

# COMPANY STANDARDS

CFS02

TITLE :

SLOTTED CHEESE HEAD SCREWS  
(PRECISION GRADE - COARSE PITCH)

PAGE NO.1 OF 5

DATE :

1999-05-10

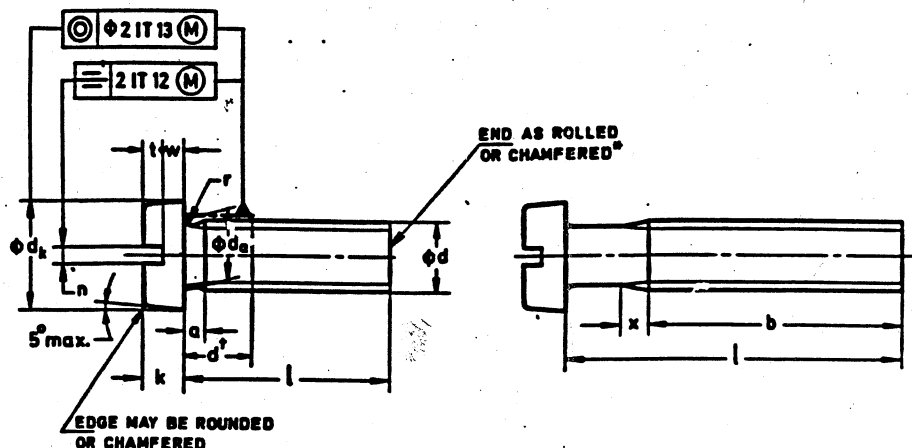


FIGURE-1

Shank diameter = Pitch diameter or = major thread diameter permissible.  
'a' and 'x' according to IS: 1369 - Dimensions for screw thread runouts and undercuts.

- \* Thread end when chamfered, shall be according to IS:1368.
- + The datum feature shall not be partly shank partly thread. If necessary, the datum features 'd' should be placed at sufficient distance (3 P max) from the head of the screw (to avoid thread runout).

TABLE-1 DIMENSIONS

Unit:mm

NOM. SIZE- d1		M3	M4	M5	M6	M8	M10
PITCH - P		0.5	0.7	0.8	1.0	1.25	1.50
b	Max. Min.	26 25	39.4 38	39.6 38	40 38	40.5 38	41.0 38.0
dk	Max. Min.	5.5 5.32	7 6.78	8.5 8.28	10 9.78	13 12.73	16.0 15.73
da	Max.	3.6	4.7	5.7	6.8	9.2	11.2
k	Max. Min.	2 1.86	2.6 2.46	3.3 3.12	3.9 3.6	5 4.7	6.0 5.7
n	Nom. Max. Min.	0.8 1 0.86	1.2 1.51 1.26	1.2 1.51 1.26	1.6 1.91 1.66	2 2.31 2.06	2.5 2.81 2.56
r	Min.	0.1	0.2	0.2	0.25	0.4	0.4
t	Min.	0.8	1.1	1.3	1.6	2	2.4
w	Min.	0.8	1.1	1.3	1.6	2	2.4

PREPARED BY :  
CST/FASTENERS COMMT.ISSUE No:  
1(ONE)

REPLACEMENT FOR:

REFERENCE:  
IS:1366

APPROVED BY :

G'

D(G)

D(P)

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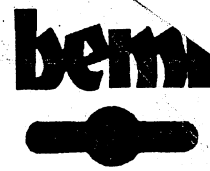
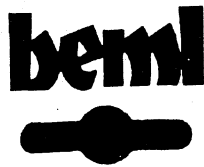


TABLE-2 MATERIAL

MATERIAL CODE	1
GRADE	4.8 of IS:1367 Part-III
MATERIAL	C1001/Fe410 of IS:2062
HARDNESS	130 to 170 BHN
SURFACE TREATMENT	ZINC PLATING & CHROMATE CONVERSION AS PER CO. STD PR1033-C.

TABLE-3 SIZE CODE

LENGTH l mm	M3	M4	M5	M6	M8	M10
6	0306					
8	0308	0408	0508	0608		
10	0310	0410	0510	0610		
12	0312	0412	0512	0612	0812	
14	0314	0414	0514	0614	0814	1014
16	0316	0416	0516	0616	0816	1016
20	0320	0420	0520	0620	0820	1020
25	0325	0425	0525	0625	0825	1025
30	0330	0430	0530	0630	0830	1030
35			0535	0635	0835	1035
40			0540	0640	0840	1040
45			0545	0645	0845	1045
50			0550	0650	0850	1050
55					0855	1055
60					0860	1060
65						1065
70						1070



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PAGE NO. 3 OF 5

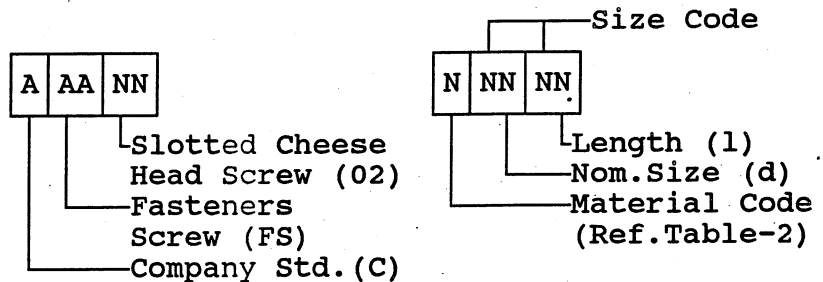
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TABLE-4

WEIGHT IN kg/1000 Nos. (APPROXIMATE)													
l mm	M3	M4	M5	M6	M8	M10	l mm	M3	M4	M5	M6	M8	M10
6	0.60	1.11	2.06				35			5.62	8.25	15.80	26.10
8	0.69	1.26	2.20	3.56			40			6.25	9.20	17.40	28.60
10	0.78	1.41	2.55	3.92	7.85		45			6.88	10.00	18.90	31.10
12	0.87	1.57	2.80	4.27	8.49	14.60	50			7.50	10.90	20.60	33.60
14	0.96	1.72	3.05	4.62	9.13	15.60	55					22.10	36.10
16	1.04	1.88	3.30	4.98	9.77	16.60	60					23.90	38.60
20	1.22	2.19	3.78	5.69	11.00	18.60	65						41.30
25	1.44	2.58	4.40	6.56	12.60	21.10	70						44.00
30	1.66	2.96	5.02	7.45	14.20	23.60							

## 1. DESIGNATION :

Part no. and description shall be as shown below.  
The first five digit appear on the document.



## EXAMPLE :

Slotted Cheese Head Screw of Nominal size M5 length 16 mm and Material code-1, the part no. shall be CFS0210516.

## 2. DIMENSIONS :

Dimensions shall be in accordance with table-1 and figure-1. The screw shall have Coarse pitch. The preferred length diameter combination for the screws are given in Table-3 (Size code).

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## 3. MECHANICAL PROPERTIES :

The Material & Mechanical properties shall conform to Table-2. Test Methods in general conform to IS:1367 - Part III "Technical Supply condition for threaded fasteners".

4. Inspection and acceptance criteria for supply of slotted cheese head screws shall be as per company standard QS1001-C.

## 5. SURFACE TREATMENT :

The surface treatment shall be zinc plating of coating thickness 8-12 micrometers (microns) and chromate conversion treatment with irredesent Yellow/Bronze colour. For Zinc plating company standard PR1033-C / IS:1573 may be referred.

6. The thread tolerance shall be 6g before coating and 6h after coating as per IS: 4218 Part-5. The thread, after coating, shall not transgress the Maximum Material limit for tolerance specified.

7. For technical requirements inclusive of dimensional and tolerances not covered in the specification, relevant parts of IS:1364 latest issuance may be refferred.

## 8. PACKAGING :

All sizes of slotted cheese head screws of quantities as mentioned in Table-1 shall be packed in polyethylene covers to protect them from entry of dust and water. The covers shall in turn be packed in cartons or crates depending on the mass as given in Table-4.

The mass of a single pack shall not exceed the following:

	Mass in kg
Paper or plastic bag	5
Plastic box or carton	10
Plastic or metal carton/crate	40
Wooden crate or box	50

Other requirements regarding packing shall conform to IS:1367 Part-18.



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Only one size of slotted Cheese head screws shall be packed in each bag.

The boxes/carton containing slotted Cheese head screws shall be marked with manufacturer's name or trade mark (if any), part No., quantity and gross weight of the carton/box.

A label or tag shall be placed on the package in such a way that the package can be identified easily during transport & storage and it shall be fixed on the package as is customary and shall not be easily removable.

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