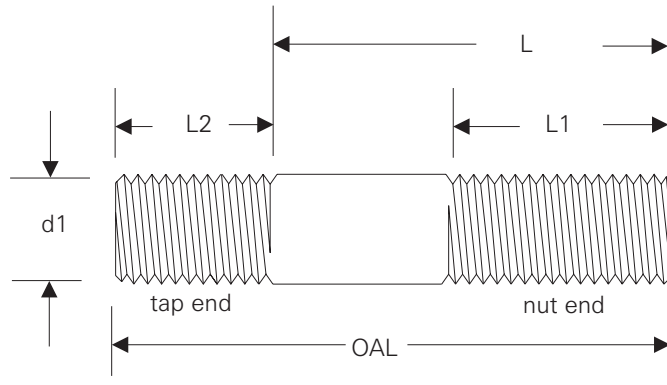


MARYLAND METRICS

METRIC STUD EXPLANATIONS



Maryland Metrics also offers custom manufactured studs. Please Inquire for a quotation.

NOTE: Metric double end studs are NOT called out by their overall length.

To calculate the overall length of a metric double end stud, add the tap end thread length (L2) to the called out length [nut thread end length (L1) + the unthreaded portion]. $OAL = L2 + L$

Some general guidelines for calculating the length of L2 are:

$d1$ (nominal diameter in mm) x multiplier. Example: for a DIN 939 stud where $d1 = M12$ ($M12 \times 1.75$, but the pitch is not used the length calculation) x (DIN 939 multiplier) 1.25 = (L2) 15 mm

Some general guidelines for calculating the length of L1 are:

Studs whose (L) dimension is less than or equal to 2 times their nominal diameter + 6 mm, will normally be fully threaded.

For studs whose (L) dimension is greater than or equal to 2 times their nominal diameter + 6 mm, but not longer than 125 mm, the L1 dimension = 2 times the nominal diameter + 6 mm.

For studs whose (L) dimension is greater than or equal to 125 mm but less than 200 mm, the L1 dimension = 2 times the nominal diameter + 12 mm.

For studs whose (L) dimension is greater than or equal to 200 mm, the L1 dimension = 2 times the nominal diameter + 25 mm.

The tap end thread of a double end stud is normally to an Sk6 thread tolerance which is an interference fit. Please specify whether you want normal fit or interference fit. To specify a stud with normal thread fit on the tap end, add the suffix FO (example: DIN 939FO).

A few national and international standards for studs and other types of screws which may be used as alternatives for studs.

Slotted set screws - flat point				Fully threaded studs		
DIN	ISO	NEN	NF	DIN	NEN	NF
551	4766	1487	E25-163	976	2369	E25-136
Fully threaded studs		Double end studs		Double end studs		
BS	ASTM	DIN	UNI	DIN	NEN	NF
4882	Gr B7	835	5916	939	2332	E25-135
Double end studs - construction style		Double end studs - workholding style		Double end studs		
DIN		DIN		DIN	NEN	NF
2510		6379		938	2331	E25-135
Socket set screws - flat point						
DIN	ISO	NEN	ANSI	BS		
913	4026	2341	B18.3.6M	4168-2		

DIN = German industrial standard
 ISO = International standard
 BS = British standard
 ANSI = American national standard
 NEN = Netherlands standard

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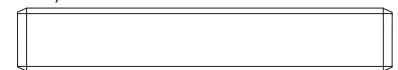
Notice: we are not responsible for typographical errors.

DIN	multiplier
939	1.25
938	1.0
940	2.5
835	2.0
UNI	multiplier
5911	1.5
5913	1.5 c x f*

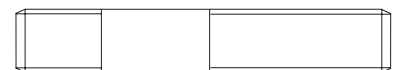
*c x f = coarse on tap end and fine thread on nut end

NOTE: Metric fully threaded studs, slotted set screws and socket set screws are called out by their overall length.

Fully threaded stud



Double end stud



Double equal end stud



Double end stud - construction style



Slotted set screw



Socket set screw

