

12.0 MACHINING OF THE ENDS

12.0 MACHINING OF THE THREADED STUD ENDS

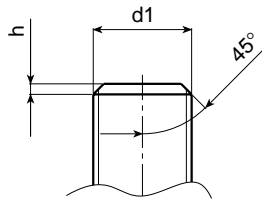
We use different types of threaded studs in our products, which differ according to the type of threading end. The two standard ends we use are type A and type Z. Due to productive requirements the type of end used is not specified on the pages of the catalogue. Consequently, if you require a chamfered thread please specify this fact when placing the order. On request and for reasonable quantities, Jencan can supply threaded stud ends which are different to the standard supply.

To make your choice easier the most commonly used types are given below. When placing an order please specify the letter which identifies the type of end you require and the measurements needed for its execution.

TYPE A • NORMAL 45° BEVEL

The standard bevel is a 45° angle. The bevels are as indicated in the table below:

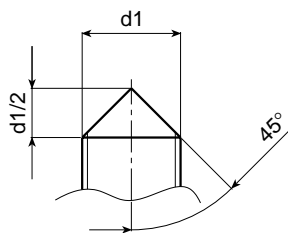
Threading d1	Bevel
M5	0,8x45°
M6	1x45°
M8	1x45°
M10	1,5x45°
M12	1,5x45°
M14	1,8x45°
M16	1,8x45°
M18	2,3x45°
M20	2,3x45°



For reasonable quantities custom bevels may be provided.

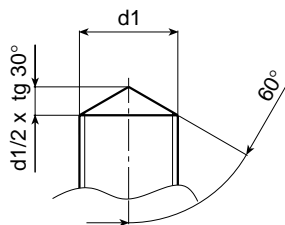
TYPE B • 45° POINTED CONE

The 45° pointed cone end starts from the diameter of the thread and ends in a point. The length of the pointed cone is equal to half the diameter.



TYPE C • 60° POINTED CONE

The 60° pointed cone end starts from the diameter of the thread and ends in a point. The length of the pointed cone is equal to half threaded diameter multiplied by the Tangent of 30° ($d1/2 \times \text{tg}30^\circ$). For reasonable quantities the pointed cone may be customised.



TYPE D • ROUNDED CONE

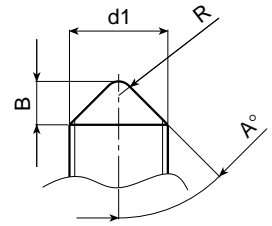
The rounded cone end is like the normal pointed cone end. The difference is that instead of ending with a point, it is

rounded. When placing an order please specify the following measurements:

R = Radius

A = Cone Angle

B = Distance of the Radius from the start of the cone



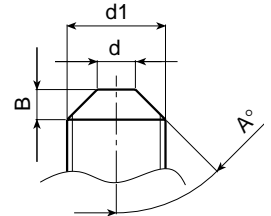
TYPE E • CYLINDER-CONE

The cylinder-cone end is similar to the normal pointed cone. The difference is that it ends with a flat top. When placing an order please specify the following measurements:

A = Cone Angle

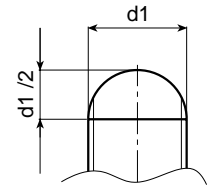
d = Diameter of the Base

B = Distance of the Base from the Cone



TYPE F • BALL

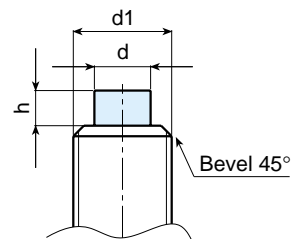
The ball end ends with ball sphere having a diameter equal to the diameter of the thread. The length of the ball is half the diameter.



TYPE G • PLASTIC FASTENING CAP

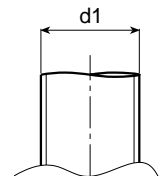
The cap is a plastic cylinder which is pushed into a hole made in the end of the stud. The cap is used if the part to be locked needs to be protected from scratching. The stud is supplied with the cap already assembled. The diameters and the projection of the cap are given in the table below:

Threading d1	dxh
M5	3x2
M6	3x2
M8	5x3
M10	6x3
M12	6x3
M14	8x4
M16	8x4
M18	10x5
M20	10x5



TYPE Z • MOULDED END

This type of end is found on all cold formed studs. It is not bevelled and its surface is not even.



Jencan has the facilities and equipment (which includes multi axis CNC lathes), to produce customised studs and other types of inserts.

For further information contact our sales office; for technical advice on the manufacturability of an article contact our technical department.