



PLANT STANDARD

HPBP TIRUCHIRAPALLI

BPS: 41704

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Based on IS: 549-1974

SPLIT PINS

1.0 SCOPE

Covers the requirements for Split Pins in the diameter range 0.6 to 20mm.

2.0 SPECIFICATION AND REFERENCE STANDARDS

Dimensions and tolerances	Table 1 of this standard	
Preferred length and size combination	Table 2 of this standard	
Material	Mild Steel Wire (Half round)	
Finish	Bright self colour finish	
Sampling and Acceptability	Indian Standard	IS: 6821
General requirements	Pins shall comply with IS: 549 in respect of requirements not covered in this standard	

2.1 Referred Standards (Only the current versions are applicable)

IS: 549 Specification for Split Pins.

IS: 6821 Methods for sampling non-threaded fasteners

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REVISIONS

DATE

APPROVED

STANDARDS SECTION
ENGINEERING AND DEVELOPMENT CENTRE
HPBP TIRUCHIRAPALLI

PREPARED

HPBP TIRUCHY

ISSUED

STANDARDS
ENGG

DATE

DEC 1986

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3.0 DESIGNATION

A Split Pin to this standard of nominal diameter 5mm and nominal length 56mm shall be designated as:

3.1 On Drawings:

- i) Material Specification column: IS: 549
- ii) Description column : PIN SPLIT 5x56
- iii) Drawing Number column : 4170405056
- iv) Material Code column : 4170450056

3.2 Ordering Description

For placing indents, issuing enquiries and on purchase order, the Ordering Description given below shall be followed.

Split Pin 5x56 IS: 549

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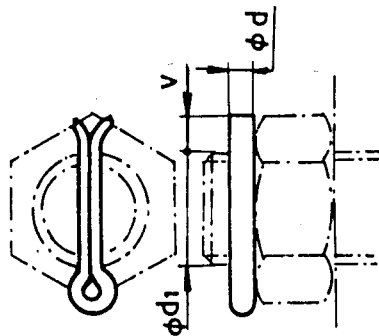
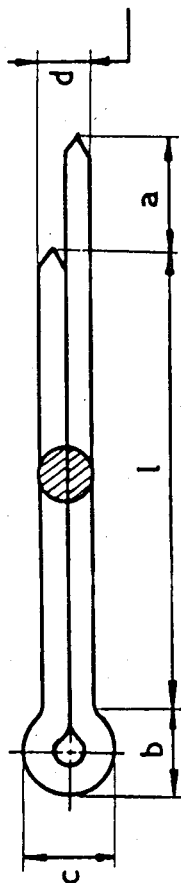
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TABLE 1 - DIMENSIONS FOR SPLIT PINS
(All dimensions in millimetres)



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Dimensions	Nominal size															
	0.6	0.8	1.0	1.2	1.6	2.0	2.5	3.2	4.0	5.0	6.3	8.0	10	13	16	20
d	Max	0.5	0.7	0.9	1.0	1.4	1.8	2.3	2.9	3.7	4.6	5.9	7.5	9.5	12.4	15.4
	Min	0.4	0.6	0.8	0.9	1.3	1.7	2.1	2.7	3.5	4.4	5.7	7.3	9.3	12.1	15.1
a	Max	1.6	1.6	1.6	2.5	2.5	2.5	3.2	4.0	4.0	4.0	4.0	4.0	6.3	6.3	6.3
	≈	2.0	2.4	3.0	3.0	3.2	4.0	5.0	6.4	8.0	10	12.6	16	26	32	40
c	Max	1.0	1.4	1.8	2.0	2.8	3.6	4.6	5.8	7.4	9.2	11.8	15	19	24.8	30.8
	Min	0.9	1.2	1.6	1.7	2.4	3.2	4.0	5.1	6.5	8.0	10.3	13.1	16.6	21.7	27.0
Corres-ponding dia-meter d ₁	Over	--	2.5	3.5	4.5	5.5	7.0	9.0	11	14	20	27	39	56	80	120
	Up to	2.5	3.5	4.5	5.5	7.0	9.0	11	14	20	27	39	56	80	120	170
v	Over	--	2	3	4	5	6	8	9	12	17	23	29	44	69	110
	Up to	2	3	4	5	6	8	9	12	17	23	29	44	69	110	160
		3	3	4	5	5	6	6	8	8	10	12	14	16	25	32



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TABLE 2 - PREFERRED LENGTH-SIZE COMBINATION
FOR SPLIT PINS

(All dimensions in millimetres)

1 Nom +1/2 IT 17	Nominal size															
	0.6	0.8	1.0	1.2	1.6	2.0	2.5	3.2	4.0	5.0	6.3	8.0	10	13	16	20
4																
5																
6																
8																
10																
12																
14						0.4										
16																
18																
20																
22									2.7							
25																
28										5.5						
32									3.6							
36										6.5						
40									4.6		11.6					
45																
50									5.6	8.4	13.4					
56										9.2						
63											17.2					
71																
80																
90																
100																
112																
125																
140																
160																
180																
200																
224																
250																
280																

NOTE:

- Weights are given in kg per 1000 numbers only
- For stocked sizes refer BPS components booklet
- Preferred lengths are in between the stepped bold lines

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