

# Fishplates for railway rails —

## Part 1: Specification for rolled steel fishplates

Confirmed  
March 2010

# Committees responsible for this British Standard

The preparation of this British Standard was entrusted by the Iron and Steel Standards Policy Committee (ISM/-) to Technical Committee ISM/74, upon which the following bodies were represented:

- British Industrial Fasteners' Federation
- British Railways Board
- British Steel Industry
- Department of Transport (Transport Industries)
- London Regional Transport
- Railway Industry Association of Great Britain
- Coopted members

This British Standard, having been prepared under the direction of the Iron and Steel Standards Policy Committee, was published under the authority of the Board of BSI and comes into effect on 28 February 1991

© BSI 04-1999

First published December 1927  
Second edition February 1959  
Third edition, as Part 1, February 1991

The following BSI references relate to the work on this standard:  
Committee reference ISM/74  
Draft for comment 88/43327 DC

ISBN 0 580 18456 0

## Amendments issued since publication

Amd. No.	Date	Comments

# Contents

	Page
Committees responsible	Inside front cover
Foreword	iii
1 Scope	1
2 Manufacture	1
3 Chemical composition	1
4 Dimensions and properties	1
5 Marking	1
6 Tensile properties	2
7 Templates and working gauges	2
8 Freedom from defects	2
9 Finishing	2
10 Tolerances	2
11 Chemical analysis	2
12 Tensile tests	2
13 Manufacturer's test and certificate	3
14 Inspection	3
Appendix A Batch inspection procedure	29
Appendix B Holing of rails to BS 11; dimensions of fishbolts and nuts to BS 64 and section properties of fishplates	30
Appendix C Information to be supplied by the purchaser of the fishplates	30
Figure 1 — Referee gauge for checking fishplate height ( $h$ )	4
Figure 2 — Method for checking longitudinal straightness in a vertical direction	5
Figure 3 — Key to Table 3 and Table 4	7
Figure 4 — Fishplates for flat bottom rail No. 50 "O"	9
Figure 5 — Fishplates for flat bottom rail No. 60 A	10
Figure 6 — Fishplates for flat bottom rail No. 60 R	11
Figure 7 — Fishplates for flat bottom rail No. 70 A	12
Figure 8 — Fishplates for flat bottom rail No. 75 A	13
Figure 9 — Fishplates for flat bottom rail No. 75 R	14
Figure 10 — Fishplates for flat bottom rail No. 80 A	15
Figure 11 — Fishplates for flat bottom rail No. 80 R	16
Figure 12 — Angled fishplates for flat bottom rail No. 80 R	17
Figure 13 — Fishplates for flat bottom rail No. 80 "O"	18
Figure 14 — Fishplates for flat bottom rail No. 90 A	19
Figure 15 — Fishplates for flat bottom rail No. 90 R	20
Figure 16 — Fishplates for flat bottom rail No. 95 A	21
Figure 17 — Fishplates for flat bottom rail No. 95 R	22
Figure 18 — Fishplates for bull head rail No. 95 RBH	23
Figure 19 — Skirted fishplates for bull head rail No. 95 RBH	24
Figure 20 — Fishplates for flat bottom rail No. 95 N	25
Figure 21 — Fishplates for flat bottom rail No. 100 A	26
Figure 22 — Fishplates for flat bottom rail No. 100 R	27
Figure 23 — Fishplates for flat bottom rail Nos. 110 A and 113 A	28
Figure 24 — Progressive sampling plan — Wald method	29
Figure 25 — Progressive sampling plan for inspection of resubmitted batches	30

	Page
Table 1 — Chemical composition	1
Table 2 — Dimensional and finished tolerances	6
Table 3 — Length and holing of fishplates (imperial dimensions)	8
Table 4 — Length and holing of fishplates (metric dimensions)	8
Table 5 — Areas, calculated masses and properties for rolled fishplate bar and finished fishplates in imperial units	31
Table 6 — Areas, calculated masses and properties for rolled fishplate bar and finished fishplates in metric units	32
Publication(s) referred to	Inside back cover