

"WHEN THIS STANDARD IS APPLIED, A CAREFUL CHECK MUST BE MADE AS TO WHETHER ANY PROTECTIVE RIGHTS EXIST. THE STANDARD ISSUER HEREBY DISCLAIMS ANY LIABILITY FOR INFRINGEMENT OF PATENT OR DESIGN RIGHTS RESULTING FROM THE USE OF THIS STANDARD"

SCREW, CHEESE HEAD
THREAD CUTTING

Published and distributed by:

AIRBUS INDUSTRIE
31707 BLAGNAC CEDEX
FRANCE

Approved
AIRBUS INDUSTRIE

Meyer

© Copyright AIRBUS INDUSTRIE 1989
All rights reserved

141 406

FORM AIF 8001.2

1 Scope and field of application

This standard specifies the dimensions and tolerances of thread cutting screws for non - structural applications

2 References

- DIN6773 Part 4 Heat treatment of ferrous metals; heat treated parts; presentation and indications on drawings; case hardening.
- DIN7962 Cross recesses for screws; ISO4757 modified.
- DIN267 Part 5 Fasteners; technical delivery conditions; acceptance inspection; modified version of ISO3269, 1984 edition
- DIN267 Part 9 Fasteners; technical specification; electroplated coating
- DIN50961 Electroplated coatings; zinc and cadmium coatings on iron and steel; chromate treatment of zinc and cadmium coatings.
- EN2424 Identification marking of standard fasteners aerospace series.

3 Required characteristics

3.1 Configuration-Dimensions-Tolerances.

3.1.1 Configuration shall be in accordance with the figure.

3.1.2 Dimensions shall conform with the figure and the tables.

3.2 Material

Case hardening steel (at manufacturer's option).

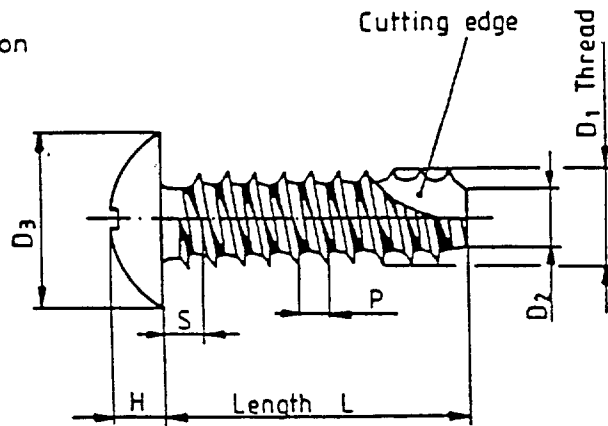
Surface hardening: 425 ± 185 HV05, Eht $0,05 \pm 0,05$ according to DIN6773 Part 4.

3.3 Surface treatment

Zinc-plated AlF according to DIN267 part 9 and chromate treatment according to DIN50961.

STANDARDS MANUAL

Figure A-Configuration
Code-letter: A



Cruziform recess per DIN7962
style Z

Figure B-Configuration
Code-letter: B
with washer

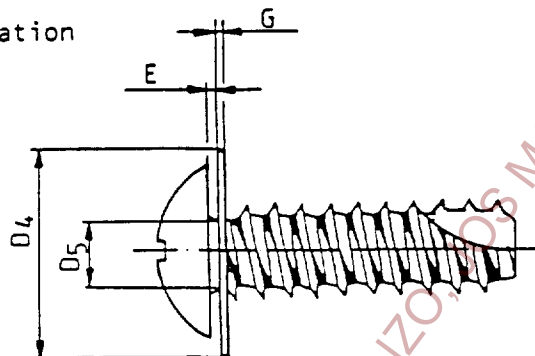


Table-Dimensions

Table 1

Dimensions in millimetres (inch)

Dash-No.	D ₁ Thread	D ₂ -0,10 (.004)	D ₃ -0,36 (.014)	D ₄ -0,36 (.014)	D ₅ +0,10 (.004)	E ±0,20 (.008)	G ±0,10 (.004)	H ±0,15 (.006)	P Pitch	S max.
- 4	4,0 + 0,18 (.16) (.007)	2,93 (.114)	8,0 (.31)	9,0 (.35)	3,3 (.13)	1,0 (.04)	1,0 (.04)	3,10 (.122)	1,04 (.041)	3,20 (.126)
- 5	5,0 + 0,18 (.20) (.007)	3,68 (.145)	10,0 (.39)	-	-	-	-	3,80 (.150)	1,23 (.048)	3,70 (.146)

Table 2

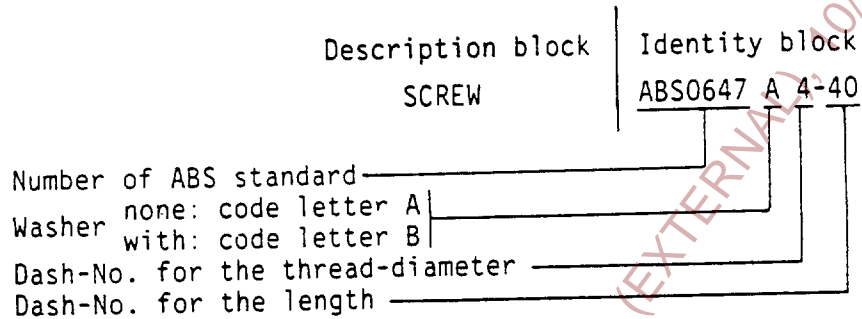
Dash-No.	Length L js 17	
	- 4	- 5
- 10	10 (.39)	
- 12	12 (.47)	
- 20	20 (.79)	
- 25	25 (.98)	

Table 2 continued

Dash-No.	Length L js 17	
	- 4	- 5
- 30	30 (1.18)	
- 40	40 (1.57)	40 (1.57)
- 50		50 (1.97)
- 55		55 (2.17)

4 Designation

Each screw shall only be designated as in following example:



5 Marking

According to: EN2424 style G

6 Technical Specification

DIN267 Part 5