

THE BRITISH MOTOR CORPORATION STANDARDS

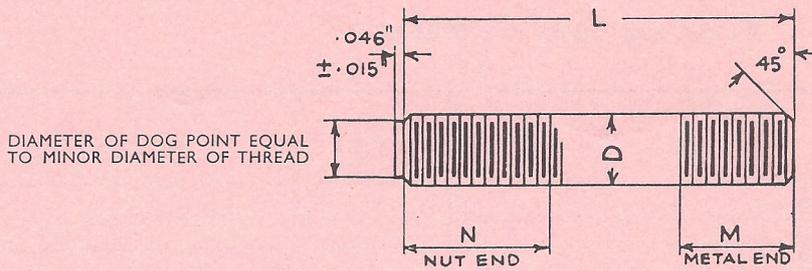
COMBINATION STUDS—55 TONS

CODE OF PART NUMBERS

LENGTH		FINISH See Note	$\frac{1}{4}$	$\frac{5}{16}$	$\frac{3}{8}$	$\frac{7}{16}$	$\frac{1}{2}$	$\frac{5}{8}$	$\frac{3}{4}$
TOL.	L								
$+\frac{1}{32}$ $-\frac{1}{32}$	1	PLAIN	CHS0408						
		ZINC	CHS2408						
	$1\frac{1}{8}$	PLAIN	CHS0409						
		ZINC	CHS2409						
	$1\frac{1}{4}$	PLAIN	CHS0410	CHS0510					
		ZINC	CHS2410	CHS2510					
	$1\frac{3}{8}$	PLAIN	CHS0411	CHS0511					
		ZINC	CHS2411	CHS2511					
	$1\frac{1}{2}$	PLAIN	CHS0412	CHS0512	CHS0612				
		ZINC	CHS2412	CHS2512	CHS2612				
	$1\frac{5}{8}$	PLAIN	CHS0413	CHS0513	CHS0613				
		ZINC	CHS2413	CHS2513	CHS2613				
	$1\frac{3}{4}$	PLAIN	CHS0414	CHS0514	CHS0614	CHS0714			
		ZINC	CHS2414	CHS2514	CHS2614	CHS2714			
	$1\frac{7}{8}$	PLAIN	CHS0415	CHS0515	CHS0615	CHS0715			
		ZINC	CHS2415	CHS2515	CHS2615	CHS2715			
	2	PLAIN	CHS0416	CHS0516	CHS0616	CHS0716	CHS0816		
		ZINC	CHS2416	CHS2516	CHS2616	CHS2716	CHS2816		
	$2\frac{1}{4}$	PLAIN	CHS0418	CHS0518	CHS0618	CHS0718	CHS0818		
		ZINC	CHS2418	CHS2518	CHS2618	CHS2718	CHS2818		
$2\frac{1}{2}$	PLAIN	CHS0420	CHS0520	CHS0620	CHS0720	CHS0820	CHS1020		
	ZINC	CHS2420	CHS2520	CHS2620	CHS2720	CHS2820	CHS3020		
$2\frac{3}{4}$	PLAIN	CHS0422	CHS0522	CHS0622	CHS0722	CHS0822	CHS1022		
	ZINC	CHS2422	CHS2522	CHS2622	CHS2722	CHS2822	CHS3022		
3	PLAIN	CHS0424	CHS0524	CHS0624	CHS0724	CHS0824	CHS1024	CHS1224	
	ZINC	CHS2424	CHS2524	CHS2624	CHS2724	CHS2824	CHS3024	CHS3224	
$3\frac{1}{4}$	PLAIN	CHS0426	CHS0526	CHS0626	CHS0726	CHS0826	CHS1026	CHS1226	
	ZINC	CHS2426	CHS2526	CHS2626	CHS2726	CHS2826	CHS3026	CHS3226	
$3\frac{1}{2}$	PLAIN	CHS0428	CHS0528	CHS0628	CHS0728	CHS0828	CHS1028	CHS1228	
	ZINC	CHS2428	CHS2528	CHS2628	CHS2728	CHS2828	CHS3028	CHS3228	
$3\frac{3}{4}$	PLAIN	CHS0430	CHS0530	CHS0630	CHS0730	CHS0830	CHS1030	CHS1230	
	ZINC	CHS2430	CHS2530	CHS2630	CHS2730	CHS2830	CHS3030	CHS3230	
4	PLAIN	CHS0432	CHS0532	CHS0632	CHS0732	CHS0832	CHS1032	CHS1232	
	ZINC	CHS2432	CHS2532	CHS2632	CHS2732	CHS2832	CHS3032	CHS3232	
$4\frac{1}{4}$	PLAIN		CHS0534	CHS0634	CHS0734	CHS0834	CHS1034	CHS1234	
	ZINC		CHS2534	CHS2634	CHS2734	CHS2834	CHS3034	CHS3234	
$4\frac{1}{2}$	PLAIN		CHS0536	CHS0636	CHS0736	CHS0836	CHS1036	CHS1236	
	ZINC		CHS2536	CHS2636	CHS2736	CHS2836	CHS3036	CHS3236	
$4\frac{3}{4}$	PLAIN			CHS0638	CHS0738	CHS0838	CHS1038	CHS1238	
	ZINC			CHS2638	CHS2738	CHS2838	CHS3038	CHS3238	
5	PLAIN			CHS0640	CHS0740	CHS0840	CHS1040	CHS1240	
	ZINC			CHS2640	CHS2740	CHS2840	CHS3040	CHS3240	
$5\frac{1}{4}$	PLAIN				CHS0742	CHS0842	CHS1042	CHS1242	
	ZINC				CHS2742	CHS2842	CHS3042	CHS3242	
$5\frac{1}{2}$	PLAIN				CHS0744	CHS0844	CHS1044	CHS1244	
	ZINC				CHS2744	CHS2844	CHS3044	CHS3244	
$5\frac{3}{4}$	PLAIN					CHS0846	CHS1046	CHS1246	
	ZINC					CHS2846	CHS3046	CHS3246	
6	PLAIN					CHS0848	CHS1048	CHS1248	
	ZINC					CHS2848	CHS3048	CHS3248	

Studs in plain finish to be treated with an agreed protective: zinc plating to B.S.1706/C.

COMBINATION STUDS—55 TONS



DIMENSIONAL DATA

D	NOMINAL DIA. OF PLAIN PORTION		$\frac{1}{4}$	$\frac{5}{16}$	$\frac{3}{8}$	$\frac{7}{16}$	$\frac{1}{2}$	$\frac{5}{8}$	$\frac{3}{4}$
	MINUS TOLERANCE		-.0035	-.0035	-.0035	-.004	-.004	-.006	-.006
L	MINIMUM STUD LENGTH		1	$1\frac{1}{4}$	$1\frac{1}{2}$	$1\frac{3}{4}$	2	$2\frac{1}{2}$	3
M	LENGTH OF THREAD INCLUDING THE RUN-OUT THREADS		$\frac{3}{8}$	$\frac{15}{32}$	$\frac{9}{16}$	$\frac{21}{32}$	$\frac{3}{4}$	$\frac{15}{16}$	$1\frac{1}{8}$
	THREADS PER INCH—UNC.		20	18	16	14	13	11	10
	MAJOR DIAMETER	max.	.2500	.3125	.3750	.4375	.5000	.6250	.7500
		min.	.2419	.3038	.3656	.4272	.4891	.6129	.7371
	EFFECTIVE DIAMETER	max.	.2201	.2793	.3375	.3945	.4537	.5700	.6893
		min.	.2172	.2762	.3343	.3911	.4500	.5660	.6850
MINOR DIAMETER	max.	.1913	.2472	.3014	.3533	.4093	.5175	.6316	
	min.	.1849	.2402	.2936	.3447	.4000	.5069	.6200	
N	LENGTH OF FULL THREAD		$\frac{1}{2}$	$\frac{5}{8}$	$\frac{3}{4}$	$\frac{7}{8}$	1	$1\frac{1}{4}$	$1\frac{1}{2}$
	THREADS PER INCH, UNF.—2A.		28	24	24	20	20	18	16

ALL DIMENSIONS ARE IN INCHES

1. MATERIAL. Studs shall be manufactured from steels which will furnish in the finished studs the properties covered by B.S. code symbol T (55 tons min. tensile).

2. DIMENSIONS. All studs shall conform to the dimensions and tolerances tabled hereon, which are in accord with B.S.2693: Part I.

3. SCREW THREADS.

M—Metal End. The screw threads shall be UNC. series of B.S.1580 machined oversize on effective diameter to the limits and tolerances shown in table above.

N—Nut End. The screw threads shall be UNF. to Class 2A tolerances specified in B.S.1580.

4. STRAIGHTNESS. Studs shall be straight within .003 in. per inch of length.

5. FITTING. The amount of oversize specified for the metal end of stud will produce a satisfactory fit in conjunction with standard tappings. For general requirements holes tapped Class 2B, or where a tighter fit is required Class 3B, should be suitable. Even when interference is not present, locking will take place on the thread run-out. Where it is considered essential that it be a true interference fit the tapping must be made special to ensure this, but the stud must be standard.

6. All studs shall be cleanly finished, sound, and free from defects.

7. Non-compliance with any factor given or indicated on this sheet shall be deemed sufficient cause for rejection.

FOR LENGTHS, FINISH AND CODE OF PART NUMBERS SEE OVERLEAF

These Standards were developed without considering whether patents may or may not be involved. In all cases, therefore, the supplier shall be required to assume patent liability.