

Submitted for recognition as an American National Standard

METRIC YOKE TYPE ROD ENDS

1. **Scope**—This SAE Standard provides dimensions, tolerances, material, and heat treatment for yoke type rod ends with metric threads and for use with metric size clevis pins.
2. **References**
 - 2.1 **Applicable Publication**—The following publication forms a part of this specification to the extent specified herein.
 - 2.1.1 ASME PUBLICATION—Available from ASME, 22 Law Drive, Fairfield, NJ 07007.

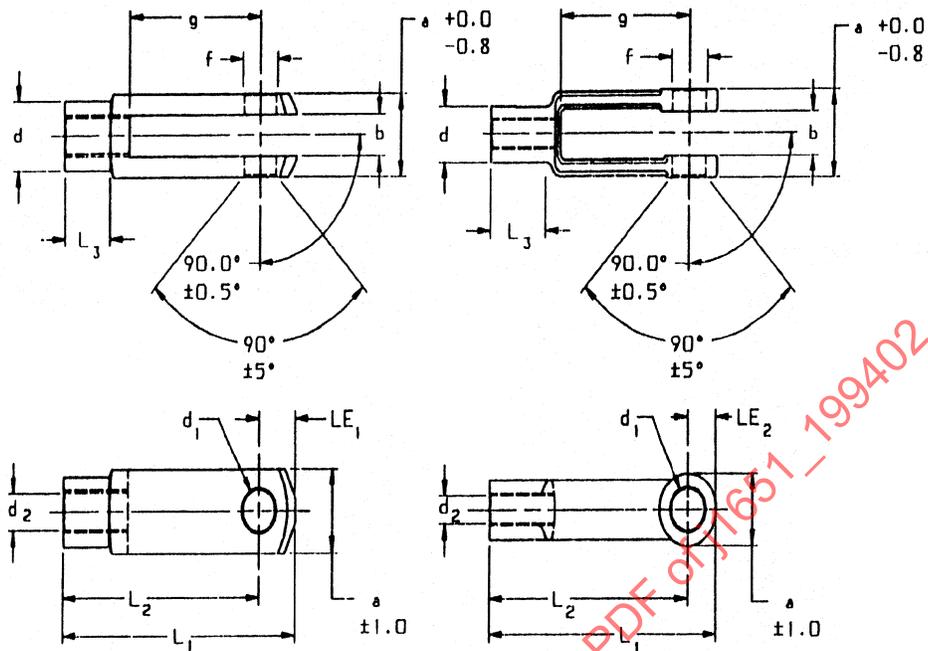
ASME B 18.8.8M—Headed Clevis Pins (Metric Series)
3. **Dimensions**—Figure 1 shows dimensions for the yoke type rod ends. Dimensions apply to either the machined from bar stock or the forged rod ends.
4. **Material**—Unless otherwise agreed to between the purchaser and the manufacturer, rod ends shall be made of low carbon steel either machined from square bar stock or forged.
5. **Case Hardening**—Unless otherwise specified, when case hardening is required the rod ends shall have a case depth of 0.05 to 0.20 mm and a hardness of Rockwell 15N 85.
6. **Coating**—Unless otherwise specified, rod ends shall be plated with a minimum of 0.0035 mm zinc with a dichromate conversion applied. Dimensions and tolerances apply after plating.
7. **Workmanship**—Yoke type ends shall be free from burrs, loose scale, sharp edges, and all other defects that affect their serviceability.
8. **Clevis Pins**—Clevis pins conforming to ASME B 18.8.8M are recommended for use with yoke type rod ends conforming to this document. Suggested lengths and some reference dimensions are shown in Figure 2.

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d_1 (H10*) -0.0 +	g min	a	b		d	d_2	f ± 0.5	L_1 max ref	L_2 ±2	L_3 ±2	LE_1		LE_2	
			min	max							min	max	min	max
4	0.05 16	8	8	4.10 4.40	M4x0.7	8	5	24.5 32.5	16 24	6	4.5 6.5	4.0 6.5		
5	0.05 20	10	10	5.10 5.40	M5x0.8	9	6	29.5 39.5	20 30	7.5	5.5 7.5	5.0 7.5		
6	0.05 24	12	12	6.10 6.40	M6x1	10	7	34.5 46.5	24 36	9	6.5 8.5	6.0 8.5		
8	0.06 32	16	16	8.15 8.50	M8x1.25	14	9	44.5 60.5	32 48	12	8.5 10.5	8.0 10.5		
10	0.07 40	20	20	10.15 10.50	M10x1.5	18	11	54.5 74.5	40 60	15	10.5 12.5	10.0 12.5		
12	0.07 48	24	24	12.15 12.50	M12x1.75	20	13	64.5 88.5	48 72	18	12.5 14.5	12.0 14.5		
16	0.07 64	32	32	16.15 16.50	M16x2	26	17	84.5 116.5	64 96	24	16.5 18.5	16.0 18.5		
20	0.08 80	40	40	20.15 20.60	M20x2.5	34	21	106.0 146.0	80 120	30	21.0 24.0	20.0 24.0		
24	0.08 96	48	48	25.15 25.60	M24x3	42	25	126.0 174.0	96 144	36	25.0 28.0	24.0 28.0		

*ROUNDED

FIGURE 1—YOKE TYPE ROD END DIMENSIONS (ALL DIMENSIONS IN MM)

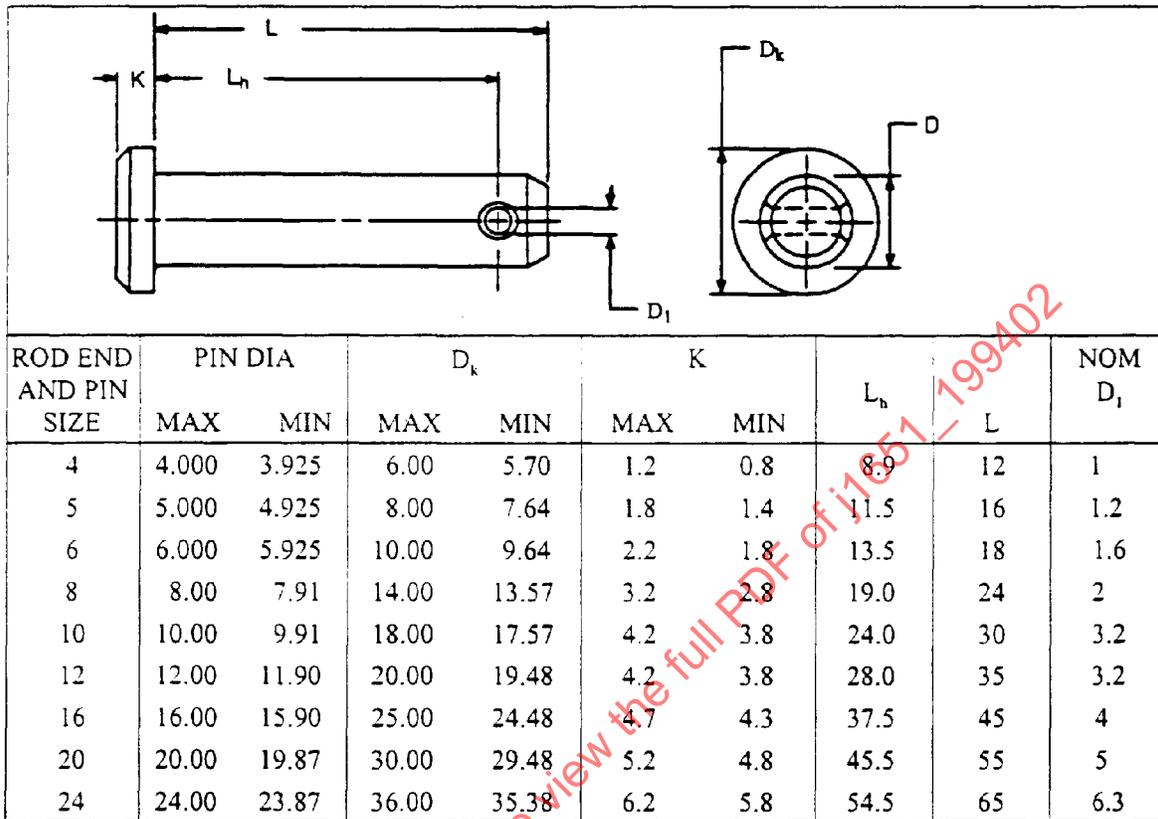


FIGURE 2—DIMENSIONS OF RECOMMENDED CLEVIS PINS (ALL DIMENSIONS IN mm)

PREPARED BY THE SAE BALL JOINT SPHERICAL ROD END COMMITTEE