

भारतीय मानक

उत्पाद ग्रेड ए और बी के लिए षटकोणीय शीर्ष वाले
काबले, पेंच और ढिबरियाँ

भाग 5 षटकोणीय पतली ढिबरियाँ (शेम्फर न किए गये)
(साइज रेंज एम 1.6 से एम 10 तक)

(चौथा पुनरीक्षण)

Indian Standard

HEXAGON HEAD BOLTS, SCREWS AND NUTS OF
PRODUCT GRADES A AND B

PART 5 HEXAGON THIN NUTS — PRODUCT GRADE B
(UNCHAMFERED) (SIZE RANGE M 1.6 TO M 10)

(*Fourth Revision*)

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Bolts, Nuts and Fasteners Accessories Sectional Committee, BP 33

NATIONAL FOREWORD

This Indian Standard (Fourth Revision) which is identical with ISO 4036 : 1999 'Hexagon thin nuts (unchamfered) — Product grade B' issued by the International Organization for Standardization (ISO) was adopted by the Bureau of Indian Standards on the recommendation of the Bolts, Nuts and Fasteners Accessories Sectional Committee and approval of the Basic and Production Engineering Division Council.

IS 1364 was originally published in 1960 and first revised in 1967. Subsequent to the publication of 1967 edition, many changes had been agreed upon at international level which have been reflected in IS 1367 series of standards covering 'Technical supply conditions for threaded steel fasteners'. Accordingly, second revision was published in 1983 splitting the standard into 5 parts covering hexagon head bolts, hexagon head screws, hexagon nuts, hexagon thin nuts (chamfered) and hexagon thin nuts (unchamfered).

The third revision of this standard was published in 1992 by adoption of ISO 4036 : 1988. This fourth revision has been made by adoption of latest version of ISO 4036 published in 1999. The remaining parts of the standard, that is, Part 1, Part 2, Part 3 and Part 4 are also being revised by adopting the corresponding latest editions of ISO Standards published in 1999.

The Committee also decided to publish Indian Standard on 'Hexagon nuts, Style 2 — Product grades A & B' as Part 6 of IS 1364. The Part 6 will supersede IS/ISO 4033 : 1979 on its publication.

In 1967 version of this standard, the width across flat dimension for M10 size fasteners was specified as 17 mm. However, in the 1983 version this width across flat dimension was brought in line with ISO 4036 : 1979 and specified as 16 mm for M10 size fasteners. Recognizing the difficulty of immediate changeover to new width across flat dimensions, the Committee decided to permit width across flat dimension as per 1967 version, that is, 17 mm for M10 fasteners till 31 December 1994. Now it is expected that the entire fastener industry would have switched over to new width across flat dimensions and from 1 January 1995 no old width across flat dimensions shall be permitted.

The text of ISO Standard has been approved as suitable for publication as Indian Standard without deviation. Certain terminology and conventions are, however, not identical to those used in the Indian Standards. Attention is drawn especially to the following:

- a) Wherever the words 'International Standard' appear referring to this standard, they should be read as 'Indian Standard'.
- b) Comma (,) has been used as a decimal marker while in Indian Standards the current practice is to use a point (.) as the decimal marker.

In this adopted standard, reference appears to certain International Standards for which Indian Standards also exist. The corresponding Indian Standards which are to be substituted in their place are listed below along with their degree of equivalence for the editions indicated:

<i>International Standard</i>	<i>Corresponding Indian Standard</i>	<i>Degree of Equivalence</i>
ISO 225 : 1983	IS 8536 : 1987 Fasteners — Bolts, screws, studs and nuts — Symbols and designation of dimensions (<i>first revision</i>)	Identical
ISO 724 : 1993	IS 4218 (Part 3) : 1999 ISO General purpose metric screw threads: Part 3 Basic dimensions (<i>second revision</i>)	do

International Standard	Corresponding Indian Standard	Degree of Equivalence
ISO 965-1 : 1998	IS 14962 (Part 1) : 2001 ISO General purpose metric screw threads — Tolerances: Part 1 Principles and basic data	Identical
ISO 3269 : ¹⁾	IS 1367 (Part 17) : 1996 ²⁾ Industrial fasteners — Threaded steel fasteners — Technical supply conditions: Part 17 Inspection, sampling and acceptance procedure (<i>third revision</i>)	do
ISO 4042 : 1999	IS 1367 (Part 11) : 2002 Technical supply conditions for threaded steel fasteners: Part 11 Electroplated coatings (<i>third revision</i>)	do
ISO 4759-1 : ³⁾	IS 1367 (Part 2) : 2002 Technical supply conditions for threaded steel fasteners: Part 2 Product grades and tolerances (<i>third revision</i>)	do
ISO 6157-2 : 1988	IS 1367 (Part 10) : 2002 Technical supply conditions for threaded steel fasteners : Part 10 Surface discontinuities — Nuts (<i>third revision</i>)	do
ISO 8992 : 1986	IS 1367 (Part 1) : 2002 Technical supply conditions for threaded steel fasteners: Part 1 Introduction and general information (<i>third revision</i>)	do

The concerned technical committee has reviewed the provisions of the following ISO Standard referred in this adopted standard and has decided that it is acceptable for use in conjunction with this standard:

ISO Standard	Title
ISO 8839 : 1986	Mechanical properties of fasteners — Bolts, screws, studs and nuts made of non-ferrous metals

ALTERATION

In clause 5, the designation of hexagon thin nut (unchamfered) shall be read as:

‘Hexagon nut IS 1364 (Part 5)/ISO 4036 - M6 - St’ in place of ‘Hexagon nut ISO 4036 - M6 - St’

CORRIGENDUM

(Page 2, Figure 1) — Replace the existing figure with the following:

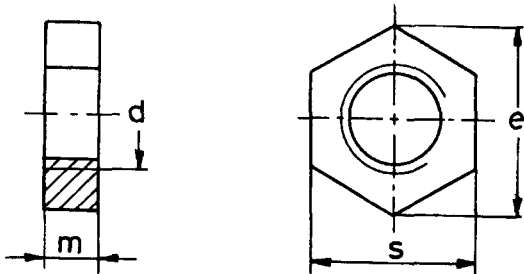


FIG. 1 HEXAGON THIN NUT — UNCHAMFERED

(Page 3, Table 2, col 1, row 4) — The word ‘Mechanical’ shall be read as ‘Mechanical properties’.

¹⁾ To be published (Revision of ISO 3269 : 1988).
²⁾ Identical with ISO 3269 : 1988.
³⁾ Since published in 2000.

PACKAGING

The packaging of hexagon thin nuts shall be in accordance with IS 1367 (Part 18) : 1996 'Industrial fasteners — Threaded steel fasteners — Technical supply conditions: Part 18 Packaging (*third revision*)'.

BIS CERTIFICATION MARKING

Details available with the Bureau of Indian Standards.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard

HEXAGON HEAD BOLTS, SCREWS AND NUTS OF
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PART 5 HEXAGON THIN NUTS — PRODUCT GRADE B
(UNCHAMFERED) (SIZE RANGE M 1.6 TO M 10)

(*Fourth Revision*)

1 Scope

This International Standard specifies the characteristics of unchamfered hexagon thin nuts, with threads from M1,6 up to and including M10 and product grade B.

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

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

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 6157-2:1988, *Fasteners — Surface discontinuities — Part 2: Nuts.*

ISO 8839:1986, *Mechanical properties of fasteners — Bolts, screws, studs and nuts made of non-ferrous metals.*

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 Table 1. Symbols and descriptions of dimensions are defined in ISO 225.

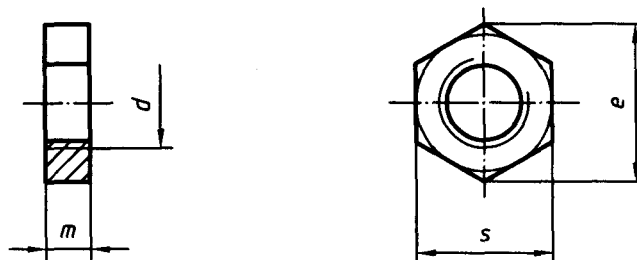


Figure 1

Table 1 — Dimensions

Dimensions in millimetres

Thread (<i>d</i>)		M1,6	M2	M2,5	M3	(M3,5) ^a	M4	M5	M6	M8	M10
<i>p_b</i>		0,35	0,4	0,45	0,5	0,6	0,7	0,8	1	1,25	1,5
<i>e</i>	min.	3,28	4,18	5,31	5,88	6,44	7,5	8,63	10,89	14,2	17,59
<i>m</i>	max.	1,00	1,20	1,60	1,80	2,00	2,20	2,70	3,2	4,0	5,0
	min.	0,75	0,95	1,35	1,55	1,75	1,95	2,45	2,9	3,7	4,7
<i>s</i>	nom. = max.	3,2	4,0	5,0	5,5	6,0	7,00	8,00	10,00	13,00	16,00
	min.	2,9	3,7	4,7	5,2	5,7	6,64	7,64	9,64	12,57	15,57

^a If possible, the size in parentheses should be avoided.

^b *P* is the pitch of the thread.

4 Specifications and reference standards

See Table 2.

Table 2 — Specifications and reference standards

Material		Steel (St)	Non-ferrous metal
General requirements	International Standard	ISO 8992	
	Tolerance	6H	
Thread	International Standards	ISO 724, ISO 965-1	
	Hardness min.	110 HV30	Materials as specified in ISO 8839
Mechanical	International Standard	—	
	Product grade	B	
Tolerances	International Standard	ISO 4759-1	
	Finish and/or coating	As processed	Plain
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	Limits for surface discontinuities are covered in ISO 6157-2.		
	For acceptance procedure, see ISO 3269.		

5 Designation

EXAMPLE

An unchamfered hexagon thin nut with thread M6 made from steel with a minimum hardness of 110 HV30 (St) is designated as follows:

Hexagon nut ISO 4036 - M6 - St

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 4016:1999, *Hexagon head bolts — Product grade C.*
- [4] ISO 4017:1999, *Hexagon head screws — Product grades A and B.*
- [5] ISO 4018:1999, *Hexagon head screws — Product grade C.*
- [6] ISO 4032:1999, *Hexagon nuts, style 1 — Product grades A and B.*
- [7] ISO 4033:1999, *Hexagon nuts, style 2 — Product grades A and B.*
- [8] ISO 4034:1999, *Hexagon nuts — Product grade C.*
- [9] ISO 4035:1999, *Hexagon thin nuts (chamfered) — Product grades A and 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 galvanized (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 galvanized (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.*

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

- [22] ISO 8765:1999, *Hexagon head bolts with metric fine pitch thread — Product grades A and B.*
- [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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Amendments Issued Since Publication

Amend No.	Date of Issue	Text Affected

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