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# International Standard



# 4018

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INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

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## ● Hexagon head screws — Product grade C

*Vis à tête hexagonale — Classe de produit C*

**First edition — 1979-06-15**

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**Ref. No. ISO 4018-1979 (E)**

**Descriptors :** fasteners, screws, hexagonal head screws, specifications, dimensions, dimensional tolerances, designation.

## FOREWORD

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been set up 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.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 4018 was developed by Technical Committee ISO/TC 2, *Fasteners*, and was circulated to the member bodies in December 1977.

It has been approved by the member bodies of the following countries:

Australia	Hungary	Poland
Belgium	India	Romania
Canada	Israel	South Africa, Rep. of
Chile	Italy	Spain
Czechoslovakia	Korea, Rep. of	Sweden
Denmark	Mexico	Switzerland
Egypt, Arab Rep. of	Netherlands	United Kingdom
Finland	New Zealand	USA
Germany, F.R.	Norway	Yugoslavia

The member bodies of the following countries expressed disapproval of the document on technical grounds:

France  
USSR

# Hexagon head screws — Product grade C

## 0 INTRODUCTION

This International Standard is part of the complete ISO product standards series on hexagon drive fasteners. The series comprises :

- a) Hexagon head bolts (ISO 4014, ISO 4015 and ISO 4016)
  - b) Hexagon head screws (ISO 4017 and ISO 4018)
  - c) Hexagon nuts (ISO 4032, ISO 4033, ISO 4034, ISO 4035 and ISO 4036)
  - d) Hexagon flanged bolts
  - e) Hexagon flanged screws
  - f) Hexagon flanged nuts
  - g) Structural bolting
- } (in preparation)

## 1 SCOPE AND FIELD OF APPLICATION

This International Standard gives specifications for hexagon head screws with metric dimensions and thread diameters from 5 up to and including 36 mm, of product grade C.

No finish is required for this product except for the thread. A small die seam across the bearing surface is permissible.

This type of product is the same as that covered by ISO 4016 with the exception of threading up to the head and lengths  $\leq 100$  mm as popular lengths.

If, in special cases, specifications other than those listed in this International Standard are required, it is recommended that they should be selected from existing International Standards, for example ISO 261, ISO 888, ISO 898, ISO 965, ISO 4759/1.

## 2 REFERENCES

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

ISO 888, *Bolts, screws and studs — Nominal lengths, and thread lengths for general purpose bolts.*

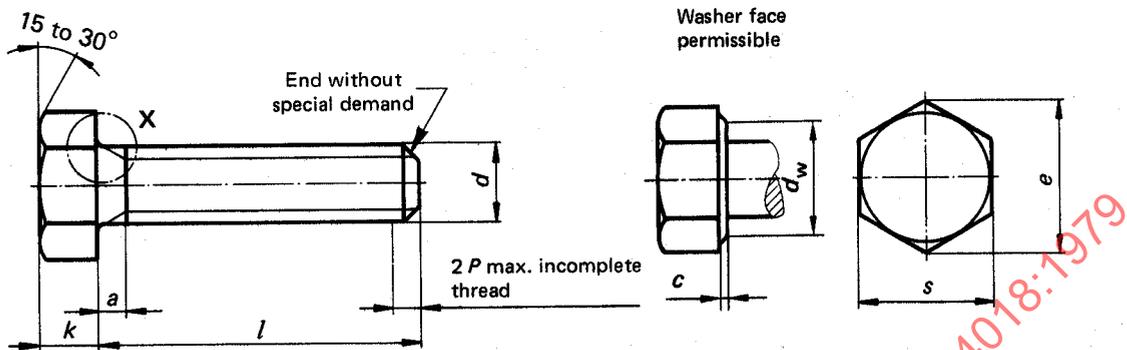
ISO 898, *Mechanical properties of fasteners.*

ISO 965, *ISO general purpose metric screw threads — Tolerances.*

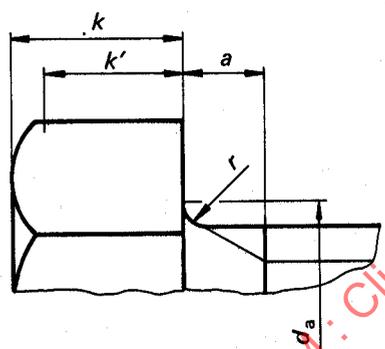
ISO 1461, *Metallic coatings — Hot dip galvanized coatings on fabricated ferrous products — Requirements.*

ISO 4759/1, *Tolerances for fasteners — Part 1: Bolts, screws and nuts with thread diameters  $\geq 1,6 \leq 150$  mm and product grades A, B and C.*

3 DIMENSIONS

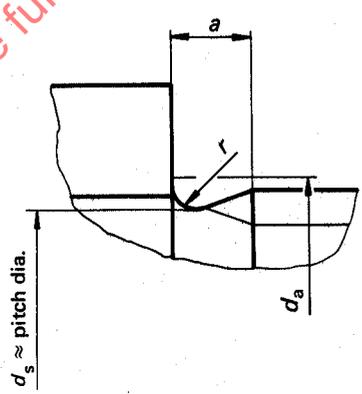


Detail X



Minimum wrenching height  
 $k' = 0,7 k$  min. (see table)

Permissible shape



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Dimensions in millimetres

Thread size <i>d</i>			M5	M6	M8	M10	M12	(M14)	M16	M20	M24	M30	M36
<i>P</i>	1)		0,8	1	1,25	1,5	1,75	2	2	2,5	3	3,5	4
<i>a</i> <sup>2)</sup>	max.		3,2	4	5	6	7	8	8	10	12	14	16
<i>c</i>	max.		0,5	0,5	0,6	0,6	0,6	0,6	0,8	0,8	0,8	0,8	0,8
<i>d<sub>a</sub></i>	max.		6	7,2	10,2	12,2	14,7	16,7	18,7	24,4	28,4	34,4	40,4
<i>d<sub>w</sub></i>	min.		6,7	8,7	11,4	14,4	16,4	19,2	22	27,7	33,2	42,7	51,1
<i>e</i>	min.		8,63	10,89	14,20	17,59	19,85	22,78	26,17	32,95	39,55	50,85	60,79
<i>k</i>	nom.		3,5	4	5,3	6,4	7,5	8,8	10	12,5	15	18,7	22,5
	min.		3,12	3,62	4,92	5,95	7,05	8,35	9,25	11,6	14,1	17,65	21,45
	max.		3,88	4,38	5,68	6,85	7,95	9,25	10,75	13,4	15,9	19,75	23,55
<i>k'</i>	min.		2,2	2,5	3,45	4,2	4,95	5,85	6,5	8,1	9,9	12,4	15,0
<i>r</i>	min.		0,2	0,25	0,4	0,4	0,6	0,6	0,6	0,8	0,8	1	1
<i>s</i>	max.		8	10	13	16	18	21	24	30	36	46	55
	min.		7,64	9,64	12,57	15,57	17,57	20,16	23,16	29,16	35	45	53,8
<i>l</i>													
nom.	min.	max.											
10	9,10	10,90											
12	11,10	12,90											
16	15,10	16,90											
20	18,95	21,05											
25	23,95	26,05											
30	28,95	31,05											
35	33,75	36,25											
40	38,75	41,25											
45	43,75	46,25											
50	48,75	51,25											
55	53,5	56,5											
60	58,5	61,5											
65	63,5	66,5											
70	68,5	71,5											
80	78,5	81,5											
90	88,25	91,75											
100	98,25	101,75											

The popular lengths are between the stepped lines. The size M14 should be avoided if possible.

1) *P* = pitch of the thread.

2) *a* min. not less than 1*P*.

## 4 SPECIFICATIONS AND REFERENCE STANDARDS

<b>Material</b>		Steel
<b>Thread</b>	Tolerance	8g
	International Standards	ISO 261, ISO 965
<b>Mechanical properties</b>	Classes	4.6-4.8
	International Standard	ISO 898/1
<b>Tolerances</b>	Product grade	C
	International Standard	ISO 4759/1
<b>Finish</b>	Requirements for electroplating are covered in ISO . . . 1) If different electroplating requirements are desired or if requirements are needed for other finishes, they should be negotiated between supplier and customer. For hot dipped galvanizing see ISO 1461.	
<b>Acceptability</b>	For acceptance procedure see ISO . . . 1)	

1) In preparation.

## 5 DESIGNATION

Example for the designation of a hexagon head screw with thread size  $d = M 12$ , nominal length  $l = 80$  mm and property class 4.6 :

**Hexagon head screw ISO 4018 M12 × 80-4.6**

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