

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION R 273

PART II

CLEARANCE HOLES FOR METRIC BOLTS

42 UP TO AND INCLUDING 150 mm THREAD DIAMETER

1st EDITION
November 1968

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Printed in Switzerland

Also issued in French and Russian. Copies to be obtained through the national standards organizations.

BRIEF HISTORY

ISO Recommendation R 273, Part II, *Clearance holes for metric bolts 42 up to and including 150 mm thread diameter*, was drawn up by Technical Committee ISO/TC 2, *Bolts, nuts and accessories*, the Secretariat of which is held by the Deutscher Normenausschuss (DNA).

ISO Recommendation R 273-1962, which is now considered as Part I of ISO/R 273, refers to clearance holes for metric bolts with thread diameters from 1.6 up to and including 39 mm, in conformity with ISO Recommendation R 272-1962.

ISO Recommendation R 273, Part II, was prepared to conform with a revision of ISO Recommendation R 272, published in 1968 and containing additional specifications for hexagon bolts and nuts with thread diameters from 42 up to and including 150 mm. In conjunction with that revision, a proposal concerning clearance holes for metric bolts with these diameters was adopted by the Technical Committee in October, 1966.

In August 1967, this document, intended originally as an addendum to ISO Recommendation R 273-1962, was circulated as Draft ISO Recommendation No. 1276 to all ISO Member Bodies for enquiry. It was approved by the following Member Bodies:

Austria	India	Romania
Belgium	Iran	South Africa, Rep. of
Canada	Israel	Spain
Chile	Italy	Sweden
Czechoslovakia	Japan	Switzerland
Denmark	Korea, Rep. of	Thailand
Finland	Netherlands	Turkey
France	New Zealand	U.A.R.
Germany	Norway	United Kingdom
Greece	Poland	U.S.A.
Hungary	Portugal	U.S.S.R.

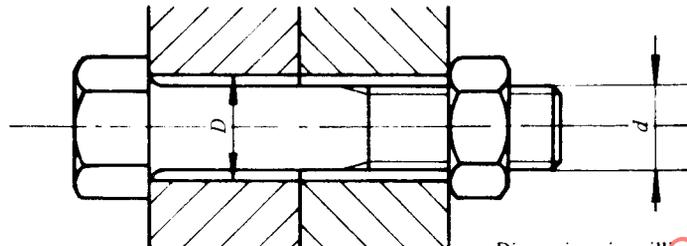
No Member Body opposed the approval of the Draft.

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in November 1968, to accept it. It is now published as Part II of ISO Recommendation R 273.

PART II

CLEARANCE HOLES FOR METRIC BOLTS

42 UP TO AND INCLUDING 150 mm THREAD DIAMETER



Thread diameter d	Clearance holes D^*		
	fine	Series medium	coarse
42	43	45	48
45	46	48	52
48	50	52	56
52	54	56	62
56	58	62	66
60	62	66	70
64	66	70	74
68	70	74	78
72	74	78	82
76	78	82	86
80	82	86	91
85	87	91	96
90	93	96	101
95	98	101	107
100	104	107	112
105	109	112	117
110	114	117	122
115	119	122	127
120	124	127	132
125	129	132	137
130	134	137	144
140	144	147	155
150	155	158	165

- * The following tolerance zones are given for information only, for use where it is considered desirable to specify tolerances in national standards :

fine series : H12
 medium series : H13
 coarse series : H14

In cases where it is necessary to avoid interference between the edge of the clearance hole and the radius under the head of the bolt, it is recommended to chamfer the edge of the clearance hole.