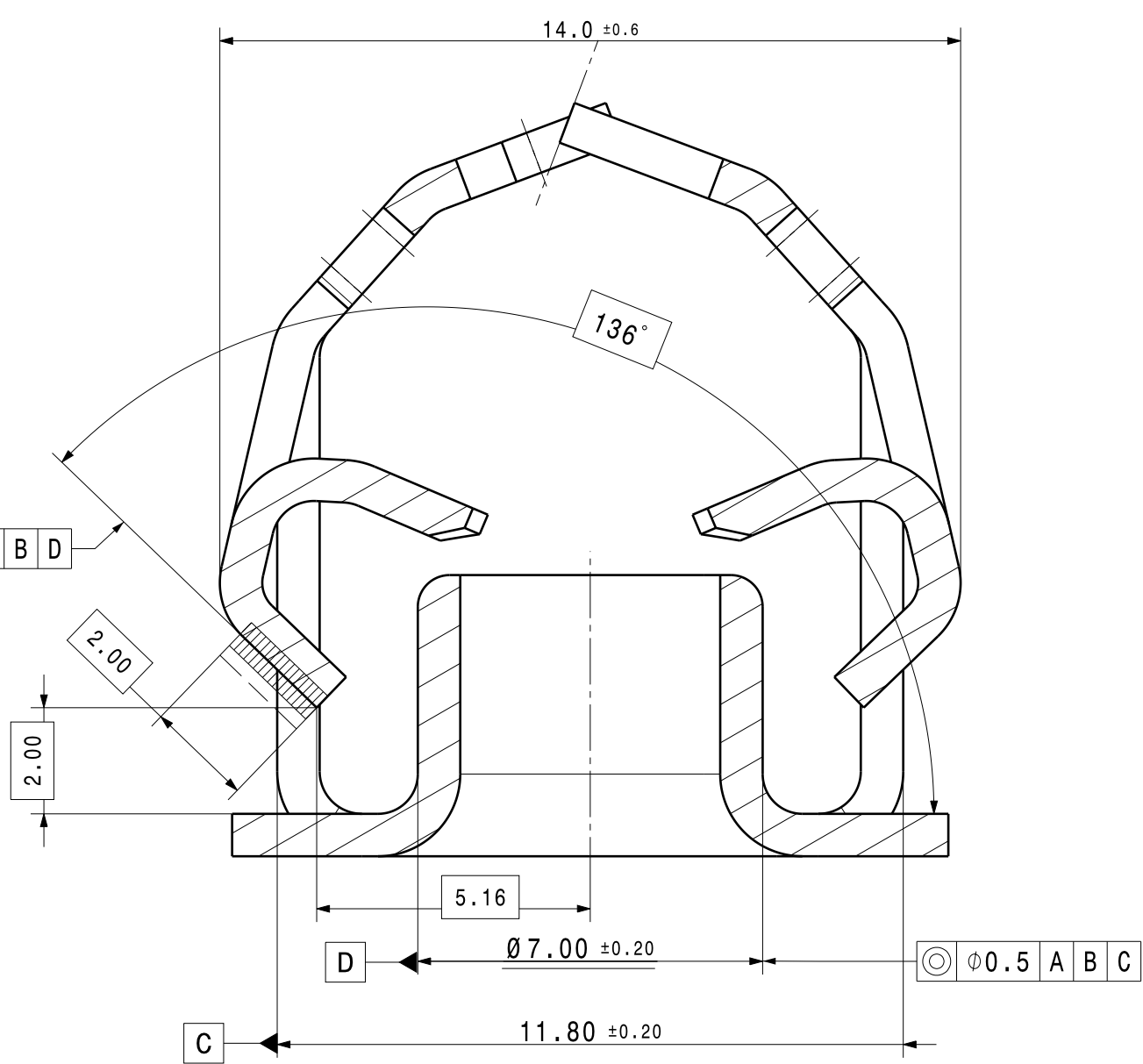


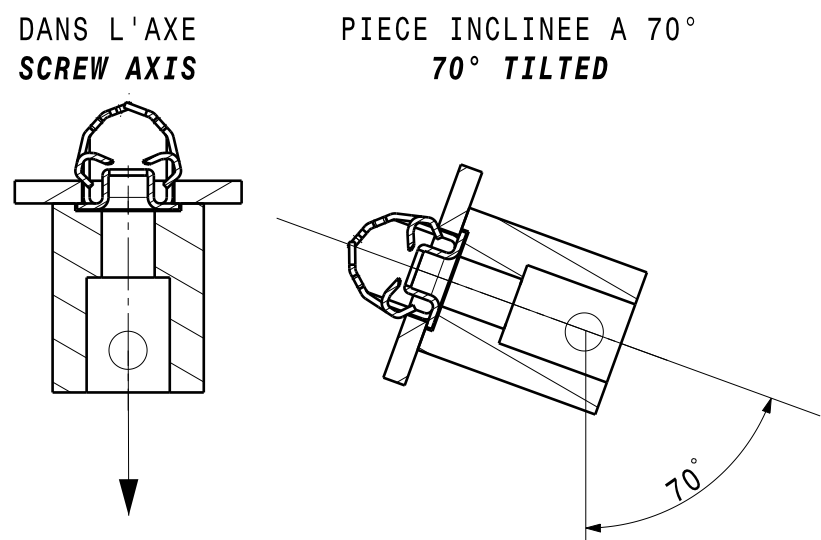
Variant	Finition / Finishes
00	ZnFL Zn-Al + Si 8µ min Magni 2.1 gris/grey BS RR:600H
01	BRUT DE TREMPE
05	ZnFL Noir/Black Zn-Al + Si 8µ min Magni 2.2 noir/black BS RR:600H



Coupe A-A



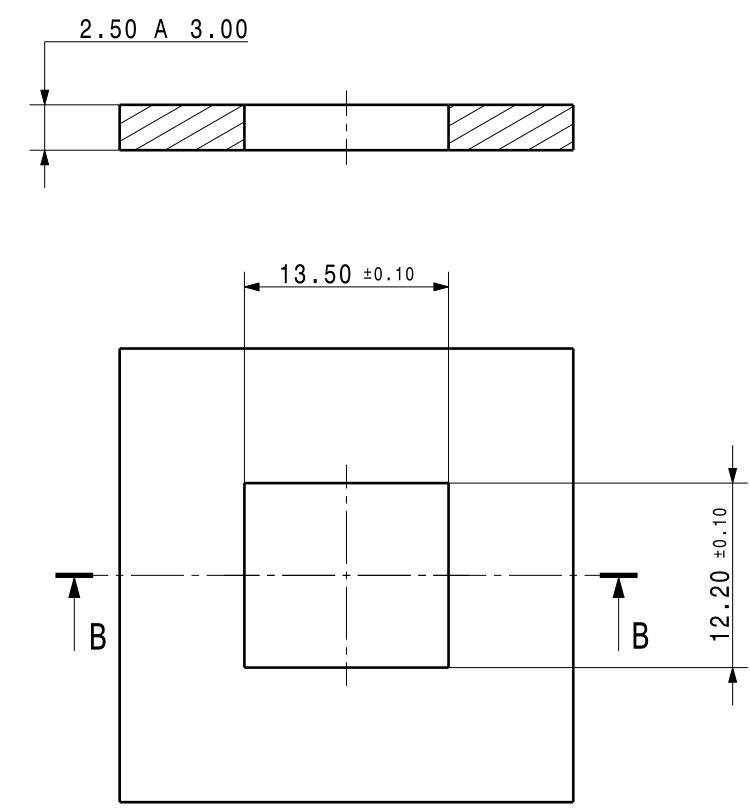
TEST D'ENDURANCE / ENDURANCE TEST



Description de l'essai / test description:
19000 cycles d'effort croissants et décroissants de 0 à 15 daN en 3 secondes.
19000 cycles increasing/decreasing force (0 to 15 daN) in 3s

Après l'essai / after test:
L'ensemble reste fonctionnel
The assembly must stay functional
aucune dégradation de la fonction
no degradation of the function

INTERFACE SUPPORT/SUPPORT INTERFACE
Echelle/Scale : 2:1

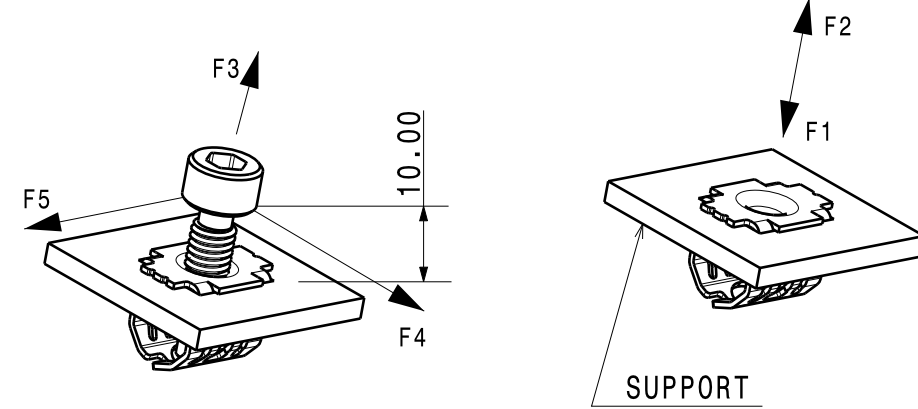


MONTAGE SUR SUPPORT
ASSEMBLY OF THE FASTENER ONTO SUPPORT

Montage manuel ou avec petit outillage.
Manually assembled or light tool.

Pas de distribution automatique en finition lamellaire 000.
Contacter la Sté A Raymond pour validation du concept de distribution
No automatic distribution for the 000 variant (paint coating)
Please contact A Raymond compagny for distribution process validation.

TENUE MECANIQUE SUR SUPPORT
MECHANICAL RESISTANCE ONTO SUPPORT



Matière support / Support material	PP 30GFL	PP 20TD
Montage écrou seul / Push-in nut alone: F1	5 daN MAXI	5 daN MAXI
Démontage écrou seul / Pull-out nut alone: F2	5 daN MINI	5 daN MINI
Démontage écrou avec vis en place / Nut pull-out with screw on position: F3	100 daN MINI	70 daN MINI
Tenue écrou avec vis en place / Nut resistance with screw on position: F4	90 daN MINI	45 daN MINI
Tenue écrou avec vis en place / Nut resistance with screw on position: F5	65 daN MINI	30 daN MINI

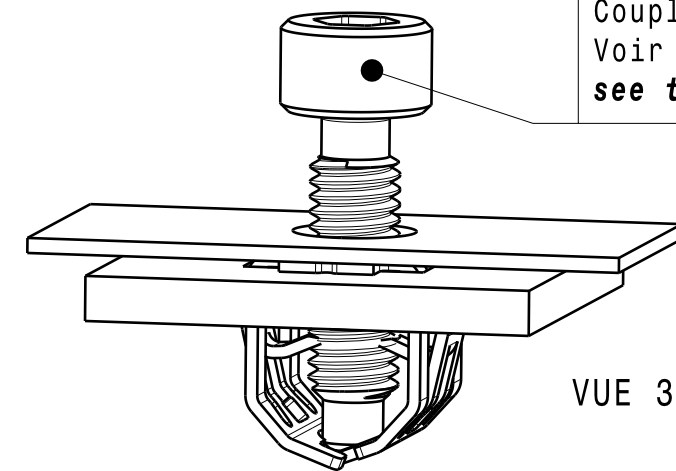


ASSEMBLAGE / ASSEMBLY
Echelle / Scale : 2:1

CONTRE-PLAQUE TOLE / SHEET METAL

SUPPORT

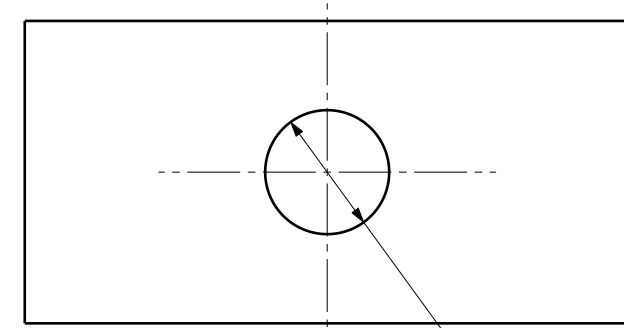
(16 Maxi à l'état vissé / at screwed state)



VUE 3D / 3D VIEW

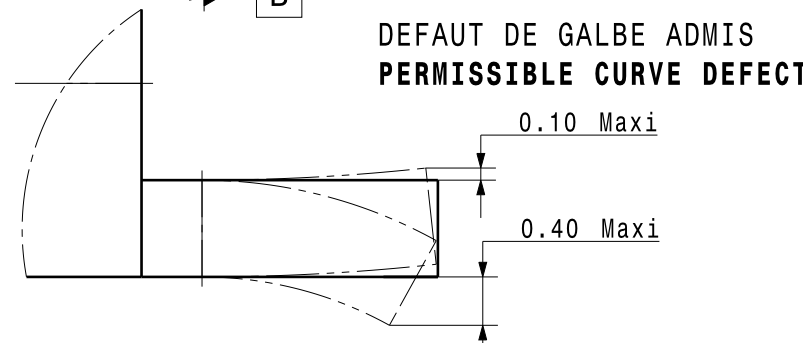
(Longueur vis mini en prise dans écrou: 12.00 mini)
(Minimum screw length in engagement in the nut)

INTERFACE CONTRE-PLAQUE TOLE / SHEET METAL INTERFACE
Echelle/scale: 2:1



Dimensions trou de passage vis (voir tableau)
Sheet metal hole dimensions (see table)

Détail D
Echelle/Scale: 16:1



VISSAGE ET TENUE AU COUPLE
SCREWING AND TORQUE RESISTANCE

Le tableau au plan est le reflet des validations effectuées par A Raymond
The graphic table (torque resistance/interface) shows the results from A Raymond test method

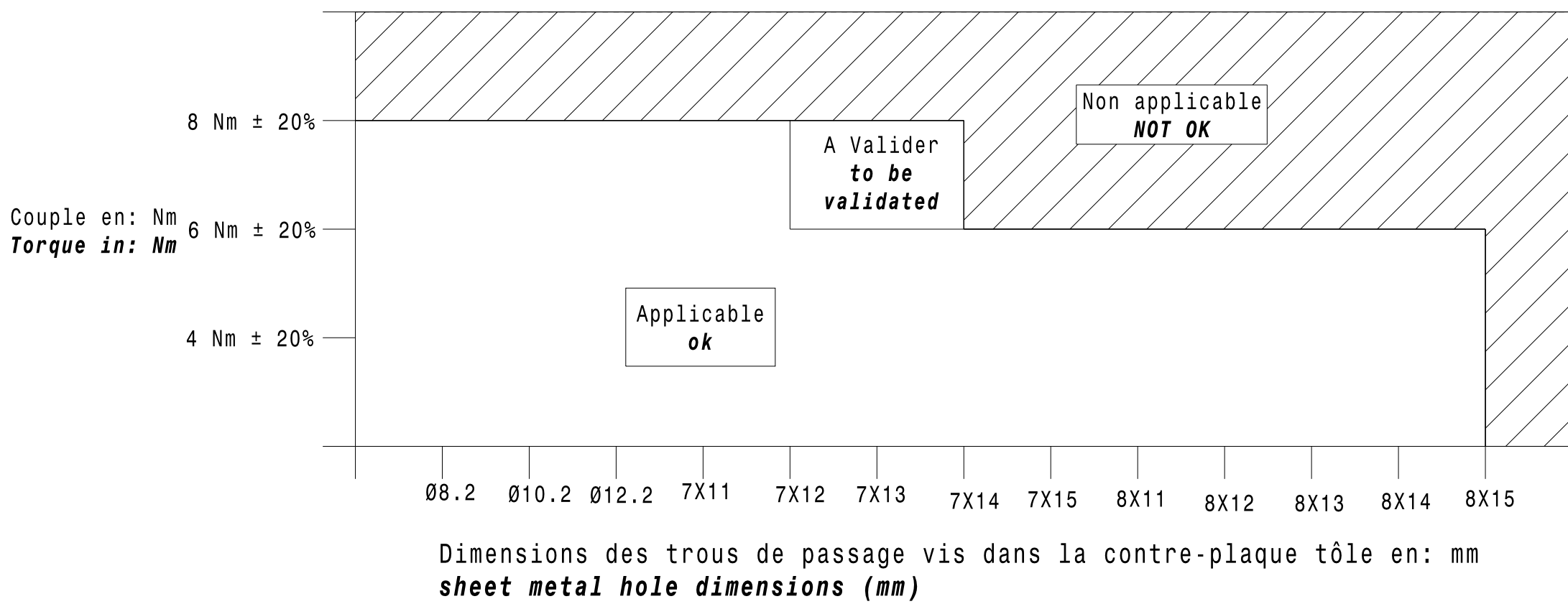
Couple de ruine du taraudage M6 avec contre plaque trou Ø 6mm : 12 Nm mini
torque with sheet metal hole Ø6mm = 12Nm mini breacking

Le respect de la tenue au couple ou les efforts est directement lié aux dimensions de passage de la contre plaque.

Force and torque resistance depend on the sheet metal hole dimensions the values in the tables are given for information only.

Quoi qu'il en soit, une validation bilatérale de l'application est nécessaire pour valider l'engagement de la Sté A Raymond.
Each application have to be validated

TENUE AU COUPLE / INTERFACE
TORQUE RESISTANCE / INTERFACE



Une consultation préalable de A.Raymond SARL est nécessaire pour toute mise en place de la pièce en automatique.
Automatic processing of the part requires prior consultation with A.Raymond SARL.

CONDITIONS D'UTILISATION / USE CONDITIONS

Vis M6 à bout pilote ou ogivale (pas de vis à tête auto-taraudeuse).
M6 dog point screw or round point screw (no self tapping or cleaning screw)

Longeur en prise dans le fût M6: 12 mm mini
Minimum length in engagement in the M6 thread

Couple de serrage / tightening torque
Voir tableau/ "couple/interface"
see table "torque resistance/interface"

Fq	- Mise à jour détail D / Updated detail D	11.04.13	PCA
Fp	- AJOUT VARIANTES 05 / ADD VARIANT 05	05.04.13	GPA
Fm	- updated drawing in english	10.02.12	GPA
Fm	01 Mise à jour plan	10.06.10	MXD
F1	- UPDATED DRAWING	16.04.10	FAI
Fk	- 3D UPDATE	31.03.10	FAI
Fj	- UPDATED DRAWING	30.03.10	FAI
Fh	- MISE A JOUR EXEMPLE D'UTILISATION	25.11.09	PCA
Fg	- MISE A JOUR / BED	04.10.09	TDA
REV.	Quant.	Indice / revision description	Date Name



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Brevets / Patent rights	Patented R6671	Classification code	AC-CC
N° Project / Project No.	Origine / Origin	Chief de projet / Project Manager	COCHARD.M
Echelle / scale	Format	Tolerance / General tolerance	Data
8:1	A1	Cf nota Cf nota	Revisé / Prepared by
		ALL DIMENSIONS ARE IN MILLIMETERS	Approuvé / Approved
		Epaisseur / Mat. thickness	0,80
		Valeur (mm)	427,1
		Poids / Weight (g)	3,3

Function / finsh
See parts list
Voir tableau

C45E CR
>0,5 : TTH.HR 30 N : 57,5 a 63 (38 a 42 Hrc)

Matériau / Material
C45E-A

Libelle / Title
Ecrou à pas métrique
M6 à clipper / Recyclable
Metric pitch nut
M6 in clipper / Recyclable

Reference / Part no.
203245-0-00

Ref. client / Customer part no.
C-Customer

Ref. client / Customer part no.
C-Customer

CAD system & version CATIA V5 R19 SP7
Non fichier / File name 203245-0000