



PLANT STANDARD

HEEP—HARDWAR

HW 714 11 95

PAGE 1 OF 3

SIGN. & DATE

SUPERSEDES INVENTORY NO.

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STUDS WITH LOCKING HOLE, PRODUCT GR.B, COARSE PITCH, STEEL C 20 (M 42-M 48)

1.0 DESIGNATION :

A stud with locking hole, product Gr.B, coarse pitch made of steel C-20 of nominal diameter 42mm, length 'L' = 100 mm shall be designated as :

1.2 On Drawings :

- i) Material specification column - HW7141195
- ii) Description column - STUD WITH HOLE A M42 X 100 - C 20

1.2 On Indents :

Stud With Locking Hole A M42X100 - C 20; HW7141195

1.3 For issuing enquiries and on purchase orders : While issuing enquiries and purchase orders, enclosed a copy of this plant standard.

2. MATERIAL :

Studs shall be made from hot rolled carbon steel bars C-20 as per plant specification
NO. ~~HW 10191~~ AA 10109

3. COMPLIANCE WITH STANDARD :

3.1 This standard is based on BHEL experience.

3.2 Dimensions, Tolerances : Dimension, Tolerances, Sub-code numbers and weights shall be as per Table-1.
Sub-code & weights

3.3 Threads: : Pitch-coarse as per IS:4218 (Pt.2)
Tolerance quality - Medium.
Tolerance class - 6g.

3.4 Technical supply conditions : Technical supply conditions shall be as per Standard number IS:1367

3.5 Finish : Zinc Plated in accordance with IS:1367 (Pt.11) in bright finish with yellow iridescent colour (Design. L, table D.3) having minimum coating thickness 5 microns.

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				NAME	SIGN. & DATE
			DRAWN	LALIT KUMAR	<i>Lalit Kumar</i> 14.9.98
			WORKED	T.C.K.	<i>T.C.K.</i> 15-9-98
			CHECKED		
AGREED DEPTT	NAME	SIGN. & DATE	SUPERVISED		
REVISED BY	<i>Lalit Kumar</i>	19.04.2003	APPROVED	PLANT	PS
CHECKED BY	<i>P. S. S. S.</i>	19.4.2003	STANDARDIZATION COMMITTEE		3.10
Rev. 01			PREPARED	ISSUED STANDARDS DIVISION	DATE
19.04.2003			TSX		15-9-98



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4. NOTE :

- 4.1 BLANK DRAWING : For manufacturing in the plant refer blank Drawing No. HW 714 11 95 - BD-1.
- 4.2 Studs are to be manufactured with out the locking pin hole. Locking pin hole shall be drilled during assembly.
- 4.3 For screw threads general (Metric) refer AA 0231800.
- 4.4 For tolerance grade, position & class refer AA 0230201.
- 4.5 Weights given in table-1 are for general reference only & are not meant for commercial transactions.
- 4.6 When the fasteners are to be tested with in BHEL, the following sampling plan be followed as detailed below for physical properties :

LOT SIZE	SAMPLE SIZE	ACCEPTANCE NO
Upto 1000	5	0
1001 - 3000	8	0
3001 - 10000	13	0
10001 - 35000	20	0
Over 35000	32	1

4.7 CROSS REFERRED STANDARDS :

- 1) AA 10109
- 2) IS: 4218 (Pt. 2)
- 3) IS: 1367
- 4) AA 0231800
- 5) AA 0230201

Rev. 01

WORKED BY

TCK

15-9-98

CHECKED BY

ISI

15-9-98

INVENTORY NO.

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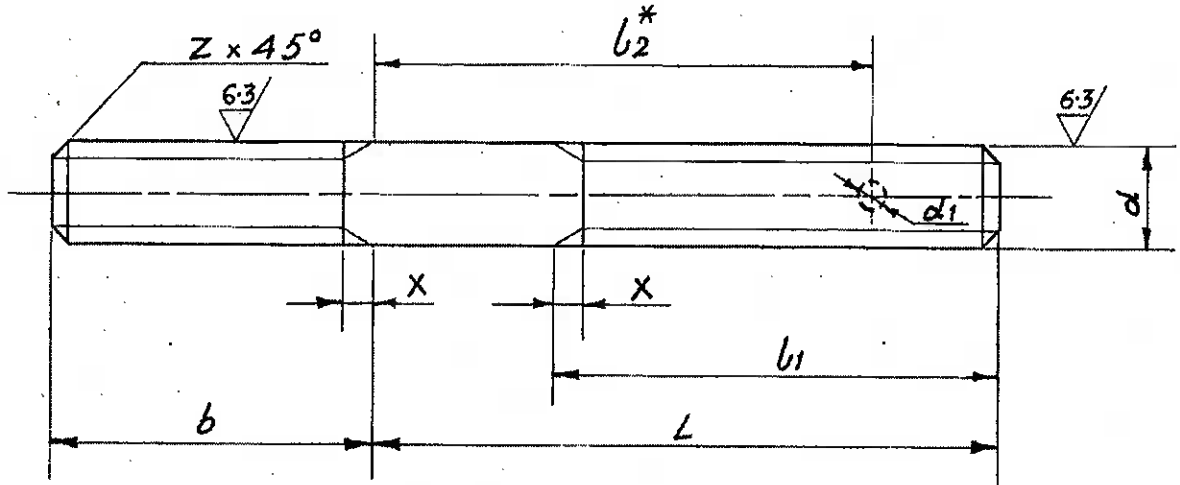
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REVISION
01

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THE REST



PLANT STANDARD
HEEP - HARDWAR

WORKED BY K.L.R.
CHECKED BY S.KUMAR
K.L.R. 11-5-82
S.KUMAR 6-10-82

TABLE -1

(ALL DIMENSIONS ARE IN MM)

d	THREADED LENGTH ON NUT END 'b'		THREADED LENGTH ON METAL END 'b'	d ₁	X	Z	SUB-CODE/ WEIGHT OF ONE PIECE IN KG./LENGTH 'L'	LENGTH 'L'													
	FOR LENGTH UP TO & INCLUDING 200MM	FOR LENGTH 'L' ABOVE 200MM						100	110	120	130	140	150	170	180	190	200	260	280		
M42	75	85	58	8	11	4.5	SUB-CODE	017		025			033								
							WEIGHT	1.532	1.634	1.743	1.851	1.960	2.069	2.286	-	2.504	-	3.258	-		
							*LENGTH 'L'	88	98	108	118	128	138	158	-	178	-	248	-		
M48	80	90	65	8	12	5.0	SUB-CODE				041										
							WEIGHT	2.076	2.209	2.351	2.493	-	-	3.061	3.203	-	3.487	-	4.614		
							*LENGTH 'L'	88	98	108	118	-	-	158	168	-	188	-	268		

* DIMENSION 'L' IS FOR REFERENCE ONLY AND MAY BE CHANGED AS AND WHEN REQUIRED.

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