

ASME B18.2.1-2012

(Revision of ASME B18.2.1-2010)

Square, Hex, Heavy Hex, and Askew Head Bolts and Hex, Heavy Hex, Hex Flange, Lobed Head, and Lag Screws (Inch Series)

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Errata
to
ASME B18.2.1-2012
Square, Hex, Heavy Hex, and Askew Head Bolts
and Hex, Heavy Hex, Hex Flange, Lobed Head,
and Lag Screws (Inch Series)

The errata corrections listed below apply to ASME B18.2.1-2012. These corrections will be incorporated into the next edition of B18.2.1.

<i>Page</i>	<i>Location</i>	<i>Change</i>
15	Table 8	In Note (3), formula for " L_G , max." corrected (see overleaf)
19	4.9(c)(1)	"SAE" corrected to read "SAE J429"
24	Table 14	Datum "A" added to straightness callout for consistency with Tables 1, 3, 4, 5, 7, and 8 (see overleaf)

THE AMERICAN SOCIETY OF MECHANICAL ENGINEERS
Two Park Avenue, New York, NY 10016-5990

July 2013



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Table 8 Dimensions of Hex Flange Screws (Cont'd)

Nominal Size or Basic Major Diameter of Thread		Minimum Bearing Diam., B_1	Maximum Runout of Bearing Surface FIM	Basic Thread Length, L_T [Note (3)]		Maximum Transition Thread Length, Y [Notes (3) and (4)]		Ring T		Ring B	
				For Screws With $L \leq$ 6 in.	For Screws With $L >$ 6 in.	For Screws With $L \leq$ 6 in.	For Screws With $L >$ 6 in.	Inside Diameter +0.0000 −0.0003	Minimum Thickness	Inside Diameter +0.0000 −0.0003	Thickness +0.0000 −0.0003
$\frac{1}{4}$	0.2500	0.480	0.010	0.750	1.000	0.400	0.650	0.4093	0.500	0.4380	0.1186
$\frac{5}{16}$	0.3125	0.600	0.011	0.875	1.125	0.417	0.667	0.5483	0.500	0.5820	0.1457
$\frac{3}{8}$	0.3750	0.730	0.012	1.000	1.250	0.438	0.688	0.6183	0.500	0.6550	0.1729
$\frac{7}{16}$	0.4375	0.850	0.013	1.125	1.375	0.464	0.714	0.6853	0.500	0.7300	0.2100
$\frac{1}{2}$	0.5000	0.980	0.014	1.250	1.500	0.481	0.731	0.8253	0.500	0.8750	0.2371
$\frac{9}{16}$	0.5625	1.100	0.015	1.375	1.625	0.750	0.750	0.8953	0.500	0.9500	0.2643
$\frac{5}{8}$	0.6250	1.230	0.017	1.500	1.750	0.773	0.773	1.0343	0.500	1.0950	0.2914
$\frac{3}{4}$	0.7500	1.470	0.020	1.750	2.000	0.800	0.800	1.2343	0.500	1.3120	0.3557

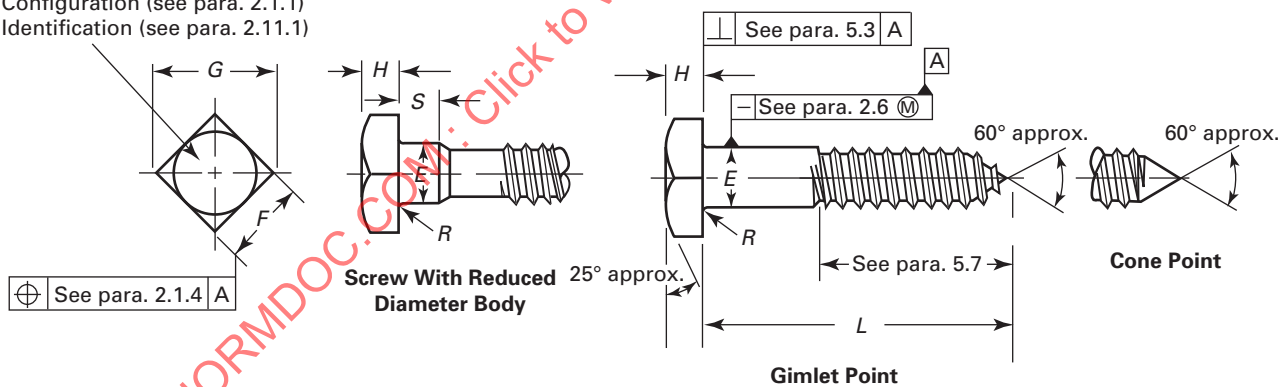
GENERAL NOTE: Refer to section 4 for further information.

NOTES:

- (1) Head acceptability shall be determined using the two rings described in Table 8. Ring B shall be placed on the screw head followed by Ring T. The head is acceptable if Ring T does not contact Ring B after both rings are in place on the head.
- (2) The top surface of the flange shall be conical or slightly rounded (convex). Radius, R_2 , applies both at the corners and at the flats of the hexagon. The contour of edge at flange periphery, between the maximum flange diameter, B , max., and the minimum bearing circle diameter, B_1 , min., shall be optional provided that the minimum flange edge thickness, K , min., is maintained at the minimum bearing circle diameter, B_1 , min.
- (3) L_G , max. = L_{nom} - L_T ; L_B , min. = L_G , max. - Y (see para. 4.7)
- (4) Use Y dimensions in Table 8 for the calculation of L_G , max./ L_B , min. (see para. 4.7) instead of following Table 12.

Table 14 Dimensions of Square Lag Screws

Configuration (see para. 2.1.1)
Identification (see para. 2.11.1)



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**The American Society of
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FOREWORD

American National Standards Committee B18 for the standardization of bolts, screws, nuts, rivets, and similar fasteners was organized in March 1922 as Sectional Committee B18, under the aegis of the American Engineering Standards Committee [AESC, later the American Standards Association (ASA), then the United States of America Standards Institute (USASI), and, as of October 6, 1969, the American National Standards Institute (ANSI)], with the Society of Automotive Engineers (SAE International) and The American Society of Mechanical Engineers (ASME) as joint sponsors. Subcommittee 2 was subsequently established and charged with the responsibility for technical content of standards covering wrench head bolts and nuts.

Subcommittee 2, after appraisal of the requirements of industry, developed a proposed standard series of bolt head and nut dimensions. This proposal was finally approved and designated a tentative American Standard in February 1927.

A first revision of the document was designated as an American Standard in March 1933 and was followed by a second revision that was granted approval as an American Standard in January 1941.

Following reorganization of the B18 Committee in 1947, Subcommittee 2 was asked to expand the standard on head proportions into a complete product standard. A proposal covering square and hexagon head bolts and nuts, hexagon head cap screws, and automotive hexagon head bolts was prepared and submitted to the B18 Committee in April 1950. While this draft was under consideration, the B18 Committee received a proposal from the British Standards Institution (BSI) for unification of dimensions on products incorporating Unified screw threads. The Committee welcomed the opportunity to discuss the proposals and an American-British-Canadian Conference was held in New York on June 1 and June 2, 1950.

It was agreed in the conference that the essentials of unification could be accomplished by selection of mutually satisfactory across-the-flats dimensions, since this would permit the use of the same wrenches and because other features would rarely affect interchangeability. After due consideration, suitable existing across-the-flats dimensions were selected for the hexagon products affected.

In its meeting of October 13, 1950, Subcommittee 2 agreed to incorporate in the proposed standard the conference recommendations on $\frac{1}{4}$ -in. hexagon head bolts, $\frac{5}{8}$ -in. hexagon head cap screws and automotive hexagon head bolts, $\frac{5}{16}$ -in. and $\frac{3}{8}$ -in. regular hexagon and square nuts, and $\frac{7}{16}$ -in. light and regular hexagon and square nuts. At a subsequent meeting of Subcommittee 2, further changes were adopted in order to combine the light and regular series of nuts and to combine the automotive hexagon head bolt, hexagon head cap screw, and regular hexagon head close tolerance bolt.

In view of the progress made in the United States and the urgency of standardization for mutual defense, BSI sponsored a second conference in London in April 1951 to complete the unification of certain hexagon bolts and nuts.

At a meeting on June 8, 1951, Subcommittee 2 reaffirmed its acceptance of the unified dimensions, which corresponded with those in the March 1951 draft, but attempted to select better nomenclature for the unified products. A final draft incorporating the nomenclature "Finished Hexagon Bolts and Nuts" and containing numerous editorial changes was submitted for letter ballot in September 1951. Following approval by the B18 Committee and the sponsors, the proposal was presented to ASA for approval and designation as an American Standard. This was granted on March 24, 1952.

Recognizing the Standard was in need of additional refinements, Subcommittee 2 immediately began to revise it, removing inconsistencies with respect to fillets, improving the length tolerances on heavy hexagon bolts, and incorporating numerous other corrections and clarifications. The most noteworthy editorial change was a decision to combine the coverage for hexagon cap screws and square head set screws from the B18.2 Standard with the coverage for slotted head cap screws and slotted headless set screws from the B18.6 Standard and publish them in a separate

document. The requirements for the unified hexagon cap screws and finished hexagon bolts being identical in the overlapping sizes, these data would now be available in two publications. Following approval by the B18 Committee and sponsor organizations, the proposal was submitted to ASA and declared an American Standard on February 2, 1955.

A revision of this document comprised of numerous editorial corrections and inclusion of an appendix for grade markings was duly approved and designated an American Standard on April 18, 1960.

At a meeting in February 1960, Subcommittee 2 approved a recommendation to reduce the head heights for heavy, heavy semifinished, and heavy finished hexagon bolts that was subsequently approved by letter ballot of the B18 Committee on August 16, 1960. A proposed standard for heavy hexagon structural bolts submitted and accepted by Subcommittee 2 at its meeting on October 17, 1960 was approved by letter ballot of the B18 Committee on May 9, 1961. To meet the urgent needs of the steel construction industry, it was considered necessary to publish the Standard for the structural bolts immediately. Consequently, Appendix IV to ASA B18.2-1960, containing coverage for the revised heavy hexagon bolts and the new heavy hexagon structural bolts, was released in 1962. In October of 1961, Subcommittee 2 appointed a subgroup to review all product standards for square and hexagon bolts, screws, and nuts and to recommend simplifications that would be compatible with technical, production, and distribution advances that had occurred over the prior several years. The subgroup presented its recommendations at a meeting of Subcommittee 2 in October of 1962. It was agreed that the internally and externally threaded products should be published in separate documents as suggested, and draft proposals for each were completed.

The proposed revision for square and hex bolts and screws incorporated the following subgroup recommendations: consolidation of hexagon head cap screws and finished hexagon bolts into a single product, consolidation of heavy semifinished hexagon bolts and heavy finished hexagon bolts into a single product, elimination of regular semifinished hexagon bolts, a new length tolerancing pattern for all bolts and screws, documentation of a positive identification procedure for determining whether an externally threaded product should properly be designated a bolt or a screw, and an abbreviated and purified set of product nomenclature reflecting application of the identification procedure. Letter ballot of this proposal to the B18 Committee in March 1964 resulted in several comments that were resolved to the satisfaction of the committee in June of 1964. Following acceptance by the sponsor organizations, the revision was submitted to ASA and was designated American Standard ASA B18.2.1 on September 8, 1965.

Subcommittee 2 continued to further develop refinements initiated by the simplification subgroup and revisions reflecting changes in manufacturing practices and consumer requirements. This work culminated in Subcommittee acceptance of a 1970 proposal incorporating, in addition to numerous editorial changes, revisions in the following significant areas: addition of coverage for askew head bolts and hex head lag screws, addition of straightness requirements to applicable products, addition of minimum fillet to square and hex bolts and lag screws, application of UNR threads and new concepts for controlling thread length on products having Unified threads, and clarification of grade markings, thread runout gages, and formulas for dimensions. Also included were refinements to hex cap screw and heavy hex screw requirements consisting of the addition of wrenching height and revision of underhead fillets, washer face thicknesses, and controls on angularity of bearing face. The proposed revision, after approval by letter ballot of the B18 Committee in March 1970, was subsequently approved by the sponsors and submitted to ANSI for designation as an American National Standard. This was granted on January 18, 1972.

Numerous user complaints on interference of the elliptical fillet added in the 1972 revision resulted in the appointment of a subcommittee to study the problem. They recommended reverting back to the maximum/minimum radius fillet specified in the 1965 version with the elliptical fillet retained for use when specified by the user. Further refinements in the definition of the fillet for short length screws were added to "Hex Cap and Heavy Hex Screws." Geometric tolerancing was updated to conform to American National Standard Y14.5. The transition length of the hex cap screw was changed to equal five coarse (UNC) threads. Few, if any, users accepted the 1972 values that were designed to reduce tooling by providing the same body length for adjacent lengths. On screws, separate straightness requirements were deleted, and the combination thread runout and straightness gage described in Mandatory Appendix I was specified.

Straightness as a variable based on length was applied to bolts with gaging described in Appendix 11. Acceptability of screw threads based on gaging systems established by American National Standard B1.3-1979 were added to each type of screw or bolt, except lag screws. This proposal was approved by letter ballot of the Subcommittee and B18 in January 1980. Following acceptance by the secretariat organizations, the revision was referred to ANSI and granted recognition as an American National Standard on June 24, 1981.

In 1991, it was recognized that B18.2.1 required extensive revision to better meet the needs of conformance with Public Law 101-592. Included in these considerations were improved definition of a full body versus a reduced body and those dimensions that should be certified to ensure product fit, form, and function. Other dimensions given for each product would only be examined in the event of a dispute. Also, the term "finished hex bolt," which is today's cap screw, was dropped. Additionally, a weight table was included to assist users.

Furthermore, it was felt that the heavy hex structural bolt, heavy hex nut, hardened steel washers, and compressible washer-type direct tension indicators should be included in a new standard for fasteners intended for use in structural applications. For this reason, the heavy hex structural bolt was removed from this Standard. The new table for maximum grip gaging lengths and minimum body lengths for cap screws and heavy hex screws was included for the first time in the 1996 edition to assist users and is similar to the pattern used for metric bolts and screws.

Subcommittee 2 agreed to undertake the revision of B18.2.1 during the first quarter of 2008. The Standard was updated to incorporate the new format and additional sections as refined in ASME B18.12.1. The notes that had followed every table were reorganized into the body of the Standard to eliminate the redundancy created by repeating the same table notes under numerous tables. This revision added flange head and lobed head screws and extended the size range of heavy hex head cap screws from 3 in. to 6 in. in diameter. The thread details for lag screws were redefined to align with the way all other spaced threads are defined. Designated inspection characteristics were eliminated from each product type, and a general section on quality assurance was created stating that all products must meet the requirements in the Standard according to ASME B18.18.2. The title of the Standard was revised to indicate that the flange head and lobed head screws were added to the Standard.

Since the publication of the 2010 revision, a number of issues were brought to the attention of the B18.2 Subcommittee that needed correcting.

(a) The location of the left-hand dimension line for L_G , L_B , and L for cut thread hex cap screws on the illustrations for Tables 6 and 7 were corrected by moving them to the bottom of the washer face. The basic head heights for $2\frac{1}{2}$ and $2\frac{3}{4}$ on Table 7 were corrected to read $1\frac{17}{32}$ and $1\frac{11}{16}$, respectively.

(b) The most significant revisions are related to Table 8 and the associated illustration for hex flange head screws. The illustration had notes connected to the L_G , L_B , and L_T dimensions that referred to para. 4.7, which then referred to Table 12, that were in error. Since the Y transition length dimension for hex flange head screws is different from hex cap screws, Table 12 is not applicable to hex head flange screws. Notes (3) and (4) have been added to Table 8 that define how to calculate L_G and L_B based on the specified L_T and Y dimensions. Also in Table 8, dimensional errors were listed for the inspection rings designated Ring T and Ring B. This revision corrects those dimensions. After the publication of the corrections to the dimensions for flange head screws, the Industrial Fasteners Institute standard IFI-111, which preceded the addition to this Standard, was withdrawn.

(c) In Table 12, the L_B lengths for $\frac{1}{2} \times 11$, $1\frac{1}{4} \times 11$, and $1\frac{1}{4} \times 12$ were corrected to read 9.12, 7.29, and 8.29, respectively.

(d) Paragraph 2.13 was expanded to explain that ASME B18.18 covers dimensional inspection requirements and that chemical and physical requirements are covered by the material standard designated in the purchaser's part designation.

Suggestions for improvement of this Standard will be welcomed. They should be sent to The American Society of Mechanical Engineers, Secretary, B18 Main Committee, Two Park Avenue, New York, NY 10016-5990.

This revision was approved as an American National Standard on December 22, 2012.

ASME B18 COMMITTEE

Standardization of Bolts, Nuts, Rivets, Screws, Washers, and Similar Fasteners

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Edition:	Cite the applicable edition of the Standard for which the interpretation is being requested.
Question:	Phrase the question as a request for an interpretation of a specific requirement suitable for general understanding and use, not as a request for an approval of a proprietary design or situation. The inquirer may also include any plans or drawings that are necessary to explain the question; however, they should not contain proprietary names or information.

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SQUARE, HEX, HEAVY HEX, AND ASKEW HEAD BOLTS AND HEX, HEAVY HEX, HEX FLANGE, LOBED HEAD, AND LAG SCREWS (INCH SERIES)

1 INTRODUCTION

1.1 Scope

1.1.1 This Standard covers the dimensional requirements for nine product types of inch series bolts and screws recognized as American National Standard. Also included are appendices covering gaging procedures, grade markings for bolts and screws, formulas on which dimensional data are based, and a specification to assist in identifying a product as being a screw or a bolt. Where questions arise concerning acceptance of product, the dimensions in the tables shall govern over recalculation by formula. Heavy hex structural bolts, formerly covered in ASME B18.2.1, are now covered in ASME B18.2.6.

1.1.2 The inclusion of dimensional data in this Standard is not intended to imply that all of the products described herein are stock production sizes. Consumers should consult with suppliers concerning lists of stock production sizes.

1.2 Comparison With ISO Standards

Since these are inch fastener standards, there are no comparable ISO standards.

1.3 Dimensions

All dimensions in this Standard are in inches and apply to unplated or uncoated product. When plating or coating is specified, the finished product dimensions shall be as agreed upon between supplier and purchaser. Where nominal sizes are expressed in decimals, zeros preceding the decimal and zeros in the fourth decimal place shall be omitted.

Symbols specifying geometric characteristics are in accord with ASME Y14.5.

1.4 Options

Where specified, options shall be at the discretion of the manufacturer unless otherwise agreed upon by the manufacturer and purchaser.

1.5 Terminology

As used in this Standard, "short bolt" or "short screw" means a bolt or screw of a diameter-length combination

that is required to be threaded for full length, whereas "long bolt" or "long screw" means a bolt or screw of a diameter-length combination that is not threaded for full length.

body length, L_B : the distance measured parallel to the axis of the bolt or screw from the underhead bearing surface to the last scratch of thread or, for rolled threads, to the top of the extrusion angle. Where specified, the minimum body length, L_B , min., is a criterion for inspection.

grip gaging length, L_G : the distance measured parallel to the axis of the bolt or screw from the underhead bearing surface to the face of the appropriate noncountersunk, noncountersunk special GO thread ring gage, assembled by hand as far as the thread will permit. The maximum grip gaging length, L_G , max., is a criterion for inspection.

point length: the length from the pointed end to the first fully formed thread at major diameter as determined by the distance that the point enters into a cylindrical NOT GO major diameter ring gage (refer to Gage 3.1 in ASME B1.2).

thread length: the length from the extreme point of the bolt or screw to the last complete (full form) thread. For bolts and screws in this Standard, other than lag screws, the nominal thread length, L_T , is a reference dimension intended for calculation purposes only.

transition thread length, Y : the length that includes the length of incomplete threads, the extrusion angle on rolled threads, and tolerances on grip length. Where specified, transition thread length is a reference dimension intended for calculation purposes only.

For definitions of terminology not specified in this Standard, refer to ASME B18.12.

1.6 Referenced Standards

The following is a list of publications referenced in this Standard.

- ASME B1.1, Unified Inch Screw Threads (UN and UNR Thread Form)
- ASME B1.2, Gages and Gaging for Unified Inch Screw Threads

ASME B1.3, Screw Thread Gaging Systems for Acceptability: Inch and Metric Screw Threads (UN, UNR, UNJ, M, and MJ)

ASME B18.2.6, Fasteners for Use in Structural Applications

ASME B18.2.8, Clearance Holes for Bolts, Screws, and Studs

ASME B18.2.9, Straightness Gage and Gaging for Bolts and Screws

ASME B18.12, Glossary of Terms for Mechanical Fasteners

ASME B18.18, Quality Assurance for Fasteners

ASME B18.24, Part Identifying Number (PIN) Code System for B18 Fastener Products

ASME B94.11M, Twist Drills

ASME Y14.5, Dimensioning and Tolerancing

Publisher: The American Society of Mechanical Engineers (ASME), Two Park Avenue, New York, NY 10016-5990; Order Department: 22 Law Drive, P.O. Box 2900, Fairfield, NJ 07007-2900 (www.asme.org)

ASTM A193, Standard Specification for Alloy-Steel and Stainless Steel Bolting Materials for High Temperature or High Pressure Service and Other Special Purpose Applications

ASTM A307, Standard Specification for Carbon Steel Bolts and Studs, 60 000 PSI Tensile Strength

ASTM A320, Standard Specification for Alloy-Steel and Stainless Steel Bolting for Low-Temperature Service

ASTM A354, Standard Specification for Quenched and Tempered Alloy Steel Bolts, Studs, and Other Externally Threaded Fasteners

ASTM A449, Standard Specification for Hex Cap Screws, Bolts and Studs, Steel, Heat Treated, 120/105/90 ksi Minimum Tensile Strength, General Use

ASTM F468, Standard Specification for Nonferrous Bolts, Hex Cap Screws, and Studs for General Use

ASTM F593, Standard Specification for Stainless Steel Bolts, Hex Cap Screws, and Studs

ASTM F788/F788M, Standard Specification for Surface Discontinuities of Bolts, Screws, and Studs, Inch and Metric Series

ASTM F1941, Standard Specification for Electrodeposited Coatings on Threaded Fasteners [Unified Inch Screw Threads (UN/UNR)]

Publisher: American Society for Testing and Materials (ASTM International), 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959 (www.astm.org)

MIL-F-18240, Fastener Element, Self-Locking, Threaded Fastener, 250°F Maximum

MS15981, Fasteners, Externally Threaded, Self-Locking, Design and Usage Limitations for

Publisher: Department of Defense, Defense Logistics Agency, Andrew T. McNamara Building, 8725 John J.

Kingman Road, Fort Belvoir, VA 22060-6221 (www.dla.mil)

SAE J429, Mechanical and Material Requirements for Externally Threaded Fasteners

Publisher: Society of Automotive Engineers (SAE International), 400 Commonwealth Drive, Warrendale, PA 15096 (www.sae.org)

2 GENERAL DATA FOR BOTH BOLTS AND SCREWS

2.1 Heads

2.1.1 Top of Head. Top of head shall be full form and chamfered, with the diameter of chamfer circle equal to the maximum width across flats, on square or hex head products and the "B" dimension shown in Table 9 for lobed head screws with a tolerance of -15% .

2.1.2 Width Across Flats. The width across flats of head shall be the overall distance measured perpendicular to the axis of product between two opposite sides of the head in accordance with the notes in respective dimensional tables.

2.1.3 Head Height. The head height shall be the overall distance measured parallel to the axis of product from the top of the head to the bearing surface and shall include the thickness of the washer face where provided.

2.1.4 True Position of Head. The true position of the head shall be no greater than 6% of the maximum width across flats or lobes. For referee purposes, the evaluation shall be made by holding the body in a collet or chuck one bolt diameter from under the head and rotating the part. With the indicator in line with the axis of the bolt or screw, find and record the lowest point on each flat or the highest point on each lobe. The true position is one-half of the largest absolute difference between the high and low values for any opposing set of flats or lobes.

2.2 Bolt or Screw Length

The bolt or screw length shall be the distance measured parallel to the axis of product from the bearing surface of the head to the extreme end of the bolt or screw, including the point if the product is pointed.

2.3 Body Diameter

The body diameter minimum/maximum limits are defined in each of the respective applicable tables. Unless otherwise specified by the purchaser, the body style supplied shall be full-size body.

NOTES:

- (1) Only bolts and lag screws are permitted to have die seams on their body that exceed the body diameter. Die seams on the body and all other styles of screws that exceed the body diameter are not permitted.
- (2) For recommended clearance of hole sizes for bolts and screws, refer to ASME B18.2.8.

2.4 Points

Unless otherwise specified, bolts need not be pointed. Products designated as screws, with the exception of lag screws, are required to have a chamfered point. The chamfer angle may vary depending on the manufacturing process. When specified, the chamfer angle should be considered a reference dimension only. The presence of a point is to reduce the possibility of damage to the leading threads and to promote ease of assembly with a tapped hole or nut. Point features not defined in a given product standard are at the discretion of the manufacturer.

2.5 Threads

2.5.1 Thread Standard. Threads on all products in this Standard except lag screws shall meet the requirements of ASME B1.1. Lag screw thread dimensions are specified in Table 16.

2.5.2 Thread Class. Unless otherwise specified, size limits for standard external thread Class 2A apply prior to coating. The external thread allowance may be used to accommodate the coating thickness on plated or coated parts, provided that the maximum coating thickness is no more than one-fourth of the allowance. Thus, the thread after plating or coating is subject to acceptance using a basic size Class 3A GO thread gage and a Class 2A NOT GO size thread gage.

2.5.3 Thread Series. Thread series on all bolts and screws may be coarse (UNC), fine (UNF), or 8 thread series (8 UN), except askew head bolts, which shall be unified coarse (UNC) only, and lag screws, which are specified in Table 16.

2.5.4 Incomplete Thread Diameter. The major diameter of incomplete thread shall not exceed the actual major diameter of the full form thread.

2.5.5 Thread Acceptability. Unless otherwise specified by the purchaser, dimensional acceptability of screw threads shall be determined using thread gaging System 21 in ASME B1.3.

2.6 Straightness

Shanks of bolts and screws shall be straight within the following limits at maximum material condition (MMC). For bolts or screws with nominal lengths up to and including 12 in., the maximum camber shall be 0.006 in./in. (0.006L) of bolt or screw length. For bolts and screws with nominal lengths over 12 in. up to and including 24 in., the maximum camber shall be 0.008 in./in. (0.008L) of bolt or screw length. For inspection, the camber allowance shall be added to the maximum body diameter or maximum major diameter of the thread, whichever is greater. A typical gage and gaging procedure for checking bolt and screw straightness are given in ASME B18.2.9.

2.7 Optional Machining: Countersunk Center Holes, Locking Elements, and Drilled Holes

For parts that require machining, it may be necessary to provide support with a countersunk center hole in the threaded end. Unless otherwise specified by the purchaser, the drill size and depth shall be in accordance with Nonmandatory Appendix C.

For the location of locking elements and the guide for the cross-drilling of heads, refer to Nonmandatory Appendix D.

2.8 Materials

Standard materials for various configurations of bolts and screws are identified in paras 3.8, 4.9, and 5.8. When materials and/or grades other than those in the applicable notes are required, the purchaser must clearly specify them in the purchase documents.

2.9 Finish

Unless otherwise specified, bolts and screws shall be supplied with a plain (as processed) finish, unplated, or uncoated. Light oil on the surface is permissible to avoid corrosion during transportation, packaging, and further handling.

2.10 Workmanship

Surface discontinuities shall be in accordance with the requirements of the applicable fastener material standard. The purchaser may specify additional surface discontinuity requirements for screws and bolts when tighter control of surface discontinuities is required or when discontinuity limits are not specified in the applicable fastener material standard.

2.11 Designation

2.11.1 Bolts and screws shall be designated by the following data in the sequence shown:

- product name
- nominal size (fractional or decimal equivalent)
- threads per inch (omit for lag screws)
- product length (fractional or decimal equivalent)
- material, including specification where necessary
- protective finish, if required

See the following examples:

EXAMPLES:

- Square Head Bolt per ASME B18.2.1, $\frac{3}{8}$ – 16 × 1½. Steel per ASTM A 307 Grade A, Zinc plated per ASTM F 1941 Fe/Zn 3A
- Hex Cap Screw per ASME B18.2.1, $\frac{1}{2}$ – 13 × 4. ASTM A 354 Grade BD, plain finish
- Hex Lag Screw per ASME B18.2.1, 0.75 × 5.00, Stainless Steel per ASTM F 593, Group 1, Condition CW (304)

2.11.2 For a recommended part identification number (PIN) system for B18 fasteners, see ASME B18.24.

2.12 Grade and Manufacturer's Identification

2.12.1 Identification Symbols. Identification marking symbols on products included in this Standard shall be raised or indented at the manufacturer's option unless otherwise specified. Markings shall be legible to the unaided eye with the exception of corrective lenses. When raised, the height of the marking may not exceed 0.015 in. over the specified maximum head height for bolts $\frac{5}{8}$ in. and smaller. For bolts larger than $\frac{5}{8}$ in., the marking may not project more than 0.030 in. over the specified maximum head height. When indented, the depth of the marking shall not reduce the load-carrying capacity of the fastener.

2.12.2 Grade Symbols. Each of the products included in this Standard shall be marked in accordance with the requirements of the applicable specification for its material, mechanical, or performance requirements.

2.12.3 Source Symbols. Each of the products included in this Standard shall be marked in accordance with the requirements of the applicable specification for its material, mechanical, or performance requirements to identify its source, manufacturer, or private label distributor.

2.13 Quality Assurance

Unless otherwise specified, manufacturers shall provide bolts and screws in accordance with ASME B18.18, Category 2 for dimensions, plus the products shall comply with all of the requirements of the material standard referenced in the purchaser's product designation (see para. 2.11).

3 BOLTS

Square head, hex, heavy hex, and askew head bolts are presented in Tables 1 through 4, respectively.

3.1 Surface Condition

Bolts need not be finished on any surface except threads.

3.2 Head Taper

Maximum width across flats and corners shall not be exceeded. No transverse section through the head between 25% and 75% of actual head height, as measured from the bearing surface, shall be less than the minimum across flats and corners requirements. (This is not applicable to askew head bolts.)

3.3 Bearing Surface

A die seam across the bearing surface of bolts is permissible. Bearing surface shall be perpendicular to the axis of the body within a tolerance of 3 deg for 1-in. size and smaller, and 2 deg for sizes larger than 1 in. Angularity and head height measurement shall be taken

at a location to avoid interference with die seams. When specified by the purchaser, the die seam shall be removed. Upon completion of the machining, all geometric requirements specified for the bearing surface and head height shall be met. For askew head bolts, see Note (1) in Table 4.

3.4 Body Diameter

Any swell or fin under the head or any die seam on the body shall not exceed the basic bolt diameter by more than the following, unless otherwise agreed to between purchaser and supplier:

- (a) 0.030 in. for sizes up through $\frac{1}{2}$ in.
- (b) 0.050 in. for sizes over $\frac{1}{2}$ in. through $\frac{3}{4}$ in.
- (c) 0.060 in. for sizes over $\frac{3}{4}$ in. through $1\frac{1}{2}$ in.
- (d) 0.090 in. for sizes over $1\frac{1}{2}$ in.

The diameter of the unthreaded length on bolts that are threaded for full length shall not be less than the minimum pitch diameter of the thread nor greater than the maximum body diameter, E , max., specified in Tables 1 through 4.

3.5 Reduced Diameter Body

When specified by the purchaser, bolts may be supplied in the reduced diameter body style. These shall have a body diameter of not less than the minimum pitch diameter of the thread and not exceeding the minimum body diameter, E , min., shown in Tables 1 through 4. Any swell or fin under the head or any die seam on the body shall not exceed E , min. by more than the following, unless otherwise agreed to between the purchaser and the supplier:

- (a) 0.030 in. for sizes up through $\frac{1}{2}$ in.
- (b) 0.050 in. for sizes over $\frac{1}{2}$ in. through $\frac{3}{4}$ in.
- (c) 0.060 in. for sizes over $\frac{3}{4}$ in. through $1\frac{1}{2}$ in.
- (d) 0.090 in. for sizes over $1\frac{1}{2}$ in.

3.6 Length Tolerance

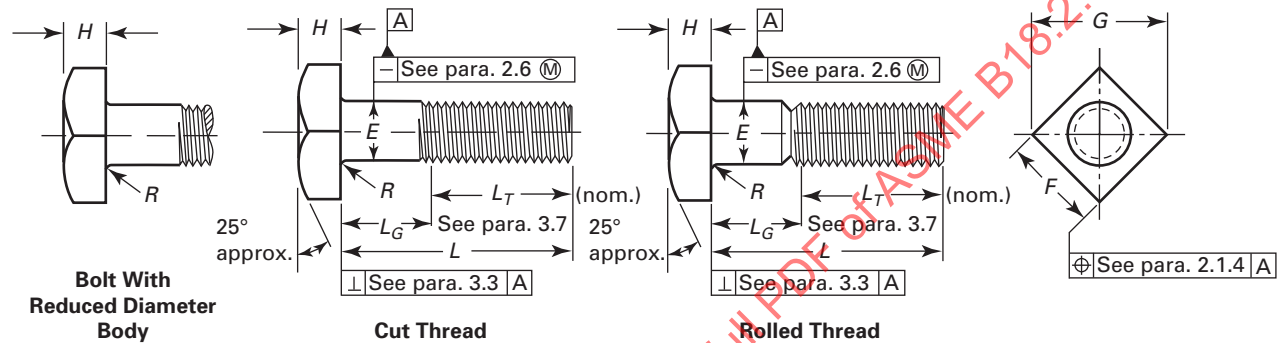
Bolt length tolerances are given in Table 5.

3.7 Thread Length

Nominal thread length, L_T , is a reference dimension intended for calculation purposes only. L_T equals twice the basic thread diameter +0.25 in. for nominal bolt lengths up to and including 6 in., and twice the basic thread diameter +0.50 in. for nominal lengths over 6 in.

The length of thread on bolts shall be controlled by the grip gaging length, L_G . The maximum grip gaging length, L_G , max., as calculated and rounded to two decimal places for any bolt not threaded full length, shall be equal to the nominal bolt length, L , nom., minus L_T (L_G , max. = L , nom. - L_T) with a tolerance of minus a length equal to five coarse thread pitches. This represents the minimum design grip length of the joint and shall be used as the criterion for inspection and determining

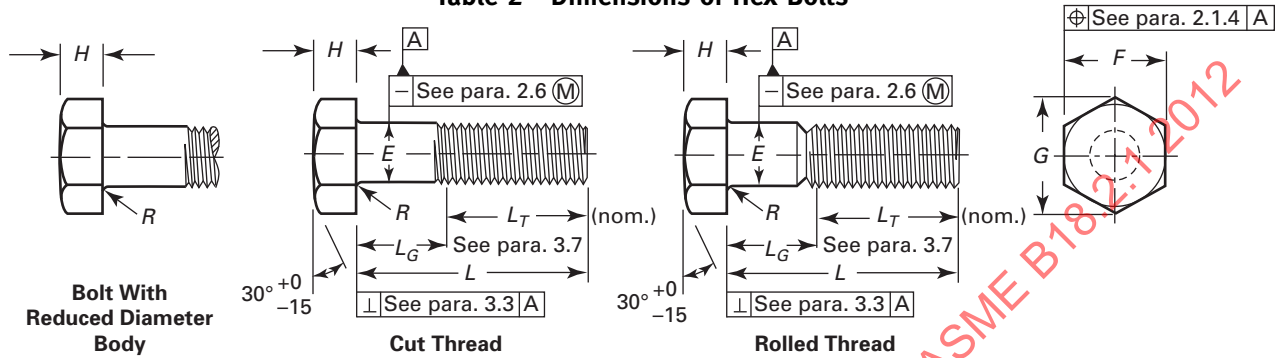
Table 1 Dimensions of Square Head Bolts



Nominal Size or Basic Product		Full-Size Body Diameter, <i>E</i> (See Paras. 3.4 and 3.5)		Width Across Flats, <i>F</i> (See Para. 2.1.2)			Width Across Corners, <i>G</i>		Head Height, <i>H</i>			Radius of Fillet, <i>R</i>		Nominal Thread Length for Bolt Lengths, <i>L_T</i> (See Para. 3.7)	
														6 in. and Shorter	Over 6 in.
		Diameter	Max.	Min.	Basic	Max.	Min.	Max.	Min.	Basic	Max.	Min.	Max.	Min.	
1/4	0.2500	0.260	0.237	3/8	0.375	0.362	0.530	0.498	11/64	0.188	0.156	0.03	0.01	0.750	1.000
5/16	0.3125	0.324	0.298	1/2	0.500	0.484	0.707	0.665	13/64	0.220	0.186	0.03	0.01	0.875	1.125
3/8	0.3750	0.388	0.360	9/16	0.562	0.544	0.795	0.747	1/4	0.268	0.232	0.03	0.01	1.000	1.250
7/16	0.4375	0.452	0.421	5/8	0.625	0.603	0.884	0.828	19/64	0.316	0.278	0.03	0.01	1.125	1.375
1/2	0.5000	0.515	0.482	3/4	0.750	0.725	1.061	0.995	21/64	0.348	0.308	0.03	0.01	1.250	1.500
5/8	0.6250	0.642	0.605	15/16	0.938	0.906	1.326	1.244	27/64	0.444	0.400	0.06	0.02	1.500	1.750
3/4	0.7500	0.768	0.729	1 1/8	1.125	1.088	1.591	1.494	1/2	0.524	0.476	0.06	0.02	1.750	2.000
7/8	0.8750	0.895	0.852	1 1/4	1.312	1.269	1.856	1.742	19/32	0.620	0.568	0.06	0.02	2.000	2.250
1	1.0000	1.022	0.976	1 1/2	1.500	1.450	2.121	1.991	21/32	0.684	0.628	0.09	0.03	2.250	2.500
1 1/8	1.1250	1.149	1.098	1 11/16	1.688	1.631	2.386	2.239	3/4	0.780	0.720	0.09	0.03	2.500	2.750
1 1/4	1.2500	1.277	1.223	1 7/8	1.875	1.812	2.652	2.489	27/32	0.876	0.812	0.09	0.03	2.750	3.000
1 3/8	1.3750	1.404	1.345	2 1/16	2.062	1.994	2.917	2.738	29/32	0.940	0.872	0.09	0.03	3.000	3.250
1 1/2	1.5000	1.531	1.470	2 1/4	2.250	2.175	3.182	2.986	1	1.036	0.964	0.09	0.03	3.250	3.500

GENERAL NOTE: Refer to section 3 for further information.

Table 2 Dimensions of Hex Bolts



Nominal Size or Basic Product Diameter		Full-Size Body Diameter, <i>E</i> (See Paras. 3.4 and 3.5)		Width Across Flats, <i>F</i> (See Para. 2.1.2)			Width Across Corners, <i>G</i>		Head Height, <i>H</i>			Radius of Fillet, <i>R</i>		Nominal Thread Length for Bolt Lengths, <i>L_T</i> (See Para. 3.7)	
														6 in. and Shorter	Over 6 in.
		Max.	Min.	Basic	Max.	Min.	Max.	Min.	Basic	Max.	Min.	Max.	Min.		
1/4	0.2500	0.260	0.237	7/16	0.438	0.425	0.505	0.484	11/64	0.188	0.150	0.03	0.01	0.750	1.000
5/16	0.3125	0.324	0.298	1/2	0.500	0.484	0.577	0.552	7/32	0.235	0.195	0.03	0.01	0.875	1.125
3/8	0.3750	0.388	0.360	9/16	0.562	0.544	0.650	0.620	1/4	0.268	0.226	0.03	0.01	1.000	1.250
7/16	0.4375	0.452	0.421	5/8	0.625	0.603	0.722	0.687	19/64	0.316	0.272	0.03	0.01	1.125	1.375
1/2	0.5000	0.515	0.482	3/4	0.750	0.725	0.866	0.826	11/32	0.364	0.302	0.03	0.01	1.250	1.500
5/8	0.6250	0.642	0.605	15/16	0.938	0.906	1.083	1.033	27/64	0.444	0.378	0.06	0.02	1.500	1.750
3/4	0.7500	0.768	0.729	1 1/8	1.125	1.088	1.299	1.240	1/2	0.524	0.455	0.06	0.02	1.750	2.000
7/8	0.8750	0.895	0.852	1 5/16	1.312	1.269	1.516	1.447	37/64	0.604	0.531	0.06	0.02	2.000	2.250
1	1.0000	1.022	0.976	1 1/2	1.500	1.450	1.732	1.653	43/64	0.700	0.591	0.09	0.03	2.250	2.500
1 1/8	1.1250	1.149	1.098	1 11/16	1.688	1.631	1.949	1.859	3/4	0.780	0.658	0.09	0.03	2.500	2.750
1 1/4	1.2500	1.277	1.223	1 7/8	1.875	1.812	2.165	2.066	27/32	0.876	0.749	0.09	0.03	2.750	3.000
1 3/8	1.3750	1.404	1.345	2 1/16	2.062	1.994	2.382	2.273	29/32	0.940	0.810	0.09	0.03	3.000	3.250
1 1/2	1.5000	1.531	1.470	2 1/4	2.250	2.175	2.598	2.480	1	1.036	0.902	0.09	0.03	3.250	3.500
1 5/8	1.6250	1.658	1.591	2 7/16	2.438	2.356	2.815	2.616	1 3/32	1.116	0.978	0.09	0.03	3.500	3.750
1 3/4	1.7500	1.785	1.716	2 3/8	2.625	2.538	3.031	2.893	1 5/32	1.196	1.054	0.12	0.04	3.750	4.000
1 7/8	1.8750	1.912	1.839	2 13/16	2.812	2.719	3.248	3.099	1 1/4	1.276	1.130	0.12	0.04	4.000	4.250
2	2.0000	2.039	1.964	3	3.000	2.900	3.464	3.306	1 11/32	1.388	1.175	0.12	0.04	4.250	4.500
2 1/4	2.2500	2.305	2.214	3 3/8	3.375	3.262	3.897	3.719	1 1/2	1.548	1.327	0.19	0.06	4.750	5.000
2 1/2	2.5000	2.559	2.461	3 3/4	3.750	3.625	4.330	4.133	1 21/32	1.708	1.479	0.19	0.06	5.250	5.500
2 3/4	2.7500	2.827	2.711	4 1/8	4.125	3.988	4.763	4.546	1 13/16	1.869	1.632	0.19	0.06	5.750	6.000
3	3.0000	3.081	2.961	4 1/2	4.500	4.350	5.196	4.959	2	2.060	1.815	0.19	0.06	6.250	6.500
3 1/4	3.2500	3.335	3.210	4 7/8	4.875	4.712	5.629	5.372	2 3/16	2.251	1.936	0.19	0.06	6.750	7.000
3 1/2	3.5000	3.589	3.461	5 1/4	5.250	5.075	6.062	5.786	2 5/16	2.380	2.057	0.19	0.06	7.250	7.500
3 3/4	3.7500	3.858	3.726	5 5/8	5.625	5.437	6.495	6.198	2 1/2	2.572	2.241	0.19	0.06	7.750	8.000
4	4.0000	4.111	3.975	6	6.000	5.800	6.928	6.612	2 11/16	2.764	2.424	0.19	0.06	8.250	8.500

GENERAL NOTE: Refer to section 3 for further information.

Table 3 Dimensions of Heavy Hex Bolts

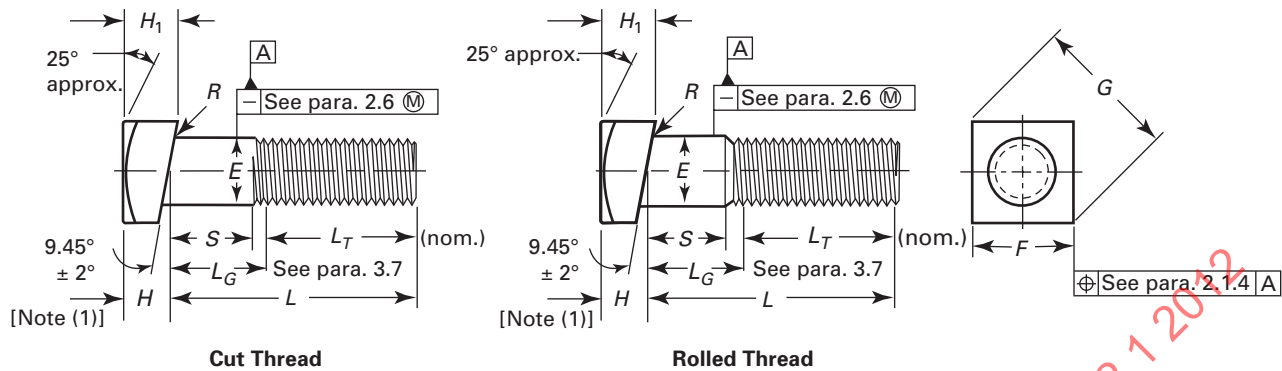
Bolt With Reduced Diameter Body

Cut Thread

Rolled Thread

Nominal Size or Basic Product Diameter	Full-Size Body Diameter, <i>E</i> (See Paras. 3.4 and 3.5)		Width Across Flats, <i>F</i> (See Para. 2.1.2)			Width Across Corners, <i>G</i>		Head Height, <i>H</i>			Radius of Fillet, <i>R</i>		Nominal Thread Lengths, <i>L_T</i> (See Para. 3.7)		
	Max.	Min.	Basic	Max.	Min.	Max.	Min.	Basic	Max.	Min.	Max.	Min.	6 in. and Shorter	Over 6 in.	
3/8	0.3750	0.388	0.360	1 1/16	0.688	0.669	0.794	0.763	1/4	0.268	0.226	0.03	0.01	1.000	1.250
1/2	0.5000	0.515	0.482	7/8	0.875	0.850	1.010	0.969	11/32	0.364	0.302	0.03	0.01	1.250	1.500
5/8	0.6250	0.642	0.605	1 1/16	1.062	1.031	1.227	1.175	27/64	0.444	0.378	0.06	0.02	1.500	1.750
3/4	0.7500	0.768	0.729	1 1/4	1.250	1.212	1.443	1.383	1/2	0.524	0.455	0.06	0.02	1.750	2.000
7/8	0.8750	0.895	0.852	1 7/16	1.438	1.394	1.660	1.589	37/64	0.604	0.531	0.06	0.02	2.000	2.250
1	1.0000	1.022	0.976	1 5/8	1.625	1.575	1.876	1.796	43/64	0.700	0.591	0.09	0.03	2.250	2.500
1 1/8	1.1250	1.149	1.098	1 13/16	1.812	1.756	2.093	2.002	3/4	0.780	0.658	0.09	0.03	2.500	2.750
1 1/4	1.2500	1.277	1.223	2	2.000	1.938	2.309	2.209	27/32	0.876	0.749	0.09	0.03	2.750	3.000
1 3/8	1.3750	1.404	1.345	2 3/16	2.188	2.119	2.526	2.416	29/32	0.940	0.810	0.09	0.03	3.000	3.250
1 1/2	1.5000	1.531	1.470	2 3/8	2.375	2.300	2.742	2.622	1	1.036	0.902	0.09	0.03	3.250	3.500
1 5/8	1.6250	1.658	1.591	2 9/16	2.562	2.481	2.959	2.829	1 3/32	1.116	0.978	0.09	0.03	3.500	3.750
1 3/4	1.7500	1.785	1.716	2 3/4	2.750	2.662	3.175	3.035	1 5/32	1.196	1.054	0.12	0.04	3.750	4.000
1 7/8	1.8750	1.912	1.839	2 15/16	2.938	2.844	3.392	3.242	1 1/4	1.276	1.130	0.12	0.04	4.000	4.250
2	2.0000	2.039	1.964	3 1/8	3.125	3.025	3.608	3.449	1 11/32	1.388	1.175	0.12	0.04	4.250	4.500
2 1/4	2.2500	2.305	2.214	3 1/2	3.500	3.388	4.041	3.862	1 1/2	1.548	1.327	0.19	0.06	4.750	5.000
2 1/2	2.5000	2.559	2.461	3 7/8	3.875	3.750	4.474	4.275	1 21/32	1.708	1.479	0.19	0.06	5.250	5.500
2 3/4	2.7500	2.827	2.711	4 1/4	4.250	4.112	4.907	4.688	1 13/16	1.869	1.632	0.19	0.06	5.750	6.000
3	3.0000	3.081	2.961	4 5/8	4.625	4.475	5.340	5.102	2	2.060	1.815	0.19	0.06	6.250	6.500

GENERAL NOTE: Refer to section 3 for further information.

Table 4 Dimensions of Askew Head Bolts

Nominal Size or Basic Product Diameter [Note (2)]	Body Diameter, <i>E</i> (See Para. 3.5)		Width Across Flats, <i>F</i> (See Para. 2.1.2)			Width Across Corners, <i>G</i>		Head Height, <i>H</i> ₁ [Note (3)]		Mid- height, <i>H</i> [Note (3)]	Radius of Fillet, <i>R</i>		Maximum Unthreaded Length, <i>S</i> [Note (4)]	Nominal Thread Length for Bolt Lengths, <i>L</i> _T [Note (4)]		
														6 in. and Shorter	Over 6 in.	
		Max.	Min.	Basic	Max.	Min.	Max.	Min.	Max.	Min.	Ref.	Max.	Min.			
³ / ₈	0.3750	0.388	0.360	⁹ / ₁₆	0.562	0.544	0.795	0.747	0.317	0.277	0.250	0.03	0.01	0.250	1.000	1.250
¹ / ₂	0.5000	0.515	0.482	³ / ₄	0.750	0.725	1.061	0.995	0.411	0.371	0.328	0.03	0.01	0.312	1.250	1.500
⁵ / ₈	0.6250	0.642	0.605	¹⁵ / ₁₆	0.938	0.906	1.326	1.244	0.520	0.480	0.422	0.06	0.02	0.344	1.500	1.750
³ / ₄	0.7500	0.768	0.729	¹ / ₈	1.125	1.088	1.591	1.494	0.614	0.574	0.500	0.06	0.02	0.406	1.750	2.000
⁷ / ₈	0.8750	0.895	0.852	¹⁵ / ₁₆	1.312	1.269	1.856	1.742	0.723	0.683	0.594	0.06	0.02	0.438	2.000	2.250
1	1.0000	1.022	0.976	¹ / ₂	1.500	1.450	2.121	1.991	0.801	0.761	0.656	0.09	0.03	0.500	2.250	2.500

NOTES:

- Bearing Surface.** A die seam across the bearing surface is permissible. Angle of bearing surface with respect to shank is based on the 2 in. 12 slope of the inner flange of American Standard beams and channels.
- Thread Series.** Askew head bolts are only available with unified coarse (UNC) threads.
- Head Height.** Midheight, H, is a reference dimension and equals the basic head height of square bolts as given in Table 2. Head height, H₁, is computed as H + 0.0833 times the specified maximum width across flats, F. Tolerance on H₁ is ±0.020 in. from computed head height.
- Thread Length.** All askew head bolts of nominal lengths equal to or shorter than the nominal thread length, L_T, plus the unthreaded length, S, shall be threaded for full length. The distance from the bearing surface of the head, as measured at midheight of head to the last scratch of thread, shall not exceed S. The distance from the bearing surface of the head, as measured at midheight, to the first complete (full form) thread, as measured with a nonchamfered GO thread ring gage assembled by hand as far as the thread will permit, shall not exceed S plus a length of 2 1/2 threads.

Table 5 Length Tolerances for Bolts

Nominal Length	Nominal Size					
	1/4 to 3/8	7/16 and 1/2	9/16 to 3/4	7/8 and 1	1 1/8 to 1 1/2	Over 1 1/2
Up to 1 in., incl.	+0.02	+0.02	+0.02	...	...	...
	-0.03	-0.03	-0.03	...	...	...
Over 1 in. to 2 1/2 in., incl.	+0.02	+0.04	+0.06	+0.08	+0.12	+0.18
	-0.04	-0.06	-0.08	-0.10	-0.12	-0.18
Over 2 1/2 in. to 4 in., incl.	+0.04	+0.06	+0.08	+0.10	+0.16	+0.20
	-0.06	-0.08	-0.10	-0.14	-0.16	-0.20
Over 4 in. to 6 in., incl.	+0.06	+0.08	+0.10	+0.12	+0.18	+0.22
	-0.10	-0.10	-0.10	-0.16	-0.18	-0.22
Longer than 6 in.	+0.10	+0.12	+0.14	+0.16	+0.22	+0.24
	-0.18	-0.18	-0.18	-0.20	-0.22	-0.24

thread availability when selecting bolt lengths, even though usable threads may extend beyond this point.

For bolts that are threaded full length, L_G , max. defines the unthreaded length under the head and shall not exceed the length of 2.5 times the thread pitch for sizes up to and including 1 in. and 3.5 times the thread pitch for sizes larger than 1 in. It shall be used as the criterion for inspection.

All bolts of nominal lengths equal to or shorter than L_T plus a length equivalent to 2.5 times the thread pitch for sizes up to and including 1 in., and 3.5 times the thread pitch for sizes larger than 1 in. shall be threaded for full length.

3.8 Material

A material standard shall be a part of every bolt's designation and all requirements of the designated material standard shall be met. Unless otherwise specified, the material choices shall be as follows:

- (a) all bolts except heavy hex bolts: ASTM A307, Grade A, or ASTM A354, Grade BC or BD
- (b) heavy hex bolts: ASTM A307, Grade B

3.9 Additional Requirements

For additional requirements, see sections 1 and 2.

4 SCREWS

4.1 General

Hex cap, heavy hex, hex flange, and lobe head screws are presented in Tables 6 through 9, respectively.

4.2 Top of Head

4.2.1 Hex Cap and Heavy Hex Cap Screws. Top of head shall be full form and chamfered, with the diameter of chamfer circle being equal to the maximum width across flats within a tolerance of -15% .

4.2.2 Hex Flange and Lobed Head Screws. Top of head may be full form or indented at the option of the manufacturer. If full form, the top of head shall be chamfered or rounded with the diameter of chamfer circle or start of rounding being equal to the maximum width across flats, within a tolerance of -15% . If the top of head is indented, the periphery may be rounded.

4.3 Washer Face

Thickness of the washer face shall be not less than 0.015 in. nor greater than 0.025 in. for screw sizes $\frac{3}{4}$ in. and smaller, and not less than 0.015 in. nor greater than 0.035 in. for screw sizes larger than $\frac{3}{4}$ in. The washer face is not applicable to hex flange or lobed head screws.

The washer face diameter shall be equal to the maximum width across flats with a tolerance of -10% . Measurement of the washer face diameter shall be taken 0.004 in. below the bearing surface plane toward the head of the screw.

Die seams are not allowed on the washer faces of screws.

4.4 Bearing Surface Runout

Runout of the bearing surface with respect to the axis of the body shall be within the full indicator measurement (FIM) limits specified. Measurement of FIM shall be made as close to the periphery of the bearing surface as possible while the screw is held in a collet or other gripping device at a distance of one screw diameter from the underside of the head.

4.5 Fillet

Two styles of head-to-shank fillets are provided for long screws in lengths longer than the maximum lengths specified in Table 11. Style 1 will be supplied unless Style 2 is specified by the purchaser.

Style 1 is a continuous radius in accordance with the maximum/minimum limits for R shown in Table 10.

Style 2 has an elliptical shape defined as a smooth, multiradius, concave curve, tangent to the underhead bearing surface at a point no greater than one-half of E_{ar} , max., or less than one-half of E_{ar} , min., from the axis of the screw and tangent to the shank at a distance from the underhead bearing surface within the limits specified for L_a . No radius in the fillet shall be less than R , min. (see Fig. 1 and Table 10).

For short screws threaded full length (see Table 10), the fillet shall be a smooth, concave curve lying within the envelope established by either

(a) a continuous radius tangent to the underhead bearing surface and minimum/maximum shank diameter, E_{1r} , min., (minimum pitch diameter) to E_{ar} , max., whose value shall be no less than R , min., as specified in Table 10, or

(b) a continuous or multiradius curve tangent to the underhead bearing surface at a point no greater than one-half E_{ar} , max. from the axis of screw and tangent to the maximum shank diameter, E_{ar} , max., at a distance not exceeding L_{fr} , max. from the bearing surface

No radius in the multiradius curve shall be less than R , min., specified in Table 10 (see Fig. 2), where

$$L_{fr}, \text{ max.} = \frac{E_{ar}, \text{ max.} - E_{1r}, \text{ min.}}{2}$$

E_{1r} , min. = minimum specified pitch diameter of coarse thread: UNC-2A

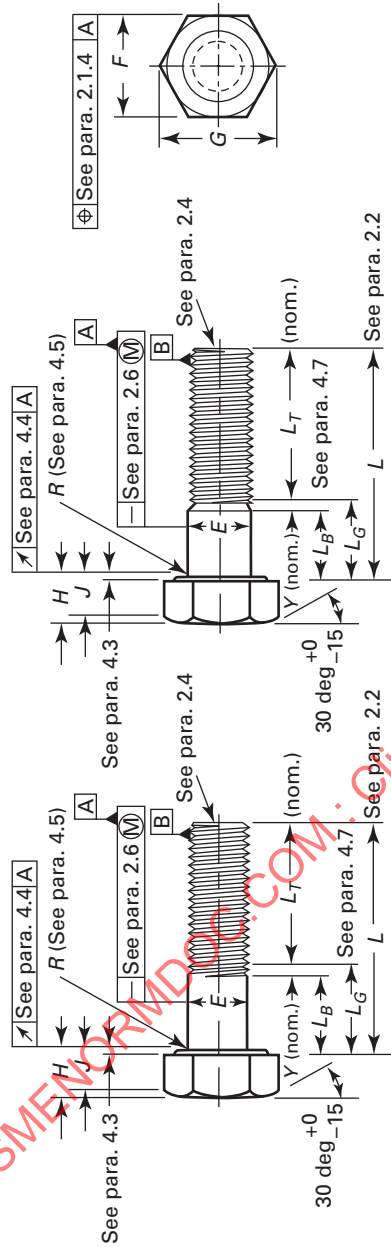
E_{ar} , max. = maximum fillet transition diameter (see Table 10)

E_{1ar} , min. = E_{ar} , max. $- 0.5 (E_{ar}$, max. $- E_{1r}$, min.)

4.6 Body Diameter

The diameter of body, except for a length equal to L_a , max. under the head, shall conform to the limits for E given in Tables 6 through 9. The diameter of the unthreaded length on short screws that are threaded for

Table 6 Dimensions of Hex Cap Screws



Nominal Size or Basic Product Diameter	Body Diameter, E (See Para. 4.6)		Width Across Flats, F (See Para. 2.1.2)		Width Across Corners, G		Head Height, H		Minimum Wrenching Height, J	Nominal Thread Length for Screw Lengths, L _T (See Para. 4.7)		Transition Thread Length, Y (See Para. 4.7)	Maximum Total Runout of Bearing Surface FIM (See Para. 4.4)
	Max.	Min.	Basic	Max.	Min.	Basic	Max.	Min.		6 in. and Shorter	Over 6 in.	Reference	
1/4	0.2500	0.2450	7/16	0.438	0.428	0.505	5/32	0.163	0.150	0.750	1.000	0.250	0.010
5/16	0.3125	0.3065	1/2	0.500	0.489	0.577	13/64	0.211	0.195	0.875	1.125	0.278	0.011
3/8	0.3750	0.3690	9/16	0.562	0.551	0.650	15/64	0.243	0.226	1.000	1.250	0.312	0.012
7/16	0.4375	0.4305	5/8	0.625	0.612	0.722	9/32	0.291	0.272	1.125	1.375	0.357	0.013
1/2	0.5000	0.4930	3/4	0.750	0.736	0.866	5/16	0.323	0.302	1.250	1.500	0.385	0.014
9/16	0.5625	0.5545	13/16	0.812	0.798	0.938	23/64	0.371	0.348	1.375	1.625	0.417	0.015
5/8	0.6250	0.6170	15/16	0.938	0.922	1.083	25/64	0.403	0.378	1.500	1.750	0.455	0.017
3/4	0.7500	0.7410	1 1/8	1.125	1.100	1.299	15/32	0.483	0.455	1.750	2.000	0.500	0.020
7/8	0.8750	0.8660	1 1/2	1.312	1.285	1.516	35/64	0.563	0.531	2.000	2.250	0.556	0.023
1	1.0000	0.9900	1 3/4	1.500	1.469	1.732	39/64	0.627	0.591	2.250	2.500	0.625	0.026
1 1/8	1.1250	1.1140	2	1.688	1.631	1.949	1 1/16	0.718	0.658	2.500	2.750	0.714	0.029
1 1/4	1.2500	1.2390	2 1/8	1.875	1.812	2.165	25/32	0.813	0.749	2.750	3.000	0.714	0.033
1 3/8	1.3750	1.3630	2 1/2	2.062	1.994	2.382	27/32	0.878	0.810	3.000	3.250	0.833	0.036
1 1/2	1.5000	1.4880	2 3/4	2.250	2.175	2.598	15/16	0.974	0.902	3.250	3.500	0.833	0.039
1 5/8	1.6250	1.6130	3	2.438	2.356	2.815	1	1.038	0.962	3.500	3.750	0.909	0.043

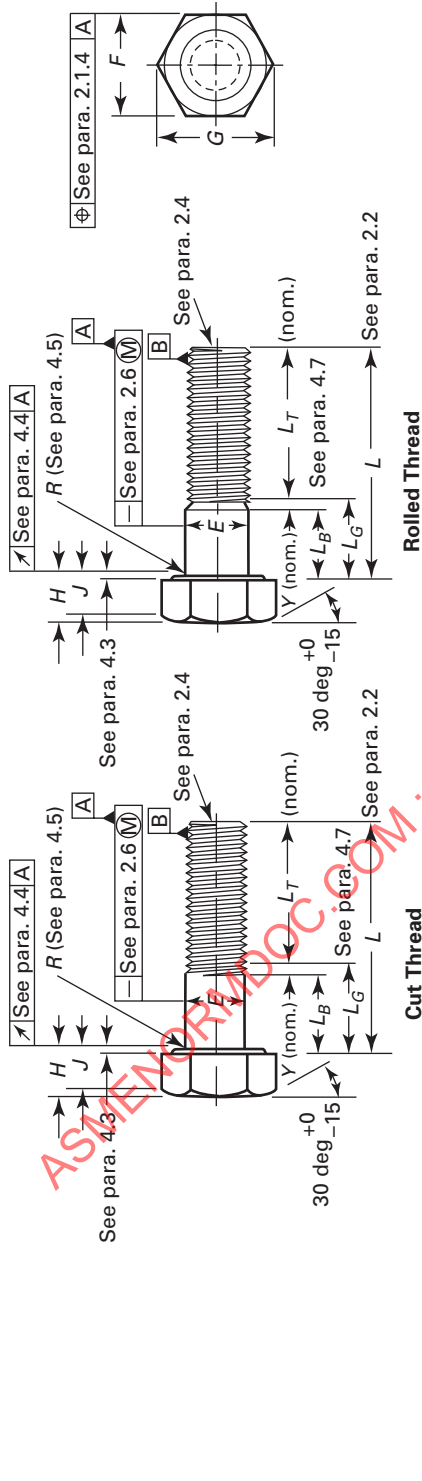
Table 6 Dimensions of Hex Cap Screws (Cont'd)

Nominal Size or Basic Product Diameter	Body Diameter, <i>E</i> (See Para. 4.6)		Width Across Flats, <i>F</i> (See Para. 2.1.2)		Width Across Corners, <i>G</i>		Head Height, <i>H</i>		Minimum Wrenching Height, <i>J</i>	Nominal Thread Length for Screw Lengths, <i>L_T</i> (See Para. 4.7)		Transition Thread Length, <i>Y</i> (See Para. 4.7) Reference	Maximum Total Runout of Bearing Surface FIM (See Para. 4.4)	
	Max.	Min.	Basic	Max.	Min.	Max.	Basic	Max.						
1 3/4	1.7500	1.7380	2 5/8	2.625	2.538	3.031	2.893	1 3/32	1.134	1.054	3.750	4.000	1.000	0.046
1 7/8	1.8750	1.8630	2 13/16	2.812	2.719	3.248	3.099	1 5/32	1.198	1.114	4.000	4.250	1.000	0.049
2	2.0000	1.9880	3	3.000	2.900	3.464	3.306	1 7/32	1.263	1.175	4.250	4.500	1.111	0.052
2 1/4	2.2500	2.2380	3 3/8	3.375	3.262	3.897	3.719	1 3/8	1.423	1.327	...	5.000	1.111	0.059
2 1/2	2.5000	2.4880	3 3/4	3.750	3.625	4.330	4.133	1 17/32	1.583	1.479	...	5.500	1.250	0.065
2 3/4	2.7500	2.7380	4 1/8	4.125	3.988	4.763	4.546	1 11/16	1.744	1.632	...	6.000	1.250	0.072
3	3.0000	2.9880	4 1/2	4.500	4.350	5.196	4.959	1 7/8	1.935	1.815	...	6.500	1.250	0.079

GENERAL NOTE:

- (a) See Table 10 for underhead fillet dimensions and Table 11 for *L_G*, max. and *L_B*, min. dimensions for fully threaded short screws.
 (b) Refer to section 4 for further information.

Table 7 Dimensions of Heavy Hex Screws



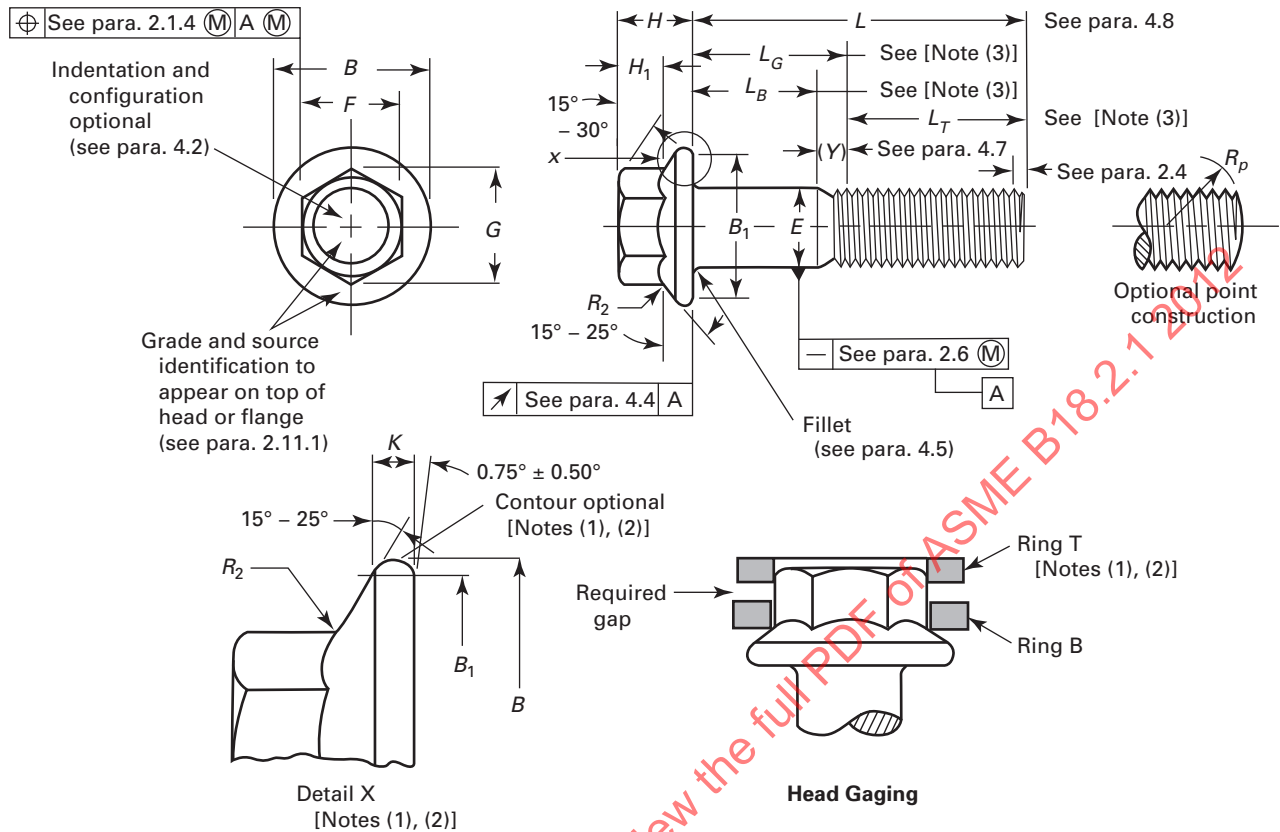
Nominal Size or Basic Product Diameter	Body Diameter, <i>E</i> (See Para. 4.6)		Width Across Flats, <i>F</i> (See Para. 2.1.2)		Width Across Corners, <i>G</i>		Head Height, <i>H</i>		Minimum Wrenching Height, <i>J</i>	Nominal Thread Length for Screw Lengths, <i>L_T</i> (See Para. 4.7)		Transition Thread Length, <i>Y</i> (See Para. 4.7)	Maximum Total Runout of Bearing Surface FIM (See Para. 4.4)
	Max.	Min.	Basic	Max.	Min.	Max.	Min.	6 in. and Shorter		Over 6 in.			
	Rolled Thread												
3/8	0.3750	0.360	11/16	0.688	0.669	0.763	15/64	0.243	0.160	1.000	1.250	0.312	0.014
1/2	0.5000	0.482	7/8	0.875	0.850	0.969	5/16	0.323	0.215	1.250	1.500	0.385	0.016
5/8	0.6250	0.605	1 1/16	1.062	1.031	1.175	25/64	0.403	0.269	1.500	1.750	0.455	0.019
3/4	0.7500	0.729	1 1/4	1.250	1.212	1.383	15/32	0.483	0.324	1.750	2.000	0.500	0.022
7/8	0.8750	0.852	1 1/2	1.438	1.394	1.589	35/64	0.563	0.378	2.000	2.250	0.556	0.025
1	1.0000	0.976	1 5/8	1.625	1.575	1.796	39/64	0.627	0.591	2.250	2.500	0.625	0.028
1 1/8	1.1250	1.098	1 3/4	1.812	1.756	2.002	11/16	0.718	0.658	2.500	2.750	0.714	0.032
1 1/4	1.2500	1.223	2	2.000	1.938	2.209	25/32	0.813	0.749	2.750	3.000	0.714	0.035
1 3/8	1.3750	1.345	2 1/16	2.188	2.119	2.416	27/32	0.878	0.810	3.000	3.250	0.833	0.038
1 1/2	1.5000	1.470	2 3/8	2.375	2.300	2.622	15/16	0.974	0.902	3.250	3.500	0.833	0.041
1 5/8	1.6250	1.591	2 1/2	2.562	2.481	2.829	1	1.038	0.962	3.500	3.750	0.909	0.044
1 3/4	1.7500	1.716	2 3/4	2.750	2.662	3.175	1 1/32	1.134	1.054	3.750	4.000	1.000	0.048
1 7/8	1.8750	1.839	2 5/8	2.938	2.844	3.392	1 5/32	1.198	1.114	4.000	4.250	1.000	0.052
2	2.0000	1.964	3 1/8	3.125	3.025	3.449	1 7/32	1.263	1.175	4.250	4.500	1.111	0.055
2 1/4	2.2500	2.214	3 1/2	3.500	3.388	3.862	1 3/8	1.423	1.327	...	5.000	1.111	0.061
2 1/2	2.5000	2.4610	3 3/8	3.8750	3.750	4.275	1 17/32	1.583	1.479	...	5.500	1.250	0.068
2 3/4	2.7500	2.7110	4 1/4	4.2500	4.112	4.688	1 11/16	1.744	1.632	...	6.000	1.250	0.074
3	3.0000	2.9610	4 3/8	4.6250	4.475	5.340	1 7/8	1.935	1.815	...	6.500	1.250	0.081
3 1/4	3.2500	3.2100	5	5.0000	4.838	5.774	2	2.126	1.998	...	7.000	1.250	0.091
3 1/2	3.5000	3.4610	5 3/8	5.3750	5.200	6.207	2 1/4	2.256	2.120	...	7.500	1.250	0.098

Table 7 Dimensions of Heavy Hex Screws (Cont'd)

Nominal Size or Basic Product Diameter	Body Diameter, <i>E</i> (See Para. 4.6)		Width Across Flats, <i>F</i> (See Para. 2.1.2)		Width Across Corners, <i>G</i>		Head Height, <i>H</i>			Minimum Wrenching Height, <i>J</i>	Nominal Thread Length for Screw Lengths, <i>L_T</i> (See Para. 4.7)		Transition Thread Length, <i>Y</i> (See Para. 4.7) Reference	Maximum Total Runout of Bearing Surface FIM (See Para. 4.4)
	Max.	Min.	Basic	Max.	Min.	Max.	Basic	Max.	Min.					
												6 in. and Shorter	Over 6 in.	
3 ³ / ₄	3.7500	3.7109	5 ³ / ₄	5.7500	5.562	6.640	6.341	2 ³ / ₈	2.447	2.303	1.612	8.000	1.250	0.105
4	4.0000	3.9609	6 ¹ / ₈	6.1250	5.925	7.073	6.755	2 ¹ / ₂	2.576	2.424	1.697	8.500	1.250	0.112
4 ¹ / ₄	4.2500	4.2228	6 ¹ / ₂	6.5000	6.288	7.506	7.168	2 ³ / ₄	2.768	2.608	1.826	9.000	1.250	0.119
4 ¹ / ₂	4.5000	4.4727	6 ⁷ / ₈	6.8750	6.650	7.939	7.581	2 ⁷ / ₈	2.896	2.728	1.910	9.500	1.250	0.126
4 ³ / ₄	4.7500	4.7227	7 ¹ / ₄	7.2500	7.012	8.372	7.994	3	3.088	2.912	2.038	10.000	1.250	0.133
5	5.0000	4.9726	7 ⁵ / ₈	7.6250	7.375	8.805	8.408	3 ¹ / ₈	3.217	3.033	2.123	10.500	1.250	0.140
5 ¹ / ₄	5.2500	5.2226	8	8.0000	7.738	9.238	8.821	3 ³ / ₈	3.408	3.216	2.251	11.000	1.250	0.147
5 ¹ / ₂	5.5000	5.4726	8 ³ / ₈	8.3750	8.100	9.671	9.234	3 ¹ / ₂	3.538	3.338	2.337	11.500	1.250	0.154
5 ³ / ₄	5.7500	5.7225	8 ⁷ / ₈	8.7500	8.462	10.104	9.647	3 ⁵ / ₈	3.729	3.521	2.465	12.000	1.250	0.161
6	6.0000	5.9725	9 ¹ / ₈	9.1250	8.825	10.537	10.060	3 ³ / ₄	3.858	3.642	2.549	12.500	1.250	0.168

GENERAL NOTES:

- (a) *Wrenching Height, J*. Wrenching height is a distance measured from the bearing surface up the side of the head at the corners. The width across corners shall be within specified limits for the full wrenching height.
- (b) Refer to section 4 for further information.

Table 8 Dimensions of Hex Flange Screws

Nominal Size or Basic Major Diameter of Thread		Body Diam., <i>E</i>		Width Across Flats, <i>F</i> (See Para. 2.1.2)			Width Across Corners, <i>G</i>		Maximum Flange Diam., <i>B</i>	Minimum Flange Thickness, <i>K</i>	Maximum Head Height, <i>H</i>	Minimum Hex Height, <i>H</i> ₁	Maximum
													Flange
		Top Radius, <i>R</i> ₂											
$\frac{1}{4}$	0.2500	0.2500	0.2450	$\frac{3}{8}$	0.3750	0.367	0.433	0.409	0.56	0.04	0.28	0.17	0.015
$\frac{5}{16}$	0.3125	0.3125	0.3065	$\frac{1}{2}$	0.5000	0.489	0.577	0.548	0.68	0.05	0.32	0.21	0.019
$\frac{3}{8}$	0.3750	0.3750	0.3690	$\frac{9}{16}$	0.5625	0.551	0.650	0.618	0.81	0.06	0.39	0.25	0.022
$\frac{7}{16}$	0.4375	0.4375	0.4305	$\frac{5}{8}$	0.6250	0.612	0.722	0.685	0.93	0.07	0.46	0.30	0.026
$\frac{1}{2}$	0.5000	0.5000	0.4930	$\frac{3}{4}$	0.7500	0.736	0.866	0.825	1.07	0.08	0.51	0.34	0.030
$\frac{9}{16}$	0.5625	0.5625	0.5545	$\frac{13}{16}$	0.8125	0.798	0.938	0.895	1.19	0.09	0.57	0.38	0.034
$\frac{5}{8}$	0.6250	0.6250	0.6170	$\frac{15}{16}$	0.9375	0.922	1.083	1.034	1.33	0.10	0.62	0.42	0.038
$\frac{3}{4}$	0.7500	0.7500	0.7410	$1\frac{1}{8}$	1.1250	1.100	1.299	1.234	1.59	0.11	0.73	0.51	0.045

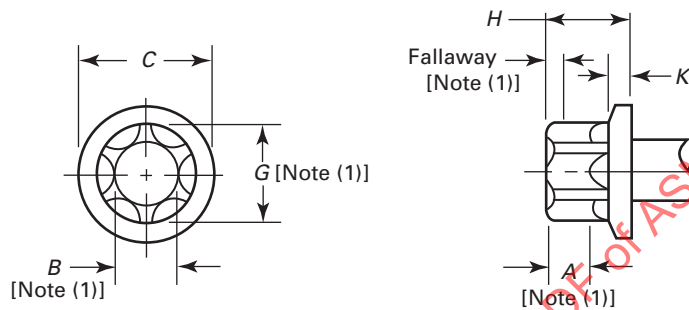
Table 8 Dimensions of Hex Flange Screws (Cont'd)

Nominal Size or Basic Major Diameter of Thread		Minimum Bearing Diam., B_1	Maximum Runout of Bearing Surface FIM	Basic Thread Length, L_T [Note (3)]		Maximum Transition Thread Length, Y [Notes (3) and (4)]		Ring T		Ring B	
				For Screws With $L \leq$ 6 in.	For Screws With $L >$ 6 in.	For Screws With $L \leq$ 6 in.	For Screws With $L >$ 6 in.	Inside Diameter +0.0000 −0.0003	Minimum Thickness	Inside Diameter +0.0000 −0.0003	Thickness +0.0000 −0.0003
$\frac{1}{4}$	0.2500	0.480	0.010	0.750	1.000	0.400	0.650	0.4093	0.500	0.4380	0.1186
$\frac{5}{16}$	0.3125	0.600	0.011	0.875	1.125	0.417	0.667	0.5483	0.500	0.5820	0.1457
$\frac{3}{8}$	0.3750	0.730	0.012	1.000	1.250	0.438	0.688	0.6183	0.500	0.6550	0.1729
$\frac{7}{16}$	0.4375	0.850	0.013	1.125	1.375	0.464	0.714	0.6853	0.500	0.7300	0.2100
$\frac{1}{2}$	0.5000	0.980	0.014	1.250	1.500	0.481	0.731	0.8253	0.500	0.8750	0.2371
$\frac{9}{16}$	0.5625	1.100	0.015	1.375	1.625	0.750	0.750	0.8953	0.500	0.9500	0.2643
$\frac{5}{8}$	0.6250	1.230	0.017	1.500	1.750	0.773	0.773	1.0343	0.500	1.0950	0.2914
$\frac{3}{4}$	0.7500	1.470	0.020	1.750	2.000	0.800	0.800	1.2343	0.500	1.3120	0.3557

GENERAL NOTE: Refer to section 4 for further information.

NOTES:

- (1) Head acceptability shall be determined using the two rings described in Table 8. Ring B shall be placed on the screw head followed by Ring T. The head is acceptable if Ring T does not contact Ring B after both rings are in place on the head.
- (2) The top surface of the flange shall be conical or slightly rounded (convex). Radius, R_2 , applies both at the corners and at the flats of the hexagon. The contour of edge at flange periphery, between the maximum flange diameter, B , max., and the minimum bearing circle diameter, B_1 , min., shall be optional provided that the minimum flange edge thickness, K , min., is maintained at the minimum bearing circle diameter, B_1 , min.
- (3) L_G , max. = $L - (L_T + Y)$; L_B , min. = L_G , max. − Y
- (4) Use Y dimensions in Table 8 for the calculation of L_G , max./ L_B , min. (see para. 4.7) instead of following Table 12.

Table 9 Dimensions of Lobed Head Screws

Nominal Size or Basic Major Diam. of Thread		Width Across Corners, <i>G</i> Reference	Head Height, <i>H</i>		Flange Thickness, <i>K</i>		Flange Diameter, <i>C</i>		Maximum Minor Diameter, <i>B</i>	Drive Size
			Max.	Min.	Max.	Min.	Max.	Min.		
$\frac{1}{4}$	0.2500	0.2870	0.255	0.245	0.070	0.060	0.375	0.365	0.2073	E8
$\frac{5}{16}$	0.3125	0.3620	0.323	0.313	0.100	0.090	0.469	0.457	0.2663	E10
$\frac{3}{8}$	0.3750	0.4310	0.394	0.384	0.125	0.115	0.562	0.550	0.3103	E12
$\frac{7}{16}$	0.4375	0.4990	0.472	0.462	0.155	0.145	0.656	0.642	0.3613	E14
$\frac{1}{2}$	0.5000	0.5710	0.515	0.505	0.160	0.150	0.750	0.735	0.4113	E16
$\frac{9}{16}$	0.5625	0.6450	0.551	0.541	0.165	0.153	0.844	0.828	0.4663	E18
$\frac{5}{8}$	0.6250	0.7150	0.630	0.620	0.200	0.188	0.938	0.921	0.5183	E20
$\frac{3}{4}$	0.7500	0.8600	0.787	0.777	0.255	0.243	1.125	1.107	0.6183	E24
$\frac{7}{8}$	0.8750	1.0000	0.866	0.856	0.270	0.260	1.312	1.293	0.7193	E28
1	1.0000	1.1380	1.063	1.053	0.355	0.343	1.500	1.479	0.8393	E32
$1\frac{1}{8}$	1.1250	1.2800	1.181	1.171	0.382	0.370	1.688	1.665	0.9433	E36
$1\frac{1}{4}$	1.2500	1.4200	1.299	1.289	0.422	0.410	1.875	1.852	1.0463	E40
$1\frac{3}{8}$	1.3750	1.5620	1.417	1.407	0.453	0.441	2.062	2.038	1.1513	E44

GENERAL NOTES:

- (a) Refer to section 4 for further information.
 (b) For all unspecified features, such as fillet radius, refer to Table 6.

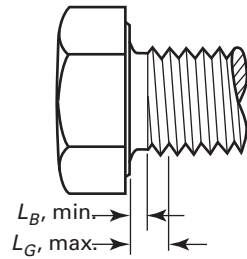
NOTE:

- (1) Fallaway, *G*, *A*, *B*, and other configuration characteristic acceptance shall be determined based on the gage and gaging practices in Mandatory Appendix I.

Table 10 Dimensions of Underhead Fillets

Nominal Size or Basic Product Diameter		Long Screws (See Fig. 1)				Long and Short Screws		Short Screws (See Fig. 2)	
		Fillet Transition Diameter, E_d		Fillet Length, L_d		Radius of Fillet, R		Maximum Fillet Transition Diameter, E_d	Maximum Fillet Length, L_f
		Max.	Min.	Max.	Min.	Max.	Min.		
$\frac{1}{4}$	0.2500	0.300	0.280	0.087	0.043	0.025	0.015	0.300	0.043
$\frac{5}{16}$	0.3125	0.362	0.342	0.087	0.043	0.025	0.015	0.362	0.045
$\frac{3}{8}$	0.3750	0.425	0.405	0.087	0.043	0.025	0.015	0.425	0.048
$\frac{7}{16}$	0.4375	0.488	0.468	0.087	0.043	0.025	0.015	0.488	0.052
$\frac{1}{2}$	0.5000	0.550	0.530	0.087	0.043	0.025	0.015	0.550	0.053
$\frac{9}{16}$	0.5625	0.652	0.602	0.157	0.078	0.045	0.020	0.652	0.075
$\frac{5}{8}$	0.6250	0.715	0.665	0.157	0.078	0.045	0.020	0.715	0.078
$\frac{3}{4}$	0.7500	0.840	0.790	0.157	0.078	0.045	0.020	0.840	0.081
$\frac{7}{8}$	0.8750	1.005	0.955	0.227	0.113	0.065	0.040	1.005	0.105
1	1.0000	1.190	1.120	0.332	0.166	0.095	0.060	1.190	0.140
$1\frac{1}{8}$	1.1250	1.315	1.245	0.332	0.166	0.095	0.060	1.315	0.146
$1\frac{1}{4}$	1.2500	1.440	1.370	0.332	0.166	0.095	0.060	1.440	0.146
$1\frac{3}{8}$	1.3750	1.565	1.495	0.332	0.166	0.095	0.060	1.565	0.154
$1\frac{1}{2}$	1.5000	1.690	1.620	0.332	0.166	0.095	0.060	1.690	0.154
$1\frac{3}{4}$	1.7500	1.940	1.870	0.332	0.166	0.095	0.060	1.940	0.166
2	2.0000	2.190	2.120	0.332	0.166	0.095	0.060	2.190	0.173
$2\frac{1}{4}$	2.2500	2.440	2.370	0.332	0.166	0.095	0.060	2.440	0.173
$2\frac{1}{2}$	2.5000	2.690	2.620	0.332	0.166	0.095	0.060	2.690	0.183
$2\frac{3}{4}$	2.7500	2.940	2.870	0.332	0.166	0.095	0.060	2.940	0.183
3	3.0000	3.190	3.120	0.332	0.166	0.095	0.060	3.190	0.183

Fig. 3 L_G , Maximum and L_B , Minimum for Short Screws Threaded Full Length



full length shall not be less than the minimum pitch diameter of the thread nor greater than the nominal diameter specified in Tables 6 through 9.

A die seam, swell, or fin is permissible along the body diameter, respectively, for screws over 1 in. Any die seam, swell, or fin shall not exceed the basic screw diameter. When specified by the purchaser, the die seam and swell on the body shall be removed. Upon completion of the machining, all dimensions and geometric requirements specified for the bearing surface and body diameter shall be met.

4.7 Thread Length

The length of thread on screws shall be controlled by the grip gaging length, L_G , max., and body length, L_B , min.

For short screws threaded full length, L_G , max. and L_B , min. are given in Table 11 (see Fig. 3). For long screws (except flange heads) not threaded full length, of diameters through 1½ in. and lengths through 12 in., L_G , max. and L_B , min. are specified in Table 12. For hex flange head screws, L_G , max. and L_B , min. shall be calculated using the thread lengths, L_T , and transition lengths, Y , given in Table 8, using the formula in Note (4).

For diameter-length combinations not included in Table 11 or Table 12, L_G , max. for long screws that are not threaded full length, as calculated and rounded to two decimal places, shall be equal to the nominal screw length, L , nom., minus the nominal thread length, L_T (L_G , max. = L , nom. - L_T). It shall be used as the criterion for inspection.

L_T is a reference dimension intended for calculation purposes only that represents the distance from the extreme end of the screw to the last complete (full form) thread. L_T equals twice the basic thread diameter +0.25 in. for nominal screw length up to and including 6 in. and twice the basic thread diameter +0.50 in. for nominal lengths over 6 in.

L_B , min. is the distance measured parallel to the axis of screw from the underhead bearing surface to the last scratch of thread or to the top of the extrusion angle. For diameter length combinations not included in Table 11 or Table 12, L_B , min. as calculated and rounded

to two decimal places, shall be equal L_G , max. minus the maximum transition thread length, Y (L_B , min. = L_G , max. - Y). It shall be a criterion for inspection.

Y is a reference dimension equal to five coarse (UNC) pitches and intended for calculation purposes only. It includes the length of incomplete threads, the extrusion angle on rolled threads, and tolerances on grip length.

4.8 Length Tolerances

Screw length tolerances are given in Table 13.

4.9 Material

A material standard shall be a part of every screw's designation and all requirements of the designated material standard shall be met. Unless otherwise specified, the material choices shall be as follows:

(a) hex head cap screws

(1) carbon and alloy steel: all grades of SAE J429 and ASTM A449

(2) stainless steel: ASTM F593

(3) nonferrous materials: ASTM F468

(b) heavy hex head cap screws

(1) all material grades in ASTM A193 and ASTM A320

(c) hex flange and lobed head screws

(1) carbon and alloy steel: all grades of SAE

4.10 Additional Requirements

For additional requirements, see sections 1 and 2.

5 LAG SCREWS

5.1 General

Square lag and hex lag screws are presented in Tables 14 and 15.

5.2 Head Taper

Maximum width across flats and across corners shall not be exceeded. No transverse section through the head between 25% and 75% of actual head height, as measured from the bearing surface, shall be less than the minimum width across flats and across corners. (This is not applicable to askew head bolts.)

5.3 Bearing Surface

A die seam across the bearing surface is permissible. Bearing surface shall be perpendicular to the axis of the body within a tolerance of 3 deg for 1-in. size and smaller, and 2 deg for sizes larger than 1 in. Angularity measurement shall be taken at a location to avoid interference from a die seam. When specified by the purchaser, the die seam shall be removed. Upon completion of the machining, all dimensions and geometric requirements specified for the bearing surface and head shall be met.

Table 12 Maximum Grip Gaging Lengths, L_G , and Minimum Body Lengths, L_B , for Screws Except Flange Head

Nominal Size	Nominal Length, L_G , max./ L_B , min.														
	$1\frac{1}{4}$	$1\frac{3}{8}$	$1\frac{1}{2}$	$1\frac{5}{8}$	$1\frac{3}{4}$	$1\frac{7}{8}$	2	$2\frac{1}{8}$	$2\frac{1}{4}$	$2\frac{3}{8}$	$2\frac{1}{2}$	$2\frac{5}{8}$	$2\frac{3}{4}$	$2\frac{7}{8}$	3
$\frac{1}{4}$	0.50/0.25	0.63/0.38	0.75/0.50	0.88/0.62	1.00/0.75	1.12/0.88	1.25/1.00	1.38/1.12	1.50/1.25	1.62/1.38	1.75/1.50	1.88/1.62	2.00/1.75	2.12/1.88	2.52/2.00
$\frac{5}{16}$	Full thread	0.50/0.22	0.62/0.35	0.75/0.47	0.88/0.60	1.00/0.72	1.12/0.85	1.25/0.97	1.38/1.10	1.50/1.22	1.62/1.35	1.75/1.47	1.88/1.60	2.00/1.72	2.12/1.85
$\frac{3}{8}$	Full thread	Full thread	0.50/0.19	0.62/0.31	0.75/0.44	0.88/0.56	1.00/0.69	1.12/0.81	1.25/0.94	1.38/1.06	1.50/1.19	1.62/1.31	1.75/1.44	1.88/1.56	2.00/1.69
$\frac{7}{16}$	Full thread	Full thread	Full thread	Full thread	0.63/0.27	0.75/0.39	0.88/0.52	1.00/0.64	1.12/0.77	1.25/0.89	1.38/1.02	1.50/1.14	1.62/1.27	1.75/1.39	1.88/1.52
$\frac{1}{2}$	Full thread	Full thread	Full thread	Full thread	Full thread	0.63/0.24	0.75/0.38	0.88/0.49	1.00/0.62	1.12/0.74	1.25/0.86	1.38/0.99	1.50/1.12	1.62/1.24	1.75/1.36
$\frac{9}{16}$	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	0.75/0.33	0.88/0.45	1.00/0.58	1.12/0.75	1.25/0.83	1.38/0.96	1.50/1.08	1.62/1.21
$\frac{5}{8}$	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	0.75/0.30	0.88/0.42	1.00/0.55	1.12/0.67	1.25/0.80	1.38/0.92	1.50/1.05
$\frac{3}{4}$	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	0.88/0.38	1.00/0.50	1.12/0.62	1.25/0.75
$\frac{7}{8}$	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	0.88/0.32	1.00/0.44
1	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread
$1\frac{1}{8}$	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread
$1\frac{1}{4}$	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread
$1\frac{3}{8}$	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread
$1\frac{1}{2}$	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread

Table 12 Maximum Grip Gaging Lengths, L_G , and Minimum Body Lengths, L_B , for Screws Except Flange Head (Cont'd)

Nominal Size	Nominal Length, L_G , max./ L_B , min.													
	$3/4$	$3 1/2$	$3 3/4$	4	$4 1/4$	$4 1/2$	$4 3/4$	5	$5 1/4$	$5 1/2$	$5 3/4$	6	$6 1/4$	$6 1/2$
$1/4$	2.50/2.25	2.75/2.50	3.00/2.75	3.25/3.00	3.50/3.25	3.75/3.50	4.00/3.75	4.25/4.00	4.50/4.25	4.75/4.50	5.00/4.75	5.25/5.00	5.25/5.00	5.50/5.25
$5/16$	2.38/2.10	2.62/2.35	2.88/2.60	3.12/2.85	3.38/3.10	3.62/3.35	3.88/3.60	4.12/3.85	4.38/4.10	4.62/4.35	4.88/4.60	5.12/4.85	5.12/4.85	5.38/5.10
$3/8$	2.25/1.94	2.50/2.19	2.75/2.44	3.00/2.69	3.25/2.94	3.50/3.19	3.75/3.44	4.00/3.69	4.25/3.94	4.50/4.19	4.75/4.44	5.00/4.69	5.00/4.69	5.25/4.94
$7/16$	2.12/1.77	2.38/2.02	2.62/2.27	2.88/2.52	3.12/2.77	3.38/3.02	3.62/3.27	3.88/3.52	4.12/3.77	4.38/4.02	4.63/4.27	4.88/4.52	4.88/4.52	5.12/4.77
$1/2$	2.00/1.62	2.25/1.86	2.50/2.12	2.75/2.36	3.00/2.62	3.25/2.86	3.50/3.12	3.75/3.36	4.00/3.62	4.25/3.87	4.50/4.12	4.75/4.36	4.75/4.36	5.00/4.62
$9/16$	1.88/1.46	2.12/1.71	2.38/1.96	2.62/2.21	2.88/2.46	3.12/2.71	3.38/2.96	3.62/3.21	3.88/3.46	4.12/3.71	4.38/3.96	4.62/4.21	4.62/4.21	4.88/4.46
$5/8$	1.75/1.30	2.00/1.55	2.25/1.80	2.50/2.05	2.75/2.30	3.00/2.55	3.25/2.80	3.50/3.05	3.75/3.30	4.00/3.55	4.25/3.80	4.50/4.05	4.50/4.05	4.75/4.30
$3/4$	1.50/1.00	1.75/1.25	2.00/1.50	2.25/1.75	2.50/2.00	2.75/2.25	3.00/2.50	3.25/2.75	3.50/3.00	3.75/3.25	4.00/3.50	4.25/3.75	4.25/3.75	4.50/4.00
$7/8$	1.25/0.69	1.50/0.94	1.75/1.19	2.00/1.44	2.25/1.69	2.50/1.94	2.75/2.19	3.00/2.44	3.25/2.69	3.50/2.94	3.75/3.19	4.00/3.44	4.00/3.44	4.25/3.69
1	1.00/0.38	1.25/0.62	1.50/0.88	1.75/1.12	2.00/1.38	2.25/1.62	2.50/1.88	2.75/2.12	3.00/2.38	3.25/2.62	3.50/2.88	3.75/3.12	3.75/3.12	4.00/3.38
$1 1/8$	Full thread	Full thread	1.25/0.54	1.50/0.79	1.75/1.04	2.00/1.29	2.25/1.54	2.50/1.79	2.75/2.04	3.00/2.29	3.25/2.54	3.50/2.79	3.50/2.79	3.75/3.04
$1 1/4$	Full thread	Full thread	Full thread	1.25/0.54	1.50/0.79	1.75/1.04	2.00/1.29	2.25/1.54	2.50/1.79	2.75/2.04	3.00/2.29	3.25/2.54	3.25/2.54	3.50/2.79
$1 3/8$	Full thread	Full thread	Full thread	Full thread	Full thread	1.50/0.79	1.75/1.04	2.00/1.29	2.25/1.54	2.50/1.79	2.75/2.04	3.00/2.29	3.25/2.54	3.50/2.79
$1 1/2$	Full thread	Full thread	Full thread	Full thread	Full thread	Full thread	1.50/0.67	1.75/0.92	2.00/1.17	2.25/1.42	2.50/1.67	2.75/1.92	2.75/1.92	3.00/2.17

Table 12 Maximum Grip Gaging Lengths, L_G , and Minimum Body Lengths, L_B , for Screws Except Flange Head (Cont'd)

Nominal Size	Nominal Length, L_G , max./ L_B , min.														
	7	7 $\frac{1}{4}$	7 $\frac{1}{2}$	7 $\frac{3}{4}$	8	8 $\frac{1}{4}$	8 $\frac{1}{2}$	8 $\frac{3}{4}$	9	9 $\frac{1}{4}$	9 $\frac{1}{2}$	9 $\frac{3}{4}$	10	11	12
$\frac{1}{4}$	6.00/5.75	6.25/6.00	6.50/6.25	6.75/6.50	7.00/6.75	7.25/7.00	7.50/7.25	7.75/7.50	8.00/7.75	8.25/8.00	8.50/8.25	8.75/8.50	9.00/8.75	10.00/9.75	11.00/10.75
$\frac{5}{16}$	5.88/5.60	6.12/5.85	6.38/6.10	6.62/6.35	6.88/6.60	7.12/6.85	7.38/7.10	7.62/7.35	7.88/7.60	8.12/7.85	8.38/8.10	8.62/8.35	8.88/8.60	9.88/9.60	10.88/10.60
$\frac{3}{8}$	5.75/5.44	6.00/5.69	6.25/5.94	6.50/6.19	6.75/6.44	7.00/6.69	7.25/6.94	7.50/7.19	7.75/7.44	8.00/7.69	8.25/7.94	8.50/8.19	8.75/8.44	9.75/9.44	10.75/10.44
$\frac{7}{16}$	5.62/5.27	5.88/5.52	6.12/5.77	6.38/6.02	6.62/6.27	6.88/6.52	7.12/6.77	7.38/7.02	7.62/7.27	7.88/7.52	8.12/7.77	8.38/8.02	8.62/8.27	9.62/9.27	10.62/10.27
$\frac{1}{2}$	5.50/5.12	5.75/5.36	6.00/5.62	6.25/5.87	6.50/6.12	6.75/6.36	7.00/6.62	7.25/6.86	7.50/7.12	7.75/7.36	8.00/7.62	8.25/7.86	8.50/8.12	9.50/9.12	10.50/10.12
$\frac{9}{16}$	5.38/4.96	5.62/5.20	5.88/5.46	6.12/5.71	6.38/5.96	6.62/6.21	6.88/6.46	7.12/6.71	7.38/6.96	7.62/7.21	7.88/7.46	8.12/7.71	8.38/7.96	9.38/8.96	10.38/9.96
$\frac{5}{8}$	5.25/4.80	5.50/5.05	5.75/5.30	6.00/5.55	6.25/5.80	6.50/6.05	6.75/6.30	7.00/6.55	7.25/6.80	7.50/7.05	7.75/7.30	8.00/7.55	8.25/7.80	9.25/8.80	10.25/9.80
$\frac{3}{4}$	5.00/4.50	5.25/4.75	5.50/5.00	5.75/5.25	6.00/5.50	6.25/5.75	6.50/6.00	6.75/6.25	7.00/6.50	7.25/6.75	7.50/7.00	7.75/7.25	8.00/7.50	9.00/8.50	10.00/9.50
$\frac{7}{8}$	4.75/4.19	5.00/4.44	5.25/4.69	5.50/4.94	5.75/5.19	6.00/5.44	6.25/5.69	6.50/5.94	6.75/6.19	7.00/6.44	7.25/6.89	7.50/6.94	7.75/7.19	8.75/8.19	9.75/9.19
1	4.50/3.88	4.75/4.12	5.00/4.38	5.25/4.52	5.50/4.88	5.75/5.12	6.00/5.38	6.25/5.62	6.50/5.88	6.75/6.12	7.00/6.38	7.25/6.62	7.50/6.88	8.50/7.88	9.50/8.88
$\frac{1}{8}$	4.25/3.54	4.50/3.79	4.75/4.04	5.00/4.29	5.25/4.54	5.50/4.79	5.75/5.04	6.00/5.29	6.25/5.54	6.50/5.79	6.75/6.04	7.00/6.29	7.25/6.54	8.25/7.54	9.25/8.54
$\frac{1}{4}$	4.00/3.29	4.25/3.54	4.50/3.79	4.75/4.04	5.00/4.29	5.25/4.54	5.50/4.79	5.75/5.04	6.00/5.29	6.25/5.54	6.50/5.79	6.75/6.04	7.00/6.29	8.00/7.29	9.00/8.29
$\frac{3}{8}$	3.75/3.04	4.00/3.29	4.25/3.54	4.50/3.79	4.75/4.04	5.00/4.29	5.25/4.54	5.50/4.79	5.75/5.04	6.00/5.29	6.25/5.54	6.50/5.79	6.75/6.04	7.75/7.04	8.75/8.04
$\frac{1}{2}$	3.50/2.67	3.75/2.92	4.00/3.17	4.25/3.42	4.50/3.67	4.75/3.92	5.00/4.17	5.25/4.42	5.50/4.67	5.75/4.92	6.00/5.17	6.25/5.42	6.50/5.67	7.50/6.67	8.50/7.67

GENERAL NOTE: For applicable full thread L_G and L_B , see Table II.

Table 13 Length Tolerances for Screws

Nominal Length	Nominal Size					
	$\frac{1}{4}$ to $\frac{3}{8}$	$\frac{7}{16}$ and $\frac{1}{2}$	$\frac{9}{16}$ to $\frac{3}{4}$	$\frac{7}{8}$ and 1	$1\frac{1}{8}$ to $1\frac{1}{2}$	Over $1\frac{1}{2}$
Up to 1 in., incl.	+0.00 -0.03	+0.00 -0.03	+0.00 -0.03			
Over 1 in. to $2\frac{1}{2}$ in., incl.	+0.00 -0.04	+0.00 -0.06	+0.00 -0.08	+0.00 -0.10	+0.00 -0.12	+0.00 -0.18
Over $2\frac{1}{2}$ in. to 4 in., incl.	+0.00 -0.06	+0.00 -0.08	+0.00 -0.10	+0.00 -0.14	+0.00 -0.16	+0.00 -0.20
Over 4 in. to 6 in., incl.	+0.00 -0.10	+0.00 -0.10	+0.00 -0.10	+0.00 -0.16	+0.00 -0.18	+0.00 -0.22
Longer than 6 in.	+0.00 -0.18	+0.00 -0.18	+0.00 -0.18	+0.00 -0.20	+0.00 -0.22	+0.00 -0.24

5.4 Body Diameter

Any swell or fin under the head or any die seam on the body shall not exceed the basic bolt diameter by more than the following:

- (a) 0.030 in. for sizes up through $\frac{1}{2}$ in.
- (b) 0.050 in. for sizes over $\frac{1}{2}$ in. through $\frac{3}{4}$ in.
- (c) 0.060 in. for sizes over $\frac{3}{4}$ in. through $1\frac{1}{4}$ in.

5.5 Reduced Diameter Body

Screws may be obtained in reduced diameter body. Where reduced diameter body is specified, the body diameter shall be reduced to the blank diameter before threading, and a shoulder of full body diameter under the head shall be provided.

5.6 Thread

Dimensions for lag screw threads are contained in Table 16.

5.7 Thread Length

The minimum thread length shall be equal to one-half of the nominal screw length +0.50 in., or 6 in., whichever is shorter. Screws too short for the formula thread length shall be threaded as close to the head or shoulder as practicable.

5.8 Material

A material standard shall be a part of every lag screw's designation and only the chemical requirements of the designated material standard shall be met. Unless otherwise specified, the material standards shall be as follows:

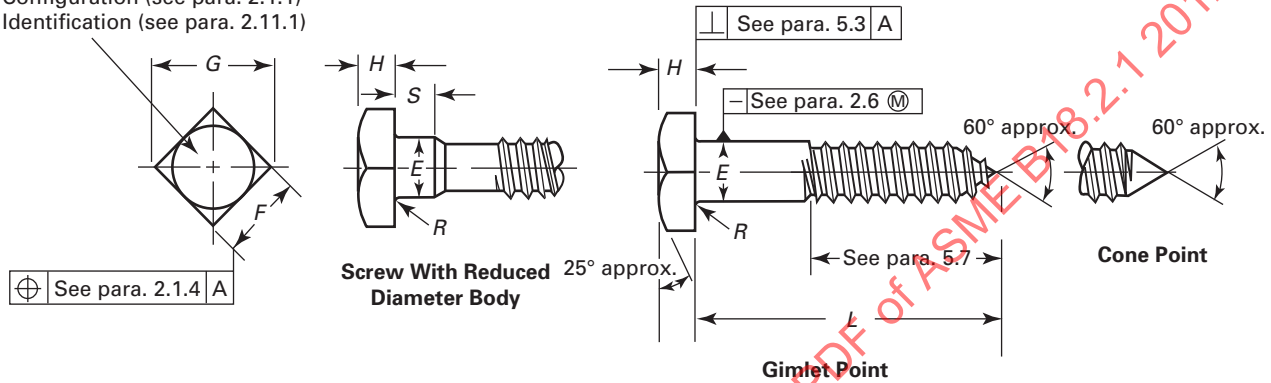
- (a) carbon steel: ASTM A307, Grade A
- (b) stainless steel: ASTM F593, Group 1, Condition CW (304)
- (c) nonferrous materials: ASTM F468.

5.9 Additional Requirements

For additional requirements, see sections 1 and 2.

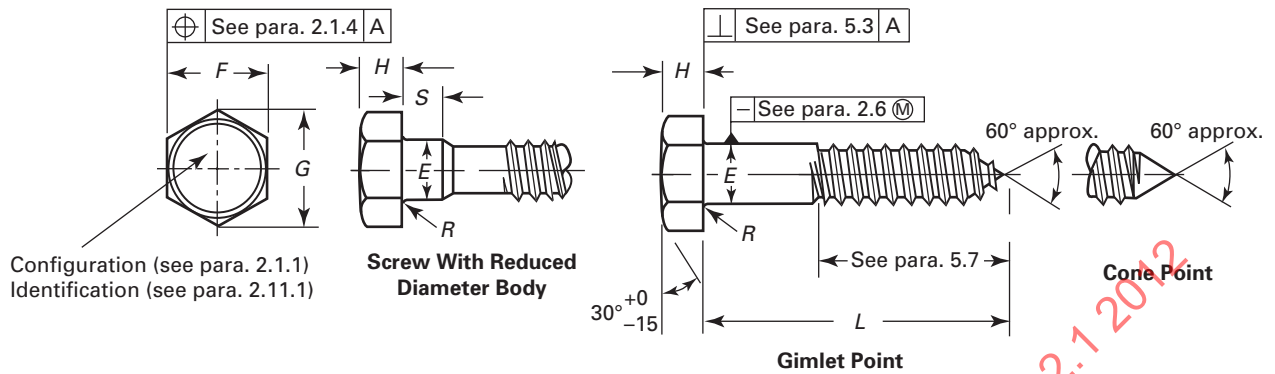
Table 14 Dimensions of Square Lag Screws

Configuration (see para. 2.1.1)
Identification (see para. 2.11.1)



Nominal Size or Basic Product Diameter		Body or Shoulder Diameter, <i>E</i> (See Paras. 5.4 and 5.5)		Width Across Flats, <i>F</i> (See Para. 2.1.2)			Width Across Corners, <i>G</i>		Head Height, <i>H</i>			Minimum Shoulder Length, <i>S</i> (See Para. 5.5)	Radius of Fillet, <i>R</i>	
		Max.	Min.	Basic	Max.	Min.	Max.	Min.	Basic	Max.	Min.		Max.	Min.
No. 10	0.1900	0.199	0.178	$\frac{9}{32}$	0.281	0.271	0.398	0.372	$\frac{1}{8}$	0.140	0.110	0.094	0.03	0.01
$\frac{1}{4}$	0.2500	0.260	0.237	$\frac{3}{8}$	0.375	0.362	0.530	0.498	$\frac{11}{64}$	0.188	0.156	0.094	0.03	0.01
$\frac{5}{16}$	0.3125	0.324	0.298	$\frac{1}{2}$	0.500	0.484	0.707	0.665	$\frac{13}{64}$	0.220	0.186	0.125	0.03	0.01
$\frac{3}{8}$	0.3750	0.388	0.360	$\frac{9}{16}$	0.562	0.544	0.795	0.747	$\frac{1}{4}$	0.268	0.232	0.125	0.03	0.01
$\frac{7}{16}$	0.4375	0.452	0.421	$\frac{5}{8}$	0.625	0.603	0.884	0.828	$\frac{19}{64}$	0.316	0.278	0.156	0.03	0.01
$\frac{1}{2}$	0.5000	0.515	0.482	$\frac{3}{4}$	0.750	0.725	1.061	0.995	$\frac{21}{64}$	0.348	0.308	0.156	0.03	0.01
$\frac{5}{8}$	0.6250	0.642	0.605	$\frac{15}{16}$	0.938	0.906	1.326	1.244	$\frac{27}{64}$	0.444	0.400	0.312	0.06	0.02
$\frac{3}{4}$	0.7500	0.768	0.729	$1\frac{1}{8}$	1.125	1.088	1.591	1.494	$\frac{1}{2}$	0.524	0.476	0.375	0.06	0.02
$\frac{7}{8}$	0.8750	0.895	0.852	$1\frac{5}{16}$	1.312	1.269	1.856	1.742	$\frac{19}{32}$	0.620	0.568	0.375	0.06	0.02
1	1.0000	1.022	0.976	$1\frac{1}{2}$	1.500	1.450	2.121	1.991	$\frac{21}{32}$	0.684	0.628	0.625	0.09	0.03
$1\frac{1}{8}$	1.1250	1.149	1.098	$1\frac{11}{16}$	1.688	1.631	2.386	2.239	$\frac{3}{4}$	0.780	0.720	0.625	0.09	0.03
$1\frac{1}{4}$	1.2500	1.277	1.223	$1\frac{7}{8}$	1.875	1.812	2.652	2.489	$\frac{27}{32}$	0.876	0.812	0.625	0.09	0.03

GENERAL NOTE: Refer to section 5 for further information on lag screws.

Table 15 Dimensions of Hex Lag Screws

Nominal Size or Basic Product Diameter		Body or Shoulder Diameter, <i>E</i> (See Paras. 5.4 and 5.5)		Width Across Flats, <i>F</i> (See Para. 2.1.2)			Width Across Corners, <i>G</i>		Head Height, <i>H</i>			Minimum Shoulder Length, <i>S</i> (See Para. 5.5)	Radius of Fillet, <i>R</i>	
		Max.	Min.	Basic	Max.	Min.	Max.	Min.	Basic	Max.	Min.		Max.	Min.
No. 10	0.1900	0.199	0.178	⁹ / ₃₂	0.281	0.271	0.323	0.309	¹ / ₈	0.140	0.110	0.094	0.03	0.01
¹ / ₄	0.2500	0.260	0.237	⁷ / ₁₆	0.438	0.425	0.505	0.484	¹¹ / ₆₄	0.188	0.150	0.094	0.03	0.01
⁵ / ₁₆	0.3125	0.324	0.298	¹ / ₂	0.500	0.484	0.577	0.552	⁷ / ₃₂	0.235	0.195	0.125	0.03	0.01
³ / ₈	0.3750	0.388	0.360	⁹ / ₁₆	0.562	0.544	0.650	0.620	¹ / ₄	0.268	0.226	0.125	0.03	0.01
⁷ / ₁₆	0.4375	0.452	0.421	⁵ / ₈	0.625	0.603	0.722	0.687	¹⁹ / ₆₄	0.316	0.272	0.156	0.03	0.01
¹ / ₂	0.5000	0.515	0.482	³ / ₄	0.750	0.725	0.866	0.826	¹¹ / ₃₂	0.364	0.302	0.156	0.03	0.01
⁵ / ₈	0.6250	0.642	0.605	¹⁵ / ₁₆	0.938	0.906	1.083	1.033	²⁷ / ₆₄	0.444	0.378	0.312	0.06	0.02
³ / ₄	0.7500	0.768	0.729	¹¹ / ₈	1.125	1.088	1.299	1.240	¹ / ₂	0.524	0.455	0.375	0.06	0.02
⁷ / ₈	0.8750	0.895	0.852	¹⁵ / ₁₆	1.312	1.269	1.516	1.447	³⁷ / ₆₄	0.604	0.531	0.375	0.06	0.02
1	1.0000	1.022	0.976	¹¹ / ₂	1.500	1.450	1.732	1.653	⁴³ / ₆₄	0.700	0.591	0.625	0.09	0.03
¹¹ / ₈	1.1250	1.149	1.098	¹¹¹ / ₁₆	1.688	1.631	1.949	1.859	³ / ₄	0.780	0.658	0.625	0.09	0.03
¹¹ / ₄	1.2500	1.277	1.223	¹⁷ / ₈	1.875	1.812	2.165	2.066	²⁷ / ₃₂	0.876	0.749	0.625	0.09	0.03

GENERAL NOTE: Refer to section 5 for further information on lag screws.

Table 16 Dimensions of Lag Screw Threads

Nominal Size or Basic Product Diameter	Threads per Inch	Major Diameter		Root Diameter		Length Tolerance	
		Max.	Min.	Max.	Min.	≤ 6 in.	> 6 in.
No. 10	11	0.199	0.178	0.122	0.107	±0.12	±0.25
$\frac{1}{4}$	10	0.260	0.237	0.177	0.160	±0.12	±0.25
$\frac{5}{16}$	9	0.324	0.298	0.228	0.210	±0.12	±0.25
$\frac{3}{8}$	7	0.388	0.360	0.268	0.250	±0.12	±0.25
$\frac{1}{2}$	6	0.515	0.482	0.374	0.354	±0.12	±0.25
$\frac{5}{8}$	5	0.642	0.605	0.473	0.453	±0.25	±0.25
$\frac{3}{4}$	$4\frac{1}{2}$	0.768	0.729	0.582	0.562	±0.25	±0.25
$\frac{7}{8}$	4	0.895	0.852	0.686	0.665	±0.25	±0.25
1	$3\frac{1}{2}$	1.022	0.976	0.784	0.760	±0.25	±0.25
$1\frac{1}{8}$	$3\frac{1}{4}$	1.149	1.100	0.892	0.867	±0.25	±0.25
$1\frac{1}{4}$	$3\frac{1}{4}$	1.277	1.223	1.017	0.987	±0.25	±0.25

GENERAL NOTE: Pilot hole sizes can be established by starting with a fractional drill size closest to the root diameter. Hard woods require a larger pilot hole size than softer woods.

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MANDATORY APPENDIX I

GAGE AND GAGING PRACTICES FOR EXTERNAL LOBED HEAD DRIVE SYSTEM

I-1 SCOPE

This Mandatory Appendix outlines the inspection method and acceptance criteria for external fastener drive configurations having six lobes.

I-2 DEFINITIONS

Drive system configuration: a gear-like shape comprising six equally spaced external radii connected by six equally spaced internal radii.

External drive: a drive that has the configuration formed on the extreme end of the product's head or shank. The configuration has an engagement length, Y , and a maximum fallaway height. The top outer edge of the configuration may be chamfered or rounded (see Fig. I-1). The gage defined in this Mandatory Appendix inspects those characteristics.

I-3 GAGE TYPE

Gages shall be manufactured of tool steel hardened and tempered to a minimum of Rockwell HRC 61.

I-3.1 GO Gages

The external GO gages inspect the acceptability of the configuration and its height of the external drive.

I-3.2 NOT GO Gages

The external NOT GO gages determine the amount of nonconforming configuration (fallaway) present on the external drive.

I-4 INSPECTING EXTERNAL CONFIGURATION

The gaging for the external drive is a single gage consisting of a GO gage on one end and a NOT GO gage on the other. These fixed limit gages shall conform to the specifications in Table I-1 (see Fig. I-2).

I-5 ACCEPTANCE CRITERIA

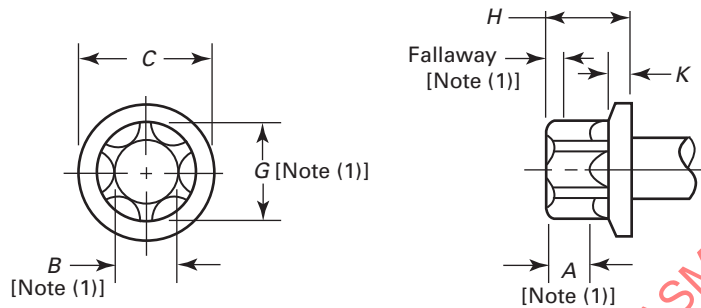
The external drive is acceptable only if it conforms to all three of the following inspections (see Fig. I-3):

(a) *Configuration — Outside Diameter.* The product must freely enter the gage GO hole.

(b) *Fallaway.* Insert the product into the NOT GO (fallaway) hole from the bottom of the gage. The product may enter the NOT GO hole but must not protrude above the top surface of the gage.

(c) *Engagement Length.* Insert the product into the lobed portion of the gage from the bottom. The product must enter the lobed portion of the gage and protrude above the step in the gage. Insert each product three times, rotating the product each time, to inspect all three pairs of interior lobes on the product. All three positions must conform.

Screws with heavy coatings that fail to meet the gaging requirements shall be stripped of the coating and inspected for acceptance in the plain (uncoated) condition.

Fig. I-1 External Lobe Head Configuration

NOTE:

- (1) Fallaway, G, A, B, and other configuration characteristic acceptance shall be determined based on the gage and gaging practice in Mandatory Appendix I.

Table I-1 External Lobed Head Gage

Drive Size	A	B	R	H	L	AA	W	J	K	T
	0.0003 -0.0001	0.0003 -0.0003	0.0000 -0.0002	Ref.	Ref.	0.0003 -0.0001	Ref.	Ref.	0.0050 -0.0000	0.0000 -0.0010
E8	0.2900	0.2070	0.0635	0.2500	3.0000	0.2710	0.7500	0.4571	0.0570	0.0630
E10	0.3650	0.2660	0.0922	0.2500	3.0000	0.3480	1.0000	0.6189	0.0720	0.0790
E12	0.4340	0.3100	0.0945	0.2500	3.0000	0.4060	1.0000	0.6799	0.0900	0.1000
E14	0.5020	0.3610	0.1035	0.3750	3.0000	0.4670	1.0000	0.7598	0.1190	0.1060
E16	0.5740	0.4110	0.1185	0.3750	4.0000	0.5340	1.0000	0.8531	0.1280	0.1170
E18	0.6490	0.4660	0.1325	0.3750	4.0000	0.6020	1.5000	0.9469	0.1470	0.1440
E20	0.7190	0.5180	0.1430	0.3750	4.0000	0.6650	1.5000	1.0630	0.1610	0.1620
E24	0.8640	0.6180	0.1860	0.3750	4.0000	0.8030	1.5000	1.3382	0.2220	0.2110
E28	1.0040	0.7190	0.2150	0.3750	6.0000	0.9340	2.0000	1.5230	0.2730	0.2490
E32	1.1420	0.8390	0.2250	0.3750	6.0000	1.0500	2.0000	1.6110	0.3160	0.2710
E36	1.2840	0.9430	0.2540	0.5000	8.0000	1.1800	4.0000	1.8550	0.3620	0.3120
E40	1.4240	1.0460	0.2820	0.5000	8.0000	1.3090	4.0000	2.0990	0.4130	0.3500
E44	1.5660	1.1510	0.3100	0.5000	8.0000	1.4410	4.0000	2.2250	0.4550	0.3910

GENERAL NOTE: Material: tool steel HRC 58-62.