
**Slotted cheese head screws — Product
grade A**

Vis à métaux à tête cylindrique fendue — Grade A

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 1207 was prepared by Technical Committee ISO/TC 2, *Fasteners*, Subcommittee SC 11, *Fasteners with metric external thread*.

This third edition cancels and replaces the second edition (ISO 1207:1992), which has been technically revised.

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Slotted cheese head screws — Product grade A

1 Scope

This International Standard specifies the characteristics of slotted cheese head screws of product grade A and with threads from M1,6 to M10 inclusive.

If, in special cases, specifications other than those listed in this International Standard are required, they can be selected from existing International Standards, for example ISO 261, ISO 888, ISO 898-1, ISO 965-2, ISO 3506-1, ISO 4759-1.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 225, *Fasteners — Bolts, screws, studs and nuts — Symbols and descriptions of dimensions*

ISO 261, *ISO general purpose metric screw threads — General plan*

ISO 898-1, *Mechanical properties of fasteners made of carbon steel and alloy steel — Part 1: Bolts, screws and studs with specified property classes — Coarse thread and fine pitch thread*

ISO 965-2, *ISO general purpose metric screw threads — Tolerances — Part 2: Limits of sizes for general purpose external and internal screw threads — Medium quality*

ISO 965-3, *ISO general purpose metric screw threads — Tolerances — Part 3: Deviations for constructional screw threads*

ISO 3269, *Fasteners — Acceptance inspection*

ISO 3506-1, *Mechanical properties of corrosion-resistant stainless steel fasteners — Part 1: Bolts, screws and studs*

ISO 4042, *Fasteners — Electroplated coatings*

ISO 4753, *Fasteners — Ends of parts with external ISO metric thread*

ISO 4759-1, *Tolerances for fasteners — Part 1: Bolts, screws, studs and nuts — Product grades A, B and C*

ISO 6157-1, *Fasteners — Surface discontinuities — Part 1: Bolts, screws and studs for general requirements*

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

ISO 8992, *Fasteners — General requirements for bolts, screws, studs and nuts*

ISO 10683, Fasteners — Non-electrolytically applied zinc flake coatings

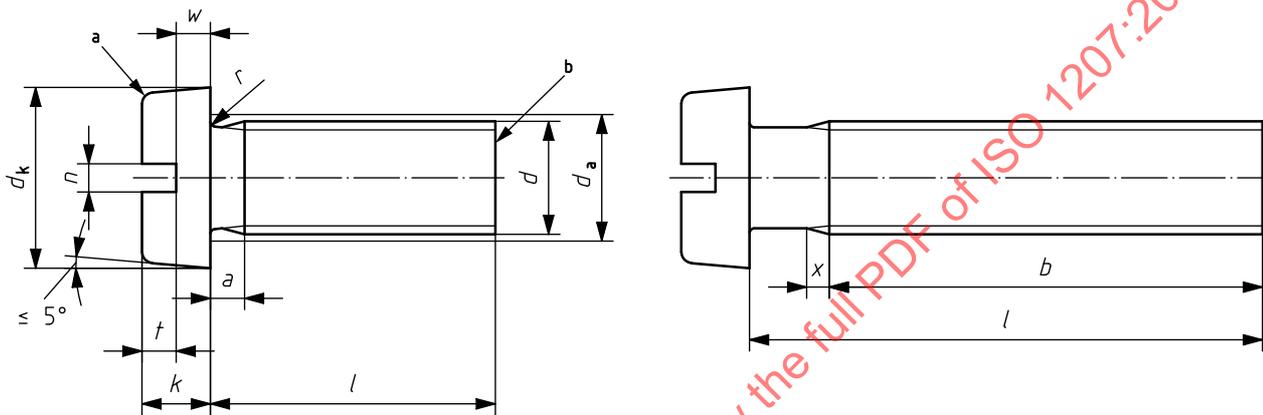
ISO 16048, Passivation of corrosion-resistant stainless-steel fasteners

3 Dimensions

See Figure 1 and Table 1.

The shank diameter is approximately equal to the pitch diameter or equal to the major thread diameter permissible.

The symbols and descriptions of dimensions are specified in ISO 225.



- a Edge may be rounded or flat.
- b As-rolled end (RL) in accordance with ISO 4753.

Figure 1 — Slotted cheese head screws

Table 1 — Dimensions

Dimensions in millimetres

Thread, d		M1,6	M2	M2,5	M3	(M3,5) ^a	M4	M5	M6	M8	M10	
p^b		0,35	0,4	0,45	0,5	0,6	0,7	0,8	1	1,25	1,5	
a	max.	0,7	0,8	0,9	1,0	1,2	1,4	1,6	2,0	2,5	3,0	
b	min.	25	25	25	25	38	38	38	38	38	38	
d_a	max.	2,0	2,6	3,1	3,6	4,1	4,7	5,7	6,8	9,2	11,2	
d_k	nom. = max.	3,00	3,80	4,50	5,50	6,00	7,00	8,50	10,00	13,00	16,00	
	min.	2,86	3,62	4,32	5,32	5,82	6,78	8,28	9,78	12,73	15,73	
k	nom. = max.	1,10	1,40	1,80	2,00	2,40	2,60	3,30	3,9	5,0	6,0	
	min.	0,96	1,26	1,66	1,86	2,26	2,46	3,12	3,6	4,7	5,7	
n	nom.	0,4	0,5	0,6	0,8	1	1,2	1,2	1,6	2	2,5	
	max.	0,60	0,70	0,80	1,00	1,20	1,51	1,51	1,91	2,31	2,81	
	min.	0,46	0,56	0,66	0,86	1,06	1,26	1,26	1,66	2,06	2,56	
r	min.	0,10	0,10	0,10	0,10	0,10	0,20	0,20	0,25	0,40	0,40	
t	min.	0,45	0,60	0,70	0,85	1,00	1,10	1,30	1,60	2,00	2,40	
w	min.	0,40	0,50	0,70	0,75	1,00	1,10	1,30	1,60	2,00	2,40	
x	max.	0,90	1,00	1,10	1,25	1,50	1,75	2,00	2,50	3,20	3,80	
l^c		Approximate mass, in kilograms per 1 000 pieces ($\rho = 7,85 \text{ kg/dm}^3$) (for information only)										
nom. ^a	min.	max.										
2	1,80	2,20	0,07									
3	2,80	3,20	0,082	0,16	0,272							
4	3,76	4,24	0,094	0,179	0,302	0,515						
5	4,76	5,24	0,105	0,198	0,332	0,56	0,786	1,09				
6	5,76	6,24	0,117	0,217	0,362	0,604	0,845	1,17	2,06			
8	7,71	8,29	0,14	0,254	0,422	0,692	0,966	1,33	2,3	3,56		
10	9,71	10,29	0,163	0,291	0,482	0,78	1,08	1,47	2,55	3,92	7,85	
12	11,65	12,35	0,186	0,329	0,542	0,868	1,2	1,63	2,8	4,27	8,49	14,6
(14)	13,65	14,35	0,209	0,365	0,602	0,956	1,32	1,79	3,05	4,62	9,13	15,6
16	15,65	16,35	0,232	0,402	0,662	1,04	1,44	1,95	3,3	4,98	9,77	16,6
20	19,58	20,42		0,478	0,782	1,22	1,68	2,25	3,78	5,69	11	18,6
25	24,58	25,42			0,932	1,44	1,98	2,64	4,4	6,56	12,6	21,1
30	29,58	30,42				1,66	2,28	3,02	5,02	7,45	14,2	23,6
35	34,50	35,50					2,57	3,41	5,62	8,25	15,8	26,1
40	39,50	40,50						3,8	6,25	9,2	17,4	28,6
45	44,50	45,50							6,88	10	18,9	31,1
50	49,50	50,50							7,5	10,9	20,6	33,6
(55)	54,05	55,95								11,8	22,1	36,1
60	59,05	60,95								12,7	23,7	38,6
(65)	64,05	65,95									25,2	41,1
70	69,05	70,95									26,8	43,6
(75)	74,05	75,95									28,3	46,1
80	79,05	80,95									29,8	48,6
NOTE Preferred lengths are those between the solid, bold, stepped lines.												
^a Sizes in parentheses should be avoided if possible.												
^b P = pitch of the thread.												
^c Screws with nominal lengths above the discontinuous line are threaded up to the head ($b = l - a$).												

4 Specifications and reference International Standards

See Table 2.

Table 2 — Specifications and reference International Standards

Material		Steel	Stainless steel	Non-ferrous metal
General requirements	International Standard	ISO 8992		
Thread	Tolerance class	6g		
	International Standard	ISO 261, ISO 965-2, ISO 965-3		
Mechanical property	Property class	4.8, 5.8	A2-50, A2-70	As agreed
	International Standard	ISO 898-1	ISO 3506-1	ISO 8839
Tolerances	Product grade	A		
	International Standard	ISO 4759-1		
Finish — Coating		As processed		
		Requirements for electroplating are specified in ISO 4042. Requirements for non-electrolytically applied zinc flake coatings are specified in ISO 10683.	Requirements for passivation are specified in ISO 16048.	Requirements for electroplating are specified in ISO 4042.
		Additional requirements or other finishes or coatings shall be agreed between the supplier and the purchaser.		
Surface integrity		Limits for surface discontinuities are specified in ISO 6157-1.		
Acceptability		Acceptance inspection is specified in ISO 3269.		

5 Designation

EXAMPLE A slotted cheese head screw with thread M5, nominal length $l = 20$ mm and property class 4.8 is designated as follows:

Cheese head screw ISO 1207 - M5 × 20 - 4.8