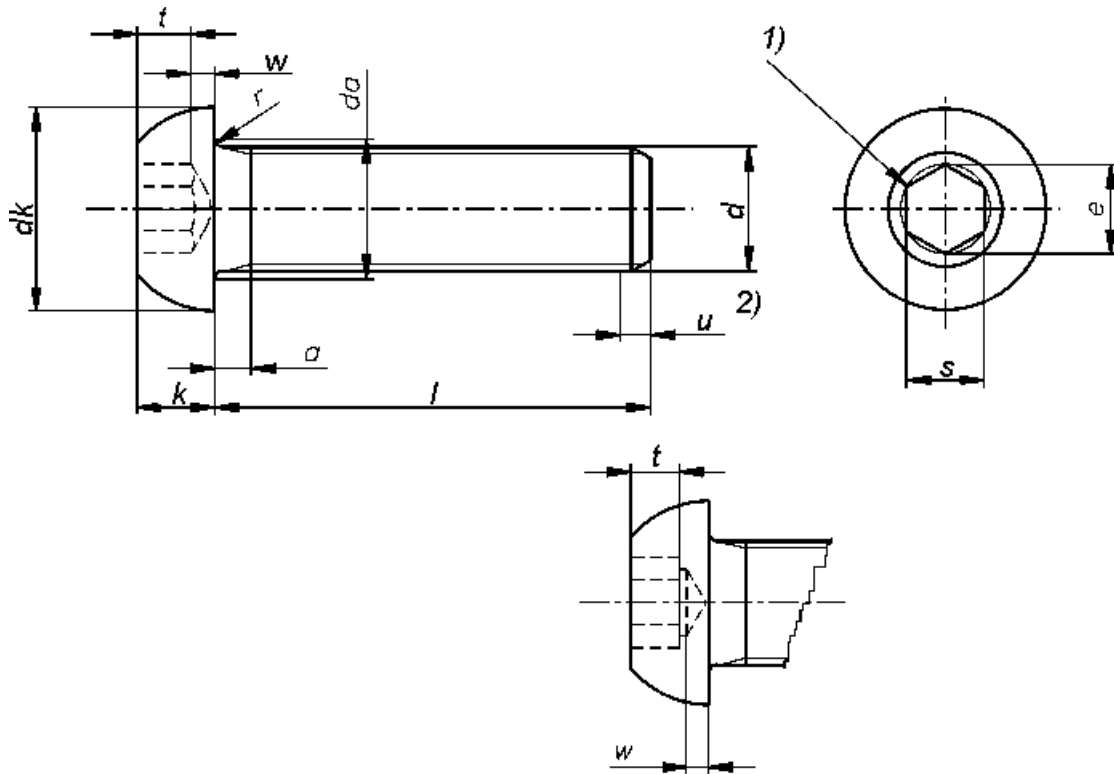


ISO 7380

BOMBE BAŞLI İMBUS CIVATALAR



Permissible Alternative
form of socket

- 1) A slight rounding or countersink at the mouth of the socket is permissible.
- 2) Incomplete thread $u \leq 2P$

Thread size (d)		M5	M6	M8	M10	M12
p ¹⁾		0,8	1	1,25	1,5	1,75
a	max.	1,6	2	2,5	3	3,5
	min.	0,8	1	1,25	1,5	1,75
d_a	max.	5,7	6,8	9,2	11,2	14,2
d_k	max.	9,5	10,5	14	17,5	21
	min.	9,14	10,07	13,57	17,07	20,48
e ²⁾	min.	3,44	4,58	5,72	6,86	9,15
k	max.	2,75	3,3	4,4	5,5	6,6
	min.	2,5	3	4,1	5,2	6,24
r	min.	0,2	0,25	0,4	0,4	0,6
s ³⁾	nom.	3	4	5	6	8
	max.	3,071	4,084	5,084	6,095	8,115
	min.	3,02	4,02	5,02	6,02	8,025
t	min.	1,56	2,08	2,6	3,12	4,16
w	min.	0,38	0,74	1,05	1,45	1,63

l ⁴⁾			Mass (7,85 kg/dm ³) kg per 1000 units approximately				
Nominal Length	min.	max.	M5	M6	M8	M10	M12
10	9,71	10,29	2,08	3,18	6,48		
12	11,65	12,35	2,32	3,52	7,10		
(14) ⁵⁾	13,65	14,35	2,56	3,86	7,72		
16	15,65	16,35	2,80	4,20	8,34	14,62	25,02
(18)	17,65	18,35	3,04	4,54	8,96	15,60	26,44
20	19,58	20,42	3,28	4,88	9,58	16,57	27,86
(22)	21,58	22,42	3,51	5,22	10,20	17,54	29,28
25	24,58	25,42	3,87	5,73	11,14	19,01	31,42
30	29,58	30,42	4,47	6,58	12,69	21,45	34,98
35	34,5	35,5	5,61	8,02	14,24	23,89	38,54
40	39,5	40,5	6,38	9,09	15,80	26,33	42,11
45	44,5	45,5	7,15	10,17	16,63	27,34	45,67
50	49,5	50,5	7,92	11,25	18,55	30,35	49,23
55	54,4	55,6			20,47	33,36	48,57
60	59,4	60,6			22,38	36,38	52,90
65	64,4	65,6			24,30	39,39	57,24
70	69,4	70,6			26,22	42,41	61,57
75	74,4	75,6			28,14	45,42	65,91
80	79,4	80,6			30,06	48,43	70,24
85	84,3	85,7			31,97	51,45	74,57
90	89,3	90,7					78,91
95	94,3	95,7					83,24
100	99,3	100,7					87,57

¹⁾ p = Pitch of thread

²⁾ $e_{min} = 1,14s_{min}$

³⁾ s shall be gauged by attribute methods

⁴⁾ For nominal lengths below the bottom stepped line, the thread lengths, at the discretion of the manufacturer, may be between a minimum of $2d + 12$ mm and maximum which is within $2p$ of the head. intermediate nominal lengths according to ISO 888 are permissible

⁵⁾ The size in brackets should be avoided if possible

PRODUCTS IN THE GREEN REGION ARE AVAILABLE

Technical Delivery Conditions

Material		Steel
General requirements	Standard	ISO 8992
Thread	Tolerance	5g6g
	Standard	ISO 261, ISO 965-2, ISO 965-3
Mechanical properties	Property class	12.9 ¹⁾
	Standard	ISO 898-1 ²⁾
Tolerances	Product grade	A
	Standard	ISO 4759-1
Finish and/or coating		Blackened (thermally or chemically)
		Requirements for electroplating are covered in ISO 4042
		Limits for surface discontinuities are covered in ISO 6157-3
		If different electroplating requirements are desired or if requirements are needed for other finishes, they should be agreed between customer and supplier
Acceptability		For acceptance procedure, see ISO 3269

¹⁾Other property classes or materials subject to agreement.

²⁾ Because their head configurations, these screws may not meet the minimum ultimate tensile load for property class 12.9, specified in ISO 898-1, when tested in accordance with the test programme B. They shall nevertheless meet other material and property requirements for property class 12.9 specified in ISO 898-1.

In addition, when full size screws are loaded using the type of testing fixture illustrated in ISO 898-1 they shall withstand %80 of the test loads specified in the same standard (minimum ultimate tensile loads) without fracture.

If tested to failure, the fracture may occur in the threaded section, the shank, the head or at the head/shank junction.