

prevent the proper installation and fit of the plates shall be ground smooth or otherwise removed.

5.1.2 Shear plates shall be permanently marked with the manufacturer's name or a readily recognizable logo, or both; the number of this ASTM standard; the country of origin; and the model number, if applicable. Such marking may be on any nonbearing surface and shall be recessed into the device so as not to interfere with installation or weaken the finished shear plate.

5.1.3 Shear plates shall have two diametrically opposed holes which can be used to nail-attach the plate in the piece of wood in which it is installed to facilitate shipping and handling without dislodging of the plate. See Fig. 1, Fig. 2, and Fig. 3.

5.1.4 Casting draft on the rim and on the hub, if present, of cast iron shear plates shall be minimal and as shown to facilitate removal from the mold without diminishing strength or creating a poor fit into cutterhead grooves (see Fig. 2 and Fig. 3).

5.1.5 Central bolt or lag screw holes shall be of the diameter shown and have uniformly straight sides to promote full bearing (see Fig. 1, Fig. 2 , and Fig. 3).

5.1.6 Shear plates may be furnished with or without galvanization depending on the exposure of the installed device. Galvanization shall conform to Specification **A653/A653M** or Specification **A924/A924M** for stamped steel shear plates or Specification **A153/A153M** for cast iron shear plates.

5.1.7 Since slight variations in some dimensions are permitted, each shear plate manufacturer shall have available the

special groove cutting tools necessary to properly install the standard shear plates of his manufacture.

5.1.8 Overall fit and finish shall be uniform.

5.2 2⁵/₈-in. Diameter Stamped Steel Shear Plates:

5.2.1 Shear plates shall be stamped from Specification **A570/A570M** or AISI/SAE No. 1010 carbon steel.

5.2.2 The geometry and dimensions of the finished shear plate shall be as shown in Fig. 1.

5.3 2⁵/₈-in. Diameter Cast Iron Shear Plates:

5.3.1 Shear plates shall be cast from Specification **A47/A47M**, Grade 32510 malleable iron.

5.3.2 The geometry and dimensions of the finished shear plate prior to application of any protective coating shall be as shown in Fig. 2.

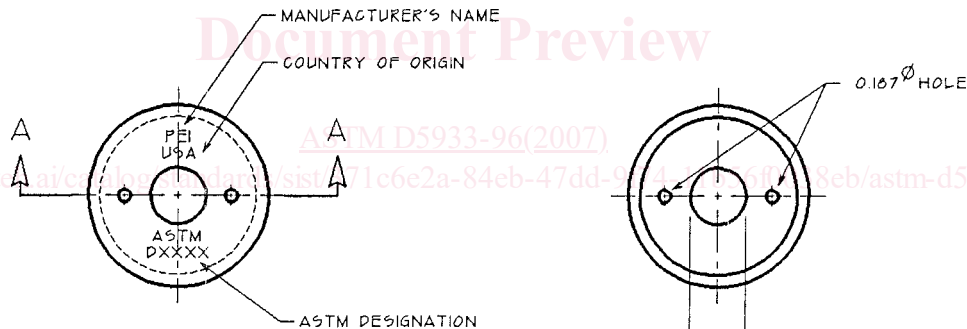
5.4 4-in. Diameter Cast Iron Shear Plates:

5.4.1 Shear plates shall be cast from Specification **A47/A47M**, Grade 32510 malleable iron.

5.4.2 The geometry and dimensions of the finished shear plate prior to application of any protective coating shall be as shown in Fig. 3.

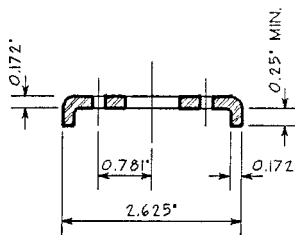
5.4.2.1 Nail attachment holes shall have nail head recesses 0.05 in. (1.3 mm) deep as shown in Fig. 3.

5.4.2.2 Additional lightening holes may be provided as shown in Fig. 3.



TOP VIEW

BOTTOM VIEW



SECTION A-A

NOTE 1—Make from Specification **A570/A570M** or AISI/SAE No. 1010 carbon steel. Tolerance on all dimensions except sheet steel thickness: ± 0.020 in. Tolerance on sheet steel thickness per manufacturing specifications.

FIG. 1 2⁵/₈-in. Diameter Stamped Steel Shear Plate