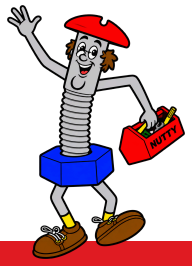
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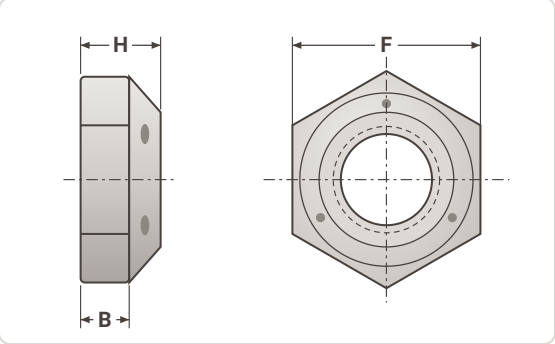
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PRODUCT DATA SHEET

Grade 8 (C) Prevailing Torque (Stover) Lock Nuts

1.0 Dimensions As per IFI-100/107 (inches)



- **Also known as:** Stover nuts, top lock nuts, all-metal lock nuts or automation lock nuts.
- **Specification:** IFI-100/107 Grade C – the Grade 8 strength level (ASME B18.16.6 all-metal hex locknut).
- **Locking:** the cone-shaped top is crimped, distorting the top threads so they grip the bolt – no nylon insert.
- **F** = across flats **H** = overall thickness **B** = hex (wrenching) height
- **Stocked in:** zinc plated & waxed steel, UNC (coarse) 1/4"–1-1/2" and UNF (fine) 1/4"–1".

Nominal Size	F – Width Across Flats			H – Overall Thickness		B – Hex Height		Stocked
	Basic	Max	Min	Max	Min	Max	Min	Thread Series
1/4	7/16	0.4385	0.428	0.226	0.212	–	0.145	UNC / UNF
5/16	1/2	0.5020	0.489	0.273	0.258	–	0.166	UNC / UNF
3/8	9/16	0.5645	0.551	0.337	0.320	–	0.198	UNC / UNF
7/16	11/16	0.6895	0.675	0.385	0.365	–	0.223	UNC / UNF
1/2	3/4	0.7520	0.736	0.448	0.427	–	0.262	UNC / UNF
9/16	7/8	0.8770	0.861	0.496	0.473	–	0.286	UNC / UNF
5/8	15/16	0.9395	0.922	0.559	0.535	–	0.329	UNC / UNF
3/4	1-1/8	1.1270	1.088	0.665	0.617	–	0.382	UNC / UNF
7/8	1-5/16	1.3145	1.2690	0.776	0.724	–	0.450	UNC / UNF
1	1-1/2	1.5020	1.4500	0.887	0.831	–	0.513	UNC / UNF
1-1/8	1-11/16	1.688	1.631	0.999	0.939	0.657	0.636	UNC
1-1/4	1-7/8	1.875	1.812	1.094	1.030	0.719	0.698	UNC
1-3/8	2-1/16	2.062	1.994	1.206	1.138	0.793	0.771	–
1-1/2	2-1/4	2.250	2.175	1.317	1.245	0.865	0.843	UNC

Dimensions in inches. 1-1/8" and larger have a larger hex, so a max hex height is listed. Sizes without a stocked thread series are available on request – call or email for pricing.



GRADE C – ZINC PLATED & WAXED

2.0 Material & Mechanical Properties

Property	Grade 8 (C) Prevailing Torque Lock Nut
Material	Medium carbon steel, heat treated (quenched and tempered)
Specification	IFI-100/107 Grade C ASME B18.16.6 (all-metal prevailing torque hex nuts)
Proof load stress	150,000 psi (all sizes)
Hardness	1/4" – 5/8": Rockwell C24 to C32 Over 5/8" – 1": Rockwell C26 to C34 Over 1" – 1-1/2": Rockwell C26 to C36
Use with bolts of	Minimum tensile strength 105,000 to 150,000 psi (e.g. SAE J429 Grade 8 and Grade 5)
Locking element	All-metal – distorted (crimped) top threads
Thread class of fit	2B (UNC / UNF)

APPLICATION NOTES

- All-metal design: no nylon insert, so Stover nuts can be used where heat would damage a nylon insert lock nut – manufacturers rate them to about 450°F (232°C).
- Install with the crimped (cone) end facing away from the joint. The nut spins on freely by hand until it reaches the crimped threads, then must be wrenched to position.
- At least 2 full threads of the bolt should extend past the top of the nut so the locking threads are fully engaged.
- The locking threads hold the nut anywhere on the bolt, even before it is tightened, and resist loosening under vibration and shock loads.
- Prevailing torque drops with each reuse. For critical joints, replace the nut rather than reusing it.

3.0 Surface Finish Zinc Plated & Waxed

Properties	Zinc Plated & Waxed
Coating	Electro zinc plated
Lubricant	Wax – lowers installation torque and helps prevent galling on the locking threads
Color	Silver / clear

Disclaimer: The above is a compilation of data from various industry standards. The Nutty Company, Inc. has made every effort to present the data accurately. However, The Nutty Company, Inc. cannot be held liable for any claim traceable to any errors, typographical or otherwise, contained herein.



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