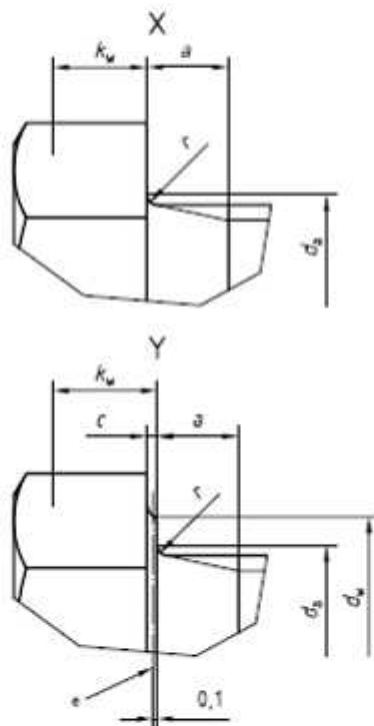
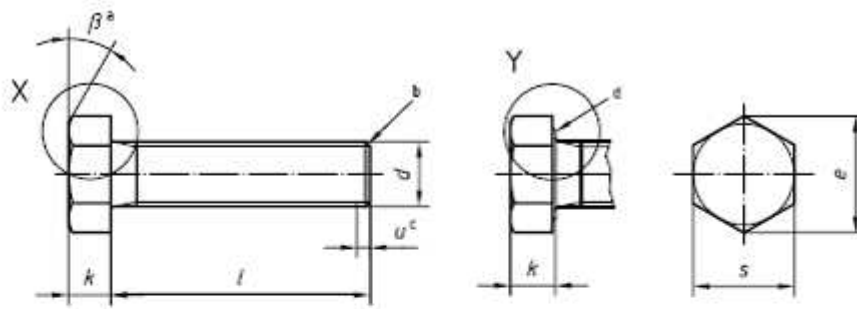
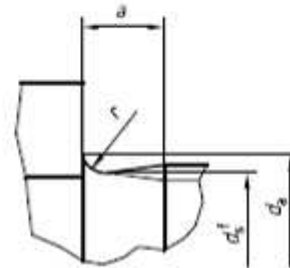


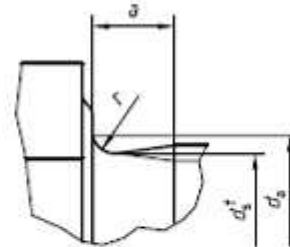
Hexagon head screws — Product grade C



Permissible shape



Permissible shape



- a $\beta = 15^\circ$ to 30°
- b End without special requirements
- c Incomplete thread $u \leq 2P$
- d Washer face permissible
- e Reference datum for d_w
- f $d_s \sim$ pitch diameter

Table 1 — Preferred threads

Dimensions in millimetres

Thread (d)	M5	M6	M8	M10	M12	M16	M20	M24	M30	M36	M42	M48	M56	M64
p^a	0,8	1	1,25	1,5	1,75	2	2,5	3	3,5	4	4,5	5	5,5	6
a	max. 2,4	3	4,00	4,5	5,30	6	7,5	9	10,5	12	13,5	15	16,5	18
	min. 0,8	1	1,25	1,5	1,75	2	2,5	3	3,5	4	4,5	5	5,5	6
c	max. 0,5	0,5	0,6	0,6	0,6	0,8	0,8	0,8	0,8	0,8	1	1	1	1
d_b	max. 6	7,2	10,2	12,2	14,7	18,7	24,4	28,4	35,4	42,4	48,6	56,6	67	75
d_w	min. 6,74	8,74	11,47	14,47	16,47	22	27,7	33,25	42,75	51,11	59,95	69,45	78,66	88,16
e	min. 8,63	10,89	14,2	17,59	19,85	26,17	32,95	39,55	50,85	60,79	71,3	82,6	93,56	104,86
	nom. 3,5	4	5,3	6,4	7,5	10	12,5	15	18,7	22,5	26	30	35	40
k	max. 3,875	4,375	5,675	6,85	7,95	10,75	13,4	15,9	19,75	23,95	27,05	31,05	36,25	41,25
	min. 3,125	3,625	4,925	5,95	7,05	9,25	11,6	14,1	17,65	21,45	24,95	28,95	33,75	38,75
k_w^b	min. 2,19	2,54	3,45	4,17	4,94	6,48	8,12	9,87	12,36	15,02	17,47	20,27	23,63	27,13
r	min. 0,2	0,25	0,4	0,4	0,6	0,6	0,8	0,8	1	1	1,2	1,6	2	2
s	nom. = max. 8,00	10,00	13,00	16,00	18,00	24,00	30,00	36	46	55,0	65,0	75,0	85,0	95,0
	min. 7,64	9,64	12,57	15,57	17,57	23,16	29,16	35	45	53,8	63,1	73,1	82,8	92,8
	f^c													
nom.	min.	max.												
10	9,25	10,75												
12	11,1	12,9												
16	15,1	16,9												
20	18,95	21,05												
25	23,95	26,05												
30	28,95	31,05												
35	33,75	36,25												
40	38,75	41,25												
45	43,75	46,25												
50	48,75	51,25												
55	53,5	56,5												
60	58,5	61,5												
65	63,5	66,5												
70	68,5	71,5												
80	78,5	81,5												
90	88,25	91,75												
100	98,25	101,75												
110	108,25	111,75												

120	118,25	121,75																		
130	128	132																		
140	138	142																		
150	148	152																		
160	156	164																		
180	176	184																		
200	195,4	204,6																		
220	215,4	224,6																		
240	235,4	244,6																		
260	254,8	265,2																		
280	274,8	285,2																		
300	294,8	305,2																		
320	314,3	325,7																		
340	334,3	345,7																		
360	354,3	365,7																		
380	374,3	385,7																		
400	394,3	405,7																		
420	413,7	426,3																		
440	433,7	446,3																		
460	453,7	466,3																		
480	473,7	486,3																		
500	493,7	506,3																		

a P is the pitch of the thread.

b $k_w, \min = 0,7 k_{\min}$

c Range of popular lengths between the solid, boldface, stepped lines.

Table 3 — Specifications and reference standards

Material		Steel
General requirements	International Standard	ISO 8992
Thread	Tolerance	8g
	International Standards	ISO 724, ISO 965-1
Mechanical properties	Property class ^a	$d \leq 39$ mm: 3.6, 4.6, 4.8 $d > 39$ mm: as agreed
	International Standard	$d \leq 39$ mm: ISO 898-1 $d > 39$ mm: as agreed
Tolerances	Product grade	C
	International Standard	ISO 4759-1
Finish and/or coating	<p>As processed</p> <p>Requirements for electroplating are covered in ISO 4042</p> <p>Requirements for non-electrolytically applied zinc flake coatings are covered in ISO 10683</p> <p>If different electroplating requirements are desired or if requirements are needed for other finishes, they should be agreed between the customer and the supplier.</p>	
Acceptability	For acceptance procedure, see ISO 3269.	

^a For other property classes see ISO 898-1.