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AUTOMOBILE INDUSTRY STANDARD
OF THE PEOPLE'S REPUBLIC OF CHINA

ICS 43.040

CCS T 33

QC/T 870-2022

Replacing QC/T 870-2011

Double end studs $b_m = 1.25d$

双头螺柱 $b_m = 1.25d$

Issued on: April 08, 2022

Implemented on: October 01, 2022

Issued by: Ministry of Industry and Information Technology of PRC

Annex:

Number, standard name and implementation dates of 45 automotive industry standards

No.	Standard No.	Standard name	Replaced standard No.	Date of implementation
177	QC/T 1157-2022	Method of calculating comprehensive energy consumption for unit output of automobile products		2022-10-01
178	QC/T 1158-2022	Method of calculating comprehensive water consumption for unit output of automobile products		2022-10-01
179	QC/T 1159-2022	Guidelines on evaluation of automobile industry green supply chain management		2022-10-01
180	QC/T 1160-2022	Guidelines on evaluation of whole vehicle manufacturing green factory in automobile industry		2022-10-01
181	QC/T 1161-2022	Technical specifications for green-design product assessment - Automobile		2022-10-01
182	QC/T 1162-2022	Honeycomb sandwich structure product for automobile exterior decoration parts		2022-10-01
183	QC/T 1163-2022	Automotive diesel engines - Reduction agent filter for selective catalytic reduction (SCR) system		2022-10-01
184	QC/T 1164-2022	Natural gas filter for road vehicle		2022-10-01
185	QC/T 1165-2022	Carbon canister air filter for gasoline passenger car		2022-10-01
186	QC/T 1166-2022	Streaming mirror view mirror for vehicle		2022-10-01
187	QC/T 1167-2022	Service brake dynamometer squeal noise test methods for passenger cars		2022-10-01
188	QC/T 1168-2022	Performance requirements and bench test methods for vehicle electric air compressor		2022-10-01
189	QC/T 463-2022	Technical requirements and bench test methods for automotive hydrodynamic torque converter assembly	QC/T 29033-1991 QC/T 557-1999 QC/T463-1999	2022-10-01
190	QC/T 792-2022	Motors and controllers for electric motorcycles and electric mopeds	QC/T 792-2007	2022-10-01
191	QC/T 1169-2022	Liquid crystal instrument for automobile		2022-10-01
192	QC/T 1170-2022	Performance film for automotive glass		2022-10-01
193	QC/T 1171-2022	Automotive paint protection film		2022-10-01
194	QC/T 804-2022	Instrument panel assembly and Console assembly for passenger cars	QC/T 804-2014	2022-10-01
195	QC/T 1016-2022	Door trim panel assembly for passenger cars	QC/T 1016-2015	2022-10-01
196	QC/T 768-2022	Toilet of passenger car	QC/T 768-2006	2022-10-01
197	QC/T 580-2022	Mounting dimensions of automobile transmission assembly	QC/T 580-1999	2022-10-01
198	QC/T 1172-2022	Performance requirements and test methods of exhaust muffler for vehicles air brake equipment		2022-10-01
199	QC/T 237-2022	Bench test methods for the performance of automobile parking brake	QC/T 237-1997	2022-10-01

No.	Standard No.	Standard name	Replaced standard No.	Date of implementation
200	QC/T 1173-2022	Road vehicles - Spark-plugs application test methods		2022-10-01
201	QC/T 1174-2022	High voltage fuse of electric vehicles		2022-10-01
202	QC/T 1175-2022	High voltage contactor for electric vehicles		2022-10-01
203	QC/T 1176-2022	Evaporator for automotive air conditioning		2022-10-01
204	QC/T 1177-2022	Condenser for automotive air conditioning		2022-10-01
205	QC/T 633-2022	The seats of passenger vehicles	QC/T 633-2009	2022-10-01
206	QC/T 80-2022	Road vehicles - Polyamide (PA) tubing for air braking systems	QC/T 80-2011	2022-10-01
207	QC/T 1178-2022	Motor vehicle and towed vehicle Pneumatic braking system - Tapped and male fitting		2022-10-01
208	QC/T 1179-2022	Specification for wheel bolts of automobile		2022-10-01
209	QC/T 869-2022	Short-cycle drawn arc welding stud	QC/T 869-2011	2022-10-01
210	QC/T 870-2022	Double end studs $b_m = 1.25d$	QC/T 870-2011	2022-10-01
211	QC/T 871-2022	Double end studs $b_m = 2d$	QC/T 871-2011	2022-10-01
212	QC/T 598-2022	Bolt-for projection welding on the bearing face	QC/T 598-1999	2022-10-01
213	QC/T 599-2022	Overhead projection weld bolts	QC/T 599-2013	2022-10-01
214	QC/T 624-2022	Rubber plugs	QC/T 624-2013	2022-10-01
215	QC/T 603-2022	Clips - Type A	QC/T 603-1999	2022-10-01
216	QC/T 604-2022	Clips - Type B	QC/T 604-1999	2022-10-01
217	QC/T 605-2022	Clips - Type C	QC/T 605-1999	2022-10-01
218	QC/T 606-2022	Clips - Type H	QC/T 606-1999	2022-10-01
219	QC/T 618-2022	Specification for plastic expansion nut	QC/T 618-2013	2022-10-01
220	QC/T 928-2022	Plastic cable and tubing clips with inter-fix hole	QC/T 928-2013	2022-10-01
221	QC/T 929-2022	Plastic cable and tubing clips with side-fix hole	QC/T 929-2013	2022-10-01

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Foreword

This document was in accordance with the requirements of GB/T 1.1-2020 "Directives for standardization - Part 1: Rules for the structure and drafting of standardizing documents".

This document replaces QC/T 870-2011 "Double end studs $b_m = 1.25d$ ". Compared with QC/T 870-2011, except for editorial modifications, the main changes are as follows:

- CHANGE the limit deviation of "l" in the dimension from "jsl7" to "js15" (see Table 2);
- CHANGE the limit deviation of d_s from "h14" to "h13" (see Table 2);
- CHANGE the limit deviation of b_m from "jsl7" to "js16" (see Table 2);
- CHANGE the product grade of tolerance, in specification, from "B" to "A" (see Table 3);
- ADD the "zinc-nickel alloy" to the surface treatment type; CANCEL the oxidation (see Table 3)
- ADD the zinc-aluminum coating; ADOPT the standard "QC/T 721" (see Table 3).

This document was proposed by AND shall be under the jurisdiction of the National Automotive Standardization Technical Committee (SAC/TC 114).

Drafting organizations of this document: Shanghai Dongfeng Motor Special Parts Co., Ltd., Dongfeng Motor Group Co., Ltd., Dongfeng Commercial Vehicle Co., Ltd.

The main drafters of this document: Xiong Yaping, Li Yurong, Cao Yanli.

This standard replaces the standard previously issued as follows:

- It was first published as QC/T 870-2011 in 2011;
- This is the first revision.

Double end studs $b_m = 1.25d$

1 Scope

This document specifies the type, size, technical conditions of double end studs $b_m = 1.25d$.

This document is applicable to double end studs for automobiles, whose thread at the screw-in base end is ordinary coarse thread, transition fit thread, ordinary fine thread (thread specification is greater than M16), AND the thread at the screw-in nut end is ordinary coarse thread and ordinary fine thread.

2 Normative references

The contents of the following documents constitute the essential provisions of this document through normative references in the text. Among them, for dated references, only the version corresponding to the date is applicable to this document; for undated references, the latest version (including all amendments) is applicable to this document.

GB/T 2 Fasteners - Ends of parts with external thread

GB/T 90.1-2002 Fasteners - Acceptance inspection

GB/T 90.2-2002 Fasteners - Marking and packaging

GB/T 196 General purpose metric screw threads - Basic dimensions

GB/T 197 General purpose metric screw threads - Tolerances

GB/T 1167 The threads for transition fit

GB/T 3098.1-2010 Mechanical properties of fasteners - Bolts, screws and studs

GB/T 3103.1-2002 Essential oils and aromatic extracts - Determination of residual benzene content

GB/T 5779.1-2000 Fasteners - Surface discontinuities - Bolts, screws and studs for general requirements

GB/T 30512 Requirements for prohibited substances on automobiles

QC/T 326 Coding rules for automotive standardized parts

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