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**Hexagon high nuts (style 2) with metric fine  
pitch thread — Product grades A and B**

*Écrous hexagonaux hauts (style 2) à filetage métrique à pas fin —  
Grades A et B*

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Published in Switzerland

**Contents**

Page

<b>Foreword</b> .....	<b>iv</b>
<b>Introduction</b> .....	<b>v</b>
<b>1 Scope</b> .....	<b>1</b>
<b>2 Normative references</b> .....	<b>1</b>
<b>3 Dimensions</b> .....	<b>1</b>
<b>4 Requirements and reference International Standards</b> .....	<b>3</b>
<b>5 Designation</b> .....	<b>3</b>
<b>Bibliography</b> .....	<b>4</b>

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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 8674 was prepared by Technical Committee ISO/TC 2, *Fasteners*, Subcommittee SC 12, *Fasteners with metric internal thread*.

This third edition cancels and replaces the second edition (ISO 8674:1999), of which it constitutes a minor revision.

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## Introduction

This International Standard belongs to a complete group of product standards developed by ISO on external hexagon drive fasteners. It comprises the following:

- a) hexagon head bolts (ISO 4014, ISO 4015, ISO 4016 and ISO 8765);
- b) hexagon head screws (ISO 4017, ISO 4018 and ISO 8676);
- c) hexagon nuts (ISO 4032, ISO 4033, ISO 4034, ISO 4035, ISO 4036, ISO 7040, ISO 7041, ISO 7042, ISO 7719, ISO 7720, ISO 8673, ISO 8674, ISO 8675, ISO 10511, ISO 10512 and ISO 10513);
- d) hexagon bolts with flange (ISO 4162, ISO 15071 and ISO 15072);
- e) hexagon nuts with flange (ISO 4161, ISO 7043, ISO 7044, ISO 10663, ISO 12125, ISO 12126 and ISO 21670).

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# Hexagon high nuts (style 2) with metric fine pitch thread — Product grades A and B

## 1 Scope

This International Standard specifies the characteristics of hexagon high nuts (style 2) with metric fine pitch thread, with nominal thread diameters,  $D$ , from 8 mm up to and including 36 mm, with product grade A for sizes  $D \leq 16$  mm and product grade B for sizes  $D > 16$  mm.

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 724, ISO 898-2, ISO 965-1 and ISO 4759-1.

## 2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable to its application. 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 724, *ISO general-purpose metric screw threads — Basic dimensions*

ISO 898-2, *Mechanical properties of fasteners made of carbon steel and alloy steel — Part 2: Nuts with specified property classes — Coarse thread and fine pitch thread*

ISO 965-1, *ISO general-purpose metric screw threads — Tolerances — Part 1: Principles and basic data*

ISO 3269, *Fasteners — Acceptance inspection*

ISO 4042, *Fasteners — Electroplated coatings*

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

ISO 6157-2, *Fasteners — Surface discontinuities — Part 2: Nuts*

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

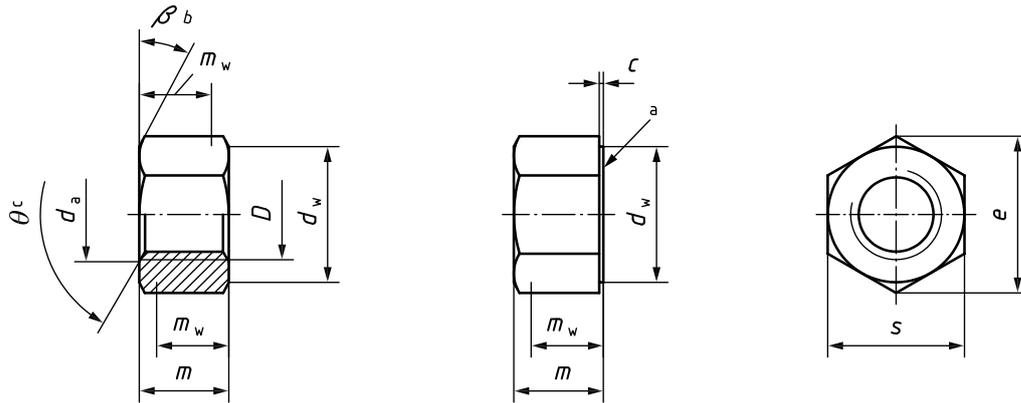
ISO 8992, *Fasteners — General requirements for bolts, screws, studs and nuts*

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

## 3 Dimensions

See Figure 1 and Tables 1 and 2.

Symbols and descriptions of dimensions are specified in ISO 225.



- a Unless otherwise specified at the time of order, the nuts are delivered without washer-face.
- b  $\beta = 15^\circ$  to  $30^\circ$ .
- c  $\theta = 90^\circ$  to  $120^\circ$ .

Figure 1

Table 1 — Preferred threads

Dimensions in millimetres

Thread ( $D \times P$ )	M8×1	M10×1	M12×1,5	M16×1,5	M20×1,5	M24×2	M30×2	M36×3
$c$	max.	0,60	0,60	0,60	0,80	0,80	0,80	0,80
	min.	0,15	0,15	0,15	0,20	0,20	0,20	0,20
$d_a$	max.	8,75	10,80	13,00	17,30	21,60	25,90	32,40
	min.	8,00	10,00	12,00	16,00	20,00	24,00	30,00
$d_w$	min.	11,63	14,63	16,63	22,49	27,70	33,25	42,75
$e$	min.	14,38	17,77	20,03	26,75	32,95	39,55	50,85
$m$	max.	7,50	9,30	12,00	16,40	20,30	23,90	28,60
	min.	7,14	8,94	11,57	15,70	19,00	22,60	27,30
$m_w$	min.	5,71	7,15	9,26	12,56	15,20	18,08	21,84
$s$	nom. = max.	13,00	16,00	18,00	24,00	30,00	36,00	46,00
	min.	12,73	15,73	17,73	23,67	29,16	35,00	45,00

Table 2 — Non-preferred threads

Dimensions in millimetres

Thread ( $D \times P$ )	M10×1,25	M12×1,25	M14×1,5	M18×1,5	M20×2	M22×1,5	M27×2	M33×2
$c$	max.	0,60	0,60	0,60	0,80	0,80	0,80	0,80
	min.	0,15	0,15	0,15	0,20	0,20	0,20	0,20
$d_a$	max.	10,80	13,00	15,10	19,50	21,60	23,70	29,10
	min.	10,00	12,00	14,00	18,00	20,00	22,00	27,00
$d_w$	min.	14,63	16,63	19,64	24,85	27,70	31,35	38,00
$e$	min.	17,77	20,03	23,36	29,56	32,95	37,29	45,20
$m$	max.	9,30	12,00	14,10	17,60	20,30	21,80	26,70
	min.	8,94	11,57	13,40	16,90	19,00	20,50	25,40
$m_w$	min.	7,15	9,26	10,72	13,52	15,20	16,40	20,32
$s$	nom. = max.	16,00	18,00	21,00	27,00	30,00	34,00	41,00
	min.	15,73	17,73	20,67	26,16	29,16	33,00	40,00

## 4 Requirements and reference International Standards

See Table 3.

**Table 3 — Requirements and reference International Standards**

<b>Material</b>		Steel
<b>General requirements</b>	International Standard	ISO 8992
<b>Thread</b>	Tolerance class	6H
	International Standards	ISO 724, ISO 965-1
<b>Mechanical properties</b>	Property class	$D \leq 16$ mm: 8, 12 $D \leq 36$ mm: 10
	International Standard	ISO 898-2
<b>Tolerance</b>	Product grade	$D \leq 16$ mm: A $D > 16$ mm: B
	International Standard	ISO 4759-1
<b>Finish — Coating</b>		As processed Requirements for electroplating are specified in ISO 4042. Requirements for non-electrolytically applied zinc flake coatings are specified in ISO 10683. Additional requirements or other finishes or coatings shall be agreed between the supplier and the purchaser.
<b>Surface integrity</b>		Limits for surface discontinuities are specified in ISO 6157-2.
<b>Acceptability</b>		Acceptance inspection is specified in ISO 3269.

## 5 Designation

EXAMPLE A hexagon high nut (style 2) with thread M16 × 1,5 and property class 12 is designated as follows:

**Hexagon high nut ISO 8674 - M16 × 1,5 - 12**