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GOST 6402-70 SPRING WASHERS

Construction and sizes.

This standard applies to lock (spring) washers for bolts, screws and studs with the diameter of a thread from 2 to 48 mm.

1.1. Spring washers should be made of 4 types:

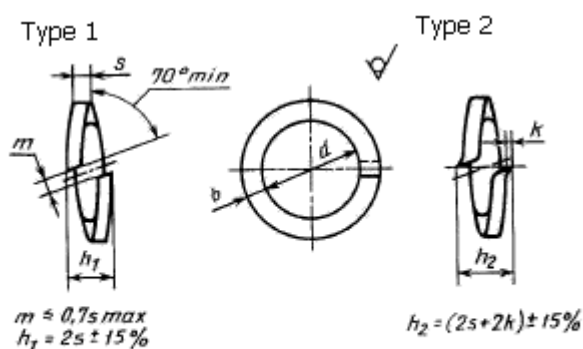
N-normal with a square cross section;

T-heavy with a square cross section;

OT-extra heavy with a square cross section;

L- light with a rectangular cross section.

1.2. Construction and main sizes of washers should be as specified in the drawing 1 and in the table.



Drawing 1

2. TECHNICAL REQUIREMENTS

2.1 Spring washers should be made of wire according to all-Union State Standard 11850-72 or another normative and technical documentation made of steel 65G, 70 and 3H13.

It's acceptable to make spring washers of bronze BrKMtsZ according to all-Union State Standard 18175-78 or other non-ferrous alloys.

(Redraft, Alteration №3)

2.2 Mass of steel washers and calculated elastic force from steel 65G are in the informative annex.

2.3 Steel spring washers should have hardness 41,5 - 49,5 HRC₃ (HRC 40-48), bronze ones at least 90 HRB. It's acceptable to increase hardness up to 51,5 HRC₃ (HRC 50) for washers made of steel 70.

2.4 There should be no scales, burrs, flaws and corrosion on washer face. Track of inseparable scale is not a discarded sign.

Defects which don't influence on washers' operational characteristics and don't output dimensions for maximum deviation are acceptable.

2.3, 2.4 (Redraft, Alteration №3)

2.5 Washer's end should have flat surface; shearing of metal, which don't output dimensions m for maximum deviation, is not a discarded sign.

Edge formed by shear plane and washer supporting surface must be sharp.

2.6 Trapezoidal washer section within height s is not a discarded sign.

For the actual thickness is taken maximum size of height s .

2.7 (Excluded, Alteration №3)

2.8 Washers should be made with covering or without it. Type of covering, their conventions and thickness - according to all-Union State Standard 1759.0-87. It's acceptable to use other types of covering - according to all-Union State Standard 9.306-85.

(Redraft, Alteration №3)

2.8a Technical requirements for covering according to all-Union State Standard 9.301-86.

(Extra added, Alteration №3)

2.9 Washers with metal layer applied by method of cathodic reduction should be dehydrogenated.

2.10 Height of washer's end $h1$ and $h2$ separation after a three-fold compression up to two-dimensional state and holding in this condition during 24 hours should be at least 1,65 from washer's actual thickness.

2.9, 2.10 (Redraft, Alteration №3)

2.11 Washers shouldn't break and have flaws in bending of ends 45°.

2.12 (Excluded, Alteration №3)