

ISO metric hexagon bolts and screws— Product grade C

[ISO title: Hexagon head bolts—Product grade C]

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Australian Standard TM

ISO metric hexagon bolts and screws— Product grade C

Part 1: Bolts

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<i>Reference to International Standard</i>		<i>Australian Standard</i>	
ISO		AS	
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724	ISO general-purpose metric screw threads—Basic dimensions	—	
888	Bolts, screws and threads—Nominal lengths, and thread lengths for general purpose bolts	—	
898	Mechanical properties of fasteners made of carbon steel and alloy steel	4291	Mechanical properties of fasteners made of carbon steel and alloy steel
898-1	Part 1: Bolts, screws and studs	4291.1	Part 1: Bolts, screws and studs
965	ISO general purpose metric screw threads—Tolerances	—	
965-1	Part 1: Principles and basic data	—	
3269	Fasteners—Acceptance inspection	—	
4018	Hexagon head screws—Product grade C	1111	ISO metric hexagon bolts and screws—Product grade C
		1111.1	Part 2: Screws
4042	Fasteners—Electroplated coatings	—	
4759	Tolerances for fasteners	—	

ISO		AS
4759-1	Part 1: Bolts, screws, studs and nuts— Product grades A, B and C	—
8992	Fasteners—General requirements for bolts, screws, studs and nuts	—
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INTRODUCTION

This International Standard is part of the complete ISO product standard series on external hexagon drive fasteners. The series comprises:

- a) hexagon head bolts (ISO 4014 to ISO 4016 and ISO 8765);
- b) hexagon head screws (ISO 4017, ISO 4018 and ISO 8676);
- c) hexagon nuts (ISO 4032 to ISO 4036, ISO 8673 to ISO 8675);
- d) hexagon bolts with flange (ISO 4162 and ISO 15071);
- e) hexagon nuts with flange (ISO 4161 and ISO 10663);
- f) structural bolts and nuts (ISO 4775, ISO 7411 to ISO 7414 and ISO 7417).

NOTES

AUSTRALIAN STANDARD

ISO metric hexagon bolts and screws—Product grade C**Part 1:
Bolts****1 Scope**

This International Standard specifies the characteristics of hexagon head bolts with threads from M5 up to and including M64 of product grade C.

If, in special cases, specifications other than those listed in this International Standard are required, they should be selected from existing International Standards, for example ISO 724, ISO 888, ISO 898-1, ISO 965-1 and ISO 4759-1.

2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this International Standard. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

ISO 225:1983, *Fasteners — Bolts, screws, studs and nuts — Symbols and designations of dimensions*.

ISO 724:1993, *ISO general-purpose metric screw threads — Basic dimensions*.

ISO 888:1976, *Bolts, screws and studs — Nominal lengths, and thread lengths for general purpose bolts*.

ISO 898-1:1999, *Mechanical properties of fasteners made of carbon steel and alloy steel — Part 1: Bolts, screws and studs*.

ISO 965-1:1998, *ISO general purpose metric screw threads — Tolerances — Part 1: Principles and basic data*.

ISO 3269:—¹⁾, *Fasteners — Acceptance inspection*.

ISO 4018:1999, *Hexagon head screws — Product grade C*.

ISO 4042:1999, *Fasteners — Electroplated coatings*.

ISO 4759-1:—²⁾, *Tolerances for fasteners — Part 1: Bolts, screws, studs and nuts — Product grades A, B and C*.

ISO 8992:1986, *Fasteners — General requirements for bolts, screws, studs and nuts*.

ISO 10683:—³⁾, *Fasteners — Non-electrolytically applied zinc flake coatings*.

¹⁾ To be published. (Revision of ISO 3269:1988)

²⁾ To be published. (Revision of ISO 4759-1:1978)

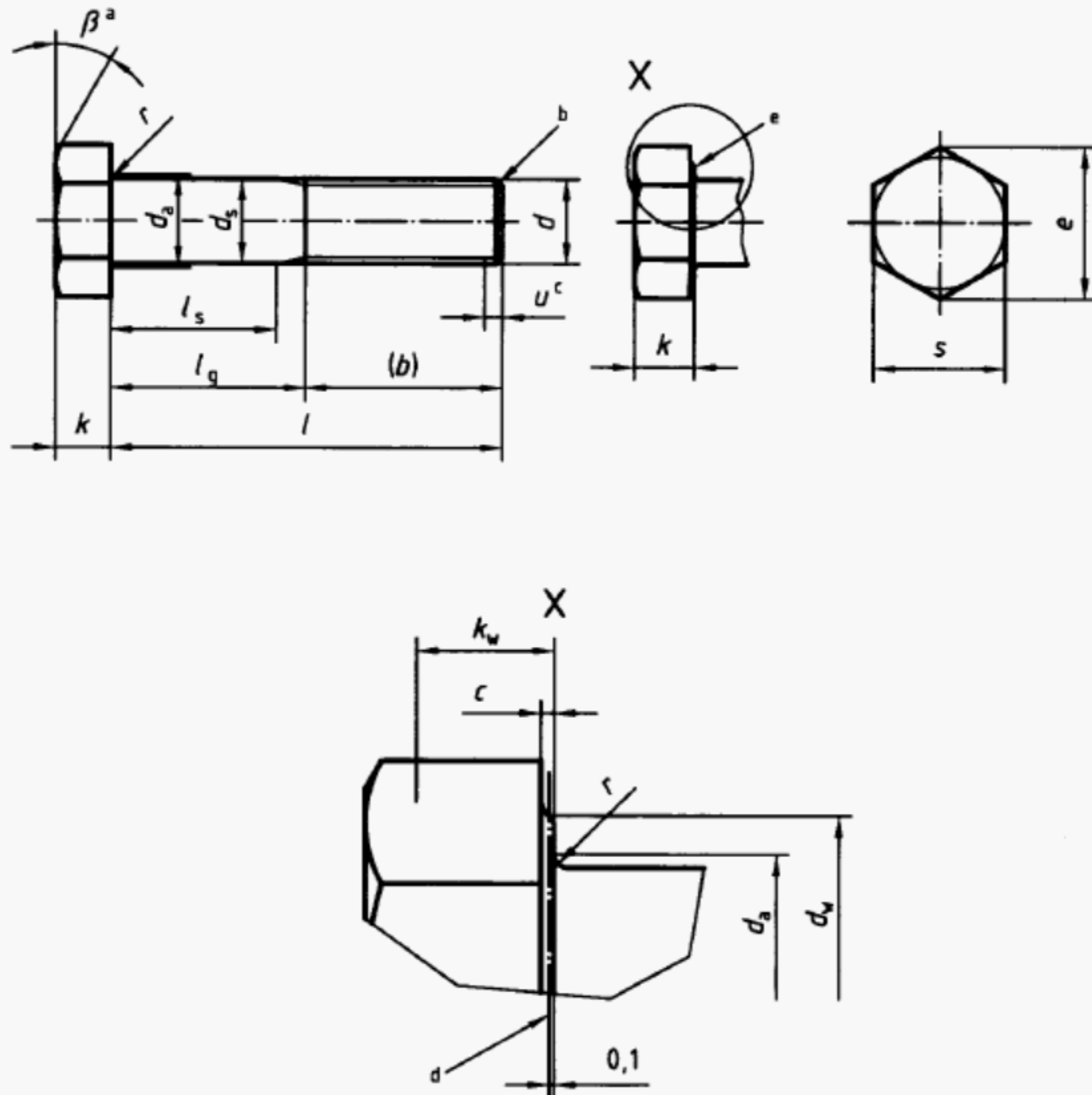
³⁾ To be published.

3 Dimensions

See Figure 1 and Tables 1 and 2.

Symbols and designations of dimensions are defined in ISO 225.

Dimensions in millimetres



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

Figure 1

Table 1 — Preferred threads

Dimensions in millimetres

Thread (<i>d</i>)			M5	M6	M8	M10	M12	M16	M20							
<i>p</i> ^a			0,8	1	1,25	1,5	1,75	2	2,5							
<i>b</i> ref.	<i>b</i>		16	18	22	26	30	38	46							
	<i>c</i>		22	24	28	32	36	44	52							
	<i>d</i>		35	37	41	45	49	57	65							
<i>c</i>	max.		0,5	0,5	0,6	0,6	0,6	0,8	0,8							
<i>d</i> _a	max.		6	7,2	10,2	12,2	14,7	18,7	24,4							
<i>d</i> _s	max.		5,48	6,48	8,58	10,58	12,7	16,7	20,84							
	min.		4,52	5,52	7,42	9,42	11,3	15,3	19,16							
<i>d</i> _w	min.		6,74	8,74	11,47	14,47	16,47	22	27,7							
<i>e</i>	min.		8,63	10,89	14,2	17,59	19,85	26,17	32,95							
<i>k</i>	nom.		3,5	4	5,3	6,4	7,5	10	12,5							
	max.		3,875	4,375	5,675	6,85	7,95	10,75	13,4							
	min.		3,125	3,625	4,925	5,95	7,05	9,25	11,6							
<i>k</i> _w ^e	min.		2,19	2,54	3,45	4,17	4,94	6,48	8,12							
<i>r</i>	min.		0,2	0,25	0,4	0,4	0,6	0,6	0,8							
<i>s</i>	nom. = max.		8,00	10,00	13,00	16,00	18,00	24,00	30,00							
	min.		7,64	9,64	12,57	15,57	17,57	23,16	29,16							
<i>l</i>			<i>l</i> _s and <i>l</i> _g ^{f,g}													
nom.	min.	max.	<i>l</i> _s min.	<i>l</i> _g max.	<i>l</i> _s min.	<i>l</i> _g max.	<i>l</i> _s min.	<i>l</i> _g max.	<i>l</i> _s min.	<i>l</i> _g max.	<i>l</i> _s min.	<i>l</i> _g max.	<i>l</i> _s min.	<i>l</i> _g max.	<i>l</i> _s min.	<i>l</i> _g max.
25	23,95	26,05	5	9	For sizes above the solid, boldface stepped line, ISO 4018 is recommended											
30	28,95	31,05	10	14												
35	33,75	36,25	15	19												
40	38,75	41,25	20	24	17	22	11,75	18								
45	43,75	46,25	25	29	22	27	16,75	23	11,5	19						
50	48,75	51,25	30	34	27	32	21,75	28	16,5	24						
55	53,5	56,5			32	37	26,75	33	21,5	29	16,25	25				
60	58,5	61,5			37	42	31,75	38	26,5	34	21,25	30				
65	63,5	66,5					36,75	43	31,5	39	26,25	35	17	27		
70	68,5	71,5					41,75	48	36,5	44	31,25	40	22	32		
80	78,5	81,5					51,75	58	46,5	54	41,25	50	32	42	21,5	34
90	88,25	91,75							56,5	64	51,25	60	42	52	31,5	44
100	98,25	101,75							66,5	74	61,25	70	52	62	41,5	54
110	108,25	111,75									71,25	80	62	72	51,5	64
120	118,25	121,75									81,25	90	72	82	61,5	74
130	128	132											76	86	65,5	78
140	138	142											86	96	75,5	88
150	148	152											96	106	85,5	98
160	156	164											106	116	95,5	108
180	176	184													115,5	128
200	195,4	204,6													135,5	148
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														

Table 1 (continued)

Thread (d)			M24	M30	M36	M42	M48	M56	M64							
p ^a			3	3,5	4	4,5	5	5,5	6							
b ref.	b		54	66	—	—	—	—	—							
	c		60	72	84	96	108	—	—							
	d		73	85	97	109	121	137	153							
c	max.		0,8	0,8	0,8	1	1	1	1							
d _a	max.		28,4	35,4	42,4	48,6	56,6	67	75							
d _s	max.		24,84	30,84	37	43	49	57,2	65,2							
	min.		23,16	29,16	35	41	47	54,8	62,8							
d _w	min.		33,25	42,75	51,11	59,95	69,45	78,66	88,16							
e	min.		39,55	50,85	60,79	71,3	82,6	93,56	104,86							
k	nom.		15	18,7	22,5	26	30	35	40							
	max.		15,9	19,75	23,55	27,05	31,05	36,25	41,25							
	min.		14,1	17,65	21,45	24,95	28,95	33,75	38,75							
k _w ^e	min.		9,87	12,36	15,02	17,47	20,27	23,63	27,13							
r	min.		0,8	1	1	1,2	1,6	2	2							
s	nom. = max.		36	46	55,0	65,0	75,0	85,0	95,0							
	min.		35	45	53,8	63,1	73,1	82,8	92,8							
l			l _s and l _g ^{f g}													
nom.	min.	max.	l _s min.	l _g max.	l _s min.	l _g max.	l _s min.	l _g max.	l _s min.	l _g max.	l _s min.	l _g max.	l _s min.	l _g max.	l _s min.	l _g max.
25	23,95	26,05														
30	28,95	31,05	For sizes above the solid, boldface stepped line, ISO 4018 is recommended													
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	31	46												
110	108,25	111,75	41	56												
120	118,25	121,75	51	66	36,5	54										
130	128	132	55	70	40,5	58										
140	138	142	65	80	50,5	68	36	56								
150	148	152	75	90	60,5	78	46	66								
160	156	164	85	100	70,5	88	56	76								
180	176	184	105	120	90,5	108	76	96	61,5	84						
200	195,4	204,6	125	140	110,5	128	96	116	81,5	104	67	92				
220	215,4	224,6	132	147	117,5	135	103	123	88,5	111	74	99				
240	235,4	244,6	152	167	137,5	155	123	143	108,5	131	94	119	75,5	103		
260	254,8	265,2			157,5	175	143	163	128,5	151	114	139	95,5	123	77	107
280	274,8	285,2			177,5	195	163	183	148,5	171	134	159	115,5	143	97	127
300	294,8	305,2			197,5	215	183	203	168,5	191	154	179	135,5	163	117	147
320	314,3	325,7					203	223	188,5	211	174	199	155,5	183	137	167
340	334,3	345,7					223	243	208,5	231	194	219	175,5	203	157	187
360	354,3	365,7					243	263	228,5	251	214	239	195,5	223	177	207
380	374,3	385,7							248,5	271	234	259	215,5	243	197	227
400	394,3	405,7							268,5	291	254	279	235,5	263	217	247
420	413,7	426,3							288,5	311	274	299	255,5	283	237	267
440	433,7	446,3									294	319	275,5	303	257	287
460	453,7	466,3									314	339	295,5	323	277	307
480	473,7	486,3									334	359	315,5	343	297	327
500	493,7	506,3											335,5	363	317	347

NOTE popular lengths are defined in terms of l_s and l_g ^a p is the pitch of the thread.^b For lengths $l_{nom} \leq 125$ mm.^c For lengths $125 \text{ mm} < l_{nom} \leq 200$ mm.^d For lengths $l_{nom} > 200$ mm.^e $k_{w, min} = 0,7 k_{min}$ ^f $l_{g, max} = l_{nom} - b$ $l_{s, min} = l_{g, max} - 5p$ ^g l_g is the minimum grip length.

Table 2 — Non-preferred threads

Dimensions in millimetres

Thread (<i>d</i>)			M14	M18	M22	M27	M33					
<i>p^a</i>			2	2,5	2,5	3	3,5					
<i>b</i> ref.	<i>b</i>		34	42	50	60	—					
	<i>c</i>		40	48	56	66	78					
	<i>d</i>		53	61	69	79	91					
<i>c</i>	max.		0,6	0,8	0,8	0,8	0,8					
<i>d_a</i>	max.		16,7	21,2	26,4	32,4	38,4					
<i>d_s</i>	max.		14,7	18,7	22,84	27,84	34					
	min.		13,3	17,3	21,16	26,16	32					
<i>d_w</i>	min.		19,15	24,85	31,35	38	46,55					
<i>e</i>	min.		22,78	29,56	37,29	45,2	55,37					
<i>k</i>	nom.		8,8	11,5	14	17	21					
	max.		9,25	12,4	14,9	17,9	22,05					
	min.		8,35	10,6	13,1	16,1	19,95					
<i>k_w^e</i>	min.		5,85	7,42	9,17	11,27	13,97					
<i>r</i>	min.		0,6	0,6	0,8	1	1					
<i>s</i>	nom. = max.		21,00	27,00	34	41	50					
	min.		20,16	26,16	33	40	49					
<i>l</i>			<i>l_s</i> and <i>l_g^{f,g}</i>									
nom.	min.	max.	<i>l_s</i> min.	<i>l_g</i> max.	<i>l_s</i> min.	<i>l_g</i> max.	<i>l_s</i> min.	<i>l_g</i> max.	<i>l_s</i> min.	<i>l_g</i> max.	<i>l_s</i> min.	<i>l_g</i> max.
60	58,5	61,5	16	26	For sizes above the solid, boldface stepped line ISO 4018 is recommended							
65	63,5	66,5	21	31								
70	68,5	71,5	26	36								
80	78,5	81,5	36	46	25,5	38						
90	88,25	91,75	46	56	35,5	48	27,5	40				
100	98,25	101,75	56	66	45,5	58	37,5	50				
110	108,25	111,75	66	76	55,5	68	47,5	60	35	50		
120	118,25	121,75	76	86	65,5	78	57,5	70	45	60		
130	128	132	80	90	69,5	82	61,5	74	49	64	34,5	52
140	138	142	90	100	79,5	92	71,5	84	59	74	44,5	62
150	148	152			89,5	102	81,5	94	69	84	54,5	72
160	156	164			99,5	112	91,5	104	79	94	64,5	82
180	176	184			119,5	132	111,5	124	99	114	84,5	102
200	195,4	204,6					131,5	144	119	134	104,5	122
220	215,4	224,6					138,5	151	126	141	111,5	129
240	235,4	244,6							146	161	131,5	149
260	254,8	265,2							166	181	151,5	167
280	274,8	285,2									171,5	189
300	294,8	305,2									191,5	209
320	314,3	325,7									211,5	229
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										

Table 2 (continued)

Thread (d)			M39	M45	M52	M60				
p^a			4	4,5	5	5,5				
b ref.	b		—	—	—	—				
	c		90	102	116	—				
	d		103	115	129	145				
c	max.		1	1	1	1				
d_a	max.		45,4	52,6	62,6	71				
d_s	max.		40	46	53,2	61,2				
	min.		38	44	50,8	58,8				
d_w	min.		55,86	64,7	74,2	83,41				
e	min.		66,44	76,95	88,25	99,21				
k	nom.		25	28	33	38				
	min.		23,95	26,95	31,75	36,75				
	max.		26,05	29,05	34,25	39,25				
k_w^e	min.		16,77	18,87	22,23	25,73				
r	min.		1	1,2	1,6	2				
s	nom. = max.		60,0	70,0	80,0	90,0				
	min.		58,8	68,1	78,1	87,8				
l			l_s and l_g^{fg}							
nom.	min.	max.	l_s min.	l_g max.	l_s min.	l_g max.	l_s min.	l_g max.	l_s min.	l_g max.
60	58,5	61,5	For sizes above the solid, boldface stepped line ISO 4018 is recommended							
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	40	60						
160	156	164	50	70						
180	176	184	70	90	55,5	78				
200	195,4	204,6	90	110	75,5	98	59	84		
220	215,4	224,6	97	117	82,5	105	66	91		
240	235,4	244,6	117	137	102,5	125	86	111	67,5	95
260	254,8	265,2	137	157	122,5	145	106	131	87,5	115
280	274,8	285,2	157	177	142,5	165	126	151	107,5	135
300	294,8	305,2	177	197	162,5	185	146	171	127,5	155
320	314,3	325,7	197	217	182,5	205	166	191	147,5	175
340	334,3	345,7	217	237	202,5	225	186	211	167,5	195
360	354,3	365,7	237	257	222,5	245	206	231	187,5	215
380	374,3	385,7	257	277	242,5	265	226	251	207,5	235
400	394,3	405,7	277	297	262,5	285	246	271	227,5	255
420	413,7	426,3			282,5	305	266	291	247,5	275
440	433,7	446,3			302,5	325	286	311	267,5	295
460	453,7	466,3					306	331	287,5	315
480	473,7	486,3					326	351	307,5	335
500	493,7	506,3					346	371	327,5	355
NOTE popular lengths are defined in terms of l_s and l_g										
^a p is the pitch of the thread.			^e $k_w, \min = 0,7 k_{\min}$							
^b For lengths $l_{\text{nom}} \leq 125$ mm.			^f $l_{g, \max} = l_{\text{nom}} - b$							
^c For lengths $125 \text{ mm} < l_{\text{nom}} \leq 200$ mm.			$l_{s, \min} = l_{g, \max} - 5p$							
^d For lengths $l_{\text{nom}} > 200$ mm.			^g l_g is the minimum grip length.							

4 Specifications and reference standards

See Table 3.

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		As processed Requirements for electroplating are covered in ISO 4042. Requirements for non-electrolytically applied zinc flake coatings are covered in ISO 10683. If different electroplating requirements are desired or if requirements are needed for other finishes, they should be agreed between customer and supplier.
Acceptability		For acceptance procedure, see ISO 3269.
^a For other property classes see ISO 898-1.		

5 Designation

EXAMPLE

A hexagon head bolt, product grade C, with thread M12, nominal length $l = 80$ mm and property class 4.6 is designated as follows:

Hexagon head bolt ISO 4016 - M12 × 80 - 4.6

Bibliography

- [1] ISO 4014:1999, *Hexagon head bolts — Product grades A and B.*
- [2] ISO 4015:1979, *Hexagon head bolts — Product grade B — Reduced shank (shank diameter approximately equal to pitch diameter).*
- [3] ISO 4017:1999, *Hexagon head screws — Product grades A and B.*
- [4] ISO 4018:1999, *Hexagon head screws — Product grade C.*
- [5] ISO 4032:1999, *Hexagon nuts, style 1 — Product grades A and B.*
- [6] ISO 4033:1999, *Hexagon nuts, style 2 — Product grades A and B.*
- [7] ISO 4034:1999, *Hexagon nuts — Product grade C.*
- [8] ISO 4035:1999, *Hexagon thin nuts (chamfered) — Product grades A and B.*
- [9] ISO 4036:1999, *Hexagon thin nuts (unchamfered) — Product grade B.*
- [10] ISO 4161:1999, *Hexagon nuts with flange — Coarse thread.*
- [11] ISO 4162:—⁴⁾, *Hexagon bolts with flange — Small series — Product grade combination A/B.*
- [12] ISO 4775:1984, *Hexagon nuts for high-strength structural bolting with large width across flats — Product grade B — Property classes 8 and 10.*
- [13] ISO 7411:1984, *Hexagon bolts for high-strength structural bolting with large width across flats (thread lengths according to ISO 888) — Product grade C — Property classes 8.8 and 10.9.*
- [14] ISO 7412:1984, *Hexagon bolts for high-strength structural bolting with large width across flats (short thread length) — Product grade C — Property classes 8.8 and 10.9.*
- [15] ISO 7413:1984, *Hexagon nuts for structural bolting, style 1, hot-dip galvanize (oversize tapped) — Product grades A and B — Property classes 5, 6 and 8.*
- [16] ISO 7414:1984, *Hexagon nuts for structural bolting with large width across flats, style 1 — Product grade B — Property class 10.*
- [17] ISO 7417:1984, *Hexagon nuts for structural bolting, style 2, hot-dip galvanize (oversize tapped) — Product grade A — Property class 9.*
- [18] ISO 8673:1999, *Hexagon nuts, style 1, with metric fine pitch thread — Product grades A and B.*
- [19] ISO 8674:1999, *Hexagon nuts, style 2, with metric fine pitch thread — Product grades A and B.*
- [20] ISO 8675:1999, *Hexagon thin nuts (chamfered) with metric fine pitch thread — Product grades A and B.*
- [21] ISO 8676:1999, *Hexagon head screws with metric fine pitch thread — Product grades A and B.*
- [22] ISO 8765:1999, *Hexagon head bolts with metric fine pitch thread — Product grades A and B.*

⁴⁾ To be published. (Revision of ISO 4162:1990)

[23] ISO 10663:1999, *Hexagon nuts with flange — Fine pitch thread.*

[24] ISO 15071:1999, *Hexagon bolts with flange — Small series — Product grade A.*

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