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Fastener Design Manual

Richard T. Barrett

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The manual describes various platings that may be used for corrosion control including cadmium and zinc plating. It does not mention outgassing problems caused by the relatively high vapor pressure of these metals. The fastener manual was intended primarily for aeronautical applications, where outgassing is typically not a concern.

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Summary

This manual was written for design engineers to enable them to choose appropriate fasteners for their designs. Subject matter includes fastener material selection, platings, lubricants, corrosion, locking methods, washers, inserts, thread types and classes, fatigue loading, and fastener torque. A section on design criteria covers the derivation of torque formulas, loads on a fastener group, combining simultaneous shear and tension loads, pullout load for tapped holes, grip length, head styles, and fastener strengths. The second half of this manual presents general guidelines and selection criteria for rivets and lockbolts.

Introduction

To the casual observer the selection of bolts, nuts, and rivets for a design should be a simple task. In reality it is a difficult task, requiring careful consideration of temperature, corrosion, vibration, fatigue, initial preload, and many other factors.

The intent of this manual is to present enough data on bolt and rivet materials, finishes, torques, and thread lubricants to enable a designer to make a sensible selection for a particular design. Locknuts, washers, locking methods, inserts, rivets, and tapped holes are also covered.

General Design Information

Fastener Materials

Bolts can be made from many materials, but most bolts are made of carbon steel, alloy steel, or stainless steel. Stainless steels include both iron- and nickel-based chromium alloys. Titanium and aluminum bolts have limited usage, primarily in the aerospace industry.

Carbon steel is the cheapest and most common bolt material. Most hardware stores sell carbon steel bolts, which are usually zinc plated to resist corrosion. The typical ultimate strength of this bolt material is 55 ksi.

An alloy steel is a high-strength carbon steel that can be heat treated up to 300 ksi. However, it is not corrosion resistant and must therefore have some type of coating to protect it from

corrosion. Aerospace alloy steel fasteners are usually cadmium plated for corrosion protection.

Bolts of stainless steel (CRES) are available in a variety of alloys with ultimate strengths from 70 to 220 ksi. The major advantage of using CRES is that it normally requires no protective coating and has a wider service temperature range than plain carbon or alloy steels.

A partial listing of bolt materials is given in table I. The following precautions are to be noted:

(1) The bolt plating material is usually the limiting factor on maximum service temperature.

(2) Carbon steel and alloy steel are unsatisfactory (become brittle) at temperatures below -65 °F.

(3) Hydrogen embrittlement is a problem with most common methods of plating, unless special procedures are used. (This subject is covered more fully in the corrosion section.)

(4) Series 400 CRES contains only 12 percent chromium and thus will corrode in some environments.

(5) The contact of dissimilar materials can create galvanic corrosion, which can become a major problem. (Galvanic corrosion is covered in a subsequent section of this manual.)

Platings and Coatings

Most plating processes are electrolytic and generate hydrogen. Thus, most plating processes require baking after plating at a temperature well below the decomposition temperature of the plating material to prevent hydrogen embrittlement. However, heating the plating to its decomposition temperature can generate free hydrogen again. Thus, exceeding the safe operating temperature of the plating can cause premature fastener failure due to hydrogen embrittlement as well as loss of corrosion protection. (A summary of platings and coatings is given in table II.)

Cadmium Plating

The most common aerospace fastener plating material is cadmium. Plating is done by electrodeposition and is easy to accomplish. However, cadmium-plated parts must be baked at 375 °F for 23 hours, within 2 hours after plating, to prevent hydrogen embrittlement. Since cadmium melts at 600 °F, its useful service temperature limit is 450 °F.

TABLE I.—SUMMARY OF FASTENER MATERIALS

Material	Surface treatment	Useful design temperature limit, °F	Ultimate tensile strength at room temperature, ksi	Comments
Carbon steel	Zinc plate	-65 to 250	55 and up	-----
Alloy steels	Cadmium plate, nickel plate, zinc plate, or chromium plate	-65 to limiting temperature of plating	Up to 300	Some can be used at 900 °F
A-286 stainless	Passivated per MIL-S-5002	-423 to 1200	Up to 220	-----
17-4PH stainless	None	-300 to 600	Up to 220	-----
17-7PH stainless	Passivated	-200 to 600	Up to 220	-----
300 series stainless	Furnace oxidized	-423 to 800	70 to 140	Oxidation reduces galling
410, 416, and 430 stainless	Passivated	-250 to 1200	Up to 180	47 ksi at 1200 °F; will corrode slightly
U-212 stainless	Cleaned and passivated per MIL-S-5002	1200	185	140 ksi at 1200 °F
Inconel 718 stainless	Passivated per QQ-P-35 or cadmium plated	-423 to 900 or cadmium plate limit	Up to 220	-----
Inconel X-750 stainless	None	-320 to 1200	Up to 180	136 ksi at 1200 °F
Waspalloy stainless	None	-423 to 1600	150	-----
Titanium	None	-350 to 500	Up to 160	-----

Zinc Plating

Zinc is also a common type of plating. The hot-dip method of zinc plating is known commercially as galvanizing. Zinc can also be electrodeposited. Because zinc plating has a dull finish, it is less pleasing in appearance than cadmium. However, zinc is a sacrificial material. It will migrate to uncoated areas that have had their plating scratched off, thus continuing to provide corrosion resistance. Zinc may also be applied cold as a zinc-rich paint. Zinc melts at 785 °F but has a useful service temperature limit of 250 °F. (Its corrosion-inhibiting qualities degrade above 140 °F.)

Phosphate Coatings

Steel or iron is phosphate coated by treating the material surface with a diluted solution of phosphoric acid, usually by submerging the part in a proprietary bath. The chemical reaction forms a mildly protective layer of crystalline phosphate. The three principal types of phosphate coatings are

zinc, iron, and manganese. Phosphate-coated parts can be readily painted, or they can be dipped in oil or wax to improve their corrosion resistance. Fasteners are usually phosphated with either zinc or manganese. Hydrogen embrittlement seldom is present in phosphated parts. Phosphate coatings start deteriorating at 225 °F (for heavy zinc) to 400 °F (for iron phosphate).

Nickel Plating

Nickel plating, with or without a copper strike (thin plating), is one of the oldest methods of preventing corrosion and improving the appearance of steel and brass. Nickel plating will tarnish unless it is followed by chromium plating. Nickel plating is a more expensive process than cadmium or zinc plating and also must be baked the same as cadmium after plating to prevent hydrogen embrittlement. Nickel plating is good to an operating temperature of 1100 °F, but is still not frequently used for plating fasteners because of its cost.

TABLE II.—SUMMARY OF PLATINGS AND COATINGS

Type of coating	Useful design temperature limit, °F	Remarks
Cadmium	450	Most common for aerospace fasteners
Zinc	140 to 250	Self-healing and cheaper than cadmium
Phosphates:		
Manganese	225	Mildly corrosion resistant but main use is for surface treatment prior to painting.
Zinc	225 to 375	Another use is with oil or wax for deterring corrosion.
Iron	400	
Chromium	800 to 1200	Too expensive for most applications other than decorative
Silver	1600	Most expensive coating
Black oxide (and oil)	~300	Ineffective in corrosion prevention
Preoxidation (CRES) fasteners only	1200	Prevents freeze-up of CRES threads due to oxidation after installation
Nickel	1100	More expensive than cadmium or zinc
SermaGard and Sermatel W	450 to 1000	Dispersed aluminum particles with chromates in a water-based ceramic base coat
Stalgard	475	Proprietary organic and/or organic-inorganic compound used for corrosion resistance and lubrication (in some cases)
Diffused nickel-cadmium	900	Expensive and requires close control to avoid hydrogen damage

²Oil boiling point.

Ion-Vapor-Deposited Aluminum Plating

Ion-vapor-deposited aluminum plating was developed by McDonnell-Douglas for coating aircraft parts. It has some advantages over cadmium plating:

- (1) It creates no hydrogen embrittlement.
- (2) It insulates against galvanic corrosion of dissimilar materials.
- (3) The coating is acceptable up to 925 °F.
- (4) It can also be used for coating titanium and aluminums.
- (5) No toxic byproducts are formed by the process.

It also has some disadvantages:

- (1) Because the process must be done in a specially designed vacuum chamber, it is quite expensive.
- (2) Cadmium will outperform ion-vapor-deposited aluminum in a salt-spray test.

Chromium Plating

Chromium plating is commonly used for automotive and appliance decorative applications, but it is not common for fasteners. Chromium-plated fasteners cost approximately as much as stainless steel fasteners. Good chromium plating requires both copper and nickel plating prior to chromium plating. Chromium plating also has hydrogen embrittlement problems. However, it is acceptable for maximum operating temperatures of 800 to 1200 °F.

Sermatel W and SermaGard

Sermatel W and SermaGard are proprietary coatings¹ consisting of aluminum particles in an inorganic binder with chromates added to inhibit corrosion. The coating material is covered by AMS3126A, and the procedure for applying it by AMS2506. The coating is sprayed or dipped on the part and cured at 650 °F. (SPS Technologies² has tested Sermatel W-coated fasteners at 900 °F without degradation.) This coating process prevents both hydrogen embrittlement and stress corrosion, since the fastener is completely coated. Sermatel is about as effective as cadmium plating in resisting corrosion but costs about 15 percent more than cadmium. Fasteners are not presently available "off the shelf" with Sermatel W or SermaGard coating, but the company will do small orders for fasteners or mechanical parts. These coatings will take up to 15 disassemblies in a threaded area without serious coating degradation.

Stalgard

Stalgard is a proprietary coating³ process consisting of organic coatings, inorganic-organic coatings, or both for corrosion resistance. According to Stalgard test data their coatings are superior to either cadmium or zinc plating in salt-spray and weathering tests. Stalgard coatings also provide galvanic corrosion protection. However, the maximum operating temperature of these organic coatings is 475 °F.

Diffused Nickel-Cadmium Plating

This process was developed by the aerospace companies for a higher temperature cadmium coating. A 0.0004-in.-thick nickel coating is plated on the substrate, followed by a 0.0002-in.-thick cadmium plate (per AMS2416). The part is then baked for 1 hour at 645 °F. The resulting coating can withstand 1000 °F. However, the nickel plate must completely cover the part at all times to avoid cadmium damage to the part. This process is expensive and requires close control.

¹Sermatech International, Inc., Limerick, Pennsylvania.

²Jenkintown, Pennsylvania.

³Elco Industries, Rockford, Illinois.

Silver Plating

Silver plating is cost prohibitive for most fastener applications. The big exception is in the aerospace industry, where silver-plated nuts are used on stainless steel bolts. The silver serves both as a corrosion deterrent and a dry lubricant. Silver plating can be used to 1600 °F, and thus it is a good high-temperature lubricant. Since silver tarnishes from normal atmospheric exposure, the silver-plated nuts are commonly coated with clear wax to prevent tarnishing. Wax is a good room-temperature lubricant. Therefore, the normal "dry torque" values of the torque tables should be reduced by 50 percent to allow for this lubricant.

Passivation and Preoxidation

Stainless steel fasteners will create galvanic corrosion or oxidation in a joint unless they are passivated or preoxidized prior to assembly (ref. 1). Passivation is the formation of a protective oxide coating on the steel by treating it briefly with an acid. The oxide coating is almost inert. Preoxidization is the formation of an oxide coating by exposing the fasteners to approximately 1300 °F temperature in an air furnace. The surface formed is inert enough to prevent galling due to galvanic corrosion.

Black Oxide Coating

Black oxide coating, combined with an oil film, does little more than enhance the appearance of carbon steel fasteners. The oil film is the only part of the coating that prevents corrosion.

Thread Lubricants

Although there are many thread lubricants from which to choose, only a few common ones are covered here. The most common are oil, grease or wax, graphite, and molybdenum disulfide. There are also several proprietary lubricants such as Never-Seez and Synergistic Coatings. Some thread-locking compounds such as Loctite can also be used as lubricants for a bolted assembly, particularly the compounds that allow the bolts to be removed. A summary of thread lubricants is given in table III.

Oil and Grease

Although oil and grease are the most common types of thread lubricants, they are limited to an operating temperature not much greater than 250 °F. (Above this temperature the oil or grease will melt or boil off.) In addition, oil cannot be used in a vacuum environment. However, oil and grease are good for both lubrication and corrosion prevention as long as these precautions are observed.

TABLE III.—SUMMARY OF THREAD LUBRICANTS

Type of lubricant	Useful design temperature limit, °F	Remarks
Oil or grease	250	Most common; cannot be used in vacuum
Graphite	^a 212 to 250	Cannot be used in vacuum
Molybdenum disulfide	750	Can be used in vacuum
Synergistic Coatings	500	Can be used in vacuum
Neverseez	2200	Because oil boils off, must be applied after each high-temperature application
Silver Goop	1500	Do not use on aluminum or magnesium parts; extremely expensive
Thread-locking compounds	275	"Removable fastener" compounds only

^aCarrier boiloff temperature.

Graphite

"Dry" graphite is really not dry. It is fine carbon powder that needs moisture (usually oil or water) to become a lubricant. Therefore, its maximum operating temperature is limited to the boiling point of the oil or water. It also cannot be used in a vacuum environment without losing its moisture. Because dry graphite is an abrasive, its use is detrimental to the bolted joint if the preceding limitations are exceeded.

Molybdenum Disulfide

Molybdenum disulfide is one of the most popular dry lubricants. It can be used in a vacuum environment but turns to molybdenum trisulfide at approximately 750 °F. Molybdenum trisulfide is an abrasive rather than a lubricant.

Synergistic Coatings

These proprietary coatings⁴ are a type of fluorocarbon injected and baked into a porous metal-matrix coating to give both corrosion prevention and lubrication. However, the maximum operating temperature given in their sales literature is 500 °F. Synergistic Coatings will also operate in a vacuum environment.

Neverseez

This proprietary compound⁵ is a petroleum-base lubricant and anticorrosion that is satisfactory as a one-time lubricant

⁴General Magnaplate Corporation, Ventura, California.

⁵Bostic Emhart, Broadview, Illinois.

up to 2200 °F, according to the manufacturer. The oil boils off, but the compound leaves nongalling oxides of nickel, copper, and zinc between the threads. This allows the fastener to be removed, but a new application is required each time the fastener is installed. NASA Lewis personnel tested this compound and found it to be satisfactory.

Silver Goop

Silver Goop is a proprietary compound⁶ containing 20 to 30 percent silver. Silver Goop can be used to 1500 °F, but it is not to be used on aluminum or magnesium. It is extremely expensive because of its silver content.

Thread-Locking Compounds

Some of the removable thread-locking compounds (such as Loctite) also serve as antigalling and lubricating substances. However, they are epoxies, which have a maximum operating temperature of approximately 275 °F.

Corrosion

Galvanic Corrosion

Galvanic corrosion is set up when two dissimilar metals are in the presence of an electrolyte, such as moisture. A galvanic cell is created and the most active (anode) of the two materials is eroded and deposited on the least active (cathode). Note that the farther apart two materials are in the following list, the greater the galvanic action between them.

According to reference 2 the galvanic ranking of some common engineering materials is as follows:

- (1) Magnesium (most active)
- (2) Magnesium alloys
- (3) Zinc
- (4) Aluminum 5056
- (5) Aluminum 5052
- (6) Aluminum 1100
- (7) Cadmium
- (8) Aluminum 2024
- (9) Aluminum 7075
- (10) Mild steel
- (11) Cast iron
- (12) Ni-Resist
- (13) Type 410 stainless (active)
- (14) Type 304 stainless (active)
- (15) Type 316 stainless (active)
- (16) Lead
- (17) Tin
- (18) Muntz Metal
- (19) Nickel (active)

- (20) Inconel (active)
- (21) Yellow brass
- (22) Admiralty brass
- (23) Aluminum brass
- (24) Red brass
- (25) Copper
- (26) Silicon bronze
- (27) 70-30 Copper-nickel
- (28) Nickel (passive)
- (29) Inconel (passive)
- (30) Titanium
- (31) Monel
- (32) Type 304 stainless (passive)
- (33) Type 316 stainless (passive)
- (34) Silver
- (35) Graphite
- (36) Gold (least active)

Note the difference between active and passive 304 and 316 stainless steels. The difference here is that passivation of stainless steels is done either by oxidizing in an air furnace or treating the surface with an acid to cause an oxide to form. This oxide surface is quite inert in both cases and deters galvanic activity.

Because the anode is eroded in a galvanic cell, it should be the larger mass in the cell. Therefore, it is poor design practice to use carbon steel fasteners in a stainless steel or copper assembly. Stainless steel fasteners can be used in carbon steel assemblies, since the carbon steel mass is the anode.

Magnesium is frequently used in lightweight designs because of its high strength to weight ratio. However, it must be totally insulated from fasteners by an inert coating such as zinc chromate primer to prevent extreme galvanic corrosion. Cadmium- or zinc-plated fasteners are closest to magnesium in the galvanic series and would be the most compatible if the insulation coating were damaged.

Stress Corrosion

Stress corrosion occurs when a tensile-stressed part is placed in a corrosive environment. An otherwise ductile part will fail at a stress much lower than its yield strength because of surface imperfections (usually pits or cracks) created by the corrosive environment. In general, the higher the heat-treating temperature of the material (and the lower the ductility), the more susceptible it is to stress corrosion cracking.

The fastener material manufacturers have been forced to develop alloys that are less sensitive to stress corrosion. Of the stainless steels, A286 is the best fastener material for aerospace usage. It is not susceptible to stress corrosion but usually is produced only up to 160-ksi strength (220-ksi A286 fasteners are available on special order). The higher strength stainless steel fasteners (180 to 220 ksi) are usually made of 17-7PH or 17-4PH, which are stress corrosion susceptible. Fasteners made of superalloys such as Inconel 718 or MP35N are available if cost and schedule are not restricted.

⁶Swagelok Company, Solon, Ohio.

An alternative is to use a high-strength carbon steel (such as H-11 tool steel with an ultimate tensile strength of 300 ksi) and provide corrosion protection. However, it is preferable to use more fasteners of the ordinary variety and strength, if possible, than to use a few high-strength fasteners. High-strength fasteners (greater than 180 ksi) bring on problems such as brittleness, critical flaws, forged heads, cold rolling of threads, and the necessity for stringent quality control procedures. Quality control procedures such as x-ray, dye penetrant, magnetic particle, thread radius, and head radius inspections are commonly used for high-strength fasteners.

Hydrogen Embrittlement

Hydrogen embrittlement occurs whenever there is free hydrogen in close association with the metal. Since most plating processes are the electrolytic bath type, free hydrogen is present. There are three types of hydrogen-metal problems:

(1) Hydrogen chemical reaction: Hydrogen reacts with the carbon in steel to form methane gas, which can lead to crack development and strength reduction. Hydrogen can also react with alloying elements such as titanium, niobium, or tantalum to form hydrides. Because the hydrides are not as strong as the parent alloy, they reduce the overall strength of the part.

(2) Internal hydrogen embrittlement: Hydrogen can remain in solution interstitially (between lattices in the grain structure) and can cause delayed failures after proof testing. There is no external indication that the hydrogen is present.

(3) Hydrogen environment embrittlement: This problem is only present in a high-pressure hydrogen environment such as a hydrogen storage tank. Unless a fastener was under stress inside such a pressure vessel, this condition would not be present.

Most plating specifications now state that a plated carbon steel fastener "shall be baked for not less than 23 hours at 375 ± 25 °F within 2 hours after plating to provide hydrogen embrittlement relief" (per MIL-N-25027D). In the past the plating specifications required baking at 375 ± 25 °F for only 3 hours within 4 hours after plating. This treatment was found to be inadequate, and most plating specifications were revised in 1981–82 to reflect the longer baking time. Hydrogen embrittlement problems also increase as the fastener strength increases.

Cadmium Embrittlement

Although hydrogen embrittlement failure of materials is well documented (ref. 3), the effects of cadmium embrittlement are not. In general, hydrogen embrittlement failure of cadmium-plated parts can start as low as 325 °F, but cadmium embrittlement can start around 400 °F. Since both elements are normally present in elevated-temperature failure of cadmium-plated parts, the combined effect of the two can be disastrous. However, the individual effect of each is indeterminate.

Locking Methods

Tapped Holes

In a tapped hole the locking technique is normally on the fastener. One notable exception is the Spiralock⁷ tap shown in figure 1. The Spiralock thread form has a 30° wedge ramp at its root. Under clamp load the crests of the male threads are wedged tightly against the ramp. This makes lateral movement, which causes loosening under vibration, nearly impossible. Independent tests by some of the aerospace companies have indicated that this type of thread is satisfactory for moderate resistance to vibration. The bolt can have a standard thread, since the tapped hole does all the locking.

Locknuts

There are various types of locking elements, with the common principle being to bind (or wedge) the nut thread to the bolt threads. Some of the more common locknuts are covered here.

Split beam.—The split-beam locknut (fig. 2) has slots in the top, and the thread diameter is undersized in the slotted portion. The nut spins freely until the bolt threads get to the slotted area. The split "beam" segments are deflected outward by the bolt, and a friction load results from binding of the mating threads.

Wedge ramps resist transverse movement

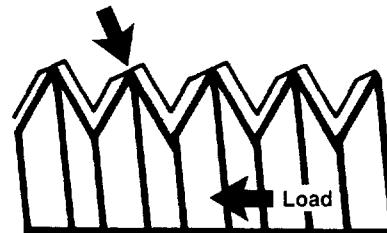


Figure 1.—Spiralock thread.

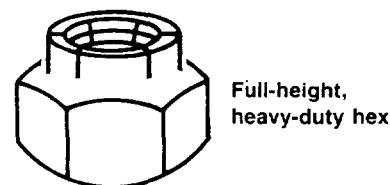


Figure 2.—Split-beam locknut.

⁷Distributed by Detroit Tap & Tool Company, Detroit, Michigan, through license from H.D. Holmes.

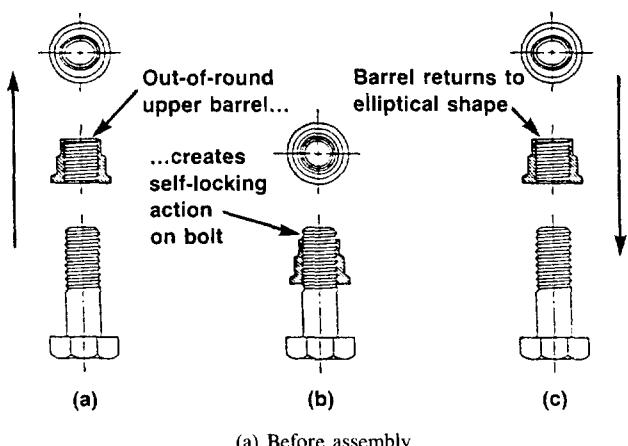


Figure 3.—Deformed-thread locknut.

Deformed thread.—The deformed-thread locknut (fig. 3) is a common locknut, particularly in the aerospace industry. Its advantages are as follows:

- (1) The nut can be formed in one operation.
- (2) The temperature range is limited only by the parent metal, its plating, or both.
- (3) The nut can be reused approximately 10 times before it has to be discarded for loss of locking capability.

Nylok pellet.—The Nylok⁸ pellet (of nylon) is usually installed in the nut threads as shown in figure 4. A pellet or patch projects from the threads. When mating threads engage, compression creates a counterforce that results in locking contact. The main drawback of this pellet is that its maximum operating temperature is approximately 250 °F. The nylon pellet will also be damaged quickly by reassembly.

Locking collar and seal.—A fiber or nylon washer is mounted in the top of the nut as shown in figure 5. The collar has an interference fit such that it binds on the bolt threads. It also provides some sealing action from gas and moisture leakage. Once again the limiting feature of this nut is the approximate 250 °F temperature limit of the locking collar.

A cost-saving method sometimes used instead of a collar or nylon pellet is to bond a nylon patch on the threads of either the nut or the bolt to get some locking action. This method is also used on short thread lengths, where a drilled hole for a locking pellet could cause severe stress concentration.

Castellated nut.—The castellated nut normally has six slots as shown in figure 6(a). The bolt has a single hole through its threaded end. The nut is torqued to its desired torque value. It is then rotated forward or backward (depending on the user's

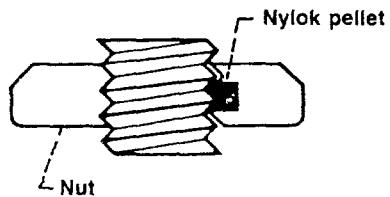


Figure 4.—Nylok pellet locknut.

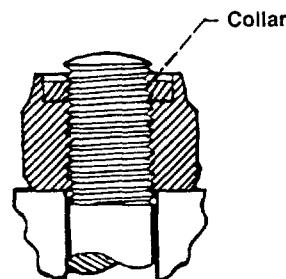


Figure 5.—Locking collar.

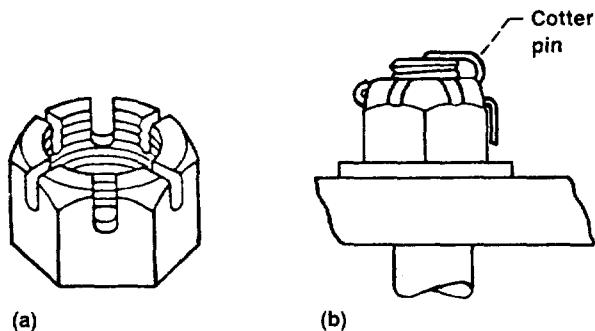


Figure 6.—Castellated nut.

preference) to the nearest slot that aligns with the drilled hole in the bolt. A cotter pin is then installed to lock the nut in place as shown in figure 6(b). This nut works extremely well for low-torque applications such as holding a wheel bearing in place.

Jam nuts.—These nuts are normally “jammed” together as shown in figure 7, although the “experts” cannot agree on which nut should be on the bottom. However, this type of assembly is too unpredictable to be reliable. If the inner nut is torqued tighter than the outer nut, the inner nut will yield before the outer nut can pick up its full load. On the other hand, if the outer nut is tightened more than the inner nut, the inner nut unloads. Then the outer nut will yield before the inner nut can pick up its full load. It would be rare to get the correct amount of torque on each nut. A locknut is a much more practical choice than a regular nut and a jam nut. However, a jam nut can be used on a turnbuckle, where it does not carry any of the tension load.

⁸Nylok Fastener Corporation, Rochester, Michigan.

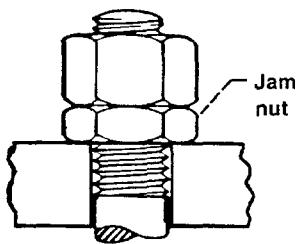


Figure 7.—Jam nut.

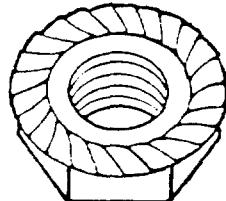
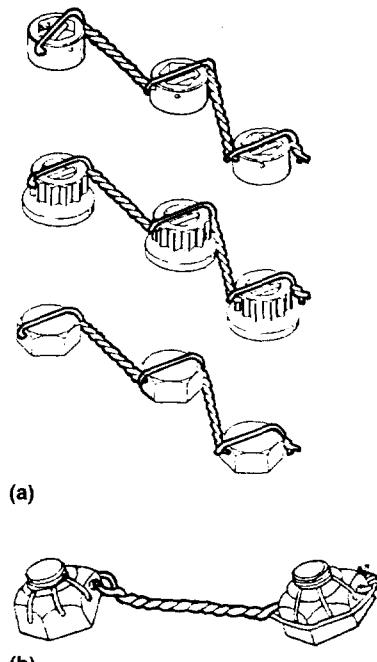


Figure 8.—Durlock nut.

Serrated-face nut (or bolthead).—The serrated face of this nut (shown in fig. 8) digs into the bearing surface during final tightening. This means that it cannot be used with a washer or on surfaces where scratches or corrosion could be a problem.

According to SPS Technologies, their serrated-face bolts (Durlock 180) require 110 percent of tightening torque to loosen them. Their tests on these bolts have shown them to have excellent vibration resistance.

Lockwiring.—Although lockwiring is a laborious method of preventing bolt or nut rotation, it is still used in critical applications, particularly in the aerospace field. The nuts usually have drilled corners, and the bolts either have throughholes in the head or drilled corners to thread the lockwire through. A typical bolthead lockwiring assembly is shown in figure 9(a), and a typical nut lockwiring assembly is shown in figure 9(b).



(a) Multiple fastener application (double-twist method, single hole).
 (b) Castellated nuts on undrilled studs (double-twist method).

Figure 9.—Lockwiring.

Direct interfering thread.—A direct interfering thread has an oversized root diameter that gives a slight interference fit between the mating threads. It is commonly used on threaded studs for semipermanent installations, rather than on bolts and nuts, since the interference fit does damage the threads.

Tapered thread.—The tapered thread is a variation of the direct interfering thread, but the difference is that the minor diameter is tapered to interfere on the last three or four threads of a nut or bolt as shown in figure 10.

Nutplates.—A nutplate (fig. 11) is normally used as a blind nut. They can be fixed or floating. In addition, they can have

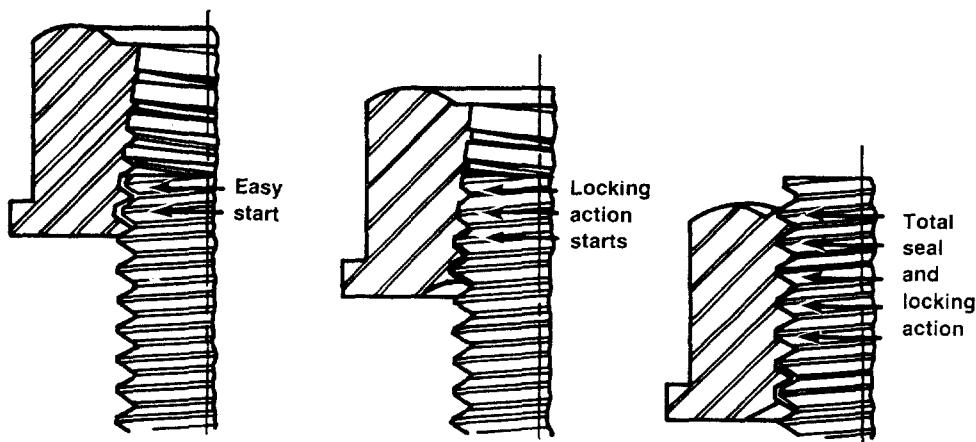


Figure 10.—Tapered thread.

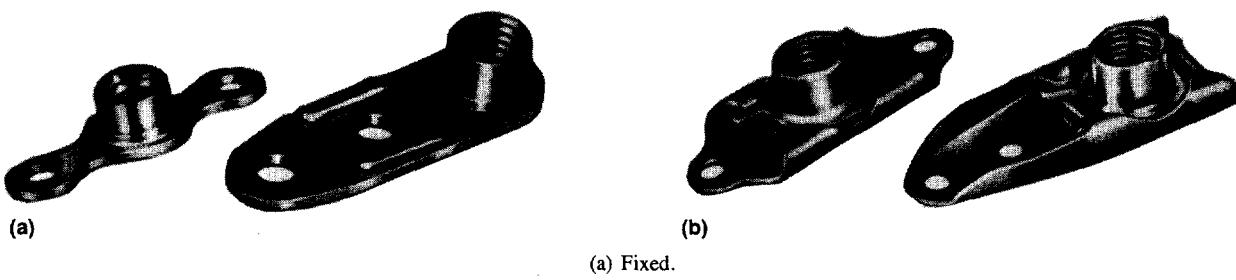


Figure 11.—Nutplate.

most of the locking and sealing features of a regular nut. Nutplates are usually used on materials too thin to tap. They are used primarily by the aerospace companies, since their installation is expensive. At least three drilled holes and two rivets are required for each nutplate installation.

Locking Adhesives

Many manufacturers make locking adhesives (or epoxies) for locking threads. Most major manufacturers make several grades of locking adhesive, so that the frequency of disassembly can be matched to the locking capability of the adhesive. For example, Loctite 242 is for removable fasteners, and Loctite 271⁹ is for tamperproof fasteners. Other manufacturers such as Bostik, ND Industries, Nylock, 3M, and Permaloc make similar products.

Most of these adhesives work in one of two ways. They are either a single mixture that hardens when it becomes a thin layer in the absence of air or an epoxy in two layers that does not harden until it is mixed and compressed between the mating threads. Note that the two-layer adhesives are usually put on the fastener as a "ribbon" or ring by the manufacturer. These ribbons or rings do have some shelf life, as long as they are not inadvertently mixed or damaged.

These adhesives are usually effective as thread sealers as well. However, *none of them will take high temperatures*. The best adhesives will function at 450 °F; the worst ones will function at only 200 °F.

Washers

Belleville Washers

Belleville washers (fig. 12) are conical washers used more for maintaining a uniform tension load on a bolt than for locking. If they are not completely flattened out, they serve as a spring in the bolt joint. However, unless they have serrations on their surfaces, they have no significant locking capability. Of course, the serrations will damage the mating surfaces under them. These washers can be stacked in

combinations as shown in figure 13 to either increase the total spring length (figs. 13(a) and (c)) or increase the spring constant (fig. 13(b)).

Lockwashers

The typical helical spring washer shown in figure 14 is made of slightly trapezoidal wire formed into a helix of one coil so that the free height is approximately twice the thickness of the washer cross section. They are usually made of hardened carbon steel, but they are also available in aluminum, silicon, bronze, phosphor-bronze, stainless steel, and K-Monel.

The lockwasher serves as a spring while the bolt is being tightened. However, the washer is normally flat by the time the bolt is fully torqued. At this time it is equivalent to a solid flat washer, and its locking ability is nonexistent. In summary, a lockwasher of this type is useless for locking.

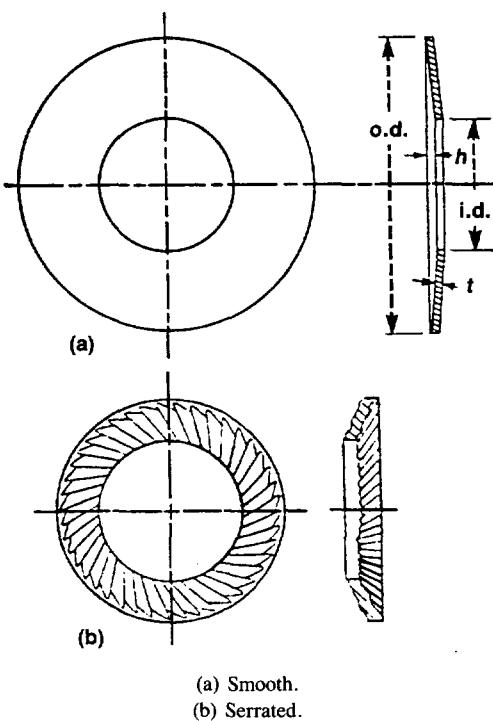
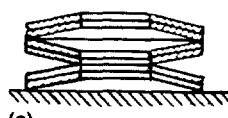
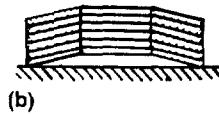
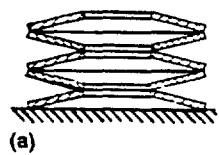


Figure 12.—Types of Belleville washers.

⁹Loctite Corporation, Newington, Connecticut.



(a) In series.
(b) In parallel.
(c) In-parallel series.

Figure 13.—Combinations of Belleville washers.



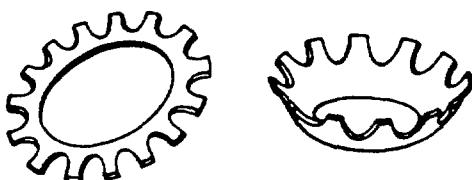
Figure 14.—Helical spring washers.

Tooth (or Star) Lockwashers

Tooth lockwashers (fig. 15) are used with screws and nuts for some spring action but mostly for locking action. The teeth are formed in a twisted configuration with sharp edges. One edge bites into the bolthead (or nut) while the other edge bites into the mating surface. Although this washer does provide some locking action, it damages the mating surfaces. These scratches can cause crack formation in highly stressed fasteners, in mating parts, or both, as well as increased corrosion susceptibility.

Self-Aligning Washers

A self-aligning washer is used with a mating nut that has conical faces as shown in figure 16. Because there is both a weight penalty and a severe cost penalty for using this nut, it should be used only as a last resort. Maintaining parallel mating surfaces within acceptable limits (2° per SAE Handbook (ref. 4)) is normally the better alternative.



(a) Flat.
(b) Countersunk.

Figure 15.—Tooth lockwashers.

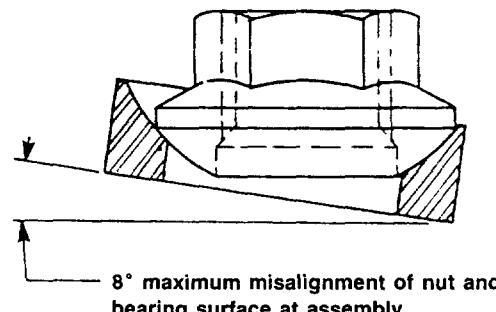


Figure 16.—Self-aligning nut.

Inserts

An insert is a special type of device that is threaded on its inside diameter and locked with threads or protrusions on its outside diameter in a drilled, molded, or tapped hole. It is used to provide a strong, wear-resistant tapped hole in a soft material such as plastic and nonferrous materials, as well as to repair stripped threads in a tapped hole.

The aerospace industry uses inserts in tapped holes in soft materials in order to utilize small high-strength fasteners to save weight. The bigger external thread of the insert (nominally 1/8 in. bigger in diameter than the internal thread) gives, for example, a 10-32 bolt in an equivalent 5/16-18 nut.

In general, there are two types of inserts: those that are threaded externally, and those that are locked by some method other than threads (knurling, serrations, grooves, or interference fit). Within the threaded inserts there are three types: the wire thread, the self-tapping, and the solid bushing.

Threaded Inserts

Wire thread.—The wire thread type of insert (Heli-coil¹⁰)

¹⁰Emhart Fastening Systems Group, Heli-Coil Division, Danbury, Connecticut.

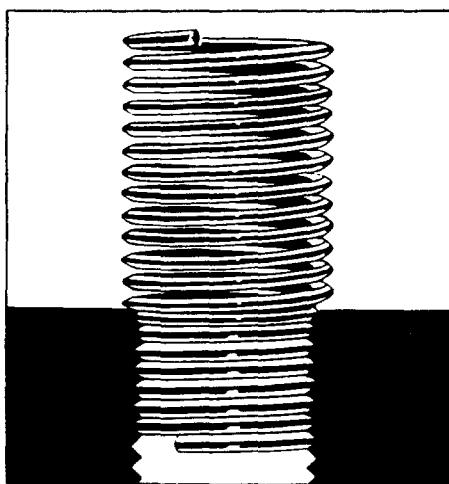
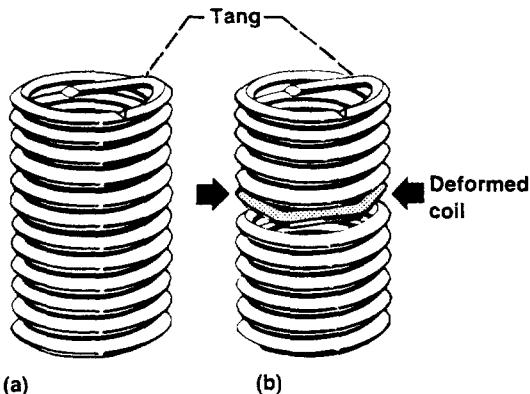


Figure 17.—Wire thread insert installation.



(a) Free running.
(b) Locking.

Figure 18.—Wire thread insert types.

is a precision coil of diamond-shaped CRES wire that forms both external and internal threads as shown in figure 17. The coil is made slightly oversize so that it will have an interference fit in the tapped hole. In addition, this insert is available with a deformed coil (fig. 18) for additional locking. The tang is broken off at the notch after installation.

The wire thread insert is the most popular type for repair of a tapped hole with stripped threads, since it requires the least amount of hole enlargement. However, the solid bushing insert is preferred if space permits.

Self-tapping.—Most of the self-tapping inserts are the solid bushing type made with a tapered external thread similar to a self-tapping screw (fig. 19). There are several different

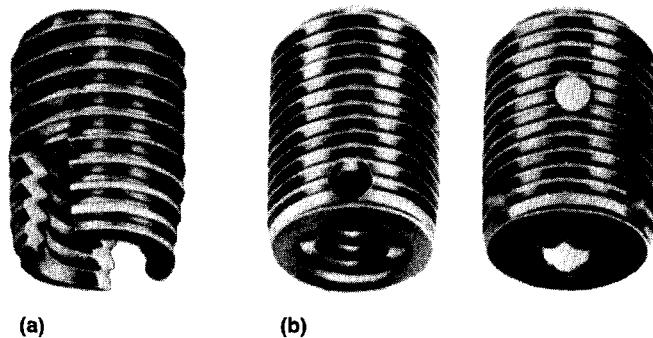


Figure 19.—Self-tapping inserts.

locking combinations, such as the Nylok plug (fig. 19(b)) or the thread-forming Speedsert¹¹ deformed thread (fig. 20). An additional advantage of the thread-forming insert is that it generates no cutting chips, since it does not cut the threads. However, it can only be used in softer materials.

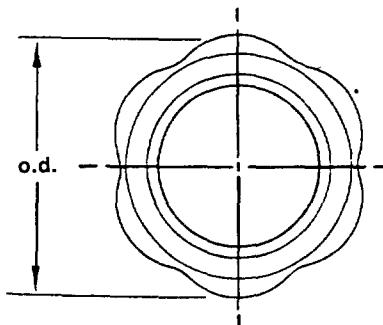
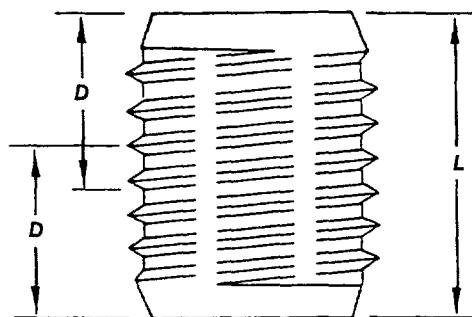


Figure 20.—Speedsert.

¹¹Rexnord Specialty Fasteners Division, Torrance, California.

Solid bushing.—Solid bushing inserts have conventional threads both internally and externally. A popular type is the Keensert¹¹ shown in figure 21. The locking keys are driven in after the insert is in place. Another manufacturer uses a two-prong ring for locking. These inserts are also available with distorted external thread or Nylok plugs for locking.

Figure 21.—Keensert.

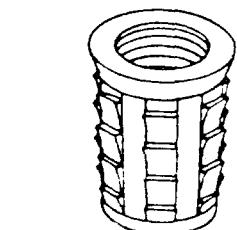


Figure 22.—Plastic expandable insert.

Nonthreaded Inserts

Plastic expandable.—The most familiar of the nonthreaded inserts is the plastic expandable type shown in figure 22. This insert has barbs on the outside and longitudinal slits that allow it to expand outward as the threaded fastener is installed, pushing the barbs into the wall of the drilled hole. (See ref. 5.)

Molded in place.—This type of insert (fig. 23) is knurled or serrated to resist both pullout and rotation. It is commonly used with ceramics, rubber, and plastics, since it can develop higher resistance to both pullout and rotation in these materials than self-tapping or conventionally threaded inserts. (See ref. 5.)

Ultrasonic.—Ultrasonic inserts (fig. 24) have grooves in various directions to give them locking strength. They are installed in a prepared hole by pushing them in while they are being ultrasonically vibrated. The ultrasonic vibration melts the wall of the hole locally so that the insert grooves are “welded” in place. Since the area melted is small, these inserts do not have the holding power of those that are molded in place. Ultrasonic inserts are limited to use in thermoplastics. (See ref. 5.)



Figure 23.—Molded-in-place insert.

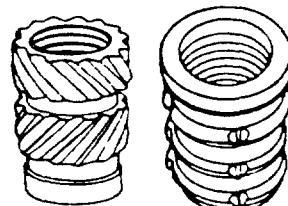


Figure 24.—Ultrasonic inserts.

Threads

Types of Threads

Since complete information on most threads can be found in the ANSI standards (ref. 6), the SAE Handbook (ref. 4), and the National Institute of Standards and Technology (formerly the National Bureau of Standards) Handbook H-28 (ref. 7) no thread standards will be included in this handbook. The goal here is to explain the common thread types, along with their advantages and disadvantages. The common thread types are unified national coarse (UNC), unified national fine (UNF), unified national extra fine (UNEF), UNJC, UNJF, UNR, UNK, and constant-pitch threads.

Unified national coarse.—UNC is the most commonly used thread on general-purpose fasteners. Coarse threads are deeper than fine threads and are easier to assemble without cross threading. The manufacturing tolerances can be larger than for finer threads, allowing for higher plating tolerances. UNC threads are normally easier to remove when corroded, owing to their sloppy fit. However, a UNC fastener can be procured with a class 3 (tighter) fit if needed (classes to be covered later).

Unified national fine.—UNF thread has a larger minor diameter than UNC thread, which gives UNF fasteners slightly higher load-carrying and better torque-locking capabilities than UNC fasteners of the same identical material and outside diameter. The fine threads have tighter manufacturing tolerances than UNC threads, and the smaller lead angle allows for finer tension adjustment. UNF threads are the most widely used threads in the aerospace industry.

Unified national extra fine.—UNEF is a still finer type of thread than UNF and is common to the aerospace field. This thread is particularly advantageous for tapped holes in hard materials and for thin threaded walls, as well as for tapped holes in thin materials.

UNJC and UNJF threads.—“J” threads are made in both external and internal forms. The external thread has a much larger root radius than the corresponding UNC, UNR, UNK, or UNF threads. This radius is mandatory and its inspection is required, whereas no root radius is required on UNC, UNF, or UNEF threads. Since the larger root radius increases the minor diameter, a UNJF or UNJC fastener has a larger net tensile area than a corresponding UNF or UNC fastener. This root radius also gives a smaller stress concentration factor in the threaded section. Therefore, high-strength (≥ 180 ksi) bolts usually have “J” threads.

UNR threads.—The UNR external thread is a rolled UN thread in all respects except that the root radius must be rounded. However, the root radius and the minor diameter are not checked or toleranced. There is no internal UNR thread.

UNK threads.—The UNK external threads are similar to UNR threads, except that the root radius and the minor diameter are toleranced and inspected. There is no internal UNK thread.

According to a survey of manufacturers conducted by the Industrial Fasteners Institute, nearly all manufacturers of externally threaded fasteners make UNR rolled threads rather than plain UN. The only exception is for ground or cut threads.

Constant-pitch threads.—These threads offer a selection of pitches that can be matched with various diameters to fit a particular design. This is a common practice for bolts of 1-in. diameter and above, with the pitches of 8, 12, or 16 threads per inch being the most common.

A graphical and tabular explanation of UN, UNR, UNK, and UNJ threads is given on page M-6 of reference 8. A copy (fig. 25) is enclosed here for reference.

Classes of Threads

Thread classes are distinguished from each other by the amounts of tolerance and allowance. The designations run from 1A to 3A and 1B to 3B for external and internal threads, respectively. A class 1 is a looser fitting, general-purpose thread; a class 3 is the closer-toleranced aerospace standard thread. (The individual tolerances and sizes for the various classes are given in the SAE Handbook (ref 4).)

Forming of Threads

Threads may be cut, hot rolled, or cold rolled. The most common manufacturing method is to cold form both the head and the threads for bolts up to 1 in. in diameter. For bolts above 1-in. diameter and high-strength smaller bolts, the heads are hot forged. The threads are still cold rolled until the bolt size prohibits the material displacement necessary to form the threads (up to a constant pitch of eight threads per inch). Threads are cut only at assembly with taps and dies or by lathe cutting.

Cold rolling has the additional advantage of increasing the strength of the bolt threads through the high compressive surface stresses, similar to the effects of shot peening. This process makes the threads more resistant to fatigue cracking.

Fatigue-Resistant Bolts

If a bolt is cycled in tension, it will normally break near the end of the threaded portion because this is the area of maximum stress concentration. In order to lessen the stress concentration factor, the bolt shank can be machined down to the root diameter of the threads. Then it will survive tensile cyclic loading much longer than a standard bolt with the shank diameter equal to the thread outside diameter.

Fatigue (Cyclic) Loading of Bolts

The bolted joint in figure 26 (from ref. 9) is preloaded with an initial load F_i , which equals the clamping load F_c , before the external load F_e is applied. The equation (from ref. 11) for this assembly is

$$F_b = F_i + \left(\frac{K_b}{K_b + K_c} \right) F_e$$

where F_b is the total bolt load. In this equation K_b is the spring constant of the bolt and K_c is the spring constant of the clamped faces. To see the effects of the relative spring constants, let $R = K_c/K_b$. Then (from ref. 10)

$$F_b = F_i + \left(\frac{1}{1+R} \right) F_e$$

In a normal clamped joint K_c is much larger than K_b ($R \approx 5.0$ for steel bolt and flanges), so that the bolt load does not increase much as the initial external load F_e is applied. (Note that the bolt load does not increase significantly until F_e exceeds F_i .)

In order to further clarify the effect of externally applied loads, a series of triangular diagrams (fig. 27, from ref. 11) can be used to illustrate loading conditions.

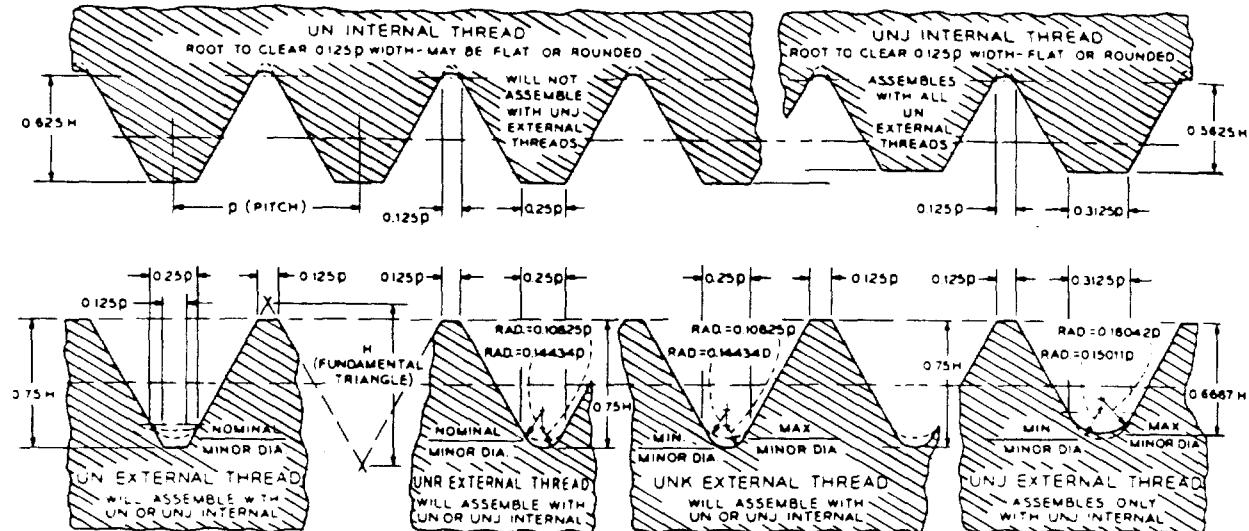
Triangle OAB is identical in all four diagrams. The slope of OA represents the bolt stiffness; the slope of AB represents the joint stiffness (joint is stiffer than bolt by ratio OC/CB.) In figure 27(a) the externally applied load $F_e(a)$ does not load the bolt to its yield point. In figure 27(b) the bolt is loaded by $F_e(b)$ to its yield point, with the corresponding decrease in clamping load to F_{CL} . In figure 27(c) external load $F_e(c)$ has caused the bolt to take a permanent elongation such that the clamping force will be less than F_i when $F_e(c)$ is removed. In figure 27(d) the joint has completely separated on its way to bolt failure.

Note that the flatter the slope of OA (or the larger the ratio OC/OB becomes), the smaller the effect F_e has on bolt load. Therefore, using more smaller-diameter fasteners rather than a few large-diameter fasteners will give a more fatigue-resistant joint.

Referring to figure 27(a), note that the cyclic (alternating) load is that portion above F_i . This is the alternating load

This page is not a screw thread standard, should not be used as a working sheet, and should only refer the reader to the proper ANSI Standards document wherein the full thread details and working data are contained.

60° SCREW THREAD NOMINAL FORMS (SEE ANSI STANDARDS FOR FURTHER DETAILS)



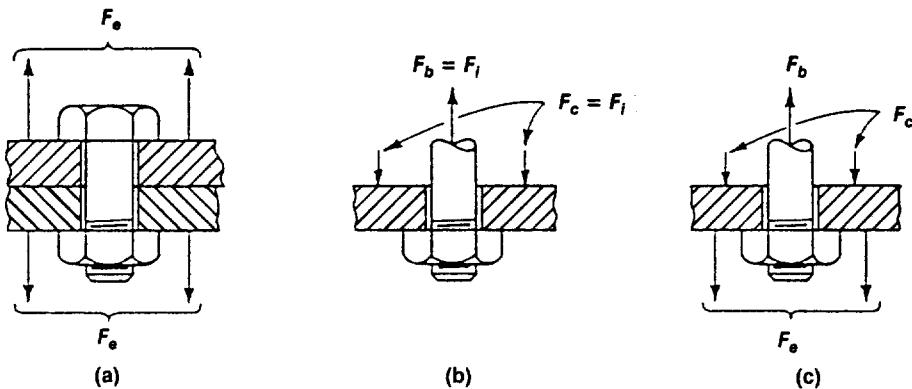
THREAD IDENTIFICATION	UN THREADS	UNR THREADS	UNK THREADS	UNJ THREADS
ANSI STANDARDS DOCUMENTS	Internal and External	External Only	External Only	Internal and External
	Unified Screw Threads B1.1-1960 (See Page M-7); Metric Translation B1.1a-1968 Gages and Gaging for Unified Screw Threads B1.2-1966	Unified Screw Threads B1.1-1960 See Page M-7; Metric Translation B1.1a-1968 Draft! UNR Addendum to B1.1-1960 (See Page M-19) Gages and Gaging for Unified Screw Threads B1.2-1966	Draft! B1.14 for Form and Conformance	Draft! B1.15 for Form and Conformance; No Radius Required on Internal Thread.
EXTERNAL ROOT	External Thread Root may be Flat or Rounded	External Thread Root Radius Required	External Thread Root Radius Mandatory Check Required	External Thread Root Radius Mandatory Check Required
EXTERNAL MINOR DIAMETER	External Thread Minor Diameter is not Toleranced	External Thread Minor Diameter is not Toleranced	External Thread Minor Diameter is Toleranced	External Thread Minor Diameter is Toleranced
EXTERNAL THREADS	UN Classes 1A, 2A and 3A	UNR Classes 1A, 2A and 3A	UNK Classes 2A and 3A	UNJ Class 3A Mates only with UNJ Internal Threads
INTERNAL THREADS	UN Classes 1B, 2B and 3B	No Internal Threads Designated UNR UNR Mates with UN Internal Thread	No Internal Threads Designated UNK Mates with UN or UNJ Internal Thread	UNJ Classes 3B and 3BG - No Radius Required on Internal Thread
ANGLE AND LEAD TOLERANCE	Individually Equivalent to 50% of P.D. Tolerance Checked only when Specified	Individually Equivalent to 50% of P.D. Tolerance Checked only when Specified	Individually Equivalent to 40% of P.D. Tolerance Mandatory Check Required	Individually Equivalent to 40% of P.D. Tolerance Mandatory Check Required

NOTES: 1. Refer to the appropriate Standards, as listed, for complete thread details and conformance data. The appropriate current Standard is the authoritative document

for complete details and data, and takes precedence over this sheet.

2. These Standards may be obtained through ASME

Figure 25.—Explanation of UN, UNR, UNK, and UNJ threads. (From ref. 8.) Reprinted with permission of Industrial Fasteners Institute.



(a) Bolted flanges with external load.
 (b) Free body with no external load.
 (c) Free body with external load.

Figure 26.—Fatigue loading of bolts.

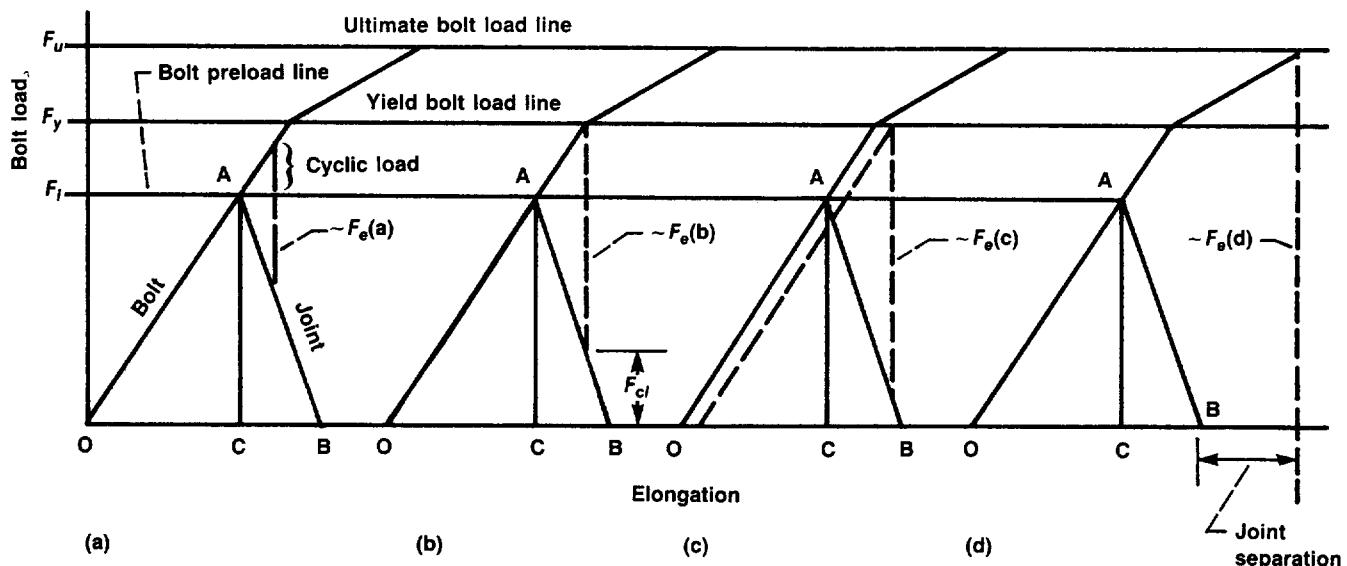


Figure 27.—Bolt external loading.

(stress) to be used on a stress-versus-load-cycles diagram of the bolt material to predict the fatigue life of the bolts. Note that an initial preload F_i near the bolt yields minimizes cyclic loading.

Thermal Cyclic Loading of Bolts

If the bolt and joint are of different materials, an operating temperature higher or lower than the installation temperature can cause problems. Differential contraction can cause the joint to unload (or separate); differential expansion can cause overloading of the fasteners. In these cases it is common practice to use conical washers (see washer section of this manual) to give additional adjustments in fastener and joint loading.

Fastener Torque

Determining the proper torque for a fastener is the biggest problem in fastener installation. Some of the many variables causing problems are

- (1) The coefficient of friction between mating threads
- (2) The coefficient of friction between the bolthead (or nut) and its mating surface
- (3) The effect of bolt coatings and lubricants on the friction coefficients
- (4) The percentage of bolt tensile strength to be used for preload
- (5) Once agreement is reached on item 4, how to accurately determine this value
- (6) Relative spring rates of the structure and the bolts

TABLE IV.—COEFFICIENTS OF STATIC AND SLIDING FRICTION
[From ref. 12.]

Materials	Sliding			Materials			Sliding		
	Dry	Greasy	Dry	Dry	Greasy	Dry	Greasy	Dry	Greasy
Hard steel on hard steel	0.78(1)	0.11(1,a)	0.42(2)	0.029(5,k)	Tungsten carbide on tungsten carbide	0.2(22)	0.12(22,a)
.....	0.23(1,b)	0.08(5,e)	Tungsten carbide on steel	0.5(22)	0.08 (22,a)
.....	0.15(1,c)	0.08(5,i)	Tungsten carbide on copper	0.35(23)
.....	0.11(1,d)	0.058(5,j)	Tungsten carbide on iron	0.8(23)
.....	0.0075(18,p)	0.084(5,d)	Bonded carbide on copper	0.35(23)
.....	0.0052(18,h)	0.105(5,k)	Bonded carbide on iron	0.8(23)
.....	0.096(5,l)	Cadmium on mild steel	0.46(3)
.....	0.108(5,m)	Copper on mild steel	0.53(8)	0.36(3)	0.18(17,a)
Mild steel on mild steel	0.74(19)	0.57(3)	0.12(5,a)	Nickel on nickel	1.10(16)	0.53(3)	0.12(3,w)
.....	0.21(1)	0.09(1,a)	0.09(3,a)	Brass on mild steel	0.51(8)	0.44(6)
.....	0.70(11)	0.23(1,b)	0.33(6)	0.16(1,b)	Brass on cast iron	0.30(6)
.....	0.15(1,c)	0.06(1,c)	0.11(1,d)	Zinc on cast iron	0.85(16)	0.2(7)
.....	0.08(1,d)	0.07(1,d)	Magnesium on cast iron	1.05(16)	0.25(7)
.....	0.085(1,e)	Copper on cast iron	1.05(16)	0.29(7)
.....	0.35(11)	0.14(1,b)	0.14(1,b)	0.065(1,c)	Tin on cast iron	0.32(7)
.....	0.17(1,b)	0.07(1,d)	0.08(1,h)	Lead on cast iron	0.43(7)
.....	0.42(11)	0.11(1,c)	0.13(1,b)	0.065(1,c)	Aluminum on aluminum	1.05(16)	1.4(3)
.....	0.09(1,d)	0.055(1,d)	0.08(1,h)	Glass on glass	0.94(8)	0.01(10,p)	0.40(3)	0.09(3,a)
.....	0.08(1,e)	0.07(1,d)	0.13(1,b)	Carbon on glass	0.005(10,q)	0.116(3,v)
.....	0.25(1,b)	0.06(1,c)	0.06(1,c)	Garnet on mild steel	0.18(3)
.....	0.12(1,c)	0.055(1,d)	0.055(1,d)	Glass on nickel	0.78(8)	0.39(3)
.....	0.10(1,d)	Copper on glass	0.68(8)	0.56(3)
.....	0.11(1,e)	Cast iron on cast iron	1.10(16)	0.53(3)
.....	0.34(3)	0.097(2,f)	0.173(2,f)	0.145(2,f)	Bronze on cast iron	0.15(9)	0.070(9,d)	0.064(9,n)
.....	0.23(6)	0.133(2,f)	0.13(1,f)	Oak on oak (parallel to grain)	0.62(9)	0.22(9)	0.77(9,n)	0.77(9,n)
.....	0.95(11)	0.5(1,f)	0.95(11)	0.3(11,f)	Oak on oak (perpendicular)	0.54(9)	0.48(9)	0.164(9,r)	0.164(9,r)
.....	0.64(3)	0.178(3,x)	0.47(3)	0.42(3)	Leather on oak (parallel)	0.61(9)	0.53(3)	0.067(9,s)	0.067(9,s)
.....	0.61(8)	Cast iron on oak	0.32(9)	0.072(9,s)	0.072(9,s)
.....	0.6(22)	0.08(22,y)	0.04(22,f)	Leather on cast iron	0.52(9)
.....	0.04(22)	0.04(22,f)	0.04(22,f)	Laminated plastic on steel	0.49(9)	0.075(9,n)	0.075(9,n)
Teflon on steel	0.04(22)	0.04(22,f)	0.04(22,f)	Fluted rubber bearing on steel	0.56(9)	0.36(9,t)	0.36(9,t)
.....	0.35(12)	0.13(9,n)	0.13(9,n)
.....	0.05(13,i)	0.05(13,i)	0.05(13,i)

(1) Campbell, *Trans. ASME*, 1939; (2) Clarke, Lincoln, and Sterrett, *Proc. API*, 1935; (3) Beare and Bowden, *Phil. Trans. Roy. Soc.*, 1985; (4) Dokos, *Trans. ASME*, 1946; (5) Boyd and Robertson, *Trans. ASME*, 1945; (6) Sachs, *Zeit f. angew. Math. und Mech.*, 1924; (7) Honda and Yamada, *Jour. I. M.* 1925; (8) Tomlinson, *Phil. Mag.*, 1929; (9) Morin, *Acad. Roy. des Sciences*, 1838; (10) Claypoole, *Trans. ASME*, 1943; (11) Tabor, *Jour. Applied Phys.*, 1945; (12) Eysen, General Discussion on Lubrication, *ASME*, 1937; (13) Brazier and Holland-Bowyer, General Discussion on Lubrication, *ASME*, 1937; (14) Burwell, *Jour. SAE*, 1942; (15) Stanton, "Friction", Longmans, Ernest and Merchant, Conference on Friction and Surface Finish, M.I.T., 1940; (16) Gongwer, Conference on Friction and Surface Finish, M.I.T., 1940; (17) Hardy and Bircumshaw, *Proc. Roy.*

Soc., 1925; (19) Hardy and Hardy, *Phil. Mag.*, 1919; (20) Bowden and Young, *Proc. Roy. Soc.*, 1951; (21) Hardy and Doubleday, *Proc. Roy. Soc.*, 1923; (22) Bowden and Tabor, "The Friction and Lubrication of Solids," Oxford; (23) Shoorer, *Research*, 4, 1951.

(a) Oleic acid; (b) Atlantic spindle oil (light mineral); (c) castor oil; (d) lard oil; (e) Atlantic spindle oil plus 2 percent oleic acid; (f) medium mineral oil; (g) medium mineral oil plus ½ percent oleic acid; (h) stearic acid; (i) grease (zinc oxide base); (j) graphic; (k) turbine oil plus 1 percent graphite; (l) turbine oil plus 1 percent stearic acid; (m) turbine oil (medium mineral); (n) olive oil; (o) palmitic acid; (q) ricinoleic acid; (r) dry soap; (s) lard; (t) water; (u) rape oil; (v) 3-in-1 oil; (w) octyl alcohol; (x) triolein; (y) 1 percent lauric acid in paraffin oil.

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- (7) Interaction formulas to be used for combining simultaneous shear and tension loads on a bolt (Should friction loads due to bolt clamping action be included in the interaction calculations?)
- (8) Whether "running torque" for a locking device should be added to the normal torque

Development of Torque Tables

The coefficient of friction can vary from 0.04 to 1.10, depending on the materials and the lubricants being used between mating materials. (Table IV from ref. 12 gives a variety of friction coefficients.) Since calculated torque values are a function of the friction coefficients between mating threads and between the bolthead or nut and its mating surface, it is vitally important that the torque table values used are adjusted to reflect any differences in friction coefficients between those used to calculate the table and the user's values. Running torque should be included in the values listed in the tables because any torque puts shear load on the bolt.

The torque values in table V have been calculated as noted in the footnotes, by using formulas from reference 13. (A similar table was published in *Product Engineering* by Arthur Korn around 1944.)

Higher torques (up to theoretical yield) are sometimes used for bolts that cannot be locked to resist vibration. The higher load will increase the vibration resistance of the bolt, but the bolt will yield and unload if its yield point is inadvertently exceeded. Since the exact yield torque cannot be determined without extensive instrumentation, it is not advisable to torque close to the bolt yield point.

Fastener proof load is sometimes listed in the literature. This value is usually 75 percent of theoretical yield, to prevent inadvertent yielding of the fastener through torque measurement inaccuracies.

Alternative Torque Formula

A popular formula for quick bolt torque calculations is $T = KFd$, where T denotes torque, F denotes axial load, d denotes bolt diameter, and K (torque coefficient) is a calculated value from the formula:

$$K = \left(\frac{d_m}{2d} \right) \frac{\tan \psi + \mu \sec \alpha}{1 - \mu \tan \psi \sec \alpha} + 0.625\mu_c$$

as given in reference 14 (p. 378) where

d_m thread mean diameter

ψ thread helix angle

μ friction coefficient between threads

α thread angle

μ_c friction coefficient between bolthead (or nut) and clamping surface

The commonly assumed value for K is 0.2, but this value should not be used blindly. Table VI gives some calculated values of K for various friction coefficients. A more realistic "typical" value for K would be 0.15 for steel on steel. Note that μ and μ_c are not necessarily equal, although equal values were used for the calculated values in table VI.

Torque-Measuring Methods

A number of torque-measuring methods exist, starting with the mechanic's "feel" and ending with installing strain gages on the bolt. The accuracy in determining the applied torque values is cost dependent. Tables VII and VIII are by two different "experts," and their numbers vary. However, they both show the same trends of cost versus torque accuracy.

Design Criteria

Finding Shear Loads on Fastener Group

When the load on a fastener group is eccentric, the first task is to find the centroid of the group. In many cases the pattern will be symmetrical, as shown in figure 28. The next step is to divide the load R by the number of fasteners n to get the direct shear load P_c (fig. 29(a)). Next, find $\sum r_n^2$ for the group of fasteners, where r_n is the radial distance of each fastener from the centroid of the group. Now calculate the moment about the centroid ($M = Re$ from fig. 28). The contributing shear load for a particular fastener due to the moment can be found by the formula

$$P_e = \frac{Mr}{\sum r_n^2}$$

where r is the distance (in inches) from the centroid to the fastener in question (usually the outermost one). Note that this is analogous to the torsion formula, $f = Tr/J$, except that P_e is in pounds instead of stress. The two loads (P_c and P_e) can now be added vectorially as shown in figure 29(c) to get the resultant shear load P (in pounds) on each fastener. Note that the fastener areas are all the same here. If they are unequal, the areas must be weighted for determining the centroid of the pattern.

Further information on this subject may be found in references 16 and 17.

Finding Tension Loads on Fastener Group

This procedure is similar to the shear load determination, except that the centroid of the fastener group may not be the geometric centroid. This method is illustrated by the bolted bracket shown in figure 30.

The pattern of eight fasteners is symmetrical, so that the tension load per fastener from P_1 will be $P_1/8$. The additional

TABLE V.—BOLT TORQUE

[No lubrication on threads. Torque values are based on friction coefficients of 0.12 between threads and 0.14 between nut and washer or head and washer, as manufactured (no special cleaning).]

Size	Root area, in. ²	Torque range (class 8, 150 ksi, bolts ^a)
10-24	0.0145	23 to 34 in.-lb
10-32	.0175	29 to 43 in.-lb
1/4-20	.0269	54 to 81 in.-lb
1/4-4-28	.0326	68 to 102 in.-lb
5/16-18	.0454	117 to 176 in.-lb
5/16-24	.0524	139 to 208 in.-lb
3/8-16	.0678	205 to 308 in.-lb
3/8-24	.0809	230 to 345 in.-lb
7/16-14	.0903	28 to 42 ft-lb
7/16-20	.1090	33 to 50 ft-lb
1/2-13	.1257	42 to 64 ft-lb
1/2-20	.1486	52 to 77 ft-lb
9/16-12	.1620	61 to 91 ft-lb
9/16-18	.1888	73 to 109 ft-lb
5/8-11	.2018	84 to 126 ft-lb
5/8-18	.2400	104 to 156 ft-lb
3/4-10	.3020	b117 to 176 ft-lb
3/4-16	.3513	b139 to 208 ft-lb
5/8-9	.4193	b184 to 276 ft-lb
5/8-14	.4805	b213 to 320 ft-lb
1-8	.5510	b276 to 414 ft-lb
1-14	.6464	b323 to 485 ft-lb
1 1/8-7	.6931	b390 to 585 ft-lb
1 1/8-12	.8118	b465 to 698 ft-lb
1 1/4-7	.8898	b559 to 838 ft-lb
1 1/4-12	1.0238	b655 to 982 ft-lb

^aThe values given are 50 and 75 percent of theoretical yield strength of a bolt material with a yield of 120 ksi. Corresponding values for materials with different yield strengths can be obtained by multiplying these table values by the ratio of the respective material yield strengths.

^bBolts of 0.75-in. diameter and larger have reduced allowables (75 percent of normal strength) owing to inability to heat treat this large a cross section to an even hardness.

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TABLE VI.—TORQUE COEFFICIENTS

Friction coefficient		Torque coefficient, <i>K</i>
Between threads, <i>μ</i>	Between bolthead (or nut) and clamping surface, <i>μ_c</i>	
0.05	0.05	0.074
.10	.10	.133
.15	.15	.189
.20	.20	.250

TABLE VII.—INDUSTRIAL FASTENERS
INSTITUTE'S TORQUE-MEASURING METHOD

[From ref. 8.]

Preload measuring method	Accuracy, percent	Relative cost
Feel (operator's judgment)	± 35	1
Torque wrench	± 25	1.5
Turn of the nut	± 15	3
Load-indicating washers	± 10	7
Fastener elongation	± 3 to 5	15
Strain gages	± 1	20

moment P_2h will also produce a tensile load on some fasteners, but the problem is to determine the "neutral axis" line where the bracket will go from tension to compression. If the plate is thick enough to take the entire moment P_2h in bending at the edge AB, that line could be used as the heeling point, or neutral axis. However, in this case, I have taken the conservative approach that the plate will not take the bending and will heel at the line CD. Now the $\sum r_n^2$ will only include bolts 3 to 8, and the r_n 's (in inches) will be measured from line CD. Bolts 7 and 8 will have the highest tensile loads (in pounds), which will be $P = P_T + P_M$, where $P_T = P_1/8$ and

$$P_m = \frac{Mr}{\sum r_n^2} = \frac{P_2hr_7}{\sum r_n^2}$$

An alternative way of stating this relationship is that the bolt load is proportional to its distance from the pivot axis and the moment reacted is proportional to the sum of the squares of the respective fastener distances from the pivot axis.

At this point the applied total tensile load should be compared with the total tensile load due to fastener torque. The torque should be high enough to exceed the maximum applied tensile load in order to avoid joint loosening or leaking. If the bracket geometry is such that its bending capability cannot be readily determined, a finite element analysis of the bracket itself may be required.

Combining Shear and Tensile Fastener Loads

When a fastener is subjected to both tensile and shear loading simultaneously, the combined load must be compared with the total strength of the fastener. Load ratios and interaction curves are used to make this comparison. The load ratios are

$$R_S(\text{or } R_1) = \frac{\text{Actual shear load}}{\text{Allowable shear load}}$$

$$R_T(\text{or } R_2) = \frac{\text{Actual tensile load}}{\text{Allowable tensile load}}$$

TABLE VIII.--MACHINE DESIGN'S TORQUE-MEASURING METHOD

[From ref. 15.]

(a) Typical tool accuracies

Type of tool	Element controlled	Typical accuracy range, percent of full scale
Slug wrench	Turn	1 Flat
Bar torque wrench	Torque	± 3 to 15
	Turn	1/4 Flat
Impact wrench	Torque	± 10 to 30
	Turn	± 10 to 20°
Hydraulic wrench	Torque	± 3 to ± 10
	Turn	± 5 to 10°
Gearhead air-powered wrench	Torque	± 10 to ± 20
	Turn	± 5 to 10°
Mechanical multiplier	Torque	± 5 to 20
	Turn	± 2 to 10°
Worm-gear torque wrench	Torque	± 0.25 to 5
	Turn	± 1 to 5°
Digital torque wrench	Torque	$\pm 1/4$ to 1
	Turn	1/4 Flat
Ultrasonically controlled wrench	Bolt elongation	± 1 to 10
Hydraulic tensioner	Initial bolt stretch	± 1 to 5
Computer-controlled tensioning	Simultaneous torque and turn	± 0.5 to 2

(b) Control accuracies

Element controlled	Preload accuracy, percent	To maximize accuracy
Torque	± 15 to ± 30	Control bolt, nut, and washer hardness, dimensions, and finish. Have consistent lubricant conditions, quantities, application, and types.
Turn	± 15 to ± 30	Use consistent snug torque. Control part geometry and finish. Use new sockets and fresh lubes.
Torque and turn	± 10 to ± 25	Plot torque vs turn and compare to previously derived set of curves. Control bolt hardness, finish, and geometry.
Torque past yield	± 3 to ± 10	Use "soft" bolts and tighten well past yield point. Use consistent snugging torque. Control bolt hardness and dimensions.
Bolt stretch	± 1 to ± 8	Use bolts with flat, parallel ends. Leave transducer engaged during tightening operation. Mount transducer on bolt centerline.

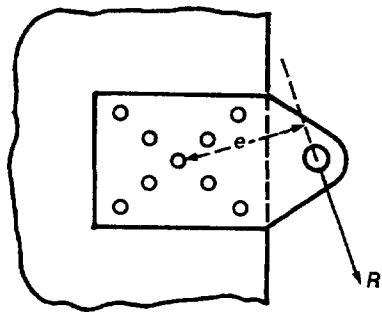


Figure 28.—Symmetrical load pattern.

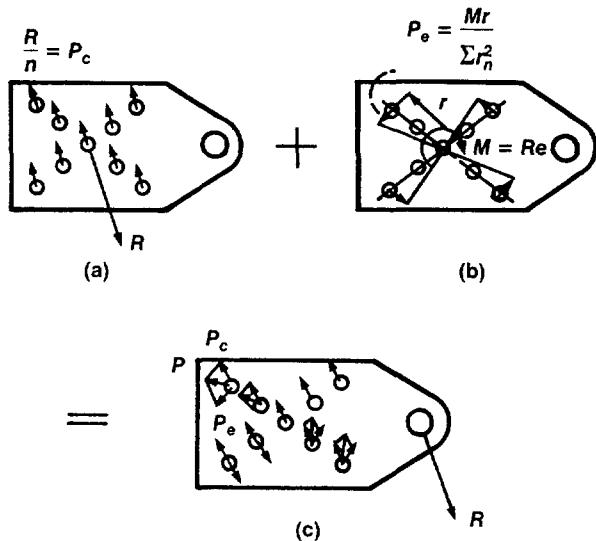


Figure 29.—Combining of shear and moment loading.

The interaction curves of figure 31 are a series of curves with their corresponding empirical equations. The most conservative is $R_1 + R_2 = 1$ and the least conservative is $R_1^3 + R_2^3 = 1$. This series of curves is from an old edition of MIL-HDBK-5. It has been replaced by a single formula, $R_S^3 + R_T^2 = 1$, in the latest edition (ref. 18). However, it is better to use $R_T + R_S = 1$ if the design can be conservative with respect to weight and stress.

Note that the interaction curves do not take into consideration the friction loads from the clamped surfaces in arriving at bolt shear loads. In some cases the friction load could reduce the bolt shear load substantially.

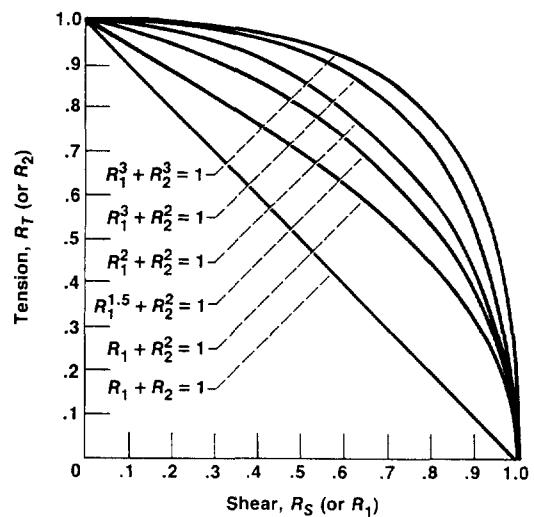


Figure 31.—Interaction curves.

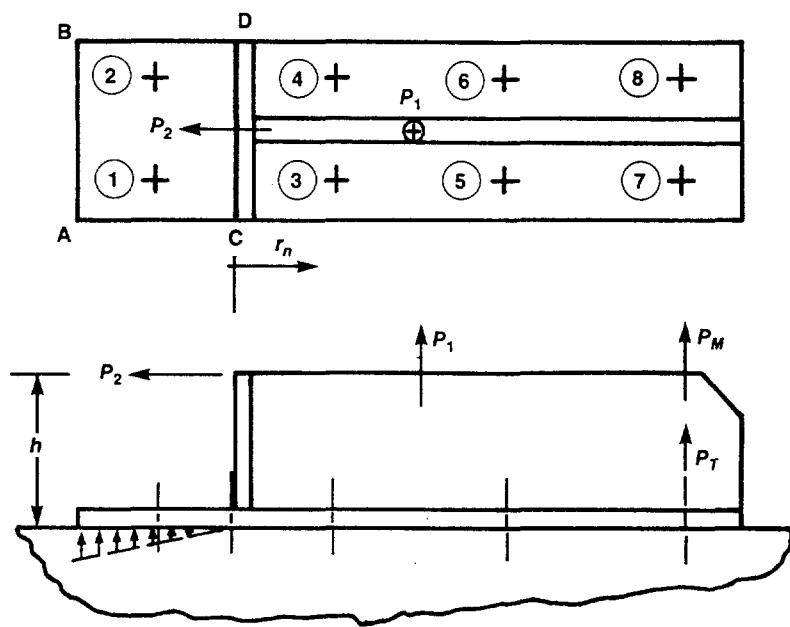


Figure 30.—Bolted bracket.

The margin of safety¹² for a fastener from figure 31 is

$$MS = \frac{1}{R_S^x + R_T^y} - 1$$

depending on which curve is used. However, note that $R_S^x + R_T^y < 1$ is a requirement for a positive margin of safety. This formula also illustrates why high torque should not be applied to a bolt when the dominant load is shear.

The margin of safety is calculated for *both* yield and ultimate material allowables, with the most critical value controlling the design. A material with a low yield will be critical for yield stress, and a material with a high yield will normally be critical for ultimate stress.

Calculating Pullout Load for Threaded Hole

In many cases a bolt of one material may be installed in a tapped hole in a different (and frequently lower strength) material. If the full strength of the bolt is required, the depth of the tapped hole must be determined for the weaker material by using the formula

$$P = \frac{\pi d_m F_s L}{3}$$

where

P pullout load, lb

d_m mean diameter of threaded hole, in. (\approx pitch diameter of threads)

F_s material ultimate or yield shear stress

L length of thread engagement, in.

The $\frac{1}{3}$ factor is empirical. If the threads were perfectly mated, this factor would be $\frac{1}{2}$, since the total cylindrical shell area of the hole would be split equally between the bolt threads and the tapped hole threads. The $\frac{1}{3}$ is used to allow for mismatch between threads.

Further information on required tapped hole lengths is given in reference 19.

Calculating Shank Diameter for "Number" Fastener

The shank diameter for a "number" fastener is calculated from

$$\text{Diameter} = 0.060 + 0.013 N$$

¹²Margin of safety is defined as

$$\frac{\text{Allowable load (Stress)}}{\text{Actual load (Stress)} \times \text{Safety factor}} - 1$$

where N is the number (4, 6, 8, 10, 12) of the fastener. For example, the shank diameter of a no. 8 fastener is

$$\text{Diameter} = 0.060 + 0.013(8) = 0.164 \text{ in.}$$

Fastener Groups in Bearing (Shear Loading)

Whenever possible, bolts in shear should have a higher shear strength than the bearing yield strength of the materials they go through. Since the bolts have some clearance and position tolerances in their respective holes, the sheet material must yield in bearing to allow the bolt pattern to load all of the bolts equally at a given location in the pattern. Note that the sloppier the hole locations, the more an individual bolt must carry before the load is distributed over the pattern.

Bolts and rivets should not be used together to carry a load, since the rivets are usually installed with an interference fit. Thus, the rivets will carry all of the load until the sheet or the rivets yield enough for the bolts to pick up some load. This policy also applies to bolts and dowel pins (or roll pins) in a pattern, since these pins also have interference fits.

Fastener Edge Distance and Spacing

Common design practice is to use a nominal edge distance $\approx 2D$ from the fastener hole centerline, where D is the fastener diameter. The minimum edge distance should not be less than $1.5D$. The nominal distance between fasteners is $4D$, but the thickness of the materials being joined can be a significant factor. For thin materials, buckling between fasteners can be a problem. A wider spacing can be used on thicker sheets, as long as sealing of surfaces between fasteners is not a problem.

Approximate Bearing and Shear Allowables

In the absence of specific shear and bearing allowables for materials, the following approximations may be used:

$$\text{Alloy and carbon steels: } F_{su} = 0.6 F_{tu}$$

$$\text{Stainless steels: } F_{su} = 0.55 F_{tu}$$

where F_{su} is ultimate shear stress and F_{tu} is ultimate tensile stress. Since bearing stress allowables are empirical to begin with, the bearing allowable for any given metallic alloy may be approximated as follows:

$$F_{bu} = 1.5 F_{tu}$$

$$F_{by} = 1.5 F_{ty}$$

where F_{bu} is ultimate bearing stress, F_{by} is yield bearing stress, and F_{ty} is tensile yield stress.

Proper Fastener Geometry

Most military standard (MS) and national aerospace standard (NAS) fasteners have coded callouts that tell the diameter, grip length, drilling of the head or shank, and the material (where the fastener is available in more than one material). Rather than listing a group of definitions, it is easier to use the NAS 1003 to NAS 1020 (fig. 32) as an example to point out the following:

(1) The last two digits give the fastener diameter in sixteenths of an inch.

(2) The first dash number is the grip length in sixteenths of an inch.

(3) The letters given with the dash number indicate the head and/or shank drilling.

In addition, an identifying letter or dash number is added to indicate the fastener material. However, this systematic practice is not rigidly followed in all MS and NAS fastener standards.

Shear Heads and Nuts

In the aerospace industry the general ground rule is to design such that fasteners are primarily in shear rather than tension. As a result, many boltheads and nuts are made about one-half as thick as normal to save weight. These bolts and nuts are referred to as shear bolts and shear nuts, and care must be used in never specifying them for tension applications. The torque table values must also be reduced to one-half for these bolts and nuts.

Use of Proper Grip Length

Standard design practice is to choose a grip length such that the threads are never in bearing (shear). Where an exact grip length is not available, the thickness of the washers used under the nut or bolthead can be varied enough to allow proper grip.

Bolthead and Screwhead Styles

Although the difference between bolts and screws is not clearly defined by industry, at least the head styles are fairly well defined. The only discrepancy found in figure 33 is that the plain head, with a square shoulder, is more commonly called a carriage bolthead. The angle of countersunk heads (flat) can vary from 60° to 120°, but the common values are 82° and 100°.

Counterfeit Fasteners

In the past two years a great deal of concern and publicity about counterfeit fasteners has surfaced. The counterfeit case with the most documentation is the deliberate marking of grade 8.2 boron bolts as grade 8 bolts.

Grade 8.2 bolts are a low-carbon (0.22 percent C) boron alloy steel that can be heat treated to the same room-temperature hardness as grade 8 medium-carbon (0.37 percent C) steel. However, the room- and elevated-temperature strengths of the grade 8.2 bolts drop drastically if they are exposed to temperatures above 500 °F. Grade 8 bolts can be used to 800 °F with little loss of room-temperature strength.

Other fasteners marked as MS and NAS but not up to the respective MS or NAS specification have shown up; however, documentation is not readily available. Since these fasteners are imported and have no manufacturer's identification mark on them, it is not possible to trace them back to the guilty manufacturer. U.S. Customs inspections have not been effective in intercepting counterfeit fasteners.

Another problem with fasteners has been the substitution of zinc coating for cadmium coating. If a dye is used with the zinc, the only way to detect the difference in coatings is by chemical testing.

Federal legislation to establish control of fastener materials from the material producer to the consumer is being formulated.

Bolthead Identification

Identifying an existing non-MS, non-NAS, or non-Air Force-Navy bolt is usually a problem. Each manufacturer seems to have a different system. Frank Akstens of Fastener Technology International magazine (ref. 20) has compiled a good listing of several hundred "common" bolts. His entire compilation is enclosed as appendix A of this report. An international guide to bolt manufacturer's identification symbols has also been published by Fastener Technology International magazine.

Fastener Strength

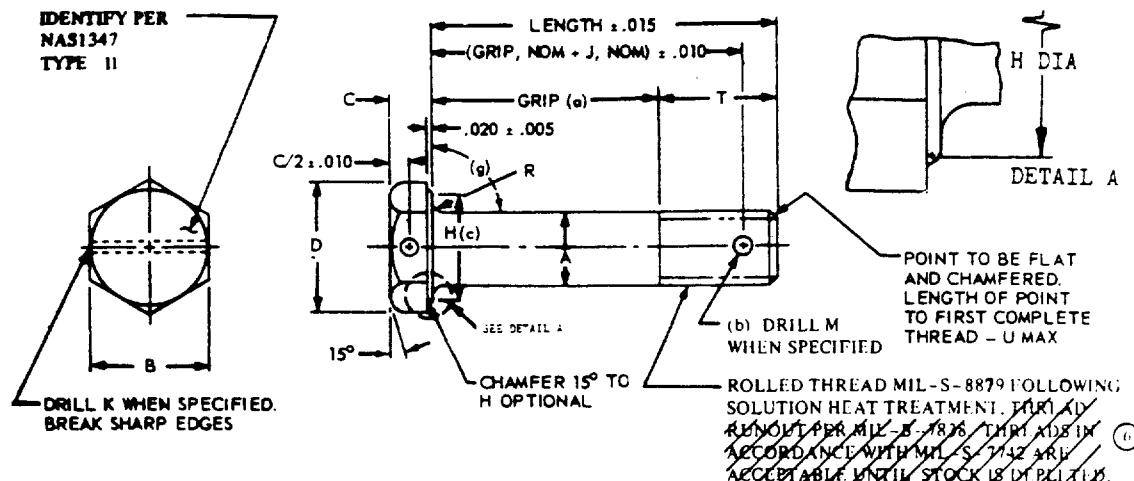
Allowable strengths for many types of fasteners are given in MIL-HDBK-5 (ref. 18). Ultimate shear and tensile strengths of various threaded fasteners are given in appendix B of this report.

NATIONAL AEROSPACE STANDARD

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA INC. 1725 DE SALES STREET N W WASHINGTON D C 20036

ALL AND THE COMMITTEE WILL NOT INTERFERE WITH OR HARM OTHER OWNERS AND IN RESPECTIVE USES
DO NOT ASK ANY LIABILITY TO PATENT OWNERS OR TO PROTECTIVE USES

IDENTIFY PER
NAS1347
TYPE II



BASIC PART NUMBER	THREAD UNJF-3A	A DIA	B	C	D	E	H(c)	J	K	M(b)	R (RAD)	T	U	X (d)	Y (e)	Z (f)
			MAX	MIN	REF	DIA	NOM	DIA	MAX	MIN	MAX	MIN	REF	U	X (d)	Y (e)
NAS1003	.1900-32	.1895 .1870	.376	.367	.125	.43	.335	.266	.046	.070	.020	.010	.481	.05	.005	.0045
NAS1004	.2500-28	.2495 .2470	.439	.430	.156	.51	.398	.312	.046	.076	.020	.010	.544	.05	.006	.0045
NAS1005	.3125-24	.3120 .3095	.501	.492	.188	.58	.460	.359	.070	.076	.020	.010	.632	.06	.008	.0045
NAS1006	.3750-24	.3745 .3720	.564	.554	.219	.65	.523	.438	.070	.106	.025	.015	.663	.06	.009	.0060
NAS1007	.4375-20	.4370 .4345	.689	.679	.250	.79	.648	.484	.070	.104	.025	.015	.745	.08	.010	.0060
NAS1008	.5000-20	.4995 .4970	.751	.741	.281	.87	.710	.609	.070	.106	.030	.020	.842	.08	.011	.0060
NAS1009	.5625-18	.5615 .5585	.876	.865	.312	.101	.835	.656	.070	.141	.035	.020	.947	.09	.012	.0060
NAS1010	.6250-18	.6240 .6210	.939	.928	.344	.109	.898	.734	.070	.141	.040	.025	.1042	.09	.013	.0060
NAS1012	.7500-16	.7490 .7460	1.064	1.053	.406	1.23	1.023	.875	.070	.141	.045	.030	1.189	.10	.018	.0090
NAS1014	.8750-14	.8740 .8716	1.252	1.239	.469	1.44	1.210	.984	.070	.141	.050	.035	1.356	.11	.020	.0090
NAS1016	1.0000-12	.9990 .9960	1.440	1.427	.531	1.66	1.398	1.094	.070	.141	.060	.045	1.481	.13	.022	.0090
NAS1018	1.1250-12	1.1240 1.1200	1.627	1.614	.594	1.88	1.585	1.188	.070	.141	.070	.055	1.658	.13	.025	.0090
NAS1020	1.2500-12	1.2490 1.2450	1.815	1.801	.656	2.10	1.772	1.375	.070	.141	.075	.060	1.846	.13	.028	.0120

~~NAS1016~~ (6) NAS1016A INACTIVE FOR DESIGN AFTER JULY 1, 1979

LIST OF CURRENT SHEETS	
NO.	REV
1	6
2	3
3	1

CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE

PROCUREMENT SPECIFICATION	TITLE	CLASSIFICATION STANDARD PART
NONE	BOLT - MACHINE HEXAGON HEAD, NON MAGNETIC, & HEAT RESISTANT	NAS 1003 THRU 1020 SHEET 1 OF 3

Published and distributed by: National Standards Association, Inc.
4827 Argyle Ave.
Washington, D. C. 20014

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Figure 32.—National aerospace standard for proper fastener geometry.

APPROVAL DATE April 1956 REVISION (1) July 1958 (2) 15 Nov. 1961 (3) 30 March 1962 (4) 31 May 1963 (5) 15 Mar. 1967 (6) 6 August 1979

NATIONAL AEROSPACE STANDARD

AEROSPACE INDUSTRIES ASSOCIATION OF AMERICA, INC. 1725 DE SALES STREET N. W. WASHINGTON, D. C. 20036

CODE: BASIC PART NUMBER DESIGNATES NOMINAL DIAMETER.
 DASH NUMBER DESIGNATES GRIP AND LENGTH (SEE SHEET 3).
 ADD "A" TO DASH NUMBER FOR UNDRILLED BOLT.
 ADD "H" TO DASH NUMBER FOR DRILLED HEAD ONLY.
 NO CODE LETTER DESIGNATES DRILLED SHANK ONLY.

EXAMPLE: NAS1003-8 = .1900 DIAMETER BOLT, .500 GRIP, DRILLED SHANK ONLY.
 NAS1003-8A = .1900 DIAMETER BOLT, .500 GRIP, UNDRILLED.
 NAS1003-8H = .1900 DIAMETER BOLT, .500 GRIP, DRILLED HEAD ONLY.

MATERIAL: CRES, A-286 SPEC AMS5735 OR AMS5737.06. ~~01504204, SPEC AMS5733~~, EXCEPT ULTIMATE TENSILE STRENGTH 140,000 PSI MINIMUM AT ROOM TEMPERATURE, FABRICATED TO AMS7478.

FINISH: CLEAN AND PASSIVATE IN ACCORDANCE WITH ~~ASME S-5002~~ QQ-P-35

- NOTES: 1. REFERENCE DIMENSIONS ARE FOR DESIGN PURPOSES ONLY AND NOT AN INSPECTION REQUIREMENT.
 2. MAGNETIC PERMEABILITY SHALL BE LESS THAN 2.0 (AIR = 1.0) FOR A FIELD STRENGTH H = 200 OERSTEDS (MAGNETIC PERMEABILITY INDICATOR PBR MIL-I-17214 OR EQUIVALENT).
 3. BOLTS SHALL BE FREE FROM BURRS AND SLIVERS.
 4. THESE BOLTS ARE INTENDED FOR USE AT TEMPERATURES UP TO 1200 F.
 (a) 5. GRIP LENGTH: FROM UNDER SIDE OF HEAD TO END OF FULL CYLINDRICAL PORTION OF SHANK.
 (b) 6. COFFEE PIN HOLE CENTERLINE: WITHIN .010 AND NORMAL WITHIN 2° OF BOLT CENTERLINE.
 (c) 7. "H" DIA MAXIMUM NOT TO EXCEED "B"; MINIMUM DIA AT TOP OF HEAD NOT LESS THAN "H".
 (d) 8. CONCENTRICITY: "H" AND "A" DIAMETERS WITHIN "X" VALUES TIR; "A" AND THREAD PITCH DIAMETER WITHIN "Y" VALUES TIR.
 (e) 9. SHANK STRAIGHTNESS: WITHIN "Z" VALUES TIR PER INCH OF LENGTH.
 (f) 10. BEARING SURFACE SQUARENESS: WITHIN .005 TIR WITH SHANK.
 11. DIMENSIONS IN INCHES.
 TOLERANCES UNLESS OTHERWISE SPECIFIED: ANGLES $\pm 5^\circ$

(3) DISCALOY INACTIVE FOR DESIGN AFTER JULY 1, 1979

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APPROVAL DATE April 1996 REVISION (1) 10 March 1962 (2) 15 May 1974 (3) 4 August 1974

Figure 32.—Continued.

NATIONAL AEROSPACE STANDARD
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DASR NO.	GRIP NO.	LENGTHS										NAS 1016	NAS 1018	NAS 1020
		NAS 1003	NAS 1004	NAS 1005	NAS 1006	NAS 1007	NAS 1008	NAS 1009	NAS 1010	NAS 1.12	NAS 1.11			
1	.062	.543	.606	.646	.725	.807	.901	1.000	1.104	1.251	1.415	1.543	1.720	1.906
2	.125	.606	.669	.757	.838	.970	.967	1.072	1.167	1.314	1.481	1.606	1.753	1.971
3	.188	.669	.732	.820	.951	.933	1.030	1.135	1.230	1.377	1.544	1.669	1.846	2.034
4	.250	.731	.794	.882	.913	.995	1.092	1.197	1.292	1.439	1.606	1.731	1.906	2.096
5	.112	.793	.856	.941	.975	1.057	1.154	1.259	1.356	1.501	1.663	1.793	1.970	2.156
6	.175	.856	.919	1.007	1.035	1.120	1.217	1.322	1.417	1.564	1.731	1.856	2.033	2.221
7	.138	.919	.982	1.070	1.101	1.183	1.280	1.385	1.480	1.627	1.794	1.919	2.096	2.284
8	.500	.981	1.044	1.132	1.163	1.245	1.342	1.447	1.542	1.689	1.856	1.981	2.158	2.446
9	.562	1.043	1.106	1.194	1.225	1.307	1.404	1.509	1.604	1.751	1.916	2.043	2.220	2.408
10	.625	1.106	1.169	1.257	1.288	1.370	1.467	1.572	1.667	1.814	1.981	2.106	2.283	2.471
11	.688	1.169	1.232	1.320	1.351	1.433	1.530	1.635	1.730	1.871	2.044	2.165	2.346	2.534
12	.750	1.231	1.294	1.382	1.411	1.495	1.592	1.697	1.792	1.939	2.106	2.231	2.406	2.596
13	.812	1.293	1.356	1.444	1.475	1.557	1.654	1.759	1.854	2.001	2.168	2.293	2.470	2.658
14	.875	1.356	1.419	1.507	1.538	1.620	1.717	1.822	1.917	2.064	2.231	2.356	2.533	2.721
15	.938	1.419	1.482	1.570	1.601	1.663	1.780	1.885	1.980	2.127	2.294	2.419	2.596	2.770
16	1.000	1.481	1.544	1.632	1.663	1.745	1.842	1.947	2.042	2.189	2.356	2.481	2.656	2.846
17	1.062	1.543	1.606	1.694	1.725	1.807	1.904	2.005	2.104	2.251	2.418	2.543	2.720	2.906
18	1.125	1.606	1.669	1.757	1.788	1.870	1.967	2.072	2.167	2.311	2.481	2.606	2.783	2.971
19	1.188	1.669	1.732	1.820	1.851	1.933	2.030	2.135	2.230	2.377	2.544	2.669	2.846	3.034
20	1.250	1.731	1.794	1.882	1.913	1.995	2.092	2.197	2.292	2.439	2.606	2.731	2.906	3.086
21	1.312	1.793	1.856	1.944	1.975	2.057	2.158	2.259	2.354	2.501	2.665	2.793	2.970	3.158
22	1.375	1.856	1.919	2.007	2.038	2.120	2.217	2.322	2.417	2.561	2.731	2.856	3.031	3.221
23	1.438	1.919	1.982	2.070	2.101	2.187	2.285	2.380	2.480	2.627	2.794	2.915	3.096	3.284
24	1.500	1.981	2.044	2.132	2.163	2.245	2.342	2.447	2.542	2.689	2.856	2.981	3.158	3.346
25	1.562	2.043	2.106	2.194	2.225	2.307	2.404	2.508	2.607	2.751	2.918	3.043	3.220	3.408
26	1.625	2.106	2.169	2.257	2.288	2.370	2.467	2.572	2.667	2.811	2.981	3.106	3.283	3.471
27	1.688	2.169	2.242	2.320	2.351	2.433	2.530	2.635	2.730	2.877	3.046	3.165	3.346	3.534
28	1.750	2.221	2.294	2.380	2.411	2.495	2.592	2.697	2.792	2.939	3.106	3.231	3.406	3.585
29	1.812	2.281	2.356	2.444	2.475	2.557	2.654	2.759	2.854	3.001	3.165	3.299	3.475	3.654
30	1.875	2.356	2.434	2.507	2.538	2.623	2.717	2.822	2.917	3.061	3.231	3.356	3.531	3.721
31	1.938	2.416	2.482	2.570	2.601	2.683	2.780	2.885	2.988	3.127	3.294	3.411	3.595	3.784
32	2.000	2.483	2.544	2.622	2.661	2.745	2.842	2.947	3.042	3.185	3.345	3.462	3.545	3.746
33	2.125	2.606	2.669	2.757	2.788	2.870	2.967	3.072	3.167	3.314	3.485	3.605	3.783	3.971
34	2.250	2.731	2.794	2.886	2.913	2.995	3.092	3.197	3.298	3.439	3.606	3.773	3.956	4.144
35	2.375	2.856	2.919	3.007	3.038	3.120	3.217	3.322	3.417	3.561	3.731	3.886	4.073	4.261
36	2.500	2.981	3.044	3.132	3.163	3.245	3.342	3.447	3.542	3.689	3.856	4.031	4.218	4.406
37	2.625	3.116	3.189	3.257	3.288	3.377	3.474	3.572	3.667	3.814	3.961	4.106	4.285	4.471
38	2.750	3.231	3.294	3.358	3.411	3.495	3.592	3.689	3.782	3.929	4.106	4.281	4.466	4.656
39	2.875	3.356	3.419	3.507	3.536	3.620	3.717	3.822	3.917	4.061	4.233	4.356	4.532	4.721
40	3.000	3.481	3.544	3.612	3.663	3.745	3.842	3.947	4.042	4.189	4.356	4.481	4.656	4.846
41	3.125	3.606	3.669	3.737	3.788	3.870	3.965	4.076	4.171	4.314	4.481	4.656	4.835	5.024
42	3.250	3.731	3.793	3.862	3.913	3.995	4.092	4.197	4.298	4.439	4.605	4.772	4.958	5.146
43	3.375	3.856	3.915	4.007	4.038	4.125	4.221	4.322	4.417	4.561	4.731	4.896	5.083	5.271
44	3.500	3.981	4.044	4.132	4.163	4.253	4.342	4.447	4.542	4.689	4.856	5.036	5.223	5.411
45	3.625	4.106	4.169	4.257	4.288	4.370	4.467	4.572	4.667	4.811	4.981	5.165	5.355	5.543
46	3.750	4.231	4.294	4.382	4.413	4.502	4.592	4.697	4.792	4.939	5.106	5.291	5.479	5.667
47	3.875	4.356	4.419	4.507	4.538	4.625	4.717	4.822	4.917	5.061	5.233	5.416	5.593	5.782
48	4.000	4.481	4.554	4.632	4.663	4.745	4.832	4.927	5.021	5.167	5.341	5.521	5.698	5.886
49	4.125	4.606	4.669	4.757	4.788	4.870	4.967	5.072	5.167	5.341	5.506	5.683	5.871	6.059
50	4.250	4.731	4.794	4.882	4.913	4.995	5.092	5.197	5.292	5.439	5.606	5.773	5.950	6.138
51	4.375	4.856	4.919	5.007	5.038	5.120	5.217	5.322	5.417	5.561	5.731	5.896	6.083	6.271
52	4.500	4.981	5.044	5.132	5.163	5.245	5.342	5.447	5.542	5.689	5.856	6.033	6.221	6.409
53	4.625	5.106	5.169	5.257	5.288	5.370	5.467	5.572	5.667	5.814	5.981	6.165	6.343	6.531
54	4.750	5.231	5.294	5.382	5.413	5.502	5.592	5.687	5.782	5.939	6.106	6.281	6.466	6.654
55	4.875	5.356	5.419	5.507	5.538	5.625	5.717	5.802	5.917	6.061	6.238	6.416	6.593	6.781
56	5.000	5.481	5.544	5.632	5.663	5.745	5.832	5.947	6.042	6.189	6.356	6.531	6.719	6.906
57	5.125	5.606	5.669	5.757	5.788	5.870	5.967	6.072	6.167	6.314	6.481	6.656	6.846	7.034
58	5.250	5.731	5.794	5.882	5.913	5.995	6.092	6.197	6.292	6.439	6.606	6.781	6.965	7.153
59	5.375	5.856	5.919	6.007	6.038	6.120	6.217	6.322	6.417	6.564	6.731	6.896	7.083	7.271
60	5.500	5.981	6.044	6.132	6.163	6.245	6.342	6.447	6.542	6.689	6.856	7.033	7.221	7.409
61	5.625	6.106	6.169	6.257	6.288	6.370	6.467	6.572	6.667	6.819	6.981	7.166	7.353	7.541
62	5.750	6.231	6.294	6.382	6.413	6.495	6.592	6.697	6.798	6.939	7.106	7.283	7.471	7.659
63	5.875	6.356	6.419	6.507	6.538	6.620	6.717	6.822	6.917	7.064	7.231	7.396	7.584	7.772
64	6.000	6.481	6.544	6.632	6.663	6.745	6.832	6.927	7.022	7.189	7.356	7.481	7.668	7.856
65	6.125	6.606	6.669	6.757	6.788	6.870	6.967	7.072	7.167	7.334	7.501	7.678	7.866	8.054
66	6.250	6.731	6.794	6.882	6.913	6.995	7.092	7.197	7.292	7.459	7.626	7.793	7.981	8.169
67	6.375	6.856	6.919	6.982	7.013	7.095	7.192	7.297	7.392	7.559	7.726	7.893	8.081	8.269
68	6.500	7.000	7.063	7.132	7.163	7.245	7.342	7.447	7.542	7.689	7.856	8.033	8.221	8.409
69	6.625	7.125	7.189	7.257	7.288	7.370	7.467	7.572	7.667	7.834	8.001	8.179	8.363	8.551
70	6.750	7.250	7.313	7.382	7.413	7.505	7.592	7.697	7.792	7.959	8.126	8.303	8.491	8.679
71	6.875	7.375	7											

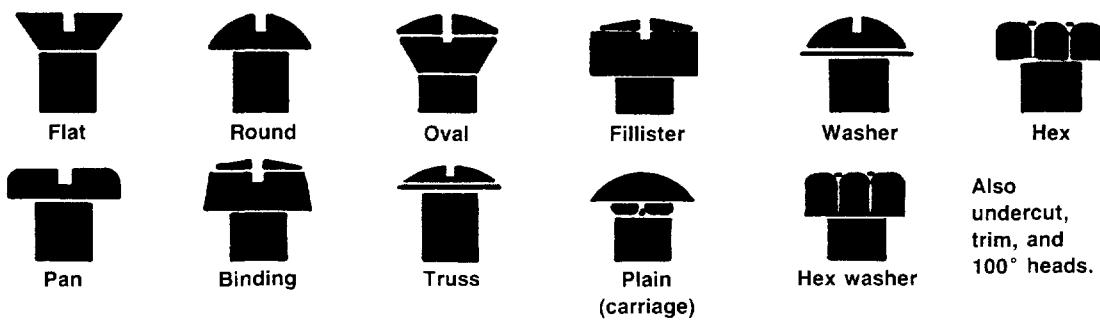


Figure 33.—Bolthead and screwhead styles.

Rivets and Lockbolts

Rivets

Rivets are relatively low-cost, permanently installed fasteners that are lighter weight than bolts. As a result, they are the most widely used fasteners in the aircraft manufacturing industry. They are faster to install than bolts and nuts, since they adapt well to automatic, high-speed installation tools. However, rivets should not be used in thick materials or in tensile applications, as their tensile strengths are quite low relative to their shear strengths. The longer the total grip length (the total thickness of sheets being joined), the more difficult it becomes to lock the rivet.

Riveted joints are neither airtight nor watertight unless special seals or coatings are used. Since rivets are permanently installed, they have to be removed by drilling them out, a laborious task.

General Rivet Types

The general types of rivets are solid, blind, tubular, and metal piercing (including split rivets). From a structural design aspect the most important rivets are the solid and blind rivets.

Solid rivets.—Most solid rivets are made of aluminum so that the shop head can be cold formed by bucking it with a pneumatic hammer. Thus, solid rivets must have cold-forming capability without cracking. A representative listing of solid rivets is given in table IX (ref. 21). Some other solid rivet materials are brass, SAE 1006 to SAE 1035, 1108 and 1109 steels, A286 stainless steel, and titanium.

Note that the rivets in table IX are covered by military standard specifications, which are readily available. Although most of the solid rivets listed in table IX have universal heads, there are other common head types, as shown in figure 34. However, because the "experts" do not necessarily agree on the names, other names have been added to the figure. Note also that the countersunk head angle can vary from 60° to 120° although 82° and 100° are the common angles.

TABLE IX.—ALUMINUM AND OTHER RIVET MATERIALS

[From ref. 21.]

Material	Rivet designation	Rivet heads available	Applications
2117-T4	AD	Universal (MS20470) 100° Flush (MS20426)	General use for most applications
2024-T4	DD	Universal (MS20470) 100° Flush (MS20426)	Use only as an alternative to 7050-T73 where higher strength is required
1100	A	Universal (MS20470) 100° Flush (MS20426)	Nonstructural
5056-H32	B	Universal (MS20470) 100° Flush (MS20426)	Joints containing magnesium
Monel (annealed)	M	Universal (MS20615) 100° Flush (MS20427)	Joining stainless steels, titanium, and Inconel
Copper (annealed)	---	100° Flush (MS20427)	Nonstructural
7050-T73	E	Universal (MS20470) 100° Flush (MS20426)	Use only where higher strength is required

The sharp edge of the countersunk head is also removed in some cases, as in the Briles¹³ BRFZ "fast" rivet (fig. 35), to increase the shear and fatigue strength while still maintaining a flush fit.

Blind rivets.—Blind rivets get their name from the fact that they can be completely installed from one side. They have the following significant advantages over solid rivets:

- (1) Only one operator is required for installation.
- (2) The installation tool is portable (comparable to an electric drill in size).

¹³Briles Rivet Corporation, Oceanside, California.

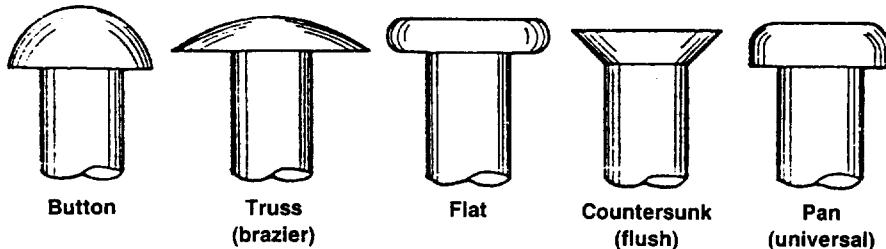


Figure 34.—United States standard rivet heads.

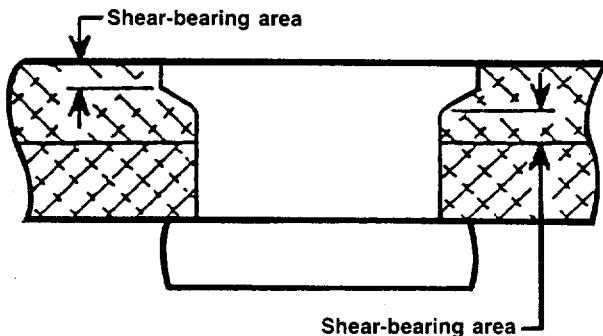


Figure 35.—BRFZ 'fast' rivet.

- (3) They can be used where only one side of the workpiece is accessible.
- (4) A given-length rivet can be used for a range of material thicknesses.
- (5) Installation time is faster than with solid rivets.
- (6) Clamping force is more uniform than with solid rivets.
- (7) Less training is required for the operator.

Blind rivets are classified according to the methods used to install them:

- (1) Pull mandrel
- (2) Threaded stem
- (3) Drive pin

Specific types (brands) of blind rivets are covered in subsequent sections of this manual.

Pull-mandrel rivets: This rivet is installed with a tool that applies force to the rivet head while pulling a prenotched serrated mandrel through to expand the far side of the tubular rivet. When the proper load is reached, the mandrel breaks at the notch. A generic pull-mandrel rivet is shown in figure 36.

Threaded-stem rivets: The threaded-stem rivet (fig. 37(a)) has a threaded internal mandrel (stem) with the external portion machined flat on two sides for the tool to grip and rotate. The head is normally hexagonal to prevent rotation of the tubular body while the mandrel is being torqued and broken off.

Drive-pin rivets: This rivet has a drive pin that spreads the far side of the rivet to form a head, as shown in figure 38. Although drive-pin rivets can be installed quickly, they are

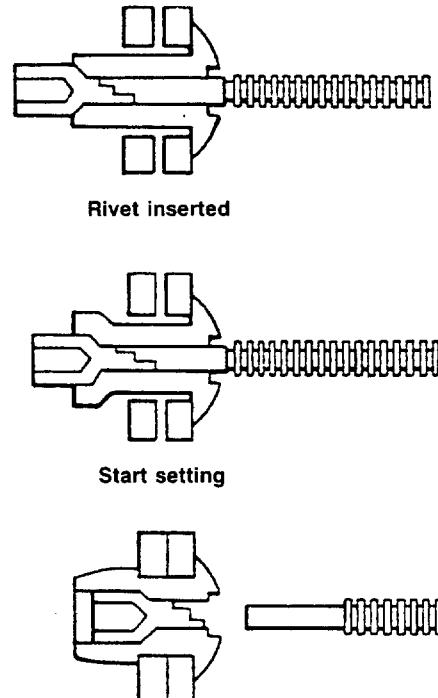


Figure 36.—Pull-mandrel rivet. (From ref. 5.)

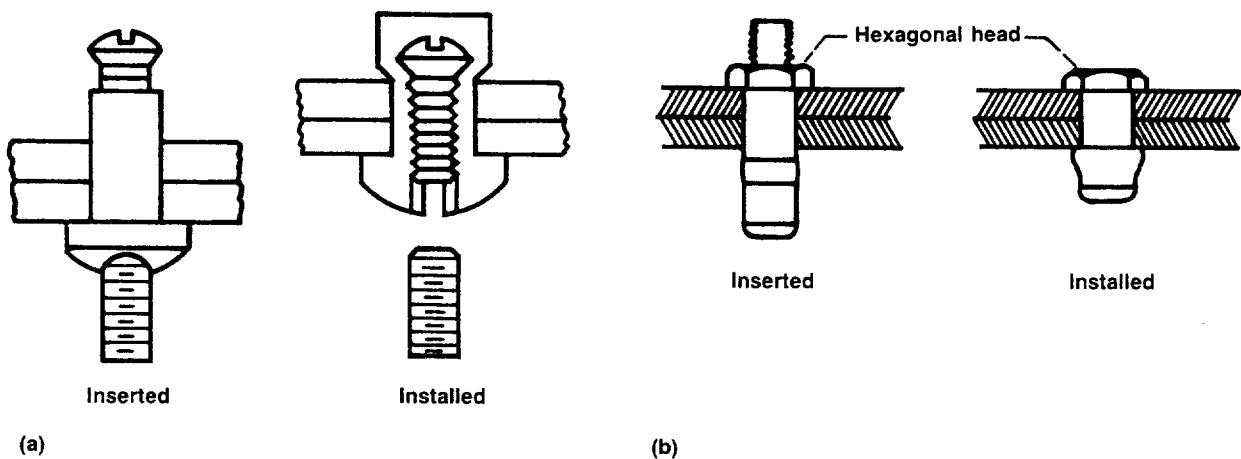
usually not used in aerospace applications. They are used primarily for commercial sheet metal applications.

Tubular rivets.—Tubular rivets are partially hollow and come in a variety of configurations. The generic form has a manufactured head on one side and a hollow end that sticks through the pieces being joined. The hollow end is cold formed to a field head.

Since extensive cold forming is required on these rivets, they must be extremely ductile and are consequently made of low-strength materials. They are normally used for commercial applications rather than in the aerospace industry.

Some specific types of tubular rivets are

- (1) Compression
- (2) Semitubular
- (3) Full tubular



(a) One-piece body. (From ref. 5.)
 (b) Two-piece body. (From ref. 22.)

Figure 37.—Threaded-stem rivets.

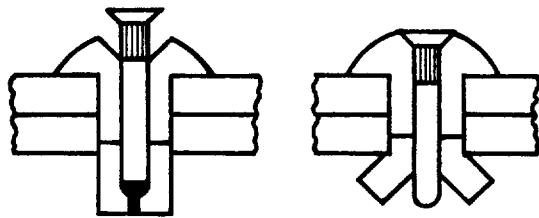


Figure 38.—Drive-pin rivet. (From ref. 5.)

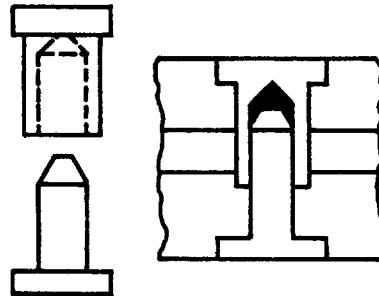


Figure 39.—Compression tubular rivet. (From ref. 5.)

Compression tubular rivets: A compression tubular rivet (fig. 39) consists of two parts that have an interference fit when driven together. These rivets are used commercially in soft materials and where a good appearance is required on both sides of the part.

Semitubular rivets: The semitubular rivet (fig. 40) has a hole in the field end (hole depth to 1.12 of shank diameter) such that the rivet approaches a solid rivet when the field head is formed.

Full tubular rivets: The full tubular rivet (fig. 41) has a deeper hole than the semitubular rivet. It is a weaker rivet than the semitubular rivet, but it can pierce softer materials such as plastic or fabric.

Metal-piercing rivets.—Metal piercing rivets (fig. 42) are similar to semitubular rivets, except that they have greater column strength. Part of the sandwich material is not drilled, and the rivet pierces all the way or most of the way through while mushrooming out to a locked position.

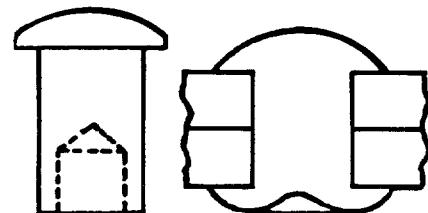


Figure 40.—Semitubular rivet. (From ref. 5.)

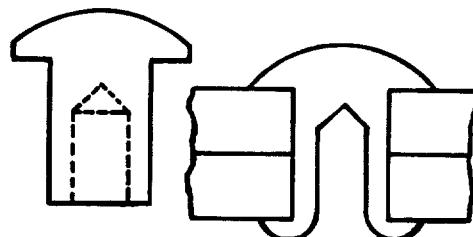


Figure 41.—Full tubular rivet. (From ref. 5.)

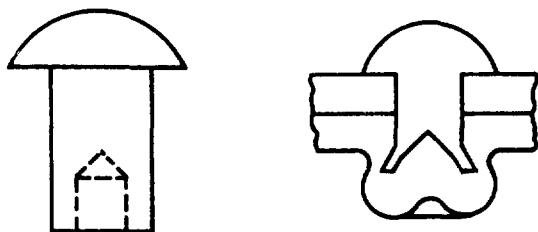


Figure 42.—Metal-piercing rivet. (From ref. 5.)

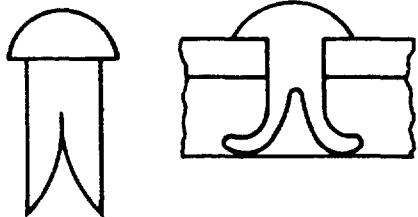


Figure 43.—Split (bifurcated) rivet. (From ref. 5.)

Split rivets.—Split (bifurcated) rivets (fig. 43) are the standard “home repair” rivets. They have sawed or split bodies with sharp ends to make their own holes through leather, fiber, plastic, or soft metals. They are not used in critical applications.

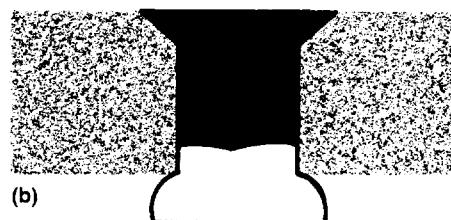
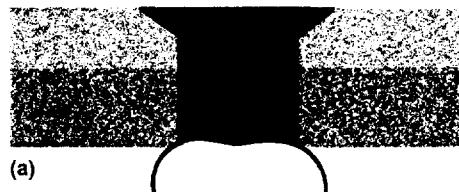
Specific Rivet Types

AD & DD solid rivets.—The most common solid rivets are the AD and DD aluminum rivets, as listed in table IX. These are the preferred rivets for joining aluminums and combinations of aluminum and steel. The “icebox” (DD) rivets can be used in higher-strength applications, but they must be kept around 0 °F until they are installed. The 7050-T73 aluminum rivets are an alternative to “icebox” rivets.

Since solid rivets are expanded to an interference fit, they *should not* be used in composites or fiber materials. They can cause delamination of the hole surfaces, leading to material failure.

Cherry Buck rivets.—The Cherry Buck rivet¹⁴ is a hybrid consisting of a factory head and shank of 95-ksi-shear-strength titanium, with a shop end shank of ductile titanium/nickel, joined together by inertia welding (fig. 44). This combination allows a shop head to be formed by bucking, but the overall shear strength of the rivet approaches 95 ksi. The Cherry Buck rivet can be used to 600 °F.

Monel rivets.—Monel (67 percent nickel and 30 percent



(a) Minimum grip.
(b) Maximum grip.

Figure 44.—Cherry Buck rivet.

copper) rivets are used for joining stainless steels, titanium, and Inconel. Monel is ductile enough to form a head without cracking but has higher strength ($F_{su} = 49$ ksi) and temperature capabilities than aluminum.

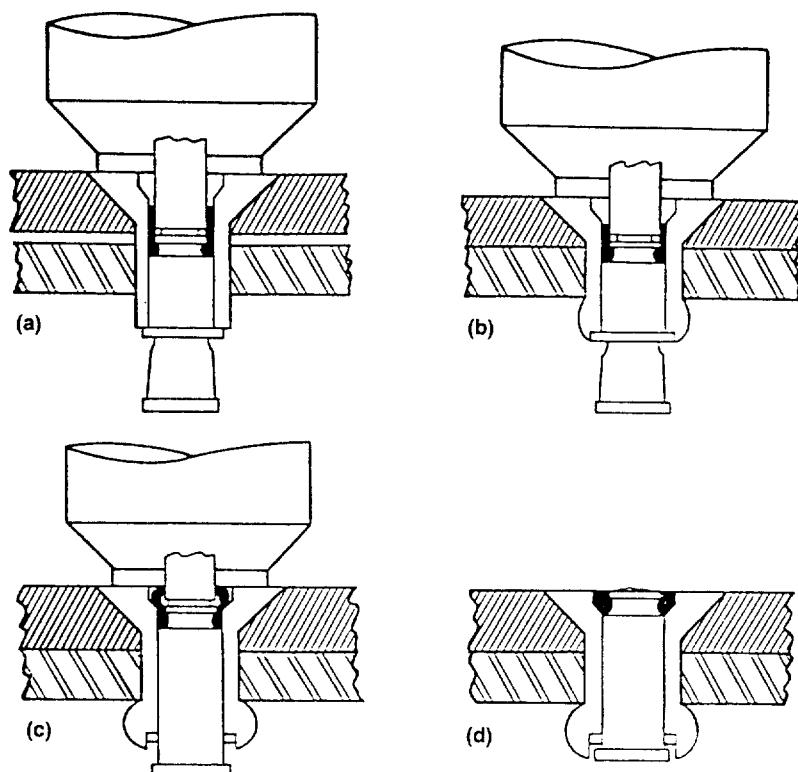
Titanium/niobium rivets.—These titanium alloy rivets (per MIL-R-5674 and AMS4982) have a shear strength of 50 ksi but are still formable at room temperature. They generally do not need a coating for corrosion protection. The Cherry E-Z Buck is a titanium/niobium rivet.

Cherry rivets.—The generic Cherry rivet is a blind structural rivet with a locking collar for the stem installed as shown in figure 45. (Different head types are available.) Cherry rivets are available in both nominal and oversize diameters in the common (1/8 through 1/4 in.) sizes. The oversize rivets are used for repairs where a nominal-size rivet (solid or blind) has been drilled out or where the initial drilled hole is oversize. These rivets have shear strengths comparable to AD solid aluminum rivets. However, their usage is restricted in aircraft manufacturing by the guidelines of MS33522, which is included as appendix C. A typical list of available Cherry rivet materials is shown in table X.

Huck blind rivets.—Huck blind rivets¹⁵ are similar to Cherry rivets, except that they are available in higher strength material. These rivets are made with and without locking collars and with countersunk or protruding heads. Note also (in fig. 46) that the sleeve on the blind side is deformed differently on the Huck rivet than on the Cherry rivet.

¹⁴Townsend Company, Cherry River Division, Santa Ana, California.

¹⁵Huck Manufacturing Company, Long Beach, California.



- (a) Insert CherryMAX rivet into prepared hole. Place pulling head over rivet stem and apply firm, steady pressure to seat head. Actuate tool.
 (b) Stem pulls into rivet sleeve and forms large bulbed blind head; seats rivet head and clamps sheets tightly together. Shank expansion begins.
 (c) "Safe-lock" locking collar moves into rivet sleeve recess. Formation of blind head is completed. Shear-ring has sheared from cone, thereby accommodating a minimum of $\frac{1}{16}$ in. in structure thickness variation.
 (d) Driving anvil forms "safe-lock" collar into head recess, locking stem and sleeve securely together. Continued pulling fractures stem, providing flush, burr-free, inspectable installation.

Figure 45.—Cherry rivet installation.

TABLE X.—CHERRY RIVET MATERIALS

Materials		Ultimate shear strength, psi	Maximum temperature, °F
Sleeve	Stem		
5055 Aluminum	Alloy steel	50 000	250
5056 Aluminum	CRES	50 000	250
Monel	CRES	55 000	900
Inco 600	Inco X750	75 000	1400

Pop rivets.—Pop rivets¹⁶ are familiar to most of the public for home repairs. However, they are not recommended for critical structural applications. The stem sometimes falls out of the sleeve after the rivet is installed, and the symmetry of the blind (formed) head leaves much to be desired. Although the pop rivet shown in figure 47 is the most common type, USM makes a closed-end rivet and three different head styles.

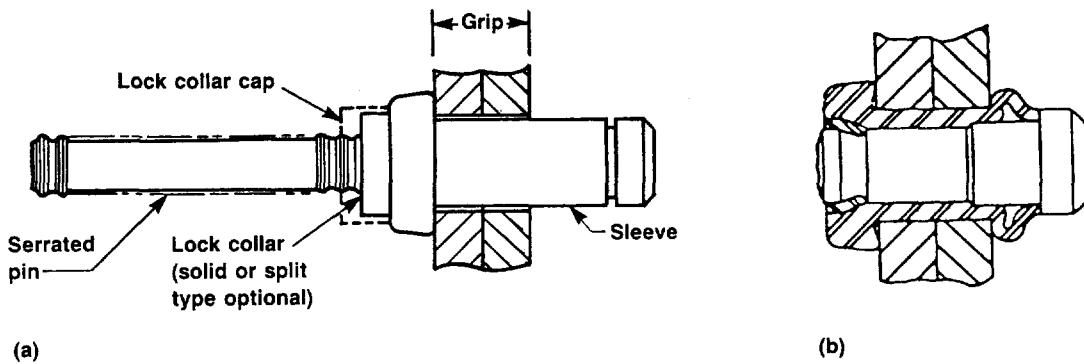
Lockbolts

In general, a lockbolt is a nonexpanding, high-strength fastener that has either a swaged collar or a type of threaded collar to lock it in place. It is installed in a standard drilled hole with a snug fit but normally not an interference fit. A lockbolt is similar to an ordinary rivet in that the locking collar or nut is weak in tension loading and is difficult to remove once installed.

Some of the lockbolts are similar to blind rivets and can be completely installed from one side. Others are fed into the workpiece with the manufactured head on the far side. The installation is then completed from the near side with a gun similar to blind rivet guns. Lockbolts are available with either countersunk or protruding heads.

Since it is difficult to determine whether a lockbolt is installed properly, they should be used only where it is not possible to install a bolt and nut of comparable strength. However, they are much faster to install than standard bolts and nuts.

¹⁶USM Corporation, Pop Rivet Division, Shelton, Connecticut.



(a) Protruding head, BP-T (MS90354) or BP-EU (MS21141).
 (b) Installed fastener.

Figure 46.—Huck blind rivets.

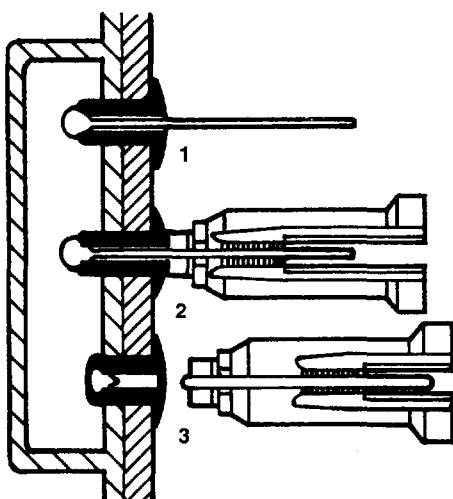


Figure 47.—Pop rivet installation.

Jo-Bolts

Jo-bolts are similar to blind rivets in appearance and installation. The locking collar (sleeve) is expanded to form a shop head by rotating the threaded stem with a gun. The threaded stem is notched and breaks off when the proper torque is reached. A typical Jo-bolt installation is shown in figure 48.

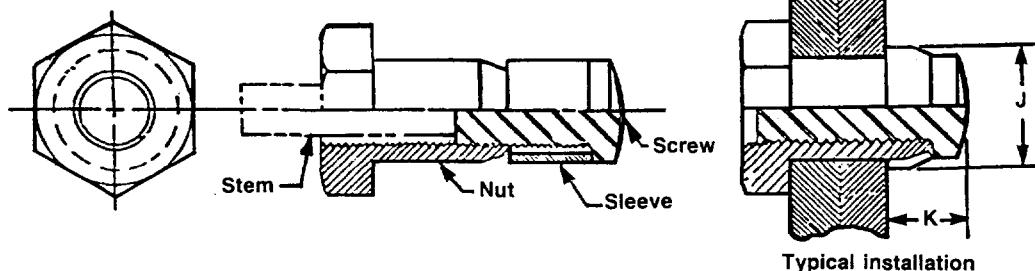


Figure 48.—Jo-bolt. (From ref. 21.)

Hi-Lok

The Hi-Lok¹⁷ lockbolt has a countersunk or protruding manufactured head and threads like a bolt. It is fed through the hole from the far side. The installation gun prevents shank rotation with a hexagonal key while the nut is installed (as shown in fig. 49). The nut (collar) hexagonal end is notched to break off at the desired torque. Hi-Lok lockbolts are available in high-strength carbon steel (to 156-ksi shear), stainless steel (to 132-ksi shear), and titanium (to 95-ksi shear).

Huckbolts

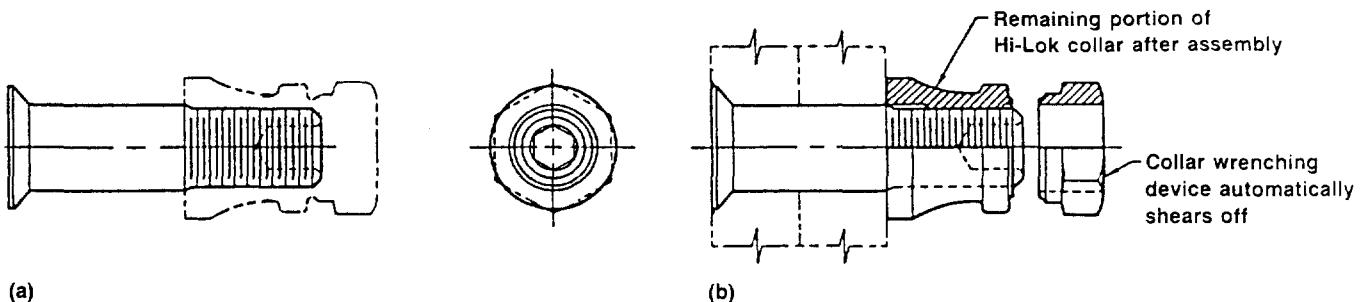
Huckbolts¹⁸ are similar to Hi-Loks except that the stem is usually serrated rather than threaded. The collar is swaged on the stem. Then the stem is broken at the notch as shown in figure 50. Huckbolts and their collars are available in carbon steel, aluminum, and stainless steel with various strengths, as listed in the Huck catalog.

Taper-Lok

Taper-Lok¹⁸ is a high-strength threaded fastener that is

¹⁷Hi-Shear Corporation, Torrance, California.

¹⁸SPS Technologies, Jenkintown, Pennsylvania.



(a) Hi-Lok pin.
 (b) Hi-Lok pin and collar after assembly.

Figure 49.—Hi-Lok installation.

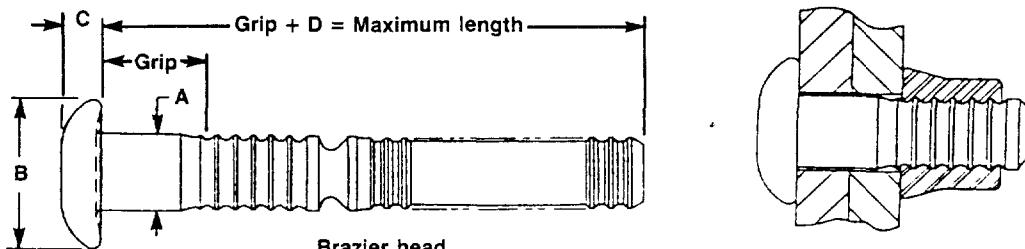


Figure 50.—Installed Huckbolt fastener.

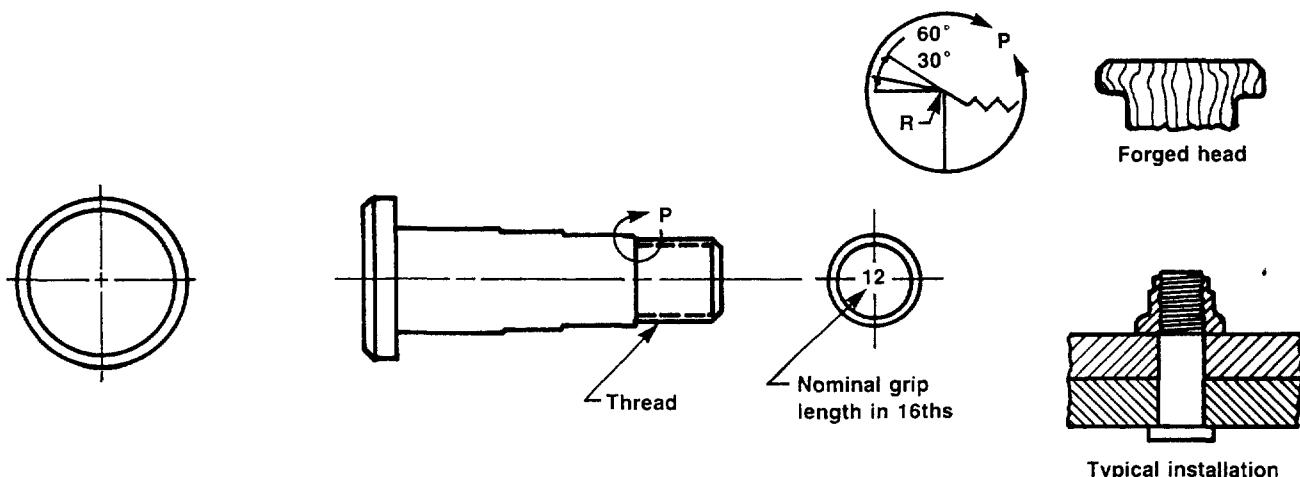


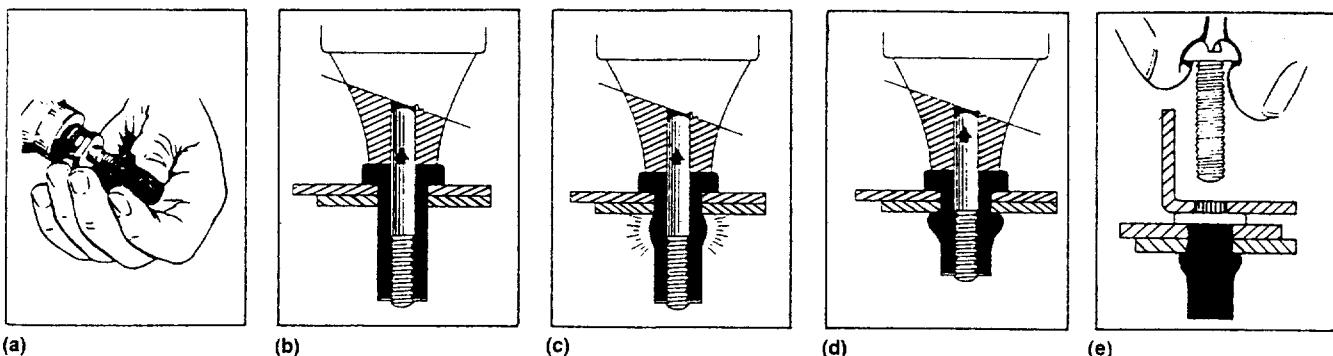
Figure 51.—Taper-Lok installation.

installed with an interference fit. Most of the shank is tapered on a 1.19° angle. The lubricated lockbolt is driven into a drilled and reamed hole. The interference fit allows the nut (tension or shear nut) to be installed and torqued to the required value without holding the lockbolt to prevent rotation (see fig. 51). The nuts are locknuts with captive washers. When a tension nut is installed, this fastener can take as much tension load as a bolt of the same size and material. Consequently, Taper-Loks are used in critical applications where cyclic loading is a problem. Taper-Lok lockbolts are available in high-strength alloy steel, H-11 tool steel, and several stainless steels, as well as titanium.

Rivnuts

A Rivnut¹⁹ is a tubular rivet with internal threads that is deformed in place to become a blind nutplate (fig. 52). Rivnuts are available with protruding, countersunk, and fillister heads. They are also available with closed ends, sealed heads, ribbed shanks, hexagonal shanks, and ribbed heads. Since the unthreaded tubular portion of the rivet must deform, the material must be ductile. Consequently, the Rivnut materials are fairly low strength, as shown in table XI.

¹⁹B.F. Goodrich, Engineered Systems Division, Akron, Ohio.



(a) Step 1—Rivnut fastener is threaded onto mandrel of installation tool.

(b) Step 2—Rivnut fastener, on tool mandrel, is inserted into hole drilled for installation.

(c) Step 3—Mandrel retracts and pulls threaded portion of Rivnut fastener shank toward blind side of work, forming bulge in unthreaded shank area.

(d) Step 4—Rivnut fastener is clinched securely in place; mandrel is unthreaded, leaving internal Rivnut threads intact.

(e) Blind nutplate—Properly installed Rivnut fastener makes excellent blind nutplate for simple screw attachments; countersunk Rivnut fasteners can be used for smooth surface installation.

Figure 52.—Rivnut installation.

TABLE XI.—STANDARD RIVNUT FASTENER MATERIALS AND FINISHES

Material	Type	Standard finish	Minimum ultimate tensile strength, psi
Aluminum	6053-T4	Anodize—Alumilite 205 will meet specifications: MIL-A-8625 (ASG)	28 000
Steel	C-1108 ^a C-1110 ^a	Cadmium plate—0.0002 in. minimum thickness per QQ-P-416b, class 3, type I	45 000
	4037	Cadmium plate—0.0002 in. minimum thickness per QQ-P-416b, class 2, type II	^b 55 000 ^c 85 000
Stainless steel	430	Pickled and passivated per QQ-P-35, type II	67 000
	305 ^d	None—bright as machined	80 000
Brass	Alloy 260	None—bright as machined	50 000

^aC-1108 and C-1110 steel may be used interchangeably.

^bNo. 4 and No. 6 thread sizes.

^cNo. 8—1/2-in. thread size.

^d305 and Carpenter No. 10 stainless steel may be used interchangeably.

Hi-Shear Rivet

Hi-Shear¹⁷ rivets consist of a high-strength carbon steel, stainless steel, aluminum, or titanium rivet (pin) with a necked-down shop head, as shown in figure 53. The collar (2024 aluminum or Monel) is swaged on to give a finished head that

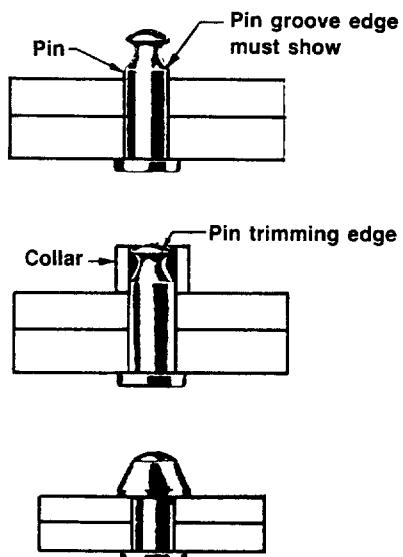


Figure 53.—Hi-Shear installation.

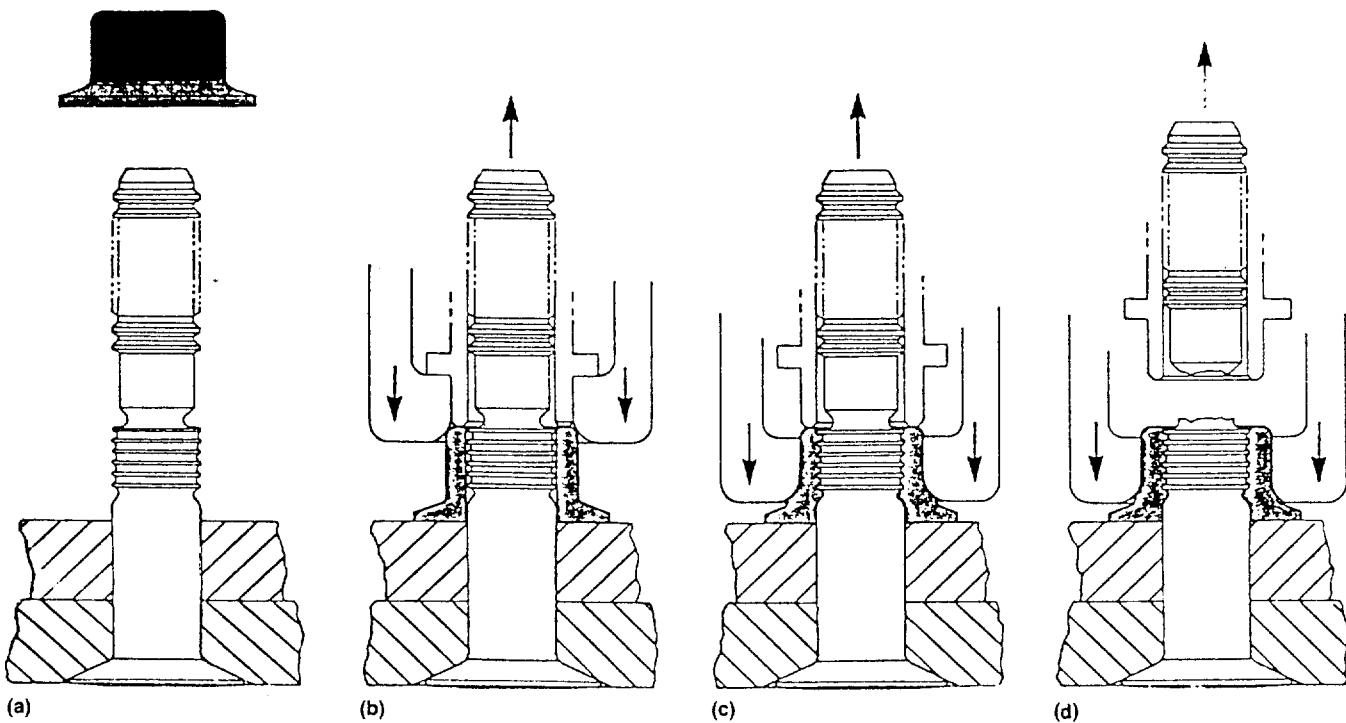
can be visually inspected for proper form. This rivet should be used for shear applications only, as the collar has negligible tensile strength.

Although this rivet has been partially superseded by various lockbolts, it is still being used in aircraft and aerospace applications.

Lightweight Grooved Proportioned Lockbolt

The lightweight grooved proportioned lockbolt (LGPL)²⁰ is made especially for composite materials. It has both an oversize head and an oversize collar to lessen contact stresses

¹⁷Monogram Aerospace Fasteners, Los Angeles, California.



(a) Flanged collar is placed over lightweight pin.

- (b) Installation tool grips and pulls pin, drawing sheets tightly together and removing sheet gap.
 (c) As pull on pin increases, tool anvil swages flanged collar into locking grooves and forms permanent vibration-resistant lock.
 (d) Pull on pin continues until pin fractures at breakneck groove and is then ejected. Tool anvil disengages swaged collar.

Figure 54.—LGPL installation.

on the composite material during both installation and service life. The shank is high-strength (95-ksi shear) titanium and the collar is 2024 aluminum. It is installed with a lockbolt tool as shown in figure 54.

General Guidelines for Selecting Rivets and Lockbolts

A number of standard documents are available for the selection, installation, and drawing callout of rivets and lockbolts as follows:

(1) Rivet installations are covered by MIL-STD-403. This specification covers pilot holes, deburring, countersinking, dimpling, and the application of zinc chromate paint between dissimilar materials. Other specifications for corrosion prevention of drilled or countersunk surfaces are covered in MIL-P-116 and MIL-STD-171.

(2) Design and selection requirements for blind *structural* rivets are given in MS33522 (appendix C).

(3) Design and selection requirements for blind *nonstructural* rivets are given in MS33557.

(4) A wealth of information on allowable rivet strengths in various materials and thicknesses is given in chapter 8 of MIL-HDBK-5 (ref. 18).

(5) Testing of fasteners is covered by MIL-STD-1312.

(6) Lockwiring is done per MS33540.

Note that the nominal rivet spacing for a rivet pattern is an edge distance of $2D$ and a linear spacing of $4D$, where D is the rivet diameter. However, the $4D$ spacing can be increased if sealing between rivets or interrivet buckling is not a problem.

Solid rivets (expanded during installation) should not be used in composite materials, as they can overstress the hole and cause delamination of the material.

Lewis Research Center
 National Aeronautics and Space Administration
 Cleveland, Ohio, June 30, 1989

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Appendix A

Bolthead Marking and Design Data

[From ref. 20]

ASTM markings

The American Society for Testing and Materials, 1916 Race St, Philadelphia, PA 19103, sponsors development of specifications for fasteners used in general and special engineering applications. These specifications detail chemical and mechanical properties of material strength levels for fasteners and are generally specific in referencing the actual product covered. A full range of types of products of various styles, thread series, lengths, etc., can be produced to meet ASTM requirements and would be marked for grade and material identification as required.

ASTM

Grade and material identification markings required by ASTM specifications

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfr's ID symbol req'd?	Nominal size range (inch)	Mechanical properties				Remarks or footnotes
						Bolts, screws, studs	Nuts	Proof load (psi)	Tensile strength (min psi)	
None req'd	A31, Grade A	Boiler rivets	Carbon steel	No	Thru 1 1/2	—	23,000	45,000	—	—
None req'd	A31, Grade B	Boiler rivets	Carbon steel	No	Thru 1 1/2	—	29,000	58,000	—	—
None req'd	A65, Grade 1	Track spikes	Carbon steel, copper not specified	Yes	—	—	0.5X tensile strength	55,000	—	Marking on top of head.
CU	A65, Grade 1	Track spikes	Carbon steel, copper specified	Yes	—	—	0.5X tensile strength	55,000	—	Marking on top of head.
HC	A65, Grade 2	Track spikes	Carbon steel, copper not specified	Yes	—	—	0.5X tensile strength	70,000	—	Marking on top of head.
HC and CU	A65, Grade 2	Track spikes	Carbon steel, copper specified	Yes	—	—	0.5X tensile strength	70,000	—	Marking on top of head.
None req'd	A66	Screw spikes	Carbon steel	Yes	—	—	0.5X tensile strength	60,000	—	Marking on spike head.
None req'd	A183, Grade 1	Track bolts	Low carbon steel, untreated	Yes	1/2 - 1 1/8	—	—	55,000	—	Marking on top of head, raised or depressed.
"Remarks"	A183, Grade 2	Track bolts	Carbon steel, heat-treated	Yes	1/2 - 1 1/8	—	80,000	110,000	—	Marking on top of head, raised or depressed. A symbol is required to indicate bolt is heat-treated.
None req'd	A183, Grade 1	Track nuts	Low carbon steel	No	1/4 - 1 1/8	—	—	—	—	—
None req'd	A183, Grade 2	Track nuts	Medium carbon steel	No	3/4 - 1 1/8	—	—	—	—	—
B5	A193	Bolts, screws, and studs for high temperature service	AISI 501	Yes	1/4 - 4	—	80,000	100,000	—	A
B6	A193	Bolts, screws, and studs for high temperature service	AISI 410	Yes	1/4 - 4	—	85,000	110,000	—	A

Footnotes are grouped on the last page of this Part 1 series.

Footnotes are grouped on the last page of this Part 1 series.

Grade ID mark	ASTM spec number	Fastener	Material	Is mfg's ID symbol req'd?	Nominal size range (inch)	Mechanical properties	Bolts, screws, studs				Brinell	Rockwell	Hardness	Remarks or footnotes
							Proof load (psi)	Yield strength (min psi)	Tensile strength (min psi)	Nuts				
B6X	A193	Bolts, screws, and studs for high temperature service	AISI 410	Yes	1/4 - 4	—	70,000	90,000	—	—	C26	max	A	
B7	A193	Bolts, screws, and studs for high temperature service	AISI 4140, 4142, 4145, 4140H, 4142H, 4145H	Yes	1/4 - 2 1/2 Over 2 1/2 - 4 Over 4 - 7	—	105,000 95,000 75,000	125,000 115,000 100,000	— — —	— — —	— — —	— — —	A A A	
B7M	A193	Bolts, screws, and studs for high temperature service	AISI 4140, 4142, 4145, 4140H, 4142H, 4145H	Yes	1/4 - 2 1/2	—	80,000	100,000	—	235 max (B)	B99 max (B)	—	A	
B16	A193	Bolts, screws, and studs for high temperature service	Chromium, molybdenum, and vanadium alloy steel	Yes	1/4 - 2 1/2 Over 2 1/2 - 4 Over 4 - 7	—	105,000 95,000 85,000	125,000 110,000 100,000	— — —	— — —	— — —	— — —	A A A	
B8	A193, A320	Bolts, screws, and studs for high or low temperature service, respectively—Class 1 (C)	AISI 304 carbide solution treated	Yes	1/4 and larger	—	30,000	75,000	—	223 ^D max	B96 ^D max	—	A	
B8C	A193, A320	Bolts, screws, and studs for high or low temperature service, respectively—Class 1 (C)	AISI 347 carbide solution treated	Yes	1/4 and larger	—	30,000	75,000	—	223 ^D max	B96 ^D max	—	A	
B8M	A193, A320	Bolts, screws, and studs for high or low temperature service, respectively—Class 1 (C)	AISI 316, carbide solution treated	Yes	1/4 and larger	—	30,000	75,000	—	223 ^D max	B96 ^D max	—	A	
B8P	A193, A320	Bolts, screws, and studs for high or low temperature service, respectively—Class 1 (C)	AISI 305 (with restricted carbon), carbide solution treated	Yes	1/4 and larger	—	30,000	75,000	—	223 ^D max	B96 ^D max	—	A	
B8T	A193, A320	Bolts, screws, and studs for high or low temperature service, respectively—Class 1 (C)	AISI 321, carbide solution treated	Yes	1/4 and larger	—	30,000	75,000	—	223 ^D max	B96 ^D max	—	A	
B8LN	A193, A320	Bolts, screws, and studs for high or low temperature service, respectively—Class 1 (C)	AISI 304N (with restricted carbon), carbide solution treated	Yes	1/4 and larger	—	30,000	75,000	—	223 ^D max	B96 ^D max	—	A	
B8MLN	A193, A320	Bolts, screws, and studs for high or low temperature service, respectively—Class 1 (C)	AISI 310N (with restricted carbon), carbide solution treated	Yes	1/4 and larger	—	30,000	75,000	—	223 ^D max	B96 ^D max	—	A	

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (inch)	Mechanical properties						Remarks or footnotes
						Bolts, screws, studs	Proof load (psi)	Yield strength (min psi)	Tensile strength (min psi)	Nuts	Brinell	Rockwell
B8A	A193, A320	Bolts, screws, and studs for high or low temperature service respectively—Class 1A (C)	AISI 304 carbide solution treated in finished condition	Yes	1/4 and larger	—	30,000	75,000	—	192 max	B90 max	A
B8CA	A193, A320	Bolts, screws, and studs for high or low temperature service respectively—Class 1A (C)	AISI 347, carbide solution treated in finished condition	Yes	1/4 and larger	—	30,000	75,000	—	192 max	B90 max	A
B8MA	A193, A320	Bolts, screws, and studs for high or low temperature service, respectively—Class 1A (C)	AISI 316, carbide solution treated in finished condition	Yes	1/4 and larger	—	30,000	75,000	—	192 max	B90 max	A
B8PA	A193, A320	Bolts, screws, and studs for high or low temperature service, respectively—Class 1A (C)	AISI 305 (with restricted carbon), carbide solution treated in finished condition	Yes	1/4 and larger	—	30,000	75,000	—	192 max	B90 max	A
B8TA	A193, A320	Bolts, screws, and studs for high or low temperature service, respectively—Class 1A (C)	AISI 321, carbide solution treated in finished condition	Yes	1/4 and larger	—	30,000	75,000	—	192 max	B90 max	A
B8LNA	A193, A320	Bolts, screws, and studs for high or low temperature service, respectively—Class 1A (C)	AISI 304N (with restricted carbon), carbide solution treated in finished condition	Yes	1/4 and larger	—	30,000	75,000	—	192 max	B90 max	A
B8MLNA	A193, A320	Bolts, screws, and studs for high or low temperature service, respectively—Class 1A (C)	AISI 316N (with restricted carbon), carbide solution treated in finished condition	Yes	1/4 and larger	—	30,000	75,000	—	192 max	B90 max	A
B8NA	A193	Bolts, screws, and studs for high temperature service, Class 1A	AISI 304N, carbide solution treated in finished condition	Yes	1/4 and larger	—	30,000	75,000	—	192 max	B90 max	A
B8MNA	A193	Bolts, screws, and studs for high temperature service, Class 1A	AISI 316N, carbide solution treated in finished condition	Yes	1/4 and larger	—	30,000	75,000	—	192 max	B90 max	A
B8N	A193	Bolts, screws, and studs for high temperature service, Class 1B	AISI 304N carbide solution treated	Yes	1/4 and larger	—	35,000	80,000	—	223 max (H)	B90 max	A

Footnotes are grouped on the last page of this Part 1 series.

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (inch)	Mechanical properties					Remarks or footnotes
						Bolts, screws, studs	Proof load (psi)	Yield strength (min psi)	Tensile strength (min psi)	Nuts	
<u>B8MN</u>	A193	Bolts, screws, and studs for high temperature service, Class 1B	AISI 316N, carbide solution treated	Yes	$\frac{1}{4}$ and larger	—	35,000	80,000	—	223 max (D)	A
<u>B8R</u>	A193	Bolts, screws, and studs for high temperature service, Class 1C	UNS 20910 (XM19), carbide solution treated	Yes	$\frac{1}{4}$ and larger	—	55,000	100,000	—	271 C28 max	A
<u>B8RA</u>	A193	Bolts, screws, and studs for high temperature service, Class 1C	UNS 20910 (XM19), carbide solution treated in finished condition	Yes	$\frac{1}{4}$ and larger	—	55,000	100,000	—	271 max	A
<u>B8S</u>	A193	Bolts, screws, and studs for high temperature service, Class 1C	S21800, carbide solution treated	Yes	$\frac{1}{4}$ and larger	—	50,000	95,000	—	271 C28 max	A
<u>B8SA</u>	A193	Bolts, screws, and studs for high temperature service, Class 1C	S21800, carbide solution treated in finished condition	Yes	$\frac{1}{4}$ and larger	—	50,000	95,000	—	271 C28 max	A
<u>B8</u>	A193, A320	Bolts, screws, and studs for high or low temperature service, respectively—Class 2 (C)	AISI 304, carbide solution treated & strain hardened	Yes	$\frac{1}{4} - \frac{3}{4}$ $\frac{3}{4} - 1$	—	100,000	125,000	—	321 C35 max	A
				Over	—	80,000	115,000	—	321 C35 max	A	
				Over	—	65,000	105,000	—	321 C35 max	A	
				Over	—	50,000	100,000	—	321 C35 max	A	
				1 $\frac{1}{4} - 1\frac{1}{2}$	—	100,000	125,000	—	321 C35 max	A	
<u>B8C</u>	A193, A320	Bolts, screws, and studs for high or low temperature service, respectively—Class 2 (C)	AISI 347 carbide solution treated & strain hardened	Yes	$\frac{1}{4} - \frac{3}{4}$	—	100,000	125,000	—	321 C35 max	A
				Over	—	80,000	115,000	—	321 C35 max	A	
				Over	—	65,000	105,000	—	321 C35 max	A	
				Over	—	50,000	100,000	—	321 C35 max	A	
<u>B8P</u>	A193, A320	Bolts, screws, and studs for high or low temperature service, respectively—Class 2 (C)	AISI 305 (with restricted carbon), carbide solution treated & strain hardened	Yes	$\frac{1}{4} - \frac{3}{4}$	—	100,000	125,000	—	321 C35 max	A
				Over	—	80,000	115,000	—	321 C35 max	A	
				Over	—	65,000	105,000	—	321 C35 max	A	
				Over	—	50,000	100,000	—	321 C35 max	A	
<u>B8T</u>	A193, A320	Bolts, screws, and studs for high or low temperature service, respectively—Class 2 (C)	AISI 321, carbide solution treated & strain hardened	Yes	$\frac{1}{4} - \frac{3}{4}$	—	100,000	125,000	—	321 C35 max	A
				Over	—	80,000	115,000	—	321 C35 max	A	
				Over	—	65,000	105,000	—	321 C35 max	A	
				Over	—	50,000	100,000	—	321 C35 max	A	

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg'r's ID symbol req'd?	Nominal size range (inch)	Mechanical properties						Remarks or footnotes
						Bolts, screws, studs	Nuts	Proof load (psi) hvy hex hex	Tensile strength (min psi)	Yield strength (min psi)	Proof load (psi)	
B8N	A193	Bolts, screws, and studs for high temperature service, Class 2	AISI 304N, carbide solution treated & strain hardened	Yes	1/4 - 3/4 Over 5/8 - 1 Over 1 - 1 1/4 Over 1 1/4 - 1 1/2	— 100,000 — 80,000 — 65,000 — 50,000	125,000 — 115,000 — 105,000 — 100,000	— — — — — — —	321 max 321 max 321 max 321 max	C35 max C35 max C35 max C35 max C35 max C35 max C35 max	A A A A A A A	
B8M	A193, A320	Bolts, screws, and studs for high or low temperature service, respectively—Class 2 (C)	AISI 316, carbide solution treated & strain hardened	Yes	1/4 - 3/4 Over 5/8 - 1 Over 1 - 1 1/4 Over 1 1/4 - 1 1/2	— 95,000 — 80,000 — 65,000 — 50,000	110,000 — 100,000 — 95,000 — 90,000	— — — — — — —	321 max 321 max 321 max 321 max	C35 max C35 max C35 max C35 max C35 max C35 max C35 max	A A A A A A A	
B8MN	A193	Bolts, screws, and studs for high temperature service, Class 2	AISI 316N, carbide solution treated & strain hardened	Yes	1/4 - 3/4 Over 5/8 - 1 Over 1 - 1 1/4 Over 1 1/4 - 1 1/2	— 95,000 — 80,000 — 65,000 — 50,000	110,000 — 100,000 — 95,000 — 90,000	— — — — — — —	321 max 321 max 321 max 321 max	C35 max C35 max C35 max C35 max C35 max C35 max C35 max	A A A A A A A	
1	A194	Hot or cold forged nuts for high pressure & high temperature service	Carbon steel	Yes	1/4 and larger	— —	— —	130,000 120,000	124 min	B70 min	—	—
1B	A194	Nuts machined from bars for high pressure & high temperature service	Carbon steel	Yes	1/4 and larger	— —	— —	130,000 120,000	124 min	B70 min	—	—
2	A194	Hot or cold forged nuts for high pressure & high temperature service	Carbon steel	Yes	1/4 and larger	— —	— —	150,000 135,000	159/352	B84 min	—	—
2B	A194	Nuts machined from bars for high pressure & high temperature service	Carbon steel	Yes	1/4 and larger	— —	— —	150,000 135,000	159/352	B84 min	—	—
2H	A194	Hot or cold forged nuts for high pressure & high temperature service	Carbon steel, heat treated	Yes	1/4 and larger	— —	— —	175,000 150,000	248/352	C24/C38	—	—
2HB	A194	Nuts machined from bars for high pressure & high temperature service	Carbon steel, heat treated	Yes	1/4 and larger	— —	— —	175,000 150,000	248/352	C24/C38	E	—
2HM	A194	Hot or cold forged nuts for high pressure & high temperature service	Carbon steel, heat treated	Yes	1/4 and larger	— —	— —	150,000 135,000	159/237	C22 max	—	—

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (inch)	Mechanical properties					Remarks or footnotes
						Bolts, screws, studs	Nuts	Hardness	Proof load (psi) hvy hex hex	Yield strength (min psi)	
2HMB	A194	Nuts machined from bars for high pressure & high temperature service	Carbon steel, heat treated	Yes	$\frac{1}{4}$ and larger	—	—	—	150,000 / 135,000	159/237 / 248/352	C22 max E
3	A194	Hot or cold forged nuts for high pressure & high temperature service	AISI 501, heat treated	Yes	$\frac{1}{4}$ and larger	—	—	—	175,000 / 150,000	248/352 / 244/38	—
3B	A194	Nuts machined from bars for high pressure & high temperature service	AISI 501, heat treated	Yes	$\frac{1}{4}$ and larger	—	—	—	175,000 / 150,000	248/352 / 244/38	E
4	A194	Hot or cold forged nuts for high pressure & high temperature service	Carbon molybdenum, heat treated	Yes	$\frac{1}{4}$ and larger	—	—	—	175,000 / 150,000	248/352 / 244/38	—
4B	A194	Nuts machined from bars for high pressure & high temperature service	Carbon, molybdenum, heat treated	Yes	$\frac{1}{4}$ and larger	—	—	—	175,000 / 150,000	248/352 / 244/38	E
6	A194	Hot or cold forged nuts for high pressure & high temperature service	AISI 410, heat treated	Yes	$\frac{1}{4}$ and larger	—	—	—	150,000 / 135,000	228/271 / 240/28	—
6B	A194	Nuts machined from bars for high pressure & high temperature service	AISI 410, heat treated	Yes	$\frac{1}{4}$ and larger	—	—	—	150,000 / 135,000	228/271 / 240/28	E
6F	A194	Hot or cold forged nuts for high pressure & high temperature service	AISI 416 with sulfur or 416Se with selenium, heat treated	Yes	$\frac{1}{4}$ and larger	—	—	—	150,000 / 135,000	228/271 / 240/28	—
6FB	A194	Nuts machined from bars for high pressure & high temperature service	AISI 416 with sulfur or 416Se with selenium, heat treated	Yes	$\frac{1}{4}$ and larger	—	—	—	150,000 / 135,000	228/271 / 240/28	E
7	A194	Hot or cold forged nuts for high pressure & high temperature service	AISI 4140/4142/4145, 4140H, 4142H, 4145H, heat treated	Yes	$\frac{1}{4}$ and larger	—	—	—	175,000 / 150,000	248/352 / 244/38	—
7B	A194	Nuts machined from bars for high pressure & high temperature service	AISI 4140/4142/4145, 4140H, 4142H, 4145H, heat treated	Yes	$\frac{1}{4}$ and larger	—	—	—	175,000 / 150,000	248/352 / 244/38	E
7M	A194	Hot or cold forged nuts for high pressure & high temperature service	AISI 4140/4142/4145, 4140H, 4142H, 4145H, heat treated	Yes	$\frac{1}{4}$ and larger	—	—	—	150,000 / 135,000	159/237 / 248/352	—
7MB	A194	Nuts machined from bars for high pressure & high temperature service	AISI 4140/4142/4145, 4140H, 4142H,	Yes	$\frac{1}{4}$ and larger	—	—	—	150,000 / 135,000	159/237 / 248/352	—
8	A194	Hot or cold forged nuts for high pressure & high temperature service	AISI 304	Yes	$\frac{1}{4}$ and larger	—	—	—	80,000 / 75,000	126/310 / 126/310	—

Footnotes are grouped on the last page of this Part 1 series.

Grade, ID mark	ASTM spec number	Fastener description	Material	Is mfgr's ID symbol req'd?	Nominal size range (inch)	Mechanical properties					Remarks or footnotes	
						Bolts, screws, studs	Nuts	Proof load (psi)	Yield strength (min psi)	Tensile strength (min psi)	Brinell	Rockwell
8B	A194	Nuts machined from bars for high pressure & high temperature service	AISI 304	Yes	1/4 and larger	—	—	—	—	80,000 / 75,000	126/300	B60/B105
8A	A194	Hot or cold forged or machined from bars for high pressure & high temperature service	AISI 304 carbide solution treated	Yes	1/4 and larger	—	—	—	—	80,000 / 75,000	126/192	B60/B90
8C	A194	Hot or cold forged nuts for high pressure & high temperature service	AISI 347	Yes	1/4 and larger	—	—	—	—	80,000 / 75,000	126/300	B60/B105
8CB	A194	Nuts machined from bars for high pressure & high temperature service	AISI 347	Yes	1/4 and larger	—	—	—	—	80,000 / 75,000	126/300	B60/B105
8CA	A194	Hot or cold forged or machined from bars for high pressure & high temperature service	AISI 347, carbide solution treated	Yes	1/4 and larger	—	—	—	—	80,000 / 75,000	126/192	B60/B90
8M	A194	Hot or cold forged nuts for high pressure & high temperature service	AISI 316	Yes	1/4 and larger	—	—	—	—	80,000 / 75,000	126/300	B60/B105
8MB	A194	Nuts machined from bars for high pressure & high temperature service	AISI 316	Yes	1/4 and larger	—	—	—	—	80,000 / 75,000	126/300	B60/B105
8MA	A194	Hot or cold forged or machined from bars for high pressure & high temperature service	AISI 316, carbide solution treated	Yes	1/4 and larger	—	—	—	—	80,000 / 75,000	126/192	B60/B90
8T	A194	Hot or cold forged nuts for high pressure & high temperature service	AISI 321	Yes	1/4 and larger	—	—	—	—	80,000 / 75,000	126/300	B60/B105
8TB	A194	Nuts machined from bars for high pressure & high temperature service	AISI 321	Yes	1/4 and larger	—	—	—	—	80,000 / 75,000	126/300	B60/B105
8TA	A194	Hot or cold forged or machined from bars for high pressure & high temperature service	AISI 321 carbide solution treated	Yes	1/4 and larger	—	—	—	—	80,000 / 75,000	126/192	B60/B90
8F	A194	Hot or cold forged nuts for high pressure & high temperature service	AISI 303 with sulfur or 303Se with selenium	Yes	1/4 and larger	—	—	—	—	80,000 / 75,000	126/300	B60/B105
8FB	A194	Nuts machined from bars for high pressure & high temperature service	AISI 303 with sulfur or 303Se with selenium	Yes	1/4 and larger	—	—	—	—	80,000 / 75,000	126/300	B60/B105

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Grade D mark	ASTM spec number	Fastener description	Is mfg'r's ID symbol req'd?	Nominal size range (inch)	Mechanical properties						Remarks or footnotes	
					Bolts, Screws, Studs	Nuts	Proof load (psi)	Yield strength (min psi)	Tensile strength (min psi)	Brinell	Rockwell	
8FA	A194	Hot or cold forged or machined from bars for high pressure & high temperature service	Yes	$\frac{1}{4}$ and larger	—	—	—	—	80,000 $\frac{75,000}{75,000}$	126/192	B60/B90	—
8P	A194	Hot or cold forged nuts for high pressure & high temperature service	Yes	$\frac{1}{4}$ and larger	—	—	—	—	80,000 $\frac{75,000}{75,000}$	126/300	B60/B105	—
8PB	A194	Nuts machined from bars for high pressure & high temperature service	Yes	$\frac{1}{4}$ and larger	—	—	—	—	80,000 $\frac{75,000}{75,000}$	126/300	B60/B105	—
8PA	A194	Hot or cold forged or machined from bars for high pressure & high temperature service	Yes	$\frac{1}{4}$ and larger	—	—	—	—	80,000 $\frac{75,000}{75,000}$	126/192	B60/B90	—
8N	A194	Hot or cold forged nuts for high pressure & high temperature service	Yes	$\frac{1}{4}$ and larger	—	—	—	—	80,000 $\frac{75,000}{75,000}$	126/300	B60/B105	—
8NB	A194	Nuts machined from bars for high pressure & high temperature service	Yes	$\frac{1}{4}$ and larger	—	—	—	—	80,000 $\frac{75,000}{75,000}$	126/300	B60/B105	—
8NA	A194	Hot or cold forged or machined from bars for high pressure & high temperature service	Yes	$\frac{1}{4}$ and larger	—	—	—	—	80,000 $\frac{75,000}{75,000}$	126/192	B60/B90	—
8MN	A194	Hot or cold forged nuts for high pressure & high temperature service	Yes	$\frac{1}{4}$ and larger	—	—	—	—	80,000 $\frac{75,000}{75,000}$	126/300	B60/B105	—
8MNB	A194	Nuts machined from bars for high pressure & high temperature service	Yes	$\frac{1}{4}$ and larger	—	—	—	—	80,000 $\frac{75,000}{75,000}$	126/300	B60/B105	—
8MNA	A194	Hot or cold forged or machined from bars for high pressure & high temperature service	Yes	$\frac{1}{4}$ and larger	—	—	—	—	80,000 $\frac{75,000}{75,000}$	126/192	B60/B90	—
8R	A194	Hot or cold forged nuts for high pressure & high temperature service	XM19	Yes	$\frac{1}{4}$ and larger	—	—	—	80,000 $\frac{75,000}{75,000}$	183/271	B88/C25	—
8RB	A194	Nuts machined from bars for high pressure & high temperature service	XM19	Yes	$\frac{1}{4}$ and larger	—	—	—	80,000 $\frac{75,000}{75,000}$	183/271	B88/C25	—

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Grade ID mark	ASTM spec number	Fastener description	Material	Is mfgr's ID symbol req'd?	Nominal size range (inch)	Mechanical properties					Remarks or footnotes	
						Bolts, screws, studs	Nuts	Hardness	Proof load (psi)	Yield strength (min psi)		
8RA	A194	Hot or cold forged or machined from bars for high pressure & high temperature service	XMT9, carbide solution treated	Yes	1/4 and larger	—	—	—	80,000 75,000	183/271	B88/C25	—
8S	A194	Hot or cold forged nuts for high pressure & high temperature service	S21800 (restricted phosphorus)	Yes	1/4 and larger	—	—	—	80,000 75,000	183/271	B88/C25	—
8SB	A194	Nuts machined from bars for high pressure & high temperature service	S21800 (restricted phosphorus)	Yes	1/4 and larger	—	—	—	80,000 75,000	183/271	B88/C25	—
8SA	A194	Hot or cold forged or machined from bars for high pressure & high temperature service	S21800 (restricted phosphorus), carbide solution treated	Yes	1/4 and larger	—	—	—	80,000 75,000	183/271	B88/C25	—
8LN	A194	Hot or cold forged nuts for high pressure & high temperature service	AISI 304N (with restricted carbon)	Yes	1/4 and larger	—	—	—	80,000 75,000	126/300	B60/B105	—
8LNB	A194	Nuts machined from bars for high pressure & high temperature service	AISI 304N (with restricted carbon)	Yes	1/4 and larger	—	—	—	80,000 75,000	126/300	B60/B105	—
8LNA	A194	Hot or cold forged or machined from bars for high pressure & high temperature service	AISI 304N (with restricted carbon), carbide solution treated	Yes	1/4 and larger	—	—	—	80,000 75,000	126/192	B60/B90	—
8MLN	A194	Hot or cold forged nuts for high pressure & high temperature service	AISI 316N (with restricted carbon)	Yes	1/4 and larger	—	—	—	80,000 75,000	126/300	B60/B105	—
8MLNB	A194	Nuts machined from bars for high pressure & high temperature service	AISI 316N (with restricted carbon)	Yes	1/4 and larger	—	—	—	80,000 75,000	126/300	B60/B105	—
8MLNA	A194	Hot or cold forged or machined from bars for high pressure & high temperature service	AISI 316N (with restricted carbon), carbide solution treated	Yes	1/4 and larger	—	—	—	80,000 75,000	126/192	B60/B90	—
8	A194	Nuts machined from bars for high pressure & high temperature service	AISI 304, strain hardened	Yes	1/4 - 1/2	—	—	—	125,000 110,000	—	—	—
					1/8 - 1	—	—	—	115,000 100,000	—	—	—
					1 1/8 - 1 1/4	—	—	—	105,000 95,000	—	—	—
					1 1/8 - 1 1/2	—	—	—	100,000 90,000	—	—	—

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Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg'r's ID symbol req'd?	Nominal size range (inch)	Proof load (psi)	Yield strength (min psi)	Tensile strength (min psi)	Mechanical properties			Remarks or footnotes
									Bolts, screws, studs	Nuts	Hardness	
<u>8E</u>	A194	Nuts machined from bars for high pressure & high temperature service	AlSI 347, strain hardened	Yes	$\frac{5}{8} - \frac{3}{4}$	—	—	—	—	125,000 110,000	—	—
<u>8F</u>	A194	Nuts machined from bars for high pressure & high temperature service	AlSI 321, strain hardened	Yes	$\frac{5}{8} - \frac{3}{4}$	—	—	—	—	115,000 100,000	—	—
<u>8M</u>	A194	Nuts machined from bars for high pressure & high temperature service	AlSI 316, strain hardened	Yes	$\frac{5}{8} - \frac{3}{4}$	—	—	—	—	125,000 110,000	—	—
<u>8P</u>	A194	Nuts machined from bars for high pressure & high temperature service	AlSI 303 with sulfur or 303Se with selenium, strain hardened	Yes	$\frac{5}{8} - \frac{3}{4}$	—	—	—	—	125,000 110,000	—	—
<u>8P</u>	A194	Nuts machined from bars for high pressure & high temperature service	AlSI 305 (with restricted carbon), strain hardened	Yes	$\frac{5}{8} - \frac{3}{4}$	—	—	—	—	125,000 110,000	—	—
					$\frac{5}{8} - 1$	—	—	—	—	115,000 100,000	—	—
					$1\frac{1}{8} - 1\frac{1}{4}$	—	—	—	—	105,000 95,000	—	—
					$1\frac{1}{4} - 1\frac{1}{2}$	—	—	—	—	100,000 90,000	—	—
					$1\frac{1}{2} - 1\frac{1}{4}$	—	—	—	—	100,000 90,000	—	—
					$1\frac{1}{4} - 1\frac{1}{2}$	—	—	—	—	105,000 95,000	—	—
					$1\frac{1}{2} - 1\frac{1}{4}$	—	—	—	—	100,000 90,000	—	—
					$1\frac{1}{4} - 1\frac{1}{2}$	—	—	—	—	105,000 95,000	—	—
					$1\frac{1}{2} - 1\frac{1}{4}$	—	—	—	—	100,000 90,000	—	—
					$1\frac{1}{4} - 1\frac{1}{2}$	—	—	—	—	105,000 95,000	—	—
					$1\frac{1}{2} - 1\frac{1}{4}$	—	—	—	—	100,000 90,000	—	—

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Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (inches)	Mechanical properties						Remarks or footnotes
						Bolts, screws, studs	Nuts	Proof load (psi)	Tensile strength (min psi)	Proof load hex hex	Brinell	Rockwell
<u>8N</u>	A194	Nuts machined from bars for high pressure & high temperature service	AlSi 304N, strain hardened	Yes	$\frac{1}{4} \cdot \frac{3}{4}$ $\frac{1}{4} \cdot 1$	—	—	—	—	125,000 110,000	—	—
					$\frac{1}{4} \cdot 1\frac{1}{4}$	—	—	—	—	115,000 100,000	—	—
					$\frac{1}{4} \cdot 1\frac{1}{4}$	—	—	—	—	105,000 95,000	—	—
					$\frac{1}{4} \cdot 1\frac{1}{4}$	—	—	—	—	100,000 90,000	—	—
<u>8MN</u>	A194	Nuts machined from bars for high pressure & high temperature service	AlSi 316N, strain hardened	Yes	$\frac{1}{4} \cdot \frac{3}{4}$ $\frac{1}{4} \cdot 1$	—	—	—	—	125,000 110,000	—	—
					$\frac{1}{4} \cdot 1\frac{1}{4}$	—	—	—	—	115,000 100,000	—	—
					$\frac{1}{4} \cdot 1\frac{1}{4}$	—	—	—	—	105,000 95,000	—	—
					$\frac{1}{4} \cdot 1\frac{1}{4}$	—	—	—	—	100,000 90,000	—	—
<u>None req'd</u>	A307, Grade A	Common bolts	Carbon steel	Yes	$\frac{1}{4} \cdot 4$	—	—	60,000	—	121/ 24 ^f	B69/ B100 ^f	Marking on head, raised or depressed.
<u>None req'd</u>	A307, Grade B	Bolts for flanged joints	Carbon steel	Yes	$\frac{1}{4} \cdot 4$	—	—	60,000	—	121/212	B69/B95	Marking on head, raised or depressed.
L7	A320	Bolts, screws, and studs for low temperature service	AlSi 4140, 4142, or 4145 quenched & tempered	Yes	$\frac{1}{4} \cdot 2\frac{1}{2}$	—	105,000	125,000	—	—	—	A
L7A	A320	Bolts, screws, and studs for low temperature service	AlSi 4037 quenched	Yes	$\frac{1}{4} \cdot 2\frac{1}{2}$	—	105,000	125,000	—	—	—	A
L7B	A320	Bolts, screws, and studs for low temperature service	AlSi 4137 quenched & tempered	Yes	$\frac{1}{4} \cdot 2\frac{1}{2}$	—	105,000	125,000	—	—	—	A
L7C	A320	Bolts, screws, and studs for low temperature service	AlSi 8740 quenched & tempered	Yes	$\frac{1}{4} \cdot 2\frac{1}{2}$	—	105,000	125,000	—	—	—	A
L7D	A320	Bolts, screws, and studs for low temperature service	AlSi 4140, 4142, or 4145 quenched & tempered	Yes	$\frac{1}{4} \cdot 2\frac{1}{2}$	—	105,000	125,000	—	—	—	A
L7E	A320	Bolts, screws, and studs for low temperature service	AlSi 4037 quenched & tempered	Yes	$\frac{1}{4} \cdot 2\frac{1}{2}$	—	105,000	125,000	—	—	—	A
L7F	A320	Bolts, screws, and studs for low temperature service	AlSi 4137 quenched & tempered	Yes	$\frac{1}{4} \cdot 2\frac{1}{2}$	—	105,000	125,000	—	—	—	A

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Grade ID mark	ASTM spec number	Fastener description	Material	Is mfr's ID symbol req'd?	Nominal size range (inch)	Mechanical properties						Remarks or footnotes
						Bolts, screws, studs	Proof load (psi)	Yield strength (min psi)	Tensile strength (min psi)	Nuts	Brinell	Rockwell
L73	A320	Bolts, screws, and studs for low temperature service	AlSi 8740 quenched & tempered	Yes	1/4 - 2 1/2	—	105,000	125,000	—	—	—	A
L43	A320	Bolts, screws, and studs for low temperature service	AlSi 4340 quenched & tempered	Yes	1/4 - 4	—	105,000	125,000	—	—	—	A
L7M	A320	Bolts, screws, and studs for low temperature service	AlSi 4140, 4142, or 4145 quenched & tempered	Yes	1/4 - 2 1/2	—	80,000	100,000	—	235C max	895S max	A
L1	A320	Bolts, screws, and studs for low temperature service	Low carbon martensitic steel, quenched & tempered	Yes	1/4 - 1	—	105,000	125,000	—	—	—	A
B8F	A320	Bolts, screws, and studs for low temperature service, Class 1	AlSi 303 with sulfur or 303Se with selenium, carbide solution treated	Yes	1/4 and larger	—	30,000	75,000	—	223D max	896D max	A
B8FA	A320	Bolts, screws, and studs for low temperature service, Class 1A	AlSi 303 or 303Se carbide solution treated in finished condition	Yes	1/4 and larger	—	30,000	75,000	—	192 max	B90 max	A
B8F	A320	Bolts, screws, and studs for low temperature service, Class 2	AlSi 303 or 303Se carbide solution treated and strain hardened	Yes	1/4 - 1	—	100,000	125,000	—	321 max	C35 max	A
A325 or option 1	A325, Type 1	High strength structural bolts	Medium carbon steel, quenched & tempered	Yes	1/4 - 1	85,000	92,000	120,000	—	321	C35 max	A
					1 1/4 - 1 1/2	74,000	81,000	105,000	—	321	C35 max	A
A325	A325, Type 2	High strength structural bolts	Low carbon martensitic steel, quenched & tempered	Yes	1 1/4 - 1 1/2	85,000	92,000	120,000	—	248/331	C24/C35	H.I. J H.I. J
A325	A325, Type 3	High strength structural bolts	Weathering steel, quenched & tempered	Yes	1 1/4 - 1 1/2	74,000	81,000	105,000	—	223/293	C19/C31	H.I. J H.I. J
A325M BS	A325M, Type 1	High strength structural bolts—metric	Medium carbon steel, quenched & tempered	Yes	M16 - M36	600	660	830	—	Vickers	C23/C34	K.L
A325M BS	A325M, Type 2	High strength structural bolts—metric	Low carbon martensitic steel, quenched & tempered	Yes	M16 - M36	600	660	830	—	Vickers	C23/C34	K.L

Footnotes are grouped on the last page of this Part 1 series.

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (Inch)	Mechanical properties					Remarks or footnotes	
						Bolts, screws, studs	Nuts	Hardness	Proof load (psi)	Yield strength (min psi)	Tensile strength (min psi)	
A325M 8S3	A325M, Type 3	High strength structural bolts—metric	Weathering steel quenched & tempered	Yes	M16 - M36	600 MPa	660 MPa	830 MPa	—	Vickers 255/336	C23/C34	J. K. L.
BC	A354, Grade BC	Bolts & studs	Alloy steel, quenched & tempered	Yes	1/4 - 2 1/2 Over 2 1/2 - 4	105,000 Over 95,000	109,000 99,000	125,000 115,000	—	255/331 235/311	C26/36 C22/C33	H.N H.N
BD or V I (M)	A354, Grade BD	Bolts & studs	Alloy steel, quenched & tempered	Yes	1/4 - 2 1/2 Over 2 1/2 - 4	120,000 Over 105,000	130,000 115,000	150,000 140,000	—	311/363 293/363	C33/C39 C31/C39	H.N.O H.N.O
Non req'd (P)	A394	Transmission lower bolts	Galvanized steel	Yes	1/4, 5/16, 3/8, 1/2, 9/16, 5/8, 11/16, 3/4, 7/8, 1 1/16, 1 1/8, 1 1/4, 1 1/2, 1 5/8, 1 3/4, 1 7/8, 2 1/8, 2 1/4, 2 5/8, 2 3/4, 2 7/8, 3 1/8, 3 1/4, 3 3/8, 3 5/8, 3 7/8, 4 1/8, 4 1/4, 4 5/8, 4 3/4, 4 7/8, 5 1/8, 5 1/4, 5 5/8, 5 3/4, 5 7/8, 6 1/8, 6 1/4, 6 5/8, 6 3/4, 6 7/8, 7 1/8, 7 1/4, 7 5/8, 7 3/4, 7 7/8, 8 1/8, 8 1/4, 8 5/8, 8 3/4, 8 7/8, 9 1/8, 9 1/4, 9 5/8, 9 3/4, 9 7/8, 10 1/8, 10 1/4, 10 5/8, 10 3/4, 10 7/8, 11 1/8, 11 1/4, 11 5/8, 11 3/4, 11 7/8, 12 1/8, 12 1/4, 12 5/8, 12 3/4, 12 7/8, 13 1/8, 13 1/4, 13 5/8, 13 3/4, 13 7/8, 14 1/8, 14 1/4, 14 5/8, 14 3/4, 14 7/8, 15 1/8, 15 1/4, 15 5/8, 15 3/4, 15 7/8, 16 1/8, 16 1/4, 16 5/8, 16 3/4, 16 7/8, 17 1/8, 17 1/4, 17 5/8, 17 3/4, 17 7/8, 18 1/8, 18 1/4, 18 5/8, 18 3/4, 18 7/8, 19 1/8, 19 1/4, 19 5/8, 19 3/4, 19 7/8, 20 1/8, 20 1/4, 20 5/8, 20 3/4, 20 7/8, 21 1/8, 21 1/4, 21 5/8, 21 3/4, 21 7/8, 22 1/8, 22 1/4, 22 5/8, 22 3/4, 22 7/8, 23 1/8, 23 1/4, 23 5/8, 23 3/4, 23 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Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (inch)	Mechanical properties					Remarks or footnotes
						Bolts, screws, studs	Nuts	Hardness	Proof load (psi)	Yield strength (min psi)	
651A (H) 651B (H)	A453, Grade 651 A453, Grade 651	Bolts, screws, studs, nuts, and washers for high temperature service Bolts, screws, studs, nuts, and washers for high temperature service	Special alloy steel, specially heat treated Special alloy steel, specially heat treated	Yes Yes	$\frac{1}{4}$ - 3 Over 3 and larger $\frac{1}{4}$ - 3 Over 3 and larger	-- -- -- --	70,000 60,000 60,000 50,000	100,000 100,000 95,000 95,000	-- -- 210/210 210/210	220/280 220/280 -- --	A, R A, R A, R A, R
	Class A Class B	Class A Class B									
662A (H) 662B (H)	A453, Grade 662 A453, Grade 662	Bolts, screws, studs, nuts, and washers for high temperature service Bolts, screws, studs, nuts, and washers for high temperature service	Special alloy steel, specially heat treated Special alloy steel, specially heat treated	Yes Yes	$\frac{1}{4}$ and larger $\frac{1}{4}$ and larger	-- --	85,000 80,000	130,000 125,000	-- --	255/321 248/321	-- --
	Class A Class B	Class A Class B									A
665A (H) 665B (H)	A453, Grade 665 A453, Grade 665	Bolts, screws, studs, nuts, and washers for high temperature service Bolts, screws, studs, nuts, and washers for high temperature service	Special alloy steel, specially heat treated Special alloy steel, specially heat treated	Yes Yes	$\frac{1}{4}$ and larger $\frac{1}{4}$ and larger	-- --	120,000 120,000	170,000 155,000	-- --	311/398 311/388	-- --
	Class A Class B	Class A Class B									A
None req'd	A489	Eyebolts	Carbon steel, quenched and tempered	Yes	$\frac{1}{4}$ - 2 $\frac{1}{2}$	(S)	30,000	65,000 min. 85,000 max	-- -- --	-- -- --	T

ASTM footnotes

- A.** Grade and manufacturer's identification symbols shall be applied to one end of studs $\frac{1}{4}$ " in diameter and larger, and to the heads of bolts and screws $\frac{1}{4}$ " in diameter and larger (if available area is inadequate, grade symbol may be marked on one end and manufacturer's identification symbol marked on the other end).
- B.** To meet tensile requirements, Brinell hardness shall be over 201 HB (91 HRB).
- C.** A191 products are for high temperature service, A320 products are for low temperature service.
- D.** For sizes $\frac{1}{4}$ " and smaller, maximum hardness of 241 HB (100 HRB) is permitted.
- E.** Nuts machined from heat treated bars need not be heat treated.
- F.** Except when tested by wedge tension test.

G. A149 in sizes $\frac{1}{4}$ " through 1 $\frac{1}{2}$ " is equivalent to SAE Grade 5.

R. In addition to identification symbols (grade and class), the type designation 2 shall also appear on all (roll threaded) bolting material so processed. Absence of the type designation number indicates Type I processed material or machine cut threads.

S. Refer to ASTM Standard A489 for specific strength requirements.

T. Manufacturer's name or identification mark shall be forged in raised characters on eyebolt surface.

P. Bolts may be marked on the head by agreement with customer.

Q. Grade BD in sizes $\frac{1}{4}$ " through 1 $\frac{1}{2}$ " is equivalent to SAE Grade 8 (Note: AISI 1541 does not satisfy chemical requirements for Grade BD).

R. Bolts may be marked on the head by agreement with customer.

L. Short length bolts need only meet hardness limits, as they are their only mechanical requirement (Refer to Table 4 of ASTM F568 for definition of minimum length of product subject to tensile testing).

M. Grade BD bolts $\frac{1}{4}$ " through 1 $\frac{1}{2}$ " diameter shall be marked with six radial lines 60 degrees apart on top of both head instead of the grade symbol.

N. Marks may be raised or depressed on the top of the head for bolts and on one end for studs.

O. Grade BD in sizes $\frac{1}{4}$ " through 1 $\frac{1}{2}$ " does not satisfy chemical requirements for Grade BD.

J. Manufacturer may add other distinguishing marks indicating the fastener is atmospheric corrosion resistant and/or weathering type.

K. All markings shall not be located on top of the head, or depressed base of properly classed bolts. They shall be positioned toward the closest periphery of the head.

Grade and material markings—Part II

ASTM markings

The American Society for Testing and Materials, 1916 Race St, Philadelphia PA 19103, sponsors development of specifications for fasteners used in general and special engineering applications. These specifications detail chemical and mechanical properties of material strength levels for fasteners and are generally specific in referencing the actual product covered. A full range of types of products of various styles, thread series, lengths, etc., can be produced to meet ASTM requirements and would be marked for grade and material identification as required.

ASTM

Grade and material identification markings required by ASTM specifications

Grade ID mark	ASTM spec number	Fastener description	Material	Is migr's ID symbol req'd?	Nominal size range (inch)	Mechanical properties					Remarks or footnotes
						Bolts, screws, studs	Yield load (psi)	Tensile strength (min psi)	Proof load (psi)	Nuis	
A490	A490, Type 1	High strength structural bolts	Alloy steel, quenched & tempered	Yes	½ - 1½	120,000	130,000	150,000	—	311/352 C33/C38	Marking on top of head, raised or depressed (H)
<u>A490</u>	A490, Type 2	High strength structural bolts	Low carbon martensite steel, quenched & tempered	Yes	½ - 1½	120,000	130,000	150,000	—	311/352 C33/C38	Marking on top of head, raised or depressed (H)
A490	A490, Type 3	High strength structural bolts	Weathering steel, quenched & tempered	Yes	½ - 1½	120,000	130,000	150,000	—	311/352 C33/C38	Marking on top of head, raised or depressed (H,J)
<u>A490M</u> 10S	A490M, Type 1	High strength structural bolts—metric	Alloy steel, quenched & tempered	Yes	M16 - M36 mm	830 MPa	940 MPa	1040 MPa	—	Vickers 327/382	C33/C39 K
<u>A490M</u> 10S	A490M, Type 2	High strength structural bolts—metric	Low carbon martensite steel, quenched & tempered	Yes	M16 - M36 mm	830 MPa	940 MPa	1040 MPa	—	Vickers 327/382	C33/C39 K
A490M 10S3	A490M, Type 3	High strength structural bolts—metric	Weathering steel, quenched & tempered	Yes	M16 - M36 mm	830 MPa	940 MPa	1040 MPa	—	Vickers 327/382	C33/C39 J,K
None req'd (U)	A502, Grade 1	Structural rivets	Carbon steel	Yes	½ - 1½	—	—	—	—	1031/126 B55/B72	Markings on top of rivet head, raised or depressed
2	A502, Grade 2	Structural rivets	Carbon manganese steel	Yes	½ - 1½	—	—	—	—	1371/163 B76/B85	Markings on top of rivet head, raised or depressed
3	A502, Grade 3	Structural rivets	Weathering steel	Yes	½ - 1½	—	—	—	—	1371/197 B76/B93	Markings on top of rivet head, raised or depressed

Footnotes are grouped on the last page of this Part II series.

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (inch)	Mechanical properties						Remarks or footnotes		
						Bolts, screws, studs			Nuts		Hardness			
						Bolt Proof load (psi)	Yield strength (min psi)	Tensile strength (min psi)	Proof load (psi)	Brinell	Rockwell			
B21 (N)	A540, Grade B21, Class 5	Bolts, studs, washers, and nuts for nuclear and other special applications	Alloy steel (Cr-Mo-V), quenched & tempered	Yes	Thru 2 Over 2 - 6 Over 6 - 8	— 105,000 100,000	120,000 115,000	— 115,000	— —	241/285 248/302	— —	W W		
B21 (N)	A540, Grade B21, Class 4	Bolts, studs, washers, and nuts for nuclear and other special applications	Alloy steel (Cr-Mo-V), quenched & tempered	Yes	Thru 3 Over 3 - 6	— 120,000	135,000 135,000	— —	269/331 277/352	— —	W W			
B21 (N)	A540, Grade B21, Class 3	Bolts, studs, washers, and nuts for nuclear and other special applications	Alloy steel (Cr-Mo-V), quenched & tempered	Yes	Thru 3 Over 3 - 6	— 130,000	145,000 145,000	— —	293/352 302/375	— —	W W			
B21 (N)	A540, Grade B21, Class 2	Bolts, studs, washers, and nuts for nuclear and other special applications	Alloy steel (Cr-Mo-V), quenched & tempered	Yes	Thru 4	— 140,000	155,000	— —	311/401	— —	W			
B21 (N)	A540, Grade B21, Class 1	Bolts, studs, washers, and nuts for nuclear and other special applications	Alloy steel (Cr-Mo-V), quenched & tempered	Yes	Thru 4	— 150,000	165,000	— —	321/429	— —	W			
B22 (N)	A540, Grade B22, Class 5	Bolts, studs, washers, and nuts for nuclear and other special applications	AISI 4142-H, quenched & tempered	Yes	Thru 2 Over 2 - 4	— 105,000 100,000	120,000 115,000	— —	248/293 255/302	— —	W W			
B22 (N)	A540, Grade B22, Class 4	Bolts, studs, washers, and nuts for nuclear and other special applications	AISI 4142-H, quenched & tempered	Yes	Thru 1 Over 1 - 4	— 120,000	135,000 135,000	— —	269/341 277/363	— —	W W			
B22 (N)	A540, Grade B22, Class 3	Bolts, studs, washers, and nuts for nuclear and other special applications	AISI 4142-H, quenched & tempered	Yes	Thru 2 Over 2 - 4	— 130,000 130,000	145,000 145,000	— —	293/363 302/375	— —	W W			
B22 (N)	A540, Grade B22, Class 2	Bolts, studs, washers, and nuts for nuclear and other special applications	AISI 4142-H, quenched & tempered	Yes	Thru 3	— 140,000	155,000	— —	311/401	— —	W			
B22 (N)	A540, Grade B22, Class 1	Bolts, studs, washers, and nuts for nuclear and other special applications	AISI 4142-H, quenched & tempered	Yes	Thru 1 1/2	— 150,000	165,000	— —	321/401	— —	W			
B23 (N)	A540, Grade B23, Class 5	Bolts, studs, washers, and nuts for nuclear and other special applications	AISI E-4340-H, quenched & tempered	Yes	Thru 6 Over 6 - 8 Over 8 - 9 1/2	— 105,000 100,000 100,000	120,000 115,000 115,000	— — —	248/311 255/321 262/321	— — —	W W W			

Footnotes are grouped on the last page of this Part II series

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (inches)	Mechanical properties					Remarks or footnotes	
						Bolts, screws, studs	Nuts	Hardness	Proof load (psi)	Yield strength (min psi)	Tensile strength (min psi)	
B23 (N)	A540, Grade B23, Class 4	Bolts, studs, washers, and nuts for nuclear and other special applications	AISI E-4340-H, quenched & tempered	Yes	Thru 3 Over 3 - 6 Over 6 - 9½	— 120,000 135,000	— 120,000 135,000	— —	135,000 145,000	— —	269/341 277/352	— —
B23 (N)	A540, Grade B23 Class 3	Bolts, studs, washers, and nuts for nuclear and other special applications	AISI E-4340-H, quenched & tempered	Yes	Thru 3 Over 3 - 6 Over 6 - 9½	— 130,000 145,000	— 130,000 145,000	— —	145,000 145,000	— —	293/363 302/375	— —
B23 (N)	A540, Grade B23 Class 2	Bolts, studs, washers, and nuts for nuclear and other special applications	AISI E-4340-H, quenched & tempered	Yes	Thru 3 Over 3 - 6 Over 6 - 9½	— 140,000 155,000	— 140,000 155,000	— —	155,000 165,000	— —	311/388 311/401	— —
B23 (N)	A540, Grade B23 Class 1	Bolts, studs, washers, and nuts for nuclear and other special applications	AISI E-4340 H, quenched & tempered	Yes	Thru 3 Over 3 - 6 Over 6 - 8	— 150,000 165,000	— 150,000 165,000	— —	165,000 170,000	— —	321/415 321/429	— —
B24 (N)	A540, Grade B24 Class 5	Bolts, studs, washers, and nuts for nuclear and other special applications	AISI 4340 Mod., quenched & tempered	Yes	Thru 6 Over 6 - 8 Over 8 - 9½	— 105,000 120,000	— 100,000 115,000	— —	120,000 135,000	— —	248/311 255/321	— —
B24 (N)	A540, Grade B24 Class 4	Bolts, studs, washers, and nuts for nuclear and other special applications	AISI 4340 Mod., quenched & tempered	Yes	Thru 6 Over 6 - 8 Over 8 - 9½	— 100,000 115,000	— —	115,000	— —	262/321	— —	
B24 (N)	A540, Grade B24 Class 3	Bolts, studs, washers, and nuts for nuclear and other special applications	AISI 4340 Mod., quenched & tempered	Yes	Thru 3 Over 3 - 6 Over 7 - 9½	— 120,000 135,000	— 120,000 135,000	— —	135,000 145,000	— —	269/341 277/352	— —
B24 (N)	A540, Grade B24 Class 2	Bolts, studs, washers, and nuts for nuclear and other special applications	AISI 4340 Mod., quenched & tempered	Yes	Thru 7 Over 7 - 9½	— 130,000 145,000	— 130,000 145,000	— —	145,000 155,000	— —	293/363 302/388	— —
B24 (N)	A540, Grade B24 Class 1	Bolts, studs, washers, and nuts for nuclear and other special applications	AISI 4340 Mod., quenched & tempered	Yes	Thru 6 Over 6 - 8	— 150,000 165,000	— 150,000 165,000	— —	165,000 170,000	— —	311/401 321/415	— —

Footnotes are grouped on the last page of this Part II series.

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfr's ID symbol req'd?	Nominal size range (inch)	Mechanical properties						Remarks or footnotes	
						Bolts, screws, studs	Yield strength (min psi)	Tensile strength (min psi)	Nuts	Proof load (psi)	Brinell	Rockwell	
B24V (V)	A540, Grade B24V Class 3	Bolts, studs, washers, and nuts for nuclear and other special applications	AISI 4340V Mod. quenched & tempered	Yes	Thru 4 Over 4 - 8 Over 8 - 11	130,000 — 130,000	145,000 145,000 145,000	— — —	299/363 302/375 311/388	— — —	W W W		
B24V (V)	A540, Grade B24V Class 2	Bolts, studs, washers, and nuts for nuclear and other special applications	AISI 4340V Mod. quenched & tempered	Yes	Thru 4 Over 4 - 8 Over 8 - 11	140,000 140,000 140,000	155,000 155,000 155,000	— — —	311/388 311/401 321/415	— — —	W W W		
B24V (V)	A540, Grade B24V Class 1	Bolts, studs, washers, and nuts for nuclear and other special applications	AISI 4340V Mod. quenched & tempered	Yes	Thru 4 Over 4 - 8 Over 8 - 11	150,000 150,000 150,000	165,000 165,000 165,000	— — —	321/415 331/429 331/444	— — —	W W W		
None req'd (X)	A563, Grade 0	Nuts for general structural and mechanical use	Carbon steel	No	1/4 - 1 1/4	—	—	—	Y	103/302	B55/C32	—	
None req'd (X)	A563, Grade A	Nuts for general structural and mechanical use	Carbon steel	No	1/4 - 4	—	—	—	Y	116/302	B68/C32	—	
None req'd (X)	A563, Grade B	Nuts for general structural and mechanical use	Carbon steel	No	1 1/4 - 1 1/2	—	—	—	Y	121/302	B69/C32	—	
(1)	A563, Grade C	Heavy hex nuts for general structural and mechanical use	Carbon steel	Yes	1/4 - 4	—	—	—	144,000	143/352	B78/C38	Grade mark shall be applied to one nut face.	(Z.J)
(3)	A563, Grade C3	Heavy hex nuts for general structural and mechanical use	Weathering steel	Yes	1/4 - 4	—	—	—	144,000	143/352	B78/C38	Grade mark shall be applied to one nut face.	(Z.AA)
D	A563, Grade D	Nuts for general structural and mechanical use	Alloy steel	Yes	1/4 - 4	—	—	—	Y	159/352	B84/C38	Grade mark shall be applied to one nut face.	(Z.BB)
DH	A563, Grade DH	Nuts for general structural and mechanical use	Alloy steel, quenched & tempered	Yes	1/4 - 4	—	—	—	Y	248/352	C24/C38	Grade mark shall be applied to one nut face.	(J.Z)
DH3	A563, Grade DH3	Heavy hex nuts for general structural and mechanical use	Weathering steel, quenched & tempered	Yes	1/4 - 4	—	—	—	175,000	248/352	C24/C38	Grade mark shall be applied to one nut face.	

Footnotes are grouped on the last page of this Part II series.

Grade ID mark	ASTM spec number	Fastener description	Material	Is major's ID symbol req'd?	Nominal size range (mm)	Mechanical properties					Remarks or footnotes
						Bolts, screws, studs	Nuts	Hardness	Yield strength	Tensile strength	Proof load
6	A563M, Class 5	Nuts for general structural and mechanical use—metric	Carbon steel	No	M1.6 - M4 & M5 & M6 & M8 & M10 - M12 - M16 M20 - M36 M42 - M100	—	—	—	520 MPa	Vickers 130/302	Z,DD
9	A563M, Class 9	Nuts for general structural and mechanical use—metric	Carbon steel	No	M3 - M4 & M5 & M6 & M8 & M10 M12 - M16 M20 - M100	—	—	—	580 MPa	Vickers 130/302	Z,DD
10	A563M, Class 10	Nuts for general structural and mechanical use—metric	Alloy steel, quenched & tempered	Yes	M1.6 - M10 M12 - M16 M20 - M36	—	—	—	900 MPa	Vickers 170/302	Z,DD
12	A563M, Class 12	Nuts for general structural and mechanical use—metric	Alloy steel, quenched & tempered	Yes	M3 - M6 & M8 & M10 M12 - M16 M20 - M100	—	—	—	940 MPa	Vickers 188/302	Z,DD
8S	A563M, Class 8S	Nuts for general structural and mechanical use—metric	Carbon steel	Yes	M12 - M36	—	—	—	950 MPa	Vickers 188/302	Z,DD
8S3	A563M, Class 8S3	Nuts for general structural and mechanical use—metric	Weathering steel	Yes	M12 - M36	—	—	—	1040 MPa	Vickers 272/353	Z,DD
10S	A563M, Class 10S	Nuts for general structural and mechanical use—metric	Alloy steel, quenched & tempered	Yes	M12 - M36	—	—	—	1050 MPa	Vickers 272/353	Z,DD
10S3	A563M, Class 10S3	Nuts for general structural and mechanical use—metric	Weathering steel, quenched & tempered	Yes	M12 - M36	—	—	—	1060 MPa	Vickers 272/353	Z,DD
									1100 MPa	Vickers 272/353	Z,DD
									1150 MPa	Vickers 272/353	Z,DD
									1160 MPa	Vickers 272/353	Z,DD
									1190 MPa	Vickers 272/353	Z,DD
									1200 MPa	Vickers 272/353	Z,DD
									1245 MPa	Vickers 272/372	J,Z,DD
									1245 MPa	Vickers 272/372	J,Z,DD

Footnotes are grouped on the last page of this Part II series.

Grade ID mark	ASTM spec number	Fastener description	Material	Is major ID symbol req'd?	Nominal size range (inch)	Mechanical properties						Remarks or footnotes	
						Bolts, screws, studs	Nuts	Hardness	Proof load (psi)	Yield strength (min psi)	Tensile strength (min psi)	Brinell	Rockwell
None req'd See EE	A574	Socket head cap screws	Alloy steel, quenched & tempered	No	$\frac{1}{8}$ and smaller $\frac{1}{4}$ - .4	140,000 135,000	— F _f	180,000	—	—	—	C39/C45	H
12.9	A574M	Socket head cap screws, metric	Alloy steel, quenched & tempered	Yes	M1.6 - M48 mm	970 MPa	1100 MPa	1220 MPa	—	Vickers 372/434 DPH	C39/C44	GG	
A687	A687	Bolts & studs	Alloy steel, quenched & tempered	No	$\frac{1}{8}$ - 3	—	105,000 max	150,000 max	—	—	—	—	Marking appears on the end of product. HH
See "Remarks"		A761	Fasteners for pipe, pipe anchors and arches	Galvanized steel	Yes	$\frac{1}{8}$ only	—	—	—	—	—	—	See Footnote II
None req'd	C646	Drill screws for gypsum board on light-gage steel shanks	Grade 1013 to 1022 carbon steel wire in accordance with ASTM A548.	No	—	—	—	—	—	—	—	—	C45 min case hardness
None req'd	C893	Type G screws for gypsum board to gypsum board	Grade 1013 to 1022 carbon steel wire in accordance with ASTM A548	No	—	—	—	—	—	—	—	—	C45 min case hardness
None req'd	C894	Type W screws for gypsum board to wood framing	Grade 1013 to 1022 carbon steel wire in accordance with ASTM A548	No	—	—	—	—	—	—	—	—	C45 min case hardness
GR30	F432, Grade 30	Roof & rock bolts and accessories	Carbon steel	Yes	$\frac{1}{8}$ - 1	—	30,000	60,000	—	See ASTM F432	—	JJ	
GR55	F432, Grade 55	Roof & rock bolts and accessories	Carbon steel	Yes	$\frac{1}{8}$ - $\frac{1}{2}$	—	55,000	85,000	—	See ASTM F432	—	JJ	
GR76	F432, Grade 75	Roof & rock bolts and accessories	Carbon steel	Yes	$\frac{1}{8}$ - 1	—	75,000	100,000	—	See ASTM F432	—	JJ	
GR40	F432, Grade 40	Roof & rock bolts—headed deformed bars	Carbon steel	Yes	All sizes	—	—	—	—	See ASTM A615	—	JJ	
GR60	F432, Grade 60	Roof & rock bolts—headed deformed bars	Carbon steel	Yes	All sizes	—	—	—	—	See ASTM A615	—	JJ	

Footnotes are grouped on the last page of this Part II series

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg'r's ID symbol req'd?	Nominal size range (inch)	Mechanical properties						Remarks or footnotes	
						Bolts, screws, studs	Proof load (psi)	Yield strength (min psi)	Tensile strength (min psi)	Proof load (psi)	Brinell	Rockwell	
M	F436M	Hardened washers— Metric type 1	Carbon steel	Yes	1/2 - 4	—	—	—	—	—	—	TT	KK
3M	F436M	Hardened washers— Metric Type 3	Weathering steel	Yes	M12 - M100 mm	—	—	—	—	—	—	TT	KK
None req'd	F467	Nuts for general use	EIP copper UNS C11000	No	1/2 - 1 1/4	—	—	—	30,000	—	F65 min	—	
None req'd	F467	Nuts for general use	Brass UNS C26200	No	1/2 - 1 1/4	—	—	—	60,000	—	F55 min	—	
None req'd	F467	Nuts for general use	Naval brass UNS C46400	No	1/2 - 1 1/4	—	—	—	50,000	—	B65 min	—	
None req'd	F467	Nuts for general use	Naval brass UNS C51000	No	1/2 - 1 1/4	—	—	—	50,000	—	B55 min	—	
None req'd	F467	Nuts for general use	Phosphor bronze UNS C61300	No	1/2 - 1 1/4	—	—	—	60,000	—	B60 min	—	
None req'd	F467	Nuts for general use	Aluminum bronze UNS C61400	No	1/2 - 1 1/4	—	—	—	80,000	—	B70 min	—	
None req'd	F467	Nuts for general use	Aluminum bronze UNS C63000	No	1/2 - 1 1/4	—	—	—	75,000	—	B70 min	—	
None req'd	F467	Nuts for general use	Aluminum silicon bronze UNS C64200	No	1/2 - 1 1/4	—	—	—	100,000	—	B85 min	—	
None req'd	F467	Nuts for general use	Silicon bronze UNS C65100	No	1/2 - 1 1/4	—	—	—	75,000	—	B75 min	—	
None req'd	F467	Nuts for general use	Silicon bronze UNS C65500	No	1/2 - 1 1/4	—	—	—	50,000	—	B60 min	—	
None req'd	F467	Nuts for general use	Silicon bronze UNS C66100	No	1/2 - 1 1/4	—	—	—	70,000	—	B75 min	—	
None req'd	F467	Nuts for general use	Manganese bronze UNS C67500	No	1/2 - 1 1/4	—	—	—	55,000	—	B60 min	—	

Footnotes are grouped on the last page of this Part II series.

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (inch)	Mechanical properties						Remarks or footnotes
						Bolts, screws, studs	Proof load (psi)	Yield strength (min psi)	Tensile strength (min psi)	Proof load (psi)	Brinell	Rockwell
None req'd	F467	Nuts for general use	Cupro-nickel UNS C71000	No	1/4 - 1 1/2	—	—	—	45,000	—	850	—
None req'd	F467	Nuts for general use	Cupro-nickel UNS C71500	No	1/4 - 1 1/2	—	—	—	55,000	—	860	—
None req'd	F467	Nuts for general use	Ni-Mo based UNS N10001	No	1/4 - 1 1/2	—	—	—	115,000	—	C20	—
None req'd	F467	Nuts for general use	Ni-Mo-Cr based UNS N10002	No	1/4 - 1 1/2	—	—	—	110,000	—	C20	—
None req'd	F467	Nuts for general use	Ni-Cu Class A UNS N04400	No	1/4 - 1 1/2	—	—	—	80,000	—	875	—
None req'd	F467	Nuts for general use	Ni-Cu Class B UNS N04405	No	1/4 - 1 1/2	—	—	—	70,000	—	860	—
None req'd	F467	Nuts for general use	Ni-Cu-Al based UNS N05500	No	1/4 - 1 1/2	—	—	—	130,000	—	C24	—
None req'd	F467	Nuts for general use	Aluminum 2024 UNS A92024	No	1/4 - 1 1/2	—	—	—	55,000	—	B70	—
None req'd	F467	Nuts for general use	Aluminum 6061 UNS A96061	No	1/4 - 1 1/2	—	—	—	40,000	—	B40	—
None req'd	F467	Nuts for general use	Aluminum 6262 UNS A96262	No	1/4 - 1 1/2	—	—	—	52,000	—	860	—

ASTM footnotes

H. Bolts (screws) less than three diameters in length and fluds less than four diameters in length shall have a load stress values not less than the minimum not more than the maximum hardness limits required as hardness is their only mechanical requirement.

I. Engraving symbols all markings located on top of head, raised or depressed.

J. Manufacturer may add other distinguishing marks including the fastener's atmospheric corrosion resistant and/or a weathering type.

K. All markings shall be located on top of the head raised or depressed. Base of property class symbols shall be positioned toward the closest periphery of the head.

L. The numeral 1 may be used at manufacturer's option of a weathering type.

M. Grade and manufacturer's identification symbols shall be located on one end of studs and to heads of bolts of all sizes. If available area is inadequate, grade symbols may be placed on one end and the manufacturer's symbol a longer symbol marked on the other end for bolts and studs.

Refer to ASTM A563M for specific values

X. When individual grade marking is specified in the inquiry and order, the mark shall be the grade letter symbol on one nut face.

Y. Proof load stresses vary depending on nut style, thread series, and in some cases on whether or not nuts are galvanized. Refer to ASTM Standard A563 for specific values.

Z. Marks may be raised or depressed. If, however, marks are located on the bearing surface for one of the wrenching flats for ASTM fasteners they shall be depressed.

AA. Nuts made in accordance with ASTM A194 Grade 2 or 2H and marked with their grade symbol are acceptable equivalents for Grades C and D nuts.

BB. Nuts made in accordance with ASTM A194 Grade 2H and marked with its grade symbol are an acceptable equivalent for Grade DH nuts.

CC. Proof load stresses are reduced for nuts and studs

II. Assembly bolts conform to ASTM A449 requirements. nuts conform to Grade C of A563 Headwill anchor bolt material conforms to A307 and nuts conform to Grade B of A563.

JJ. Nut heads shall be marked with either raised or depressed marks at manufacturer's option. Marks shall include grade and diameter identifying when applicable manufacturer's symbol and bolt length. Threaded bars threaded slotted bars extensions bevelled washers threaded tapered pins, wedges spherical washers threaded couplings and flat bearing plates are not required to be marked. Deformed bearing and header plates plus hardened washers shall be marked with manufacturer's symbol. Nuts shall be marked in accordance with the ASME Specification to which they were manufactured. Strips shall be marked with manufacturer's symbol and no size for which they are intended.

KK. All marking symbols shall be impressed on one washer face.

LL. Rockwell hardness C30, 45, through hardened to C35, 45, 50, 55, 60, 65, 70, 75, 80, 85, 90, 95, 100, 105, 110, 115, 120, 125, 130, 135, 140, 145, 150, 155, 160, 165, 170, 175, 180, 185, 190, 195, 200, 205, 210, 215, 220, 225, 230, 235, 240, 245, 250, 255, 260, 265, 270, 275, 280, 285, 290, 295, 300, 305, 310, 315, 320, 325, 330, 335, 340, 345, 350, 355, 360, 365, 370, 375, 380, 385, 390, 395, 400, 405, 410, 415, 420, 425, 430, 435, 440, 445, 450, 455, 460, 465, 470, 475, 480, 485, 490, 495, 500, 505, 510, 515, 520, 525, 530, 535, 540, 545, 550, 555, 560, 565, 570, 575, 580, 585, 590, 595, 600, 605, 610, 615, 620, 625, 630, 635, 640, 645, 650, 655, 660, 665, 670, 675, 680, 685, 690, 695, 700, 705, 710, 715, 720, 725, 730, 735, 740, 745, 750, 755, 760, 765, 770, 775, 780, 785, 790, 795, 800, 805, 810, 815, 820, 825, 830, 835, 840, 845, 850, 855, 860, 865, 870, 875, 880, 885, 890, 895, 900, 905, 910, 915, 920, 925, 930, 935, 940, 945, 950, 955, 960, 965, 970, 975, 980, 985, 990, 995, 1000, 1005, 1010, 1015, 1020, 1025, 1030, 1035, 1040, 1045, 1050, 1055, 1060, 1065, 1070, 1075, 1080, 1085, 1090, 1095, 1100, 1105, 1110, 1115, 1120, 1125, 1130, 1135, 1140, 1145, 1150, 1155, 1160, 1165, 1170, 1175, 1180, 1185, 1190, 1195, 1200, 1205, 1210, 1215, 1220, 1225, 1230, 1235, 1240, 1245, 1250, 1255, 1260, 1265, 1270, 1275, 1280, 1285, 1290, 1295, 1300, 1305, 1310, 1315, 1320, 1325, 1330, 1335, 1340, 1345, 1350, 1355, 1360, 1365, 1370, 1375, 1380, 1385, 1390, 1395, 1400, 1405, 1410, 1415, 1420, 1425, 1430, 1435, 1440, 1445, 1450, 1455, 1460, 1465, 1470, 1475, 1480, 1485, 1490, 1495, 1500, 1505, 1510, 1515, 1520, 1525, 1530, 1535, 1540, 1545, 1550, 1555, 1560, 1565, 1570, 1575, 1580, 1585, 1590, 1595, 1600, 1605, 1610, 1615, 1620, 1625, 1630, 1635, 1640, 1645, 1650, 1655, 1660, 1665, 1670, 1675, 1680, 1685, 1690, 1695, 1700, 1705, 1710, 1715, 1720, 1725, 1730, 1735, 1740, 1745, 1750, 1755, 1760, 1765, 1770, 1775, 1780, 1785, 1790, 1795, 1800, 1805, 1810, 1815, 1820, 1825, 1830, 1835, 1840, 1845, 1850, 1855, 1860, 1865, 1870, 1875, 1880, 1885, 1890, 1895, 1900, 1905, 1910, 1915, 1920, 1925, 1930, 1935, 1940, 1945, 1950, 1955, 1960, 1965, 1970, 1975, 1980, 1985, 1990, 1995, 2000, 2005, 2010, 2015, 2020, 2025, 2030, 2035, 2040, 2045, 2050, 2055, 2060, 2065, 2070, 2075, 2080, 2085, 2090, 2095, 2100, 2105, 2110, 2115, 2120, 2125, 2130, 2135, 2140, 2145, 2150, 2155, 2160, 2165, 2170, 2175, 2180, 2185, 2190, 2195, 2200, 2205, 2210, 2215, 2220, 2225, 2230, 2235, 2240, 2245, 2250, 2255, 2260, 2265, 2270, 2275, 2280, 2285, 2290, 2295, 2300, 2305, 2310, 2315, 2320, 2325, 2330, 2335, 2340, 2345, 2350, 2355, 2360, 2365, 2370, 2375, 2380, 2385, 2390, 2395, 2400, 2405, 2410, 2415, 2420, 2425, 2430, 2435, 2440, 2445, 2450, 2455, 2460, 2465, 2470, 2475, 2480, 2485, 2490, 2495, 2500, 2505, 2510, 2515, 2520, 2525, 2530, 2535, 2540, 2545, 2550, 2555, 2560, 2565, 2570, 2575, 2580, 2585, 2590, 2595, 2600, 2605, 2610, 2615, 2620, 2625, 2630, 2635, 2640, 2645, 2650, 2655, 2660, 2665, 2670, 2675, 2680, 2685, 2690, 2695, 2700, 2705, 2710, 2715, 2720, 2725, 2730, 2735, 2740, 2745, 2750, 2755, 2760, 2765, 2770, 2775, 2780, 2785, 2790, 2795, 2800, 2805, 2810, 2815, 2820, 2825, 2830, 2835, 2840, 2845, 2850, 2855, 2860, 2865, 2870, 2875, 2880, 2885, 2890, 2895, 2900, 2905, 2910, 2915, 2920, 2925, 2930, 2935, 2940, 2945, 2950, 2955, 2960, 2965, 2970, 2975, 2980, 2985, 2990, 2995, 3000, 3005, 3010, 3015, 3020, 3025, 3030, 3035, 3040, 3045, 3050, 3055, 3060, 3065, 3070, 3075, 3080, 3085, 3090, 3095, 3100, 3105, 3110, 3115, 3120, 3125, 3130, 3135, 3140, 3145, 3150, 3155, 3160, 3165, 3170, 3175, 3180, 3185, 3190, 3195, 3200, 3205, 3210, 3215, 3220, 3225, 3230, 3235, 3240, 3245, 3250, 3255, 3260, 3265, 3270, 3275, 3280, 3285, 3290, 3295, 3300, 3305, 3310, 3315, 3320, 3325, 3330, 3335, 3340, 3345, 3350, 3355, 3360, 3365, 3370, 3375, 3380, 3385, 3390, 3395, 3400, 3405, 3410, 3415, 3420, 3425, 3430, 3435, 3440, 3445, 3450, 3455, 3460, 3465, 3470, 3475, 3480, 3485, 3490, 3495, 3500, 3505, 3510, 3515, 3520, 3525, 3530, 3535, 3540, 3545, 3550, 3555, 3560, 3565, 3570, 3575, 3580, 3585, 3590, 3595, 3600, 3605, 3610, 3615, 3620, 3625, 3630, 3635, 3640, 3645, 3650, 3655, 3660, 3665, 3670, 3675, 3680, 3685, 3690, 3695, 3700, 3705, 3710, 3715, 3720, 3725, 3730, 3735, 3740, 3745, 3750, 3755, 3760, 3765, 3770, 3775, 3780, 3785, 3790, 3795, 3800, 3805, 3810, 3815, 3820, 3825, 3830, 3835, 3840, 3845, 3850, 3855, 3860, 3865, 3870, 3875, 3880, 3885, 3890, 3895, 3900, 3905, 3910, 3915, 3920, 3925, 3930, 3935, 3940, 3945, 3950, 3955, 3960, 3965, 3970, 3975, 3980, 3985, 3990, 3995, 4000, 4005, 4010, 4015, 4020, 4025, 4030, 4035, 4040, 4045, 4050, 4055, 4060, 4065, 4070, 4075, 4080, 4085, 4090, 4095, 4100, 4105, 4110, 4115, 4120, 4125, 4130, 4135, 4140, 4145, 4150, 4155, 4160, 4165, 4170, 4175, 4180, 4185, 4190, 4195, 4200, 4205, 4210, 4215, 4220, 4225, 4230, 4235, 4240, 4245, 4250, 4255, 4260, 4265, 4270, 4275, 4280, 4285, 4290, 4295, 4300, 4305, 4310, 4315, 4320, 4325, 4330, 4335, 4340, 4345, 4350, 4355, 4360, 4365, 4370, 4375, 4380, 4385, 4390, 4395, 4400, 4405, 4410, 4415, 4420, 4425, 4430, 4435, 4440, 4445, 4450, 4455, 4460, 4465, 4470, 4475, 4480, 4485, 4490, 4495, 4500, 4505, 4510, 4515, 4520, 4525, 4530, 4535, 4540, 4545, 4550, 4555, 4560, 4565, 4570, 4575, 4580, 4585, 4590, 4595, 4600, 4605, 4610, 4615, 4620, 4625, 4630, 4635, 4640, 4645, 4650, 4655, 4660, 4665, 4670, 4675, 4680, 4685, 4690, 4695, 4700, 4705, 4710, 4715, 4720, 4725, 4730, 4735, 4740, 4745, 4750, 4755, 4760, 4765, 4770, 4775, 4780, 4785, 4790, 4795, 4800, 4805, 4810, 4815, 4820, 4825, 4830, 4835, 4840, 4845, 4850, 4855, 4860, 4865, 4870, 4875, 4880, 4885, 4890, 4895, 4900, 4905, 4910, 4915, 4920, 4925, 4930, 4935, 4940, 4945, 4950, 4955, 4960, 4965, 4970, 4975, 4980, 4985, 4990, 4995, 5000, 5005, 5010, 5015, 5020, 5025, 5030, 5035, 5040, 5045, 5050, 5055, 5060, 5065, 5070, 5075, 5080, 5085, 5090, 5095, 5100, 5105, 5110, 5115, 5120, 5125, 5130, 5135, 5140, 5145, 5150, 5155, 5160, 5165, 5170, 5175, 5180, 5185, 5190, 5195, 5200, 5205, 5210, 5215, 5220, 5225, 5230, 5235, 5240, 5245, 5250, 5255, 5260, 5265, 5270, 5275, 5280, 5285, 5290, 5295, 5300, 5305, 5310, 5315, 5320, 5325, 5330, 5335, 5340, 5345, 5350, 5355, 5360, 5365, 5370, 5375, 5380, 5385, 5390, 5395, 5400, 5405, 5410, 5415, 5420, 5425, 5430, 5435, 5440, 5445, 5450, 5455, 5460, 5465, 5470, 5475, 5480, 5485, 5490, 5495, 5500, 5505, 5510, 5515, 5520, 5525, 5530, 5535, 5540, 5545, 5550, 5555, 5560, 5565, 5570, 5575, 5580, 5585, 5590, 5595, 5600, 5605, 5610, 5615, 5620, 5625, 5630, 5635, 5640, 5645, 5650, 5655, 5660, 5665, 5670, 5675, 5680, 5685, 5690, 5695, 5700, 5705, 5710, 5715, 5720, 5725, 5730, 5735, 5740, 5745, 5750, 5755, 5760, 5765, 5770, 5775, 5780, 5785, 5790, 5795, 5800, 5805, 5810, 5815, 5820, 5825, 5830, 5835, 5840, 5845, 5850, 5855, 5860, 5865, 5870, 5875, 5880, 5885, 5890, 5895, 5900, 5905, 5910, 5915, 5920, 5925, 5930, 5935, 5940, 5945, 5950, 5955, 5960, 5965, 5970, 5975, 5980, 5985, 5990, 5995, 6000, 6005, 6010, 6015, 6020, 6025, 6030, 6035, 6040, 6045, 6050, 6055, 6060, 6065, 6070, 6075, 6080, 6085, 6090, 6095, 6100, 6105, 6110, 6115, 6120, 6125, 6130, 6135, 6140, 6145, 6150, 6155, 6160, 6165, 6170, 6175, 6180, 6185, 6190, 6195, 6200, 6205, 6210, 6215, 6220, 6225, 6230, 6235, 6240, 6245, 6250, 6255, 6260, 6265, 6270, 6275, 6280, 6285, 6290, 6295, 6300, 6305, 6310, 6315, 6320, 6325, 6330, 6335, 6340, 6345, 6350, 6355, 6360, 6365, 6370, 6375, 6380, 6385, 6390, 6395, 6400, 6405, 6410, 6415, 6420, 6425, 6430, 6435, 6440, 6445, 6450, 6455, 6460, 6465, 6470, 6475, 6480, 6485, 6490, 6495, 6500, 6505, 6510, 6515, 6520, 6525, 6530, 6535, 6540, 6545, 6550, 6555, 6560, 6565, 6570, 6575, 6580, 6585, 6590, 6595, 6600, 6605, 6610, 6615, 6620, 6625, 6630, 6635, 6640, 6645, 6650, 6655, 6660, 6665, 6670, 6675, 6680, 6685, 6690, 6695, 6700, 6705, 6710, 6715, 6720, 6725, 6730, 6735, 6740, 6745, 6750, 6755, 6760, 6765, 6770, 6775, 6780, 6785, 6790, 6795, 6800, 6805, 6810, 6815, 6820, 6825, 6830, 6835, 6840, 6845, 6850, 6855, 6860, 6865, 6870, 6875, 6880, 6885, 6890, 6895, 6900, 6905, 6910, 6915, 6920, 6925, 6930, 6935, 6940, 6945, 6950, 6955, 6960, 6965, 6970, 6975, 6980, 6985, 6990, 6995, 7000, 7005, 7010, 7015, 7020, 7025, 7030, 7035, 7040, 7045, 7050, 7055, 7060, 7065, 7070, 7075, 7080, 7085, 7090, 7095, 7100, 7105, 7110, 7115, 7120, 7125, 7130, 7135, 7140, 7145, 7150, 7155, 7160, 7165, 7170, 7175, 7180, 7185, 7190, 7195, 7200, 7205, 7210, 7215, 7220, 7225, 7230, 7235, 7240, 7245, 7250, 7255, 7260, 7265, 7270, 7275, 7280, 7285, 7290, 7295, 7300, 7305, 731

Grade and material markings — Part III

ASTM markings

The American Society for Testing and Materials, 1916 Race St, Philadelphia, PA 19103, sponsors development of specifications for fasteners used in general and special engineering applications. These specifications detail chemical and mechanical properties of material strength levels for fasteners and are generally specific in referencing the actual product covered. A full range of types of products of various styles, thread series, lengths, etc., can be produced to meet ASTM requirements and would be marked for grade and material identification as required.

ASTM

Grade and material identification markings required by ASTM specifications

Grade ID mark	ASTM spec number	Fastener description	Material	Is migr's ID symbol req'd?	Nominal size range (inch)	Mechanical properties					Remarks or footnotes
						Bolts, screws, studs	Nuts	Hardness	Proof load (psi)	Yield strength (min psi)	
None req'd	F467	Nuts for general use	Titanium Gr 1	No	1/4 - 1 1/2	—	—	—	40,000	—	Vickers 140 min
None req'd	F467	Nuts for general use	Titanium Gr 2	No	1/4 - 1 1/2	—	—	—	55,000	—	Vickers 150 min
None req'd	F467	Nuts for general use	Titanium Gr 4	No	1/4 - 1 1/2	—	—	—	85,000	—	Vickers 200 min
None req'd	F467	Nuts for general use	Titanium Gr 5	No	1/4 - 1 1/2	—	—	—	135,000	—	C30 min
None req'd	F467	Nuts for general use	Titanium Gr 7	No	1/4 - 1 1/2	—	—	—	55,000	—	Vickers 160 min
None req'd	F467M	Nuts for general use—metric	ETP copper UNS C11000	No	M6 - M36 mm	—	—	—	205 MPa	—	F65 min
None req'd	F467M	Nuts for general use—metric	Brass UNS C27000	No	M6 - M36 mm	—	—	—	415 MPa	—	F55 min
None req'd	F467M	Nuts for general use—metric	Naval brass UNS C46200	No	M6 - M36 mm	—	—	—	345 MPa	—	B65 min
None req'd	F467M	Nuts for general use—metric	Naval brass UNS C46400	No	M6 - M36 mm	—	—	—	345 MPa	—	B55 min
None req'd	F467M	Nuts for general use—metric	Phosphor bronze UNS C51000	No	M6 - M36 mm	—	—	—	415 MPa	—	B60 min
None req'd	F467M	Nuts for general use—metric	Aluminum bronze UNS C61400	No	M6 - M36 mm	—	—	—	520 MPa	—	B70 min
None req'd	F467M	Nuts for general use—metric	Aluminum bronze UNS C63000	No	M6 - M36 mm	—	—	—	690 MPa	—	B85 min

Grade ID mark	ASTM spec number	Fastener description	Material	Is milgr's ID symbol req'd?	Nominal size range	Mechanical properties						Remarks or footnotes
						Bolts, screws, studs	Nuts	Hardness		Brinell	Rockwell	
					M6 - M36 mm	Proof load	Yield strength (min)	Tensile strength (min)	Proof load	Brinell	Rockwell	
None req'd	F-467M	Nuts for general use—metric	Aluminum silicon bronze UNS C64200	No	M6 - M36 mm	—	—	—	520 MPa	—	875 min	—
None req'd	F-467M	Nuts for general use—metric	Silicon bronze UNS C65100	No	M6 - M36 mm	—	—	—	485 MPa	—	875 min	—
None req'd	F-467M	Nuts for general use—metric	Silicon bronze UNS C65500	No	M6 - M36 mm	—	—	—	345 MPa	—	860 min	—
None req'd	F-467M	Nuts for general use—metric	Silicon bronze UNS C66100	No	M6 - M36 mm	—	—	—	485 MPa	—	875 min	—
None req'd	F-467M	Nuts for general use—metric	Manganese bronze UNS C67500	No	M6 - M36 mm	—	—	—	380 MPa	—	860 min	—
None req'd	F-467M	Nuts for general use—metric	Cupro-nickel UNS C71000	No	M6 - M36 mm	—	—	—	310 MPa	—	850 min	—
None req'd	F-467M	Nuts for general use—metric	Cupro-nickel UNS C71500	No	M6 - M36 mm	—	—	—	380 MPa	—	860 min	—
None req'd	F-467M	Nuts for general use—metric	Ni-Mo based UNS N10001	No	M6 - M36 mm	—	—	—	790 MPa	—	C20 min	—
None req'd	F-467M	Nuts for general use—metric	Ni-Mo-Cr based UNS N10002	No	M6 - M36 mm	—	—	—	760 MPa	—	C20 min	—
None req'd	F-467M	Nuts for general use—metric	Ni-Cu Class A UNS N04400	No	M6 - M36 mm	—	—	—	550 MPa	—	875 min	—
None req'd	F-467M	Nuts for general use—metric	Ni-Cu Class B UNS N04405	No	M6 - M36 mm	—	—	—	485 MPa	—	860 min	—
None req'd	F-467M	Nuts for general use—metric	Ni-Cu-Al based UNS N05500	No	M6 - M36 mm	—	—	—	900 MPa	—	C24 min	—
None req'd	F-467M	Nuts for general use—metric	Aluminum 2024 UNS A92024	No	M6 - M36 mm	—	—	—	330 MPa	—	870 min	—
None req'd	F-467M	Nuts for general use—metric	Aluminum 6061 UNS A96061	No	M6 - M36 mm	—	—	—	275 MPa	—	840 min	—
None req'd	F-467M	Nuts for general use—metric	Aluminum 6262 UNS A96262	No	M6 - M36 mm	—	—	—	360 MPa	—	860 min	—
None req'd	F-467M	Nuts for general use—metric	Titanium Gr 1	No	M6 - M36 mm	—	—	—	275 MPa	—	Vickers 140 min	—
None req'd	F-467M	Nuts for general use—metric	Titanium Gr 2	No	M6 - M36 mm	—	—	—	380 MPa	—	Vickers 150 min	—

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (inch)	Mechanical properties						Remarks or footnotes	
						Bolts, screws, studs	Proof load (psi)	Yield strength (min psi)	Tensile strength (min psi)	Nuts	Brinell	Rockwell	
None req'd	F-467M	Nuts for general use—metric	Titanium Gr 4	No	M6 - M36 mm	—	—	—	—	590 MPa	—	Vickers 200 min	—
None req'd	F-467M	Nuts for general use—metric	Titanium Gr 5	No	M6 - M36 mm	—	—	—	—	930 MPa	—	C30 min	—
None req'd	F-467M	Nuts for general use—metric	Titanium Gr 7	No	M6 - M36 mm	—	—	—	—	380 MPa	—	Vickers 160 min	—
None req'd	F-468	Bolts, hex cap screws, and studs for general use	ETP copper UNS C11000	No	1/4 - 1 1/2	—	10,000	30,000 min 50,000 max	—	—	F ₆₅ F ₉₀	—	—
None req'd	F-468	Bolts, hex cap screws, and studs for general use	Brass UNS C27000	No	1/4 - 1 1/2	—	50,000	60,000 min 90,000 max	—	—	F ₅₅ F ₈₀	—	—
None req'd	F-468	Bolts, hex cap screws, and studs for general use	Naval brass UNS C46200	No	1/4 - 1 1/2	—	25,000	50,000 min 80,000 max	—	—	B ₆₅ B ₉₀	—	—
None req'd	F-468	Bolts, hex cap screws, and studs for general use	Naval brass UNS C46400	No	1/4 - 1 1/2	—	15,000	50,000 min 80,000 max	—	—	B ₅₅ B ₇₅	—	—
None req'd	F-468	Bolts, hex cap screws, and studs for general use	Phosphor bronze UNS C31000	No	1/4 - 1 1/2	—	35,000	60,000 min 90,000 max	—	—	B ₆₀ B ₉₅	—	—
None req'd	F-468	Bolts, hex cap screws, and studs for general use	Aluminum bronze UNS C61300	No	1/4 - 1 1/2	—	50,000	80,000 min 110,000 max	—	—	B ₇₀ B ₉₅	—	—
None req'd	F-468	Bolts, hex cap screws, and studs for general use	Aluminum bronze UNS C61400	No	5/8 - 1 1/2	—	45,000	75,000 min 105,000 max	—	—	B ₇₀ B ₉₅	—	—
None req'd	F-468	Bolts, hex cap screws, and studs for general use	Aluminum bronze UNS C61400	No	1/4 - 1 1/2	—	35,000	75,000 min 110,000 max	—	—	B ₇₀ B ₉₅	—	—

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfrgr's ID symbol req'd?	Nominal size range (inch)	Mechanical properties					Remarks or footnotes
						Bolts, screws, studs	Yield strength (min psi)	Tensile strength (min psi)	Nuts	Proof load (psi)	
None req'd	F468	Bolts, hex cap screws, and studs for general use	Aluminum bronze UNS C63000	No	1/4 - 1 1/2	—	50,000	100,000 min 130,000 max	—	—	885 B100
None req'd	F468	Bolts, hex cap screws, and studs for general use	Aluminum silicon bronze UNS C64200	No	1/4 - 1 1/2	—	35,000	75,000 min 110,000 max	—	—	875 B95
None req'd	F468	Bolts, hex cap screws, and studs for general use	Silicon bronze UNS C65100	No	1/4 - 1/2	—	55,000	70,000 min 100,000 max	—	—	875 B95
None req'd	F468	Bolts, hex cap screws, and studs for general use	Silicon bronze UNS C65500	No	1/4 - 1 1/2	—	40,000	55,000 min 90,000 max	—	—	870 B95
None req'd	F468	Bolts, hex cap screws, and studs for general use	Silicon bronze UNS C66100	No	1/4 - 1 1/2	—	20,000	50,000 min 80,000 max	—	—	860 B80
None req'd	F468	Bolts, hex cap screws, and studs for general use	Manganese bronze UNS C67500	No	1/4 - 1 1/2	—	35,000	70,000 min 100,000 max	—	—	875 B95
None req'd	F468	Bolts, hex cap screws, and studs for general use	Cupro-nickel UNS C71000	No	1/4 - 1 1/2	—	25,000	55,000 min 85,000 max	—	—	860 B80
None req'd	F468	Bolts, hex cap screws, and studs for general use	Cupro-nickel UNS C71500	No	1/4 - 1 1/2	—	15,000	45,000 min 75,000 max	—	—	850 B85
None req'd	F468	Bolts, hex cap screws, and studs for general use	Ni-Mo based UNS N10031	No	1/4 - 1 1/2	—	20,000	55,000 min 85,000 max	—	—	860 B95
None req'd	F468	Bolts, hex cap screws, and studs for general use	—	—	—	—	—	—	—	—	C20-C32 Max

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfr's ID symbol req'd?	Nominal size range (inch)	Mechanical properties					Remarks or footnotes
						Bolts, screws, studs	Proof load (psi)	Yield strength (min psi)	Tensile strength (min psi)	Nuts	
None req'd	F468	Bolts, hex cap screws, and studs for general use	Ni-Mo-Cr based UNS N10002	No	1/4 - 1 1/2	—	45,000	110,000 min	—	—	C20/C32
None req'd	F468	Bolts, hex cap screws, and studs for general use	Ni-Cu Class A UNS N04400	No	1/4 - 1 1/2	—	40,000	80,000 min 130,000 max	—	—	B75/C25
None req'd	F468	Bolts, hex cap screws, and studs for general use	Ni-Cu Class A UNS N04400 Hot formed product	No	1/4 - 1 1/2	—	30,000	70,000 min 130,000 max	—	—	B60/C25
None req'd	F468	Bolts, hex cap screws, and studs for general use	Ni-Cu Class B UNS N05500	No	1/4 - 1 1/2	—	30,000	70,000 min 120,000 max	—	—	B60/B95
None req'd	F468	Bolts, hex cap screws, and studs for general use	Ni-Cu-Al based UNS N05601	No	1/4 - 1 1/2	—	30,000	70,000 min 125,000 max	—	—	B60/C20
None req'd	F468	Bolts, hex cap screws, and studs for general use	Aluminum 2024 - UNS A92024	No	1/4 - 1 1/2	—	30,000	130,000 min 180,000 max	—	—	C24/C37
None req'd	F468	Bolts, hex cap screws, and studs for general use	Aluminum 6061 - UNS A96061	No	1/4 - 1 1/2	—	36,000	56,000 min 70,000 max	—	—	B70/B85
None req'd	F468	Bolts, hex cap screws, and studs for general use	Aluminum 6061 - UNS A96061	No	1/4 - 1 1/2	—	31,000	37,000 min 52,000 max	—	—	B40/B50

Grade and material markings—Part IV

ASTM markings

The American Society for Testing and Materials, 1916 Race St., Philadelphia, PA 19103, sponsors development of specifications for fasteners used in general and special engineering applications. These specifications detail chemical and mechanical properties of material strength levels for fasteners and are generally specific in referencing the actual product covered. A full range of types of products of various styles, thread series, lengths, etc. can be produced to meet ASTM requirements and would be marked for grade and material identification as required.

Grade and material identification markings required by ASTM specifications

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (inch)	Mechanical properties				Remarks or footnotes
						Bolts, screws, studs	Nuts	Hardness	Brinell	
None req'd	F-468	Bolts, hex cap screws, and studs for general use	Aluminum 7075 UNS A97075	No	4 - 1½	—	50,000	61,000 min 76,000 max	—	B80 F90
None req'd	F-468	Bolts, hex cap screws, and studs for general use	Titanium Gr 1	No	4 - 1½	—	30,000	40,000 min 70,000 max	—	Vickers 140/160
None req'd	F-468	Bolts, hex cap screws, and studs for general use	Titanium Gr 2	No	4 - 1½	—	45,000	55,000 min 85,000 max	—	Vickers 160/180
None req'd	F-468	Bolts, hex cap screws, and studs for general use	Titanium Gr 4	No	4 - 1½	—	75,000	85,000 min 115,000 max	—	Vickers 200/220
None req'd	F-468	Bolts, hex cap screws, and studs for general use	Titanium Gr 5	No	4 - 1½	—	125,000	135,000 min 165,000 max	—	C30 C46
None req'd	F-468M	Bolts, hex cap screws, and studs for general use	LIP copper UNS C11000	No	4 - 1½	—	45,000	55,000 min 85,000 max	—	Vickers 160/180
None req'd	F-468M	Bolts, hex cap screws, and studs for general use	M6 - M36 mm	—	70 MPa	205 min 345 max MPa	—	—	E65 F90	

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfr's ID symbol req'd?	Nominal size range (mm)	Mechanical properties					Remarks or footnotes
						Bolts, screws, studs	Nuts	Hardness	Proof load (MPa)	Yield strength (min MPa)	
None req'd	F468M	Bolts, hex cap screws, and studs for general use —metric	Brass UNS C27000	No	M6 - M36	—	345	410 min 620 max	—	—	F55 - F80
None req'd	F468M	Bolts, hex cap screws, and studs for general use —metric	Naval brass UNS C46200	No	M6 - M36	—	170	345 min 550 max	—	—	B65 - B90
None req'd	F468M	Bolts, hex cap screws, and studs for general use —metric	Naval brass UNS C46400	No	M6 - M36	—	105	345 min 550 max	—	—	B55 - B75
None req'd	F468M	Bolts, hex cap screws, and studs for general use —metric	Phosphor bronze UNS C51100	No	M6 - M36	—	240	410 min 620 max	—	—	B60 - B95
None req'd	F468M	Bolts, hex cap screws, and studs for general use —metric	Aluminum bronze UNS C61400	No	M6 - M36	—	240	520 min 760 max	—	—	B70 - B95
None req'd	F468M	Bolts, hex cap screws, and studs for general use —metric	Aluminum bronze UNS C65000	No	M6 - M36	—	345	690 min 900 max	—	—	B85 - B100
None req'd	F468M	Bolts, hex cap screws, and studs for general use —metric	Aluminum silicon bronze UNS C64200	No	M6 - M36	—	240	520 min 760 max	—	—	B75 - B95
None req'd	F468M	Bolts, hex cap screws, and studs for general use —metric	Silicon bronze UNS C65100	No	M6 - M20 - M24 - M36	—	380	480 min 690 max 380 min 620 max	—	—	B75 - B95
None req'd	F468M	Bolts, hex cap screws, and studs for general use —metric	Silicon bronze UNS C65500	No	M6 - M36	—	140	345 min 550 max	—	—	B60 - B80
None req'd	F468M	Bolts, hex cap screws, and studs for general use —metric	Silicon bronze UNS C66100	No	M6 - M36	—	240	480 min 690 max	—	—	B75 - B95
None req'd	F468M	Bolts, hex cap screws, and studs for general use —metric	Manganese bronze UNS C67500	No	M6 - M36	—	170	380 min 590 max	—	—	B60 - B90
None req'd	F-468M	Bolts, hex cap screws, and studs for general use —metric	Cupro-nickel UNS C71000	No	M6 - M36	—	105	310 min 520 max	—	—	B50 - B85

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (mm)	Mechanical properties						Remarks or footnotes
						Bolts, screws, studs	Nuts	Hardness		Brinell	Rockwell	
						Proof load (MPa)	Yield strength (min MPa)	Tensile strength MPa	Proof load	Brinell	Rockwell	
None req'd	F 468M	Bolts, hex cap screws, and studs for general use —metric	Cupro nickel UNS C71500	No	M6 - M36	—	140	380 min 590 max	—	—	B60/B95	—
None req'd	F 468M	Bolts, hex cap screws, and studs for general use —metric	Ni-Mo based UNS N10001	No	M6 - M36	—	310	790 min 1000 max	—	—	C20/C32	—
None req'd	F 468M	Bolts, hex cap screws, and studs for general use —metric	Ni-Mo-Cr based UNS N10002	No	M6 - M36	—	310	760 min 970 max	—	—	C20/C32	—
None req'd	F 468M	Bolts, hex cap screws, and studs for general use —metric	Ni-Cu Class A UNS N04400	No	M6 - M20 - M24 - M36	—	275	550 min 900 max	—	—	B75/C25	—
None req'd	F 468M	Bolts, hex cap screws, and studs for general use —metric	Ni-Cu Class A UNS N04400 Hot formed product	No	M6 - M36	—	205	480 min 900 max	—	—	B60/B95/C25	—
None req'd	F 468M	Bolts, hex cap screws, and studs for general use —metric	Ni-Cu Class B UNS N04405	No	M6 - M36	—	205	480 min 860 max	—	—	B60/C20	—
None req'd	F 468M	Bolts, hex cap screws, and studs for general use —metric	Ni-Cu-Al based UNS N05500	No	M6 - M20 - M24 - M36	—	620	900 min 1240 max	—	—	C24/C37	—
None req'd	F 468M	Bolts, hex cap screws, and studs for general use —metric	Aluminum 2024	No	M6 - M36	—	250	360 min 480 max	—	—	B70/B85	—
None req'd	F 468M	Bolts, hex cap screws, and studs for general use —metric	Aluminum 6061	No	M6 - M36	—	215	260 min 360 max	—	—	B40/B50	—
None req'd	F 468M	Bolts, hex cap screws, and studs for general use —metric	Aluminum 7075	No	M6 - M36	—	345	420 min 520 max	—	—	B80/B90	—
None req'd	F 468M	Bolts, hex head screws, and studs for general use —metric	Titanium Gr 1	No	M6 - M36	—	205	280 min 480 max	—	—	Vickers 140/160	—

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Mechanical properties						Remarks or footnotes	
					Nominal size range (mm)	Proof load (MPa)	Yield strength (min MPa)	Tensile strength (min MPa)	Nuts	Brinell	Proof load	
None req'd	F468M	Bolts, hex head screws, and studs for general use—metric	Titanium Gr 2	No	M6 - M36	—	310	380 min 590 max	—	—	Vickers 160/180	—
None req'd	F468M	Bolts, hex head screws, and studs for general use—metric	Titanium Gr 4	No	M6 - M36	—	520	590 min 790 max	—	—	Vickers 200/220	—
None req'd	F468M	Bolts, hex head screws, and studs for general use—metric	Titanium Gr 5	No	M6 - M36	—	860	930 min 1140 max	—	—	C30/C36	—
None req'd	F468M	Bolts, hex head screws, and studs for general use—metric	Titanium Gr 7	No	M6 - M36	—	310	380 min 590 max	—	—	Vickers 160/180	—
4.6	F568	Bolts, screws, studs for general engineering applications—metric	Low or medium carbon steel	Yes	M5 - M100	225	240	400	—	Vickers 120/120	B67/B95	K,LL,MM,NN
4.8	F568	Bolts, screws, studs for general engineering applications—metric	Low or medium carbon steel, partially or fully annealed as required	Yes	M16 - M16	310	340	420	—	Vickers 130/120	B71/B95	K,LL,MM,NN
5.8	F568	Bolts, screws, studs for general engineering applications—metric	Low or medium carbon steel, cold worked	Yes	M5 - M24	380	420	520	—	Vickers 160/120	B82/B95	K,LL,MM,NN
8.8	F568	Bolts, screws, studs for general engineering applications—metric	Medium carbon steel, quenched and tempered	Yes	M16 - M72	600	660	830	—	Vickers 255/336	C23/C34	K,LL,MM,NN
8.8.3	F568	Bolts, screws, studs for general engineering applications—metric	Low carbon martensite steel, quenched and tempered	Yes	M16 - M36	600	660	830	—	Vickers 255/336	C23/C34	K,LL,MM,NN
9.8	F568	Bolts, screws, studs for general engineering applications—metric	Atmospheric corrosion resistant steel, quenched and tempered	Yes	M16 - M16	650	720	900	—	Vickers 255/336	C23/C34	J,K,LL,MM,NN
+ (O)	F568	Studs for general engineering applications—metric	Medium carbon steel, quenched and tempered	Yes	less than M12	650	720	900	—	Vickers 280/360	C27/C36	K,LL,MM,NN,OO

Footnotes are grouped on the last page of this Part IV series

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfr's ID symbol req'd?	Nominal size range (mm)	Mechanical properties					Remarks or footnotes
						Bolts, screws, studs	Proof load (MPa)	Yield strength (min MPa)	Tensile strength (min MPa)	Nuts	
\pm (OO)	F568	Studs for general engineering applications—metric	Low carbon martensite steel, quenched and tempered	Yes	Less than M12	650	720	900	—	Vickers 280/360	K.LL.MM.NN.OO
<u>9.8</u>	F568	Bolts, screws (and studs) M12 (or larger) for general engineering applications—metric	Low carbon martensite steel, quenched and tempered	Yes	M16 - M16	830	940	1040	—	Vickers 327/382	K.LL.MM.NN.OO
<u>10.9</u>	F568	Bolts, screws (and studs) M12 (or larger) for general engineering applications—metric	Medium carbon steel, quenched and tempered	Yes	M5 - M20	830	940	1040	—	Vickers 327/382	K.LL.MM.NN.OO
<input checked="" type="checkbox"/>	F568	Studs for general engineering applications—metric	Medium carbon alloy steel, quenched and tempered	Yes	M5 - M10	830	940	1040	—	Vickers 327/382	K.LL.MM.NN.OO
<input checked="" type="checkbox"/>	F568	Studs for general engineering applications—metric	Medium carbon or medium carbon alloy steel, quenched and tempered	Yes	Less than M12	830	940	1040	—	Vickers 327/382	K.LL.MM.NN.OO
<input checked="" type="checkbox"/>	F568	Studs for general engineering applications—metric	Low carbon martensite steel, quenched and tempered	Yes	M16 - M16	830	940	1040	—	Vickers 327/382	K.LL.MM.NN.OO
<u>10.9</u>	F568	Bolts, screws (and studs) M12 (or larger) for general engineering applications—metric	Low carbon martensite steel, quenched and tempered	Yes	M5 - M36	830	940	1040	—	Vickers 327/382	K.LL.MM.NN.OO
<u>10.9.3</u>	F568	Bolts, screws, studs for general engineering applications—metric	Alloyed/corrosion resistant steel, quenched and tempered	Yes	M16 - M36	830	940	1040	—	Vickers 327/382	K.LL.MM.NN.OO
<u>12.9</u>	F568	Bolts, screws (and studs) M12 (or larger) for general engineering applications—metric	Alloy steel, quenched and tempered	Yes	M16 - M36	970	1100	1220	—	Vickers 327/434	K.LL.MM.NN.OO
Δ (OO)	F568	Studs for general engineering applications—metric	Alloy steel, quenched and tempered	Yes	Less than M12	970	1100	1220	—	Vickers 327/434	K.LL.MM.NN.OO

Footnotes are grouped on the last page of this Part IV series

Grade ID mark	ASTM Spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (inch)	Mechanical properties						Remarks or footnotes
						Bolts, screws, studs	Proof load (psi)	Yield strength (min psi)	Tensile strength psi	Nuts	Hardness	
1 (PP)	F593	Bolts, hex cap screws and studs	Stainless steel alloys 303, 303 Se, 304, 305, 384, XM1, XM7	<ul style="list-style-type: none"> • Cold worked • Headed and rolled from annealed stock and then re-annealed • Machined from annealed or solution annealed stock • Machined from strain hardened stock 	No (PP)	$\frac{5}{8}$ - $\frac{5}{8}$	—	65,000	$\frac{100,000}{150,000}$	—	—	$\frac{B95}{C32}$ $\frac{B80}{C32}$
					$\frac{3}{4}$ - $1\frac{1}{2}$	—	45,000	$\frac{85,000}{140,000}$	—	—	—	$\frac{B85}{C32}$
					$\frac{5}{8}$ - $1\frac{1}{2}$	—	50,000	85,000	—	—	—	$\frac{B85}{C32}$
					$\frac{5}{8}$ - $1\frac{1}{2}$	—	30,000	$\frac{75,000}{100,000}$	—	—	—	$\frac{B65}{B95}$
					$\frac{5}{8}$ - $\frac{5}{8}$	—	95,000	$\frac{120,000}{160,000}$	—	—	—	$\frac{C24}{C36}$
					$\frac{3}{4}$ - 1	—	75,000	$\frac{110,000}{150,000}$	—	—	—	$\frac{C20}{C32}$
					$1\frac{5}{8}$ - $1\frac{1}{4}$	—	60,000	$\frac{100,000}{140,000}$	—	—	—	$\frac{B95}{C30}$
					$1\frac{5}{8}$ - $1\frac{1}{2}$	—	45,000	$\frac{95,000}{130,000}$	—	—	—	$\frac{B90}{C28}$
					$\frac{5}{8}$ - $1\frac{1}{2}$	—	30,000	$\frac{75,000}{100,000}$	—	—	—	$\frac{B65}{B95}$
					$\frac{5}{8}$ - $\frac{5}{8}$	—	95,000	$\frac{120,000}{160,000}$	—	—	—	$\frac{C24}{C36}$
2 (PP)	F593	Bolts, hex cap screws and studs	Stainless steel alloy 316	<ul style="list-style-type: none"> • Cold worked • Headed and rolled from annealed stock and then re-annealed • Machined from annealed or solution annealed stock • Machined from strain hardened stock 	No (PP)	$\frac{5}{8}$ - $\frac{5}{8}$	—	65,000	$\frac{100,000}{150,000}$	—	—	$\frac{B95}{C32}$ $\frac{B80}{C32}$
					$\frac{3}{4}$ - $1\frac{1}{2}$	—	45,000	$\frac{85,000}{140,000}$	—	—	—	$\frac{B85}{C32}$
					$\frac{5}{8}$ - $1\frac{1}{2}$	—	50,000	85,000	—	—	—	$\frac{B85}{C32}$
					$\frac{5}{8}$ - $1\frac{1}{2}$	—	30,000	$\frac{75,000}{100,000}$	—	—	—	$\frac{B65}{B95}$
					$\frac{5}{8}$ - $\frac{5}{8}$	—	95,000	$\frac{120,000}{160,000}$	—	—	—	$\frac{C24}{C36}$
3 (PP)	F593	Bolts, hex cap screws and studs	Stainless steel alloy 316	<ul style="list-style-type: none"> • Cold worked • Headed and rolled from annealed stock and then re-annealed • Machined from annealed or solution annealed stock • Machined from strain hardened stock 	$\frac{5}{8}$ - 1	—	75,000	$\frac{110,000}{150,000}$	—	—	—	$\frac{B95}{C32}$ $\frac{B80}{C32}$
					$1\frac{5}{8}$ - $1\frac{1}{4}$	—	60,000	$\frac{100,000}{140,000}$	—	—	—	$\frac{B95}{C30}$
					$1\frac{5}{8}$ - $1\frac{1}{2}$	—	45,000	$\frac{95,000}{130,000}$	—	—	—	$\frac{B90}{C28}$
					$\frac{5}{8}$ - $\frac{5}{8}$	—	95,000	$\frac{120,000}{160,000}$	—	—	—	$\frac{C24}{C36}$

Footnotes are grouped on the last page of this Part IV series

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (inch)	Mechanical properties						Remarks or footnotes	
						Proof load (psi)	Yield strength (min psi)	Tensile strength psi	Nuts	Hardness	Brinell	Rockwell	
3 (PP)	F593	Bolts, hex cap screws, and studs	Stainless steel alloys 321 and 347	No (PP)	$\frac{1}{4} - \frac{5}{8}$	—	65,000	<u>100,000</u>	—	—	—	—	B95 C32 B80 C32
			• Cold worked		$\frac{3}{4} - 1\frac{1}{2}$	—	45,000	<u>85,000</u>	—	—	—	—	
			• Headed and rolled from annealed stock and then re-annealed		$\frac{7}{8} - 1\frac{1}{2}$	—	50,000	<u>85,000</u>	—	—	—	—	B85 max
			• Machined from annealed or solution annealed stock		$\frac{1}{4} - 1\frac{1}{2}$	—	36,000	<u>75,000</u>	—	—	—	—	B65 B95
			• Machined from strain hardened stock		$\frac{1}{4} - \frac{5}{8}$	—	95,000	<u>120,000</u>	—	—	—	—	C24 C36 C20 C32
					$\frac{3}{4} - 1$	—	75,000	<u>110,000</u>	—	—	—	—	
					$1\frac{1}{8} - 1\frac{1}{4}$	—	60,000	<u>100,000</u>	—	—	—	—	
					$1\frac{1}{8} - 1\frac{1}{2}$	—	45,000	<u>95,000</u>	—	—	—	—	B95 C30 B90 C28
4 (PP)	F593	Bolts, hex cap screws, and studs	Stainless steel alloys 430 and 430F	No (PP)	$\frac{1}{4} - 1\frac{1}{2}$	—	35,000	<u>70,000</u>	—	—	—	—	B65 B95 I,PP
			• Machined from annealed or solution annealed stock										
5 (PP)	F593	Bolts, hex cap screws, and studs	Stainless steel alloys 410, 416, and 416 Se	No (PP)	$\frac{1}{4} - 1\frac{1}{2}$	—	90,000	<u>110,000</u>	—	—	—	—	C20 C30
			• Hardened and tempered at 1050 F min										
			• Hardened and tempered at 525 F min		$\frac{7}{8} - 1\frac{1}{2}$	—	120,000	<u>160,000</u>	—	—	—	—	C34 C45
6 (PP)	F593	Bolts, hex cap screws, and studs	Stainless steel alloy 431	No (PP)	$\frac{1}{4} - 1\frac{1}{2}$	—	100,000	<u>125,000</u>	—	—	—	—	C25 C32 C40 C48
			• Hardened and tempered at 1050 F min										
			• Hardened and tempered at 525 F min		$\frac{7}{8} - 1\frac{1}{2}$	—	140,000	<u>180,000</u>	—	—	—	—	C40 C48
													Footnotes are grouped on the last page of this Part IV series

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (inch)	Mechanical properties							Remarks or footnotes
						Proof load (psi)	Yield strength (min psi)	Tensile strength psi	Nuts	Proof load (psi)	Brinell	Rockwell	
7 (PP)	F593	Bolts, hex cap screws, and studs	Stainless steel, alloy 630 • Solution annealed and age hardened after forming	No (PP)	1/4 - 1 1/2	—	105,000	135,000 170,000	—	—	C28 C38	I, PP	
1	F594	Nuts	Stainless steel, alloys 303, 303 Se, 304, 305, 384, XM1, and XM7 • Annealed after all threading • Machined from annealed or solution annealed stock • Cold worked	Yes	1/4 - 1 1/2	—	—	—	70,000 min	—	B85 max		
					1/4 - 1 1/2	—	—	—	75,000 min	—	B65 B95		
					1/4 - 5/8	—	—	—	100,000 min	—	B95 C32		
					1/4 - 1 1/2	—	—	—	85,000 min	—	B80 C32		
					1/4 - 5/8	—	—	—	120,000 min	—	C24 C36		
					1/4 - 1	—	—	—	110,000 min	—	C20 C32		
					1 1/8 - 1 1/4	—	—	—	100,000 min	—	B95 C30		
					1 1/8 - 1 1/2	—	—	—	85,000 min	—	B90 C28		
A	F-541	Eyebolts	Alloy steel, forged, quenched, and tempered	Yes	1/4 - 2 1/2	Refer to complete F-541 spec	100,000 min max	95,000	—	197/248	B93 B101	M	

ASTM footnotes

- L1. Indenting studs, all markings located on head of head fastened or depressed.
- J. Handbolts, fastener may add either distinguishing marks and calling the fastener by name, location, material and place of manufacture.
- K. All markings shall be located on top of the head, forged or deformed. None of property class symbols shall be performed toward the shank periphery of the head.
- M. Studs of nominal thread diameters smaller than M5 need not be marked. Additionally classes 4, 6, 4 H, and 5 B studs smaller than M12 need not be marked.
- O. This is the grade mark symbol for studs of this property class or above. May be followed by letter indicating M12.
- P. Studs and fasteners of nominal thread diameters smaller than M5 need not be marked. Metric bolts and screws shall have recessed screws of nominal thread diameters M5 and larger located not on the head. Metric bolts and screws shall not be marked with inch line symbols required only when specified on the code.

Grade and material markings—Part V

ASTM markings

The American Society for Testing and Materials, 1916 Race St, Philadelphia, PA 19103, sponsors development of specifications for fasteners used in general and special engineering applications. These specifications detail chemical and mechanical properties of material strength levels for fasteners and are generally specific in referencing the actual product covered. A full range of types of products of various styles, thread series, lengths, etc. can be produced to meet ASTM requirements and would be marked for grade and material identification as required.

ASTM

Grade and material identification markings required by ASTM specifications

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (inch)	Mechanical properties					Remarks or footnotes
						Bolts, screws, studs	Nuts	Hardness	Yield strength (min psi)	Tensile strength psi	
2 (PP)	F594	Nuts	Stainless steel, alloy 316	No (PP)	1/4 - 1 1/2	—	—	—	70,000	—	I, PP
		• Annealed after all threading	• Machined from annealed or solution annealed stock		1/4 - 1 1/2	—	—	—	75,000	—	B65 B95
		• Cold worked	• Machined from strain hardened stock		1/4 - 3/8	—	—	—	100,000	—	B95 C32 B80 C32
			• Machined from annealed or solution annealed stock		1/4 - 1 1/2	—	—	—	85,000	—	C24 C36 C20 C32
			• Cold worked		1/4 - 3/8	—	—	—	120,000	—	C24 C36
			• Machined from strain hardened stock		3/4 - 1	—	—	—	110,000	—	C20 C32
			• Machined from annealed or solution annealed stock		1 1/4 - 1 1/2	—	—	—	100,000	—	B95 C30 B90 C28
			• Cold worked		1 3/8 - 1 1/2	—	—	—	85,000	—	C24 C36 C20 C32
3 (PP)	F594	Nuts	Stainless steel, alloys 321, 347	No (PP)	1/4 - 1 1/2	—	—	—	70,000	—	I, PP
		• Annealed after all threading	• Machined from annealed or solution annealed stock		1/4 - 1 1/2	—	—	—	75,000	—	B65 B95
		• Cold worked	• Machined from annealed or solution annealed stock		1/4 - 3/8	—	—	—	100,000	—	B95 C32 B80 C32

Footnotes are grouped on the last page of this Part V series

Grade ID mark	ASTM spec number	Fastener description	Material	Is migr's ID symbol req'd?	Nominal size range (inch)	Mechanical properties						Remarks or footnotes
						Bolts, screws, studs	Proof load (psi)	Yield strength (min)	Tensile strength (min)	Nuts	Brinell	Rockwell
4	F594 (PP)	Nuts	Stainless steel, alloys No 430, 430F • Machined from annealed or solution annealed stock	$\frac{1}{4} - \frac{5}{8}$ $\frac{3}{8} - 1$ $1\frac{1}{8} - 1\frac{1}{4}$ $1\frac{3}{8} - 1\frac{1}{2}$	$\frac{1}{4} - \frac{5}{8}$	—	—	—	120,000 min	—	—	<u>C24</u> <u>C36</u>
					$\frac{3}{8} - 1$	—	—	—	110,000 min	—	—	<u>C20</u> <u>C32</u>
					$1\frac{1}{8} - 1\frac{1}{4}$	—	—	—	100,000 min	—	—	<u>B95</u> <u>C30</u>
					$1\frac{3}{8} - 1\frac{1}{2}$	—	—	—	85,000 min	—	—	<u>B90</u> <u>C28</u>
5	F594 (PP)	Nuts	Stainless steel alloys 410, 416, 416 Se • Hardened and tempered at 1050 F min	$\frac{1}{4} - 1\frac{1}{2}$	No (PP)	$\frac{1}{4} - 1\frac{1}{2}$	—	—	70,000 min	—	<u>B65</u> <u>B95</u>	I,PP
									110,000 min	—	—	<u>C20</u> <u>C30</u>
									160,000 min	—	—	<u>C34</u> <u>C45</u>
6	F594	Nuts	Stainless steel, alloy 431 • Hardened and tempered at 1050 F min	$\frac{1}{4} - 1\frac{1}{2}$	No (PP)	$\frac{1}{4} - 1\frac{1}{2}$	—	—	125,000 min	—	—	<u>C25</u> <u>C32</u>
									180,000 min	—	—	<u>C40</u> <u>C48</u>
										—	—	
7	F594	Nuts	Stainless steel, alloy 630 • Solution annealed and age hardened after forming	$\frac{1}{4} - 1\frac{1}{2}$	No (PP)	$\frac{1}{4} - 1\frac{1}{2}$	—	—	—	135,000 min	—	<u>C28</u> <u>C38</u>
										—	—	I,PP
A150	F738	Bolts, screws, and studs —metric	Stainless steel, alloys 303, 303 Se, 304, 305, 384, XM1, XM7 • Headed and rolled from annealed stock and then re-annealed	Yes	M1.6 - M5 mm M6 - M36 mm	—	—	500 MPa	—	Vickers 155/220 Vickers 155/220	<u>R81</u> <u>B95</u> <u>B81</u> <u>B95</u>	I,MM,QQ

Footnotes are grouped on the last page of this Part V series.

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's HD symbol req'd?	Nominal size range (mm)	Mechanical properties						Remarks or footnotes
						Proof load (N/mm²)	Yield strength (Min N/mm²)	Tensile strength (min MPa)	Nuts	Proof load (MPa)	Brinell	Rockwell
A1-70	F738	Bolts, screws, and studs —metric	Stainless steel, alloys 303, 303 Se, 304, 305, 384, XM1, XM7 • Cold worked	Yes	M1.6 - M5 - M6 - M20 - Over M20 - - M36	— — — 450 300 550	— 700 700 — — —	— Vickers B96 B96 B96 Vickers B83 160/310	220/330 220/330 220/330	B96 B96 B96 B83 C31	C33 C33 C33 C31	I, MM, QQ
A1-80	F738	Bolts, screws, and studs —metric	Stainless steel, alloys 303, 303 Se, 304, 305, 384, XM1, XM7 • Machined from strain hardened stock	Yes	M1.6 - M5 - M6 - M20 - Over M20 - - M24 Over M24 - - M30 Over M30 - - M36	— — — — — — 400 650 300 600 —	— 800 800 500 700 400 650 300 600 —	— Vickers C23 Vickers C23 Vickers C23 Vickers B96 Vickers B93 Vickers B93 Vickers B93 Vickers B89 Vickers B89	240/350 240/350 220/330 220/330 200/310 180/285	C23 C23 C36 C36 C33 C33 B93 C30 C28	C36 C36 C33 C33 C30 C28	I, MM, QQ
A2-50	F738	Bolts, screws, and studs —metric	Stainless steel, alloys 321, 347 • Headed and rolled from annealed stock and then re-annealed	Yes	M1.6 - M5 - M6 - M36	— — — —	— 500 500 —	— Vickers B81 Vickers B81	155/220 155/220	B95 B95	B95	I, MM, QQ
A2-70	F738	Bolts, screws, and studs —metric	Stainless steel, alloys 321, 347 • Cold worked	Yes	M1.6 - M5 - M6 - M20 - Over M20 - - M36	— — — — — —	— 700 700 300 550 —	— Vickers B96 Vickers B96 Vickers B96 Vickers B83 160/310	220/330 220/330 220/330 200/310	C33 C33 C33 C30	C36 C36 C33 C31	I, MM, QQ
A2-80	F738	Bolts, screws, and studs —metric	Stainless steel, alloys 321, 347 • Machined from strain hardened stock	Yes	M1.6 - M5 - M6 - M20 - Over M20 - - M24 Over M24 - - M30 Over M30 - - M36	— — — — — — 400 650 300 600 —	— 800 800 450 700 300 550 600 600 —	— Vickers C23 Vickers C23 Vickers B96 Vickers B96 Vickers B93 Vickers B93 Vickers B89 Vickers B89	240/350 240/350 220/330 220/330 200/310 180/285	C36 C36 C33 C33 C30 C28	C36 C36 C33 C33 C30 C28	I, MM, QQ
A4-50	F738	Bolts, screws, and studs —metric	Stainless steel, alloy 316 • Headed and rolled from annealed stock and then re-annealed	Yes	M1.6 - M5 - M6 - M36	— — — —	— 500 500 210 —	— Vickers B81 Vickers B81	155/220 155/220	B95 B95	B95	I, MM, QQ

Footnotes are grouped on the last page of this Part V series.

Grade ID, mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (mm)	Mechanical properties						Remarks or footnotes
						Bolts, screws, studs	Proof load (MPa)	Yield strength (Min MPa)	Tensile strength (min MPa)	Nuts	Proof load (MPa)	Brinell
A4-70	F738	Bolts, screws, and studs —metric	Stainless steel, alloy 316 • Cold worked	Yes	M1.6 - M5 - M6 - M20 - Over M20 - M36 -	—	—	700	—	Vickers B96 220/330 Vickers B96 220/330 Vickers B83 160/310	<u>C33</u> <u>C33</u> <u>B83</u> <u>C31</u>	1,MM,QQ
A4-80	F738	Bolts, screws, and studs —metric	Stainless steel, alloy 316 • Machined from strain hardened stock	Yes	M1.6 - M5 - M6 - M20 - Over M20 - M24 - Over M24 - M30 - Over M30 - M36 -	—	—	800	—	Vickers C23 240/350 Vickers C23 240/350 Vickers B96 220/330 Vickers B93 200/310 Vickers B89 180/285	<u>C36</u> <u>C36</u> <u>C36</u> <u>C33</u> <u>B93</u> <u>C30</u> <u>C28</u>	1,MM,QQ
F1-45	F738	Bolts, screws, and studs —metric	Stainless steel, alloys 430, 430F • Headed and rolled from annealed stock and then re-annealed	Yes	M1.6 - M5 - M6 - M36 -	—	—	450	—	Vickers B74 135/220 Vickers B74 135/220	<u>B96</u> <u>B96</u>	1,MM,QQ
F1-60	F738	Bolts, screws, and studs —metric	Stainless steel, alloys 430, 430F • Cold worked	Yes	M1.6 - M5 - M6 - M36 -	—	—	600	—	Vickers B89 180/285 Vickers B89 180/285	<u>C28</u> <u>C28</u>	1,MM,QQ
C1-50	F738	Bolts, screws, and studs —metric	Stainless steel, alloy 410 • Machined from annealed or solution annealed stock	Yes	M1.6 - M5 - M6 - M36 -	—	—	500	—	Vickers B81 155/220 Vickers B81 155/220	<u>B96</u> <u>B96</u>	1,MM,QQ
C1-70	F738	Bolts, screws, and studs —metric	Stainless steel, alloy 410 • Hardened and tempered at 565 C min	Yes	M1.6 - M5 - M6 - M36 -	—	—	700	—	Vickers B96 220/330 Vickers B96 220/330	<u>C34</u> <u>C34</u>	1,MM,QQ
C1-110	F738	Bolts, screws, and studs —metric	Stainless steel, alloy 410 • Hardened and tempered at 275 C min	Yes	M1.6 - M5 - M6 - M36 -	—	—	1100	—	Vickers C36 350/440 Vickers C36 350/440	<u>C45</u> <u>C45</u>	1,MM,QQ

Footnotes are grouped on the last page of this Part V series

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfr's ID symbol req'd?	Nominal size range (mm)	Mechanical properties					Remarks or footnotes	
						Proof load (MPa)	Yield strength (MPa)	Tensile strength (min MPa)	Nuts	Brinell		
C3-80	F738	Bolts, screws, and studs —metric	Stainless steel, alloy 431 • Hardened and tempered at 565 C min	Yes	M1.6 - M5 - M6 - M36	— — 640	— 800	800	Vickers 240/340 240/340	C23 C35 C23 C35	I, MM, QQ	
C3-120	F738	Bolts, screws, and studs —metric	Stainless steel, alloy 431 • Hardened and tempered at 275 C min	Yes	M1.6 - M5 - M6 - M36	— — 950	— 1200	1200	Vickers 380/480 380/480	C39 C48 C39 C48	I, MM, QQ	
C4-50	F738	Bolts, screws, and studs —metric	Stainless steel, alloys 416, 416 Se • Machined from annealed or solution annealed stock	Yes	M1.6 - M5 - M6 - M36	— — 250	— 500	500	Vickers 155/220 155/220	B81 B96 B81 B96	I, MM, QQ	
C4-70	F738	Bolts, screws, and studs —metric	Stainless steel, alloys 416, 416 Se • Hardened and tempered at 565 C min	Yes	M1.6 - M5 - M6 - M36	— — 410	— 700	700	Vickers 220/330 220/330	B96 B96 B96 B96	I, MM, QQ	
C4-110	F738	Bolts, screws, and studs —metric	Stainless steel, alloys 416, 416 Se • Hardened and tempered at 275 C min	Yes	M1.6 - M5 - M6 - M36	— — 820	— 1100	1100	Vickers 350/440 350/440	C36 C45 C36 C45	I, MM, QQ	
P1-90	F738	Bolts, screws, and studs —metric	Stainless steel alloy 630 • Solution annealed and age hardened after forming	Yes	M1.6 - M5 - M6 - M36	— — 700	— 900	900	Vickers 285/370 285/370	C23B C38 C23B C38	I, MM, QQ	
None req'd	F835M	Hex socket head cap screws — metric	Alloy steel— quenched and tempered	No	M3 - M20	— —	1100	1040	— —	Vickers 372/434	C38 RR	
A1-50	F836	Nuts — metric	Stainless steel— alloys 303, 303 Se, 304, 305, 384, XM1, XM7 • Machined from annealed or solution annealed stock, or formed and annealed	Yes	M1.6 M36	— —	— —	— 500	Vickers 155/220	B81 B95	SS	

Footnotes are grouped on the last page of this Part V series

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (mm)	Mechanical properties						Remarks or footnotes
						Bolts, screws, studs	Proof load (MPa)	Yield strength (Min MPa)	Tensile strength (min MPa)	Nuts	Brinell	Rockwell
A1.70	F8.9j	Huts - metric	Stainless steel—alloys 303, 303 Se, 304, 305, 304L, XM1, XM7 • Cold worked	Yes	M1.6 - M20 Over M20 - M36	—	—	—	—	700 550	Vickers B96 B83 160/310	SS C33 C31
A1.80	F8.9j	Huts - metric	Stainless steel, alloys 303, 303 Se, 304, 305, 384, XM1, XM7 • Machined from strain hardened stock	Yes	M1.6 - M20 Over M20 - M24 Over M24 - M30 Over 30 - M36	—	—	—	—	700 700 650 600	Vickers B96 B96 B93 B89 180/285	SS C23 C36 B96 C33 C30 C28
A2.50	F8.9j	Huts - metric	Stainless steel, alloy 321, 347 • Machined from annealed or solution annealed stock, or formed and annealed	Yes	M1.6 - M36	—	—	—	—	500 550/220	Vickers B81 B85 155/220	SS
A2.70	F8.9j	Huts - metric	Stainless steel, alloy 321, 347 • Cold worked	Yes	M1.6 - M20 Over M20 - M36	—	—	—	—	700 550	Vickers B96 B83 160/310	SS C33 C31
A2.80	F8.9j	Huts - metric	Stainless steel, alloy 321, 347 • Machined from strain hardened stock	Yes	M1.6 - M20 Over M20 - M24 Over M24 - M30 Over 30 - M36	—	—	—	—	800 700 650 600	Vickers C23 C240/350 B96 C33 C30 B89 180/285	SS
A4.50	F8.9j	Huts - metric	Stainless steel, alloy 316 • Machined from annealed or solution annealed stock, or formed and annealed	Yes	M1.6 - M36	—	—	—	—	500 550/220	Vickers B81 B85 155/220	SS

ASTM footnotes

- J** For full detail of markings, refer to Table 3 of the standard.
- R** Refer to Table 3 of the standard for the required torque coefficient.
- S** Not to be tested.

PP Grade and manufacturer's identification symbols are required only when specified on the order.

QQ Identification marking of studs, shims, etc., as applicable, per purchase order.

SS Markings shall be on the top of nut, top of flange, or on one of the two flat faces. Markings located on one of the two flat faces shall be chiseled or debossed. Markings on all other locations may be casted or debossed. Nuts in nominal thread diameter, M1 and smaller need not be marked.

Grade and material markings—Part VI

ASTM markings

The American Society for Testing and Materials, 1916 Race St., Philadelphia, PA 19103, sponsors development of specifications for fasteners used in general and special engineering applications. These specifications detail chemical and mechanical properties of material strength levels for fasteners and are generally specific in referencing the actual product covered. A full range of types of products of various styles, thread series, lengths, etc. can be produced to meet ASTM requirements and would be marked for grade and material identification as required.

ASTM Grade and material identification markings required by ASTM specifications

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (mm)	Mechanical properties				Remarks or footnotes
						Bolts, screws, studs	Proof load (MPa)	Yield strength (Min MPa)	Tensile strength (min MPa)	
A4-70	F836	Nuts—metric	Stainless steel, alloy 316 • Cold worked	Yes	M1.6 - M20 Over M20 - M36	—	—	—	—	700 Vickers 160/310 SS
A4-80	F836	Nuts—metric	Stainless steel, alloy 316 • Machined from stain hardened stock	Yes	M1.6 - M20 Over M20 - M24 Over M24 - M30 Over M30 - M36	—	—	—	—	800 Vickers 200/310 SS
F1-45	F836	Nuts—metric	Stainless steel, alloy 430, 430F • Machined from annealed or solution annealed stock, or formed and annealed	Yes	M1.6 - M36	—	—	—	—	450 Vickers 135/220 SS

Footnotes are grouped on the last page of this Part VI series.

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (mm)	Mechanical properties					Remarks or footnotes
						Bolts, screws, studs	Proof load (MPa)	Yield strength (Min MPa)	Tensile strength (min MPa)	Nuts	
C1-70	F836	Nuts—metric	Stainless steel, alloy 410 • Hardened and tempered at 565°C min	Yes	M1.6 - M36	—	—	—	—	700 Vickers 220/330 B96 C34	SS
C1-110	F836	Nuts—metric	Stainless steel, alloy 410 • Hardened and tempered at 275°C min	Yes	M1.6 - M36	—	—	—	—	1100 Vickers 350/440 B96 C34	SS
C3-80	F836	Nuts—metric	Stainless steel, alloy 431 • Hardened and tempered at 565°C min	Yes	M1.6 - M36	—	—	—	—	1100 Vickers 240/340 B96 C35	SS
C3-120	F836	Nuts—metric	Stainless steel, alloy 431 • Hardened and tempered at 275°C min	Yes	M1.6 - M36	—	—	—	—	1200 Vickers 380/480 B96 C34	SS
C4-70	F836	Nuts—metric	Stainless steel, alloy 416, 416 Se • Hardened and tempered at 565°C min	Yes	M1.6 - M36	—	—	—	—	1100 Vickers 220/330 B96 C34	SS
C4-110	F836	Nuts—metric	Stainless steel, alloy 416, 416 Se • Hardened and tempered at 275°C min	Yes	M1.6 - M36	—	—	—	—	1100 Vickers 350/440 B96 C35	SS

Footnotes are grouped on the last page of this Part VI series

Grade ID mark	ASTM spec number	Fastener description	Material	Is mfr's ID symbol req'd?	Nominal size range (mm)	Mechanical properties						Remarks or footnotes
						Bolts, screws, studs	Proof load (MPa)	Yield strength (MPa)	Tensile strength (min MPa)	Nuts	Hardness	
P1-90	F836	Nuts - metric	Stainless steel, alloy 630 • Solution annealed and age hardened after forming	Yes	M1.6 - M36	—	—	—	—	Vickers 285/370	C48/C38	SS
A1-50	F837/M	Socket head cap screws —metric	Stainless steel alloys 303, 304, 305, 384, XM1, XM7 • Annealed	Yes	M1.6 - M5 M6 - M36	—	—	500	—	Vickers 155/220	B70/B95	GG
A1-70	F837M	Socket head cap screws —metric	Stainless steel alloys 303, 304, 305, 384, XM1, XM7 • Cold worked	Yes	M1.6 - M5 M6 - M14 M16 - M36	—	—	500	—	Vickers 155/220	B70/B95	GG
C1-110	F837/M	Socket head cap screws —metric	Stainless steel, alloy 410 • Heat treated	Yes	M1.6 - M5 M6 - M36	—	—	700	—	Vickers 220/330	B96/C33	GG
None reqd	#844	Plain (flat) washers for general use	Steel, unhardened	No	—	—	—	—	—	—	—	—

ASTM Footnotes

GG. All screws with nominal diameters of 5 mm and larger require marking. Marking may be on the side or top of the fastener.

SS. Markings shall be on the top or on the side or top of fasteners. The markings shall be deposited markings on all other parts of the fastener. They may be stamped or deburred parts in material.

This concludes the ASTM grade marking compilation.

Grade and material markings—Part VII

SAE and GM markings

Several years ago the Society of Automotive Engineers, 400 Commonwealth Dr., Warrendale, PA 15096, developed a strength grading system for carbon and alloy steel commercial fasteners. Today it is the most widely used and copied system in existence in this country. General requirements are presented in the following table. General Motors Corp issues standards which are broadly used outside this one company. For this reason, GM cross references to SAE Grades are included in this listing.

SAE and GM Grade and material identification markings required by SAE and GM specifications

Grade ID mark	Spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (inch)	Mechanical properties				Remarks or footnotes
						Bolts, screws, studs	Yield strength (min psi)	Tensile strength (min psi)	Nuts	
None req'd	SAE J429 Grade 1 GM	Bolts, screws, studs and U-bolts ^A	Low or medium carbon steel	Yes except studs	1/4 - 1 1/2	33,000 ^B	36,000 ^C	60,000	—	B70/B100 Equivalent to ASTM A307, Grade A D
None req'd	SAE J429 Grade 2 GM	Bolts, screws, and studs	Low or medium carbon steel	Yes except studs	1/4 - 3/4 Over 1 1/2	55,000 ^B	57,000 ^C	74,000	—	B80/B100 D
None req'd	SAE J429 Grade 4 GM	Studs	Medium carbon cold drawn steel	No	1/4 - 1 1/2	65,000	100,000 ^E	115,000	—	C22/C32 D
None req'd	SAE J429 Grade 5 GM	Bolts, screws, and studs	Medium carbon steel, quenched and tempered	Yes except studs	1/4 - 1 Over 1 - 1 1/2	85,000	92,000 ^E	120,000	—	C25/C34 D
—	SAE J429 Grade 5.1 (E) GM	Screws	Low or medium carbon steel, quenched and tempered	Yes	#6 - 5/8	85,000	—	120,000	—	C25/C40 D F
—	SAE J429 Grade 5.2 GM	Bolts and screws	Low carbon martensite steel, fully killed, fine grain, quenched and tempered	Yes	#6 - 5/8	85,000	92,000 ^C	120,000	—	C23/C39 D
—	SAE J429 Grade 5.2 GM	Bolts and screws	Low carbon martensite steel, fully killed, fine grain, quenched and tempered	Yes	1/4 - 1	85,000	92,000 ^C	120,000	—	C26/C36 D

Footnotes are grouped on the last page of this Part VII series.

Grade ID mark	Spec number	Fastener description	Is mfg's ID symbol req'd?	Nominal size range (inch)	Mechanical properties						Remarks or footnote(s)
					Proof load (psi)	Yield strength (min psi)	Tensile strength (min psi)	Nuts	Brinell	Rockwell	
1	SAE J429 Grade 7 GM 290M	Bolts and screws	Yes	1/4 - 1 1/2	105,000	115,000 ^c	133,000	—	—	C28/C34	Roll threaded after heat treatment D,F
2	SAE J429 Grade 8 GM 300M	Bolts, screws, and studs	Yes	1/4 - 1 1/2	120,000	130,000 ^c	150,000	—	—	C33/C39	Equivalent to ASTM A354, Grade BD.
3	None req'd	SAE J429 Studs Grade 8 1	No	1/4 - 1 1/2	120,000	130,000 ^c	150,000	—	—	—	D
4	SAE J429 Grade 8 2	Bolts and screws	Yes	1/4 - 1	120,000	130,000 ^c	150,000	—	—	—	D
5	GM 455M	Bolts and screws	Corrosion resistant steel	1/4 - 1 1/2	40,000	—	55,000	—	143	B79 min	D
6	SAE J429 GM 500M (4.6)	Bolts, screws, studs and nuts — metric	Low or medium carbon steel	M5 - M36 mm	225	240 MPa ^c	400 MPa _u	—	B67/B87	Approximately equivalent to SAE J429 Grade 1 and ASTM A367 Grade A.	G
7	SAE J1199 GM 500M (4.8)	Bolts, screws, studs and nuts metric	Low or medium carbon steel	M16 mm	310	—	420 MPa	—	B71/B87	—	G
8	SAE J1199 GM 500M (5.8)	Bolts, screws, and studs — metric	Low or medium carbon steel (cold worked)	M24 mm	—	—	520 MPa _u	—	B71/B100	Approximately equivalent to SAE J429 Grade 2	G

Footnotes are grouped on the last page of this Part VII series.

Grade ID mark	Spec number	Fastener description	Material	Is mfr's ID symbol req'd?	Nominal size range	Mechanical properties					Remarks or footnotes(s)	
						Bolts, screws, studs	Proof load	Yield strength (min)	Tensile strength (min)	Nuts	Brinell	Rockwell
8.8	SAE J1199	Bolts, screws, and studs —metric	Medium carbon or medium carbon alloy steel, quenched and tempered	Yes	M16 - M36 mm	600 MPa	680 ^c MPa	830 MPa	—	—	—	C ₂₃ /C ₃₄
O (H)	GM 500M (8.8)	Studs—metric	Medium carbon or medium carbon alloy steel, quenched and tempered	Yes	M16 - M36 mm	600 MPa	680 ^c MPa	830 MPa	—	—	—	G Approximately equivalent to SAE J429 Grade 5 and ASTM A449
8.8	SAE J1199	Bolts, screws, and studs —metric	Low carbon martensite steel, quenched and tempered	Yes	M16 - M36 mm	600 MPa	680 ^c MPa	830 MPa	—	—	—	C ₂₄ /C ₃₄
9.8	SAE J1199	Bolts, screws, sets and studs —metric	Medium carbon steel, quenched and tempered	Yes	M16 mm	650 MPa	—	—	900 MPa _d	—	—	C ₂₇ /C ₃₆
+ (H)	GM 500M (9.8)	Studs —metric	Medium carbon steel, quenched and tempered	Yes	M16 mm	650 MPa	—	—	900 MPa _d	—	—	G Approximately 9% stronger than SAE J429 Grade 5 and ASTM A449
9.8	SAE J1199	Bolts, screws, sets, and studs —metric	Low carbon martensite steel, quenched and tempered	Yes	M16 mm	650 MPa	—	—	900 MPa _d	—	—	C ₂₇ /C ₃₆
± (H)	GM 500M (9.8)	Studs —metric	Low carbon martensite steel, quenched and tempered	Yes	M16 mm	650 MPa	—	—	900 MPa _d	—	—	G Approximately 9% stronger than SAE J429 Grade 5 and ASTM A449
9.8	(H)	Same as sets, but no washers — metric	Medium carbon steel, quenched and tempered	Yes	M16 mm	650 MPa	—	—	900 MPa _d	—	—	C ₂₇ /C ₃₆
12.9	SAE J1199	Bolts, screws, and studs metric	Alloy steel oil quenched and tempered	Yes	M16 - M36 mm	970 MPa	1100 ^c MPa	1220 MPa	—	—	—	C ₃₈ /C ₄₄

Footnotes are grouped on the last page of this Part VII series.

Grade ID mark	Spec number	Fastener description	Material	Is mfg'r's ID symbol req'd?	Nominal size range (inch)	Mechanical properties						Remarks or footnotes(s)	
						Bolts, screws, studs	Proof load	Yield strength (min)	Tensile strength (min)	Nuts	Proof load (psi)	Brinell	
10.9		Bolts, screws, and studs —metric	Medium carbon alloy steel, quenched and tempered		M6 - M36 mm								G Approximately equivalent to SAE J429, Grade 8 and ASTM A354, Grade BD
	SAE J1199 (H)	Studs — metric	Medium carbon alloy steel, quenched and tempered	Yes	830 MPa	940 C MPa	1040 MPa	—	—	—	C33/C39		
	GM 500M (10.9)	Studs — metric	Low carbon martensite steel, quenched and tempered										
10.9		Bolts, screws, and studs —metric	Low carbon martensite steel, quenched and tempered		M5 - M36 mm								
None req'd	SAE J995 Grade 2 GM 284M	Nuts	Low or medium carbon steel	No	1/4 - 1 1/2	—	—	—	90,000	—	C32 max	C30 max	
	SAE J995 Grade 5 GM 286M (L,M)	Nuts	Low or medium carbon steel	No	1/4 - 1 1 1/2	—	—	—	120,000 ^J	—	C32 max	C30 max	
				Over 1 - 1 1/2	—	—	—	—	109,000 ^K	—			
				1/4 - 3/4	—	—	—	—	105,000 ^J	—			
				1/8 - 1	—	—	—	—	94,000 ^K	—			
				1 1/8 - 1 1/2	—	—	—	—	104,000 ^K	—			
				1 1/4 - 2 1/2	—	—	—	—	105,000 ^J	—			
				Over 5/8 - 1	—	—	—	—	94,000 ^K	—			
				Over 1 - 1 1/2	—	—	—	—	150,000	—	C34	C36	
				Smaller than 1, 1 and larger,	—	—	—	—	150,000	—	C34	C36	
	SAE J995 Grade 8 GM 301M (L,M)	Nuts	Low or medium carbon steel	No	—	—	—	—	150,000	—	C34	C36	
				Smaller than 1, 1 and larger,	—	—	—	—	150,000	—	C34	C36	

Footnotes are grouped on the last page of this Part VII series.

Grade ID mark	Spec number	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (inch)	Mechanical properties								
						Proof load	Yield strength (min psi)	Tensile strength (min psi)	Nuts	Proof load (MPa)	Brinell	Rockwell	Coarse thread Style 1 hex nuts.	Coarse thread Style 2 hex nuts.
	GM 51(M (5))	Nuts - metric	Non heat treated carbon steel	No	1 6 - 4 mm 5-6 mm 8-10 mm 12-16 mm 20 - 36 mm	— — — — —	— — — — —	— — — — —	520 580 590 610 630	B70 min C30 max	B70 min C30 max	Coarse thread Style 1 hex nuts.	Coarse thread Style 2 hex nuts.	
	GM 510(M (9))	Nuts - metric	Non heat treated carbon steel	No	3-4 mm 5-6 mm 8-10 mm 12-16 mm 20-36 mm	— — — — —	— — — — —	— — — — —	900 915 940 950 920	B85 min C30 max	B85 min C30 max	Coarse thread Style 1 hex nuts.	Coarse thread Style 2 hex nuts.	
	GM 510(M (10))	Nuts - metric	Heat treated carbon steel	No	1 6-10 mm 12-16 mm 20-36 mm	— — —	— — —	— — —	1040 1050 1060	C26 min C36 max	C26 min C36 max	Coarse thread Style 1 hex nuts.	Coarse thread Style 1 hex nuts.	
None req'd	SAE J430 Grade 0					—	—	—	—	—	—	—	B65 max for sizes $t_{\frac{1}{16}}$ " and less.	
None req'd	SAE J430 Grade 1	Solid rivets	Carbon steel	No	All sizes	—	—	—	—	—	—	—	B65 max for sizes $t_{\frac{1}{16}}$ " and less.	
None req'd	SAE J430 Grade 2					—	23,000	40,000- 75,000	—	—	—	—	Not specified	
None req'd	SAE J430 Grade 3					—	28,000	52,000- 62,000	—	—	—	—	Not specified	
None req'd	SAE J82 Grade 60M	Machine screws	Carbon steel	No	#4 - $\frac{1}{4}$	—	—	—	60,000 100,000	—	—	—	B70 B100	
None req'd	SAE J82 Grade 120M	Machine screws	Carbon steel, quenched and tempered	No	#4 - $\frac{1}{4}$	—	—	—	120,000 min	—	—	—	C25 C38	

SAE & GM Initiatives

- A.** Whenever the word "shall" appears, it shall be implied.

B. Requirements for products used in construction, industry, or renewing products.

C. Value applied to machine tool dies and dies.

D. Threaded fasteners and their head forms shall be clearly marked as required in addition to bolts and nuts. They shall be inscribed with the manufacturer's identification symbol marked "ASME B18.2.1-1972" or "ASME B18.2.1-1972" or "ASME B18.2.1-1972".

E. Bolts and similar products without washers.

F. The washer faced and hex flange bolts with all other standard features shall have core hardened and recessed top surfaces and surface hardened according to K and S with H.S.

G. Slotted and cross recessed screws of all sizes and other sizes smaller than No. 100 need not be slotted. All other bolts and screws of sizes No. 100 and larger shall be slotted to readily permit cleaning and manipulation. Markings shall be located on top of the head of slot-headed screws, and may be car code dated and lettered.

H. This is the optional property class symbol for a bolt of this property less than size M5 through M11.

I. Products made same as items except without shoulders, shall be additionally identified with one of the following property class symbols, as shown:

J. Values apply to UH, LH, TH, and fine thread series.

K. Values apply to UH, LH, TH, and fine thread series.

L. All modes of location, tolerance, joint force, shutoff, heavy duty load, test load, and heats of tools not required for grade marked.

M. Grade markings for nuts, fastened by cutting threads, shall consist of letters of the heptagon corners and switch gear for grade, and two numbers each, correct for grade 8.

Grade and material markings—Part VIII

ISO markings

ISO (the International Organization for Standardization) is a federation of the national standards bodies of the countries of the world. Purpose of developing international standards is to form the basis of a one-world system of engineering practices. It is intended that international decisions being documented as ISO standards will become accepted into the national standards of ISO member countries. Copies of ISO standards are available from American National Standards Institute (ANSI), 1430 Broadway, New York, NY 10018.

ISO

Identification markings required by ISO standards for externally threaded fasteners

Property class ID mark	ISO standard number ^A	Fastener description	Material	Is mfr's ID symbol req'd?	Nominal size range (mm)	Mechanical requirements					Remarks or footnotes	
						Externally threaded fasteners		Rockwell hardness				
						Proof load stress MPa	Yield strength (min MPa)	Tensile strength (min MPa)	Surface (Max)	Core (Min)	(Max)	
4.6	ISO 898/1	Bolts, screws and studs	Low or medium carbon steel	Yes	M5 M100	225	240	400	B67	B95	B,C
4.8	ISO 898/1	Bolts, screws and studs	Low or medium carbon steel, fully or partially annealed	Yes	M16 M16	310	340	420	B71	B95	B,C
5.8	ISO 898/1	Bolts, screws and studs	Low or medium carbon steel, cold worked	Yes	M5 M24	380	420	520	B82	B95	B,C,D
8.8	ISO 898/1	Bolts, screws and studs	Medium carbon steel, quenched and tempered	Yes	M16 M72	600	660	830	30N56	C23	C34	B,C
8.8	ISO 898/1	Bolts, screws and studs	Low carbon martensite steel, quenched and tempered	Yes	M16 M36	600	660	830	30N56	C23	C34	B,C
9.8	ISO 898/1	Bolts, screws (and studs M12 or larger)	Medium carbon steel, quenched and tempered	Yes	M16 M16	650	770	900	30N58	C27	C36	B,C

Footnotes are grouped on the last page of this Part VIII series.

Property class ID mark	ISO standard number ^A	Fastener description	Material	Is mfg's ID symbol req'd?	Nominal size range (mm)	Mechanical requirements						Remarks or footnotes
						Externally threaded fasteners			Rockwell hardness			
						Proof load stress MPa	Yield strength (min MPa)	Tensile strength (min MPa)	Surface (Max)	Core (Min)	(Max)	
+	ISO 898/1	Studs of class 9.8	Medium carbon steel, quenched and tempered	Yes	Less than M12	650	720	900	30N58	C27	C36	C, E
<u>9.8</u>	ISO 898/1	Bolts, screws (and studs) M12 or larger	Low carbon martensite steel, quenched and tempered	Yes	M1.6-M16	650	720	900	30N58	C27	C36	B, C
±	ISO 898/1	Studs of class 9.8	Low carbon martensite steel, quenched and tempered	Yes	Less than M12	650	720	900	30N58	C27	C36	C, E
<u>10.9</u>	ISO 898/1	Bolts, screws (and studs) M12 or larger	Medium carbon steel, quenched and tempered	Yes	M5-M20	830	940	1040	30N59	C34	C39	B, C
□	ISO 898/1	Studs of class 10.9	Medium carbon or medium carbon alloy steel, quenched and tempered	Yes	M5-M100	830	940	1040	30N59	C33	C39	B, C
<u>10.9</u>	ISO 898/1	Bolts, screws (and studs) M12 or larger	Low carbon martensite steel, quenched and tempered	Yes	Less than M12	830	940	1040	30N59	C33	C39	C, E
□	ISO 898/1	Studs of class 10.9	Low carbon martensite steel, quenched and tempered	Yes	M5-M36	830	940	1040	30N59	C33	C39	B, C
<u>12.9</u>	ISO 898/1	Bolts, screws (and studs) M12 or larger	Alloy steel, quenched and tempered	Yes	M1.6-M100	970	1100	1220	30N63	C38	C44	B, C, F
△	ISO 898/1	Studs of class 12.9	Alloy steel, quenched and tempered	Yes	Less than M12	970	1100	1220	30N63	C38	C44	C, E

Footnotes are grouped on the last page of this Part VIII series.

ISO

Identification markings required by ISO standards for internally threaded fasteners.

Property class ID mark	Property class of nut ^G	Dimensional style of nut	Material	Is mfg's ID symbol req'd?	Nominal size range (mm)	Mechanical requirements for nuts			Remarks or footnotes
						Proof load stress (MPa)	Overtapped nuts	(Min) (Max)	
None req'd	04	Hex jam	Carbon steel	No	M5-M36	380	—	B89	C30
05	05	Hex jam	Carbon steel	Yes	M5-M36	500	—	C26	H
					M1.6-M4	520	—		
					M5, M6	580	465	B70	C30
5	5	Hex, Style 1	Carbon steel	Yes	M8, M10	590	470		H
					M12-M16	610	490		
					M20-M36	630	500	B78	C30
					M42-M100	630	500	B70	C30
					M3-M4	900	—	B85	C30
9	9	Hex, Style 2 and hex flange	Carbon steel	Yes	M5, M6	915	—		
					M8, M10	940	—	B89	C30
					M12-M16	950	—		H1
					M20	920	—		
					M24-M36	920	—		
					M42-M100	920	—		
10	10	Hex, Style 1 and hex flange	Alloy steel quenched and tempered	Yes	M1.6-M4	1040	—		
					M5-M10	1040	—		
					M12-M16	1050	—	C26	C36
					M20	1060	—		H1
					M24-M36	1060	—		
12	12	Hex, Style 2	Alloy steel quenched and tempered	Yes	M3-M4	1150	—		
					M5, M6	1150	920		
					M8, M10	1160	930		
					M12-M16	1190	950	C26	C36
					M20-M36	1200	960		H1
					M42-M100	1200	960		

Footnotes are on next page

ISO footnotes from preceding tables

- A. Although ISO 898-1 presents 10 property classes, [F] has been unable to identify any commercial or industrial need by North American industry for ISO property classes 36, 5, 6 and 8 bolts, screws and studs.
- B. Marking is required for hex bolts and screws with nominal diameters $\geq 5\text{mm}$ where shape of fastener allows marking to be accomplished, preferably on the head, after machining on the side of head by indenting.
- C. Marking is required for studs with nominal diameters equal to or greater than 5mm. Preferably on the extreme end of the threaded portion by indenting. For studs with reference [I], the marking shall be at the nut end.

D. Class 5.8 applies only to bolts and screws with lengths $> 15\text{mm}$ and shorter and to studs of all lengths.

E. This is the Grade mark symbol for studs of this property class in sizes M5 up to but not including M12.

F. Caution is advised when considering use of Class 12.9 products. Capability of the fastener manufacturer, as well as anticipated service environment, should be carefully considered. Class 12.9 products require tight control of heat treating operations and careful monitoring of as-quenched hardness, surface discontinuities, depth of partial decarburization, and freedom from porosity. Stress corrosion cracking susceptibility also needs to be addressed.

- G. All data was extracted from ASTM A563M and ISO 898-2. All values are as given in A563M. Values for drop-in classes 9, 10, 10 and 12 non-overlapped nuts in sizes M36 and smaller are in both documents and are identical. Other classes, sizes and overlapped nut values are unique to A563M.
- H. Hex nuts of thread diameters $> 5\text{mm}$ and property classes equal to or higher than 8 and property class 9 shall be marked as noted by indenting on the side or bearing surface, or by embossing on the chamfer.
- I. Alternative marking system according to clock-face system is as follows:

Property class either designation symbol	9	10	12
Alternative marking or code symbol (clock-face system)			

Appendix B

Bolt Ultimate Shear and Tensile Strengths

[From ref. 18]

MIL-HDBK-5E
1 June 1987

TABLE 8.1.5(a). *Ultimate Single Shear Strength of Threaded Steel Fasteners*

Shear strength of fastener, ksi		35	38	75	91	95	108	125	132	156	180	Ultimate single shear strength, lbs.
Fastener diameter In.	b	Basic shank area										
0.112	# 4	0.0098520	345	374	739	897	936	1064	1232	1300	1537	1773
0.125	1/8	0.012272	430	466	920	1117	1166	1325	1534	1620	1914	2209
0.138	# 6	0.014957	523	568	1122	1361	1421	1615	1870	1974	2333	2692
0.156	5/32	0.019175	671	729	1438	1745	1822	2071	2397	2531	2991	3452
0.164	# 8	0.021124	739	803	1584	1922	2007	2281	2640	2788	3295	3802
0.188	3/16	0.027612	966	1049	2071	2513	2623	2982	3452	3645	4310	4970
0.190	#10	0.028353	992	1077	2126	2580	2694	3062	3544	3743	4420	5100
0.216	#12	0.036644	1283	1392	2748	3335	3481	3958	4580	4840	5720	6600
0.219	7/32	0.037582	1315	1428	2819	3420	3570	4060	4700	4960	5860	6760
0.250	1/4	0.049087	1718	1865	3682	4470	4660	5300	6140	6480	7660	8840
0.312	5/16	0.076699	2684	2915	5750	6980	7290	8280	9590	10120	11970	13810
0.375	3/8	0.11045	3866	4200	8280	10050	10490	11930	13810	14580	17230	19880
0.438	7/16	0.15033	5260	5710	11270	13680	14280	16240	18790	19840	23450	27060
0.500	1/2	0.19635	6870	7460	14730	17870	18650	21210	24540	25920	30630	35340
0.562	9/16	0.24850	8700	9440	18640	22610	23610	26840	31060	32800	38770	44700
0.625	5/8	0.30680	10740	11660	23010	27920	29150	33130	38350	40500	47900	55200
0.750	3/4	0.44179	15460	16790	33130	40200	42000	47700	55200	58300	68900	79500
0.875	7/8	0.60132	21050	22850	45100	54700	57100	64900	75200	79400	93800	108200
1.000	1	0.78540	27490	29850	58900	71500	74600	84800	98200	103700	122500	141400
1.125	1-1/8	0.99402	34790	37770	74600	90500	94400	107400	124300	131200	155100	178900
1.250	1-1/4	1.2272	43000	46600	92000	111700	116600	132500	153400	162000	191400	220900
1.375	1-3/8	1.4849	52000	56400	111400	135100	141100	160400	185600	196000	231600	267300
1.500	1-1/2	1.7671	61800	67100	132500	160800	167900	190800	220900	233300	275700	318100

^aValues with the first digit < 4 are shown to 4 significant figures, all other are shown to 3 significant figures.

^bFractional equivalent of screw number.

TABLE 8.1.5(b). *Ultimate Tensile Strength of Threaded Steel Fasteners*

		Ultimate tensile strength, lbs. ^{a,b,c}							
		55	62	62.5	125	140	160	180	
Fastener diameter		Nominal minor area ^d							
In.	d								
0.112	4-40	0.0050896	280	316	318	636	713	814	916
0.138	6-32	0.0076821	423	476	480	960	1 075	1 229	1 383
0.164	8-32	0.012233	673	758	765	1 529	1 713	1 957	2 202
0.190	10-32	0.018074	994	1,121	1,130	2 259	2 530	2 892	3 253
0.250	1/4-28	0.0333394	1 837	2 070	2 087	4 170	4 680	5 340	6 010
0.312	5/16-24	0.0536666	2 952	3 327	3 354	6 710	7 510	8 590	9 660
0.375	3/8-24	0.082397	4 530	5 110	5 150	10 300	11 540	13 180	14 830
0.438	7/16-20	0.111115	6 110	6 890	6 950	13 890	15 560	17 780	20 010
0.500	1/2-20	0.151116	8 310	9 370	9 450	18 900	21 160	24 190	27 210
0.562	9/16-18	0.19190	10 550	11 900	11 990	23 990	26 870	30 700	34 540
0.625	5/8-18	0.24349	13 390	15 100	15 220	30 440	34 090	38 960	43 800
0.750	3/4-16	0.35605	19 580	22 080	22 250	44 500	49 800	57 000	64 100
0.875	7/8-14	0.48695	26 780	30 190	30 430	60 900	68 200	77 900	87 700
1.000	1-12	0.63307	34 820	39 250	39 570	79 100	88 600	101 300	114 000
1.125	1-1/8-12	0.82162	45 200	50 900	51 400	102 700	115 000	131 500	147 900
1.250	1-1/4-12	1.0347	56 900	64 200	64 700	129 300	144 900	165 600	186 200
1.375	1-3/8-12	1.2724	70 000	78 900	79 500	159 000	178 100	203 600	229 000
1.500	1-1/2-12	1.5345	84 400	95 100	95 900	191 800	214 800	245 500	276 200

^aValues shown above heavy line are for 2A threads; all other values are for 3A threads.^bNuts designed to develop the ultimate tensile strength of the fastener are required to develop the tabulated tension loads.^cValues with the first digit < 4 are shown to 4 significant figures; all others are shown to 3 significant figures.^dFractional equivalent or number and threads per inch.

•Area computed using nominal minor diameter as published in Table 2.2.1 of Handbook 11-28.

TABLE 8.1.5(b₂). Ultimate Tensile Strength of Threaded Steel Fasteners (Continued)

Tensile strength of fastener, ksi	Fastener diameter In.	d	Maximum minor area*	Ultimate tensile strength, lbs a,b,c			
				160	180	220	260
0.112	4-40	0.0054367	869	979	1,196	1,414	1,631
0.138	6-32	0.0081553	1,305	1,468	1,794	2,120	2,447
0.164	8-32	0.012848	2,055	2,313	2,827	3,340	3,854
0.190	10-32	0.018602	2,976	3,348	4,090	4,840	5,580
0.250	1/4-28	0.034241	5,480	6,160	7,530	8,900	10,270
0.312	5/16-24	0.054905	8,780	9,880	12,080	14,280	16,470
0.375	3/8-24	0.083879	13,420	15,100	18,450	21,810	25,160
0.438	7/16-20	0.11323	18,120	20,380	24,910	29,440	33,970
0.500	1/2-20	0.15358	24,570	27,640	33,750	39,930	46,180
0.562	9/16-18	0.19502	31,200	35,100	42,900	50,700	58,560
0.625	5/8-18	0.24700	39,520	44,500	54,300	64,200	74,100
0.750	3/4-16	0.35082	57,700	64,900	79,400	93,800	108,200
0.875	7/8-14	0.49327	78,900	88,800	108,500	128,300	148,000
1.000	1-12	0.64156	102,600	115,500	141,100	166,800	192,500
1.125	1-1/8-12	0.83129	133,000	149,600	182,900	216,100	249,400
1.250	1-1/4-12	1.0456	167,300	188,200	230,000	271,900	313,700
1.375	1-3/8-12	1.2844	205,500	231,200	282,600	333,900	385,300
1.500	1-1/2-12	1.5477	247,600	278,600	340,500	402,400	464,300

*All values are for 3A threads.

bNuts designed to develop the ultimate tensile strength of the fastener are required to develop the tabulated tension loads.

cValues with the first digit < 4 are shown to 4 significant figures; all others are shown to 3 significant figures.

dFractional equivalent or number and threads per inch.

eArea computed using maximum minor diameter as published in Tables II and III of MIL-S-8879.

Appendix C

Blind Rivet Requirements

USER SYMBOL:
ARMY - MI

REVIEWER SYMBOL:
ARMY - 99
USAF - 99
DLA - 1S

For future coordination of changes to this document, draft circulations
should be based on the information in the current DD FORMS.

This military standard is approved for use by all Departments
& Agencies of the Department of Defense. Selection for all new
engineering and design applications and for replacement use shall
be made from this document.

FED. SUP CLASS
5320

BLIND RIVETS SHALL BE USED IN COMPLIANCE WITH THE JOINT ALLOWABLE TABLES IN MIL-HDBK-5, CHAPTER 8.

BLIND RIVETS SHALL CONFORM TO THE FOLLOWING REQUIREMENTS:

1. THE HOLE SIZE FOR BLIND INSTALLATION SHALL BE WITHIN THE LIMITS SPECIFIED ON THE APPLICABLE SPECIFICATION SHEET, STANDARD, OR DRAWING.
2. FOR DIMPLED ASSEMBLY, THE RIVET HOLES SHALL BE SIZED AFTER THE SHEETS HAVE BEEN DIMPLED.
3. MECHANICALLY LOCKED SPINOLE BLIND RIVETS (LOCKING RING OR COLLAR) MAY BE USED ON AIRCRAFT IN AIR INTAKE AREAS AND IN THE AREA FORWARD OF THE ENGINE.
4. FOR REPAIR AND REWORK, THE BLIND RIVETS USED IN REPLACEMENT OF SOLID SHANK RIVETS SHALL BE OVERSIZE OR ONE STANDARD SIZE LARGER (SEE REQMT 5).
5. OVERSIZE BLIND RIVETS MAY BE USED FOR REPAIR AND REWORK:
 - a. OVERSIZE RIVETS ARE FOR USE IN NON-STANDARD HOLE DIAMETERS. NON-STANDARD HOLES ARE THE RESULT OF HOLE RESIZING DURING REWORK OR REPAIR, OR DUE TO MANUFACTURING ERROR IN NEW DESIGN.
 - b. THE GRIP LENGTH OF THE OVERSIZE RIVET, THE BACKSIDE CLEARANCE (INSTALLED AND UNINSTALLED), AND THE PERFORMANCE CHARACTERISTICS SHALL BE EQUAL TO THE STANDARD RIVET THAT IS BEING REPLACED.
6. BLIND RIVETS SHALL NOT BE USED:
 - a. IN FLUID TIGHT AREAS.
 - b. ON AIRCRAFT CONTROL SURFACE HINGES, HINGE BRACKETS, FLIGHT CONTROL ACTUATING SYSTEMS, WING ATTACHMENT FITTINGS, LANDING GEAR FITTINGS, OR OTHER HEAVILY STRESSED LOCATIONS ON THE AIRCRAFT.
7. FRICTION LOCKED BLIND RIVETS (NO LOCKING RING OR COLLAR) SHALL NOT BE USED ON AIRCRAFT IN AIR INTAKE AREAS WHERE RIVET PARTS MAY BE INGESTED BY THE ENGINE.
8. NICKEL-COPPER ALLOY (MONEL) RIVETS WITH CADMIUM PLATING SHALL NOT BE USED WHERE THE AMBIENT TEMPERATURE IS ABOVE 400°F.
9. FLUSH HEAD RIVETS SHALL NOT BE MILLED TO OBTAIN FLUSHNESS WITH THE SURROUNDING SHEET WITHOUT PRIOR WRITTEN APPROVAL FROM THE DESIGN ACTIVITY.
10. OVERSIZE BLIND RIVETS SHALL NOT BE SPECIFIED IN NEW DESIGN. AN OVERSIZE BLIND RIVET IS ONE SPECIFICALLY DESIGNED FOR REPLACEMENT PURPOSES. ITS SHANK DIAMETER DIMENSION IS GREATER THAN A STANDARD BLIND RIVET.
11. CHEMICALLY EXPANDED BLIND RIVETS SHALL NOT BE USED.

THIS IS A DESIGN STANDARD, NOT TO BE USED AS A PART NUMBER.

(C) REWRITTEN

P.A. NAVY - AS Other Cust ARMY - AV USAF - 11	TITLE RIVETS, BLIND, STRUCTURAL, MECHANICALLY LOCKED AND FRICTION RETAINER SPINOLE, (RELIABILITY AND MAINTAINABILITY) DESIGN AND CONSTRUCTION REQUIREMENTS FOR.	MILITARY STANDARD MS33522
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16. Abstract This manual was written for design engineers to enable them to choose appropriate fasteners for their designs. Subject matter includes fastener material selection, platings, lubricants, corrosion, locking methods, washers, inserts, thread types and classes, fatigue loading, and fastener torque. A section on design criteria covers the derivation of torque formulas, loads on a fastener group, combining simultaneous shear and tension loads, pullout load for tapped holes, grip length, head styles, and fastener strengths. The second half of this manual presents general guidelines and selection criteria for rivets and lockbolts.			
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