

Indian Standard

SPECIFICATION FOR USE IN FOUNDRIES

1. SCOPE

1.1 This standard covers the requirements for chaplets for use in foundries.

2. SUPPLY OF MATERIAL

2.1 General requirements relating to the supply of chaplets, shall be as laid down in IS: 1387-1967.

3. MATERIAL

3.1 Stamped Chaplets, the supporting heads of assembled chaplets and also rectangular columns shall be made of low carbon cold rolled steel strips corresponding to grade 'O' of IS: 531 - 1963*.

3.2 Chaplets with round column of diameter up to 12.5 mm shall be manufactured from soft steel wire conforming to IS: 280 - 1962; and those of diameter above 12.5 mm from hot rolled round bars conforming to IS: 226 - 1969.

4. SHAPES AND SIZES

4.1 The shapes and sizes of chaplets shall be as given in Tables 1 to 16.

4.1.1 Chaplets of dimensions other than those specified in Tables 1 to 16 may be supplied by agreement between the purchaser and the manufacturer.

4.1.2 For special applications, tolerances closer than those specified in the tables may be agreed to between the purchaser and the manufacturer.

5. DESIGNATION

5.1 The chaplets shall be designated by the word 'Chaplet' followed by type, variant and major dimension in the same order with a dash between each number and further followed by number of this standard.

Example:

Stem chaplet, type5, variant 6 with a height 125 mm will be designated as; Chaplet V-6-125, IS: 5904

* *Specification for cold-rolled carbon steel sheets (revised).
Specification for mild steel wire for general engineering purposes (revised).
Specification for structural steel (standard quality) (fourth revision).*