

# EDS

Engineering,  
GM DAEWOO Auto & Technology  
Standards

## TEST METHOD OF WELD BOLT

EDS-T-7170

ISSUED DATE: 1996. 12. 21

REVISED DATE: 2006. 06. 19

VERSION: 2

## 1. PURPOSE

This standard specifies additional test methods for weld bolts

## 2. SCOPE

- 2.1. This standard applies weld bolts which specified EDS-G-1214 or special standard parts in **GMDAT**
- 2.2. The weld bolt can be applied on sheet metal which is 0.8 to 6.0 mm thick.

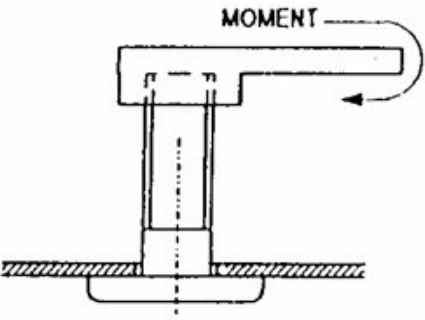
## 3. TEST METHODS

After projection welding, the moment shall be sufficient as stated in table 1, when tested as figure 1.

Table 1

| Thread | Moment                |                       |                       |
|--------|-----------------------|-----------------------|-----------------------|
|        | Strength grade<br>4.8 | Strength grade<br>6.8 | Strength grade<br>8.8 |
| M5     | 1.5 Nm                | 2.0 Nm                | 3.0 Nm                |
| M6     | 2.5 Nm                | 4.0 Nm                | 5.0 Nm                |
| M8     | 6.0 Nm                | 9.0 Nm                | 12.0 Nm               |
| M10    | 13.0 Nm               | 18.0 Nm               | 25.0 Nm               |

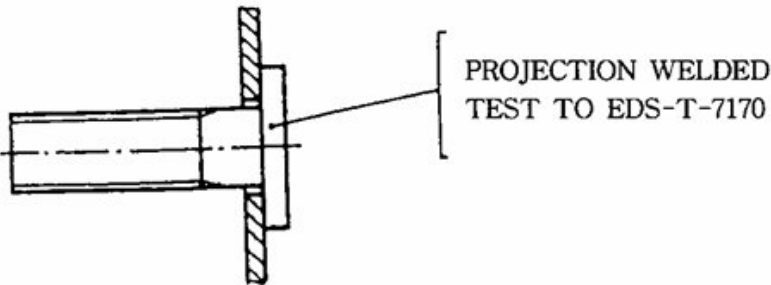
Figure 1



## 4. ADDITIONAL REQUIREMENTS

As the test conditions specified here are not sufficient for constructive reasons(design), the additional requirements shall be indicated on the relevant drawings.

## 5. CODING SYSTEM ON THE DRAWING



## 6. RELATED STANDARDS

EDS-G-1214      BOLT-WELD