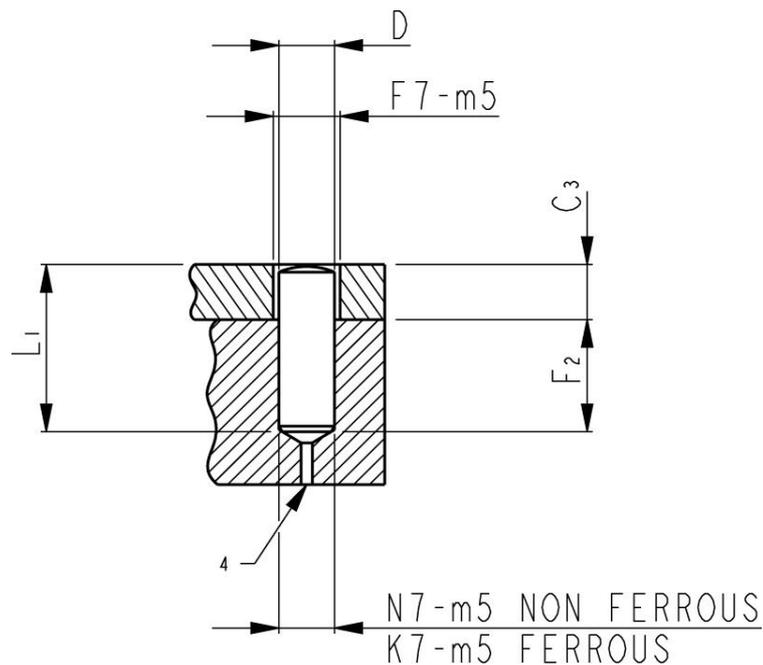


## Dowel Fitting



Dowels to BS.1804 grade 1 (cam 2J150)		Interference Fit				Clearance fit (In one side)		Pilot Hole	
		Non Ferrous		Ferrous		Hole F7	Extremes of fit	Dia	H11
Nom.dia. D	Dowel M5	Hole N7	Extremes of fit	Hole K7	Extremes of fit	Hole F7	Extremes of fit	Dia	H11
2	+6	-4	-20	+0	-16	+16	+0	1.8	+100
3	+2	-14	-6	-10	-2	+6	+14	2.8	-0
4	+9	-4	-25	+3	-18	+22	+1	3.8	+120
5	+4	-16	-8	-9	-1	+10	+18	4.7	+0
6								5.7	

1. Dowel length (L) is recommended to be 4 times the dowel diameter (D)
2. Depth of fixed portion (F) is recommended to be 1.5 to 2 times the dowel diameter
3. Depth of free portion (C) is recommended to be 1 to 2 times the dowel diameter
4. Dowel pins having an interference fit in blind holes must have provision for the release of air. This can be either a small vent hole of diameter 1mm, or a small flat can be ground on the dowel prior to insertion.
5. Not more than two dowels are to be used to hold or locate two parts together
6. The fits given are suitable for use up to 100°C, provided the coefficient of thermal expansion for the non-ferrous material does not exceed  $26 \times 10^{-6}$

