

## Sea Fastening Manual Zahyhzs

Fastener Design ManualFastener Design ManualStandard Handbook of Fastening and JoiningHilti Fastening ManualIPT's Industrial Fasteners Handbook Training ManualIndustrial Fastener Reference ManualFastening Systems Richard T. Barrett Richard T. Barrett Robert O. Parmley Hilti AG. Bruce M. Basaraba Fastener Design Manual Fastener Design Manual Standard Handbook of Fastening and Joining Hilti Fastening Manual IPT's Industrial Fasteners Handbook Training Manual Industrial Fastener Reference Manual Fastening Systems *Richard T. Barrett Richard T. Barrett Robert O. Parmley Hilti AG. Bruce M. Basaraba*

this manual was written for design engineers to enable them to choose appropriate fasteners for their designs subject matter includes fastener material selection platings lubricants corrosion locking methods washers inserts thread types and classes fatigue loading and fastener torque a section on design criteria covers the derivation of torque formulas loads on a fastener group combining simultaneous shear and tension loads pullout load for tapped holes grip length head styles and fastener strengths the second half of this manual presents general guidelines and selection criteria for rivets and lockbolts to the casual observer the selection of bolts nuts and rivets for a design should be a simple task in reality it is a difficult task requiring careful consideration of temperature corrosion vibration fatigue initial preload and many other factors the intent of this manual is to present enough data on bolt and rivet materials finishes torques and thread lubricants to enable a designer to make a sensible selection for a particular design lockouts washers locking methods inserts rivets and tapped holes are also covered bolts can be made from many materials but most bolts are made of carbon steel alloy steel or stainless steel stainless steels include both iron and nickel based chromium alloys titanium and aluminum bolts have limited usage primarily in the aerospace industry carbon steel is the cheapest and most common bolt material most hardware stores sell carbon steel bolts which are usually zinc plated to resist corrosion the typical ultimate strength of this bolt material is 55 ksi an alloy steel is a high strength carbon steel that can be heat treated up to 300 ksi however it is not corrosion resistant and must therefore have some type of coating to protect it from corrosion aerospace alloy steel fasteners are usually cadmium plated for corrosion protection bolts of stainless

steel cres are available in a variety of alloys with ultimate strengths from 70 to 220 ksi the major advantage of using cres is that it normally requires no protective coating and has a wider service temperature range than plain carbon or alloy steels a partial listing of bolt materials is given in table 1 the following precautions are to be noted 1 the bolt plating material is usually the limiting factor on maximum service temperature 2 carbon steel and alloy steel are unsatisfactory become brittle at temperatures below 65 f 3 hydrogen embrittlement is a problem with most common methods of plating unless special procedures are used this subject is covered more fully in the corrosion section 4 series 400 cres contains only 12 percent chromium and thus will corrode in some environments 5 the contact of dissimilar materials can create galvanic corrosion which can become a major problem galvanic corrosion is covered in a subsequent section of this manual platings and coatings most plating processes are electrolytic and generate hydro gen thus most plating processes require baking after plating at a temperature well below the decomposition temperature of the plating material to prevent hydrogen ernhrittlernent however heating the plating to its decomposition temperature can generate free hydrogen again thus exceeding the safe operating temperature of the plating can cause premature fastener failure due to hydrogen embrittlement as well as loss of corrosion protection a summary of platings and coatings is given in table ii cadmium plating the most common aerospace fastener plating material is cadmium plating is done by electrodeposition and is easy to accomplish however cadmium plated parts must be baked at 375 f for 23 hours within 2 hours after plating to prevent hydrogen embrittlement since cadmium melts at 600 f its useful service temperature limit is 450 f

threaded fasteners standard pins pipe fastening expansion welding concrete fastening lumber and timber connections structural steel connections electrical connections adhesive bonding industrial riveting aerospace fastening wire rope injected metal fastening sheet metal assembly retaining compounds rope splicing and tying metrics general data

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