

# M1,6 to M39 hexagon head bolts

Product grades A and B

**DIN**  
**931**  
Part 1

Sechskantschrauben mit Schaft; Gewinde M1,6 bis M39;  
Produktklassen A und B

This standard, together with  
DIN ISO 4014, September 1987 edition,  
supersedes the December 1982 edition.

This standard should be used together with ISO 4014. For details, see Explanatory notes. It is intended to withdraw the present standard by 1 July 1992 at the latest.

In keeping with current practice in standards published by the International Organization for Standardization (ISO), a comma has been used throughout as the decimal marker.

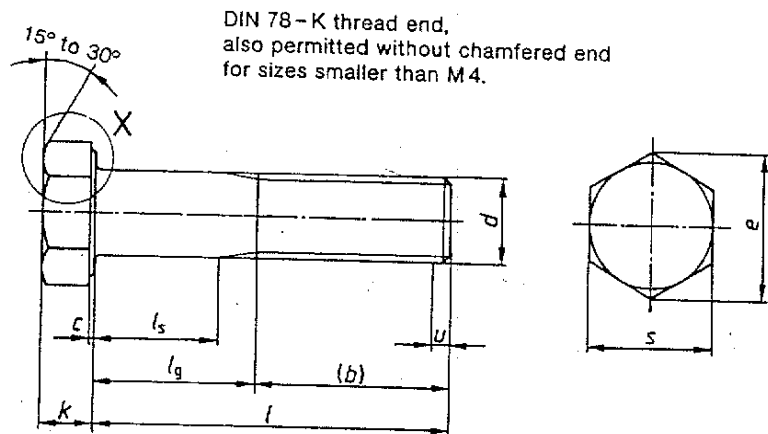
Dimensions in mm

## 1 Field of application

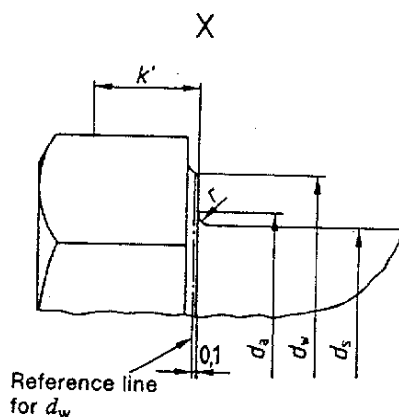
This standard specifies requirements for M1,6 to M36 hexagon head bolts assigned to product grade A for thread sizes up to and including M24 and lengths smaller than  $10d$  or 150 mm, and assigned to product grade B for thread sizes above M24 or lengths exceeding  $10d$  or 150 mm.

If, in special cases, bolts are to comply with specifications other than those given in this standard, e.g. regarding nominal lengths, these shall be selected in accordance with the appropriate standard.

## 2 Dimensions



$u$  = maximum of  $2P$  incomplete thread.



$k'$  = minimum wrenching  
height (0,7  $k$  min.).

Continued on pages 2 to 7

Table.

Thread size	M 1,6		M 2		M 2,5		M 3		(M 3,5)		M 4		M 5		M 6		
	<i>p</i>	<i>b</i>	<i>c</i>	<i>d<sub>s</sub></i>	<i>d<sub>t</sub></i>	<i>d<sub>w</sub></i>	<i>e</i>	<i>k</i>	<i>k'</i>	<i>r</i>	<i>s</i>	<i>l<sub>s</sub></i>	<i>l<sub>g</sub></i>	<i>l<sub>s</sub></i>	<i>l<sub>g</sub></i>	<i>l<sub>s</sub></i>	<i>l<sub>g</sub></i>
1)	0,35	9	0,4	10	0,45	11	0,5	12	0,6	0,7	0,8	0,8	1	1	1	1	1
2)																	
3)																	
4)																	
min.	0,1	0,1	0,1	0,1	0,1	0,1	0,15	0,15	0,15	0,15	0,15	0,15	0,15	0,15	0,15	0,15	0,15
max.	0,25	0,25	0,25	0,25	0,25	0,25	0,4	0,4	0,4	0,4	0,4	0,4	0,4	0,4	0,4	0,4	0,4
max.	2	2	2	2	2	2	3,6	3,6	3,6	3,6	3,6	3,6	3,6	3,6	3,6	3,6	3,6
max.	1,6	1,6	1,6	1,6	1,6	1,6	2,5	2,5	2,5	2,5	2,5	2,5	2,5	2,5	2,5	2,5	2,5
max.	1,46	1,46	1,46	1,46	1,46	1,46	2,36	2,36	2,36	2,36	2,36	2,36	2,36	2,36	2,36	2,36	2,36
A																	
B																	
A	2,4	2,4	3,2	3,2	4,1	4,1	4,6	4,6	5,1	5,1	5,9	5,9	6,9	6,9	8,9	8,9	8,9
B																	
A	3,41	3,41	4,32	4,32	5,45	5,45	6,01	6,01	6,58	6,58	7,66	7,66	8,79	8,79	11,05	11,05	11,05
B																	
Nominal size	1,1	1,1	1,4	1,4	1,7	1,7	2	2	2,4	2,4	2,8	2,8	3,5	3,5	4	4	4
A	0,98	0,98	1,28	1,28	1,58	1,58	1,88	1,88	2,28	2,28	2,68	2,68	3,35	3,35	3,85	3,85	3,85
max.	1,22	1,22	1,52	1,52	1,82	1,82	2,12	2,12	2,52	2,52	2,92	2,92	3,65	3,65	4,15	4,15	4,15
min.																	
max.																	
min.	0,7	0,7	0,9	0,9	1,1	1,1	1,3	1,3	1,6	1,6	1,9	1,9	2,28	2,28	2,63	2,63	2,63
min.	0,1	0,1	0,1	0,1	0,1	0,1	0,1	0,1	0,1	0,1	0,2	0,2	0,2	0,2	0,25	0,25	0,25
min.	3,2	3,2	4	4	5	5	5,5	5,5	6	6	7	7	8	8	10	10	10
A	3,02	3,02	3,82	3,82	4,82	4,82	5,32	5,32	5,82	5,82	6,78	6,78	7,78	7,78	9,78	9,78	9,78
B																	

Nominal size	Product grade A		Product grade B		Shank length, <i>l<sub>s</sub></i> , and grip length, <i>l<sub>g</sub></i> *)																	
	min.	max.	min.	max.	<i>l<sub>s</sub></i> min.	<i>l<sub>s</sub></i> max.	<i>l<sub>g</sub></i> min.	<i>l<sub>g</sub></i> max.	<i>l<sub>s</sub></i> min.	<i>l<sub>s</sub></i> max.	<i>l<sub>g</sub></i> min.	<i>l<sub>g</sub></i> max.	<i>l<sub>s</sub></i> min.	<i>l<sub>s</sub></i> max.	<i>l<sub>g</sub></i> min.	<i>l<sub>g</sub></i> max.	<i>l<sub>s</sub></i> min.	<i>l<sub>s</sub></i> max.	<i>l<sub>g</sub></i> min.	<i>l<sub>g</sub></i> max.		
12	11,65	12,35	-	-	1,2	3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
(14)	13,65	14,35	-	-	3,2	5	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
16	15,65	16,35	-	-	5,2	7	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
(18)	17,65	18,35	-	-	-	-	4	6	2,75	5	-	-	-	-	-	-	-	-	-	-	-	
20	19,58	20,42	-	-	-	-	6	8	4,75	7	-	-	-	-	-	-	-	-	-	-	-	
(22)	21,58	22,42	-	-	-	-	8	10	6,75	9	-	-	-	-	-	-	-	-	-	-	-	
25	24,58	25,42	-	-	-	-	8	10	8,75	11	-	-	-	-	-	-	-	-	-	-	-	
(28)	27,58	28,42	-	-	-	-	11,75	14	11,75	14	9	12	7,5	11	11	14	15	19	19	21	26	30
30	29,58	30,42	-	-	-	-	-	-	-	-	12	15	10,5	14	14	17	17,5	21	25	29	34	37
35	34,5	35,5	-	-	-	-	-	-	-	-	13	16	12	16	16	19	22,5	26	29	34	37	42
40	39,5	40,5	-	-	-	-	-	-	-	-	10,5	13	10,5	14	14	17	17,5	21	25	29	34	37
45	44,5	45,5	-	-	-	-	-	-	-	-	13,5	16	13,5	16	16	19	22,5	26	29	34	37	42
50	49,5	50,5	-	-	-	-	-	-	-	-	15,5	18	15,5	18	18	22	22,5	26	29	34	37	42
55	54,4	55,6	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
60	59,4	60,6	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

For commercial sizes, shank lengths have been specified. Use of values given in brackets should be avoided where possible.

Product grade A has been given above, product grade B below the stepped line.

For 1) to 4), see page 5.

\*)  $l_g \text{ max.} = l \text{ (nominal size)} - b.$

$l_s \text{ min.} = l_g \text{ max.} - 5 P.$

Note: Values of mass have been included in Supplement 1 to DIN 931.

Table. (continued).

P	Thread size		M 8	M 10	M 12	M 14	M 16	M 18	M 20
	(M 7)	(M 18)							
b	1)	2)	1,25	1,5	1,75	2	2	2,5	2,5
	3)	4)	22	26	30	34	38	42	48
	min.	max.	28	32	36	40	44	48	52
	min.	max.	45	49	53	57	61	65	69
d <sub>g</sub>	min.	max.	0,15	0,15	0,15	0,15	0,2	0,2	0,2
	min.	max.	0,6	0,6	0,6	0,6	0,8	0,8	0,8
d <sub>s</sub>	min.	max.	7,8	11,2	13,7	15,7	17,7	20,2	22,4
	min.	max.	7	10	12	14	16	18	20
d <sub>w</sub>	min.	max.	6,78	9,78	11,73	13,73	15,73	17,73	19,67
	min.	max.	9,6	15,6	17,4	20,5	22,5	25,3	28,2
e	min.	max.	12,12	18,9	21,1	24,49	26,75	29,56	32,53
	min.	max.	4,8	6,4	7,5	8,8	10	11,5	12,5
k	min.	max.	4,65	6,22	7,32	8,62	9,92	11,28	12,28
	min.	max.	4,95	6,58	7,68	8,98	10,18	11,72	12,72
k'	min.	max.	3,19	4,28	5,05	5,96	6,8	7,8	8,5
	min.	max.	0,25	0,4	0,6	0,6	0,6	0,6	0,8
s	min.	max.	11	17	19	22	24	27	30
	min.	max.	10,73	16,73	18,67	21,67	23,67	26,67	29,67

Nominal size	Product grade A		Product grade B		Shank length, l <sub>s</sub> , and grip length, l <sub>g</sub> *)																
	min.	max.	min.	max.	l <sub>s</sub> min.	l <sub>s</sub> max.	l <sub>g</sub> min.	l <sub>g</sub> max.	l <sub>s</sub> min.	l <sub>s</sub> max.	l <sub>g</sub> min.	l <sub>g</sub> max.	l <sub>s</sub> min.	l <sub>s</sub> max.	l <sub>g</sub> min.	l <sub>g</sub> max.	l <sub>s</sub> min.	l <sub>s</sub> max.	l <sub>g</sub> min.	l <sub>g</sub> max.	
30	29,58	30,42	-	-	5	10	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
35	35,5	35,5	-	-	10	15	6,75	13	-	-	-	-	-	-	-	-	-	-	-	-	-
40	39,5	40,5	-	-	15	20	11,75	18	-	-	-	-	-	-	-	-	-	-	-	-	-
45	44,5	45,5	-	-	20	25	16,75	23	6,25	15	-	-	-	-	-	-	-	-	-	-	-
50	49,5	50,5	-	-	25	30	21,75	28	11,25	20	16	-	-	-	-	-	-	-	-	-	-
55	54,4	55,6	-	-	30	35	26,75	33	16,25	25	11	21	-	-	-	-	-	-	-	-	-
60	59,4	60,6	-	-	35	40	31,75	38	21,25	30	16	26	36	-	-	-	-	-	-	-	-
65	64,4	65,6	-	-	40	45	36,75	43	26,25	35	21	31	41	26	-	-	-	-	-	-	-
70	69,4	70,6	-	-	45	50	41,75	48	31,25	40	26	36	46	31	41	26	-	-	-	-	-
75	74,4	75,6	-	-	50	55	46,75	53	36,25	45	31	41	51	31	41	26	10,5	6,5	23	28	19
80	79,4	80,6	-	-	55	60	51,75	58	41,25	50	36	46	56	36	46	32	15,5	11,5	33	38	24
85	84,3	85,7	-	-	60	65	56,75	63	46,25	55	41	51	61	41	51	37	20,5	15,5	37	42	29
90	89,3	90,7	-	-	65	70	61,75	68	51,25	60	46	56	66	46	56	42	25,5	20,5	42	47	34
95	94,3	95,7	-	-	70	75	66,75	73	56,25	65	51	61	71	51	61	47	30,5	25,5	47	52	39
100	99,3	100,7	-	-	75	80	71,75	78	61,25	70	56	66	76	56	66	52	35,5	30,5	52	57	44
110	109,3	110,7	-	-	80	85	76,75	83	66,25	74	61	71	81	61	71	57	40,5	35,5	57	62	49
120	119,3	120,7	-	-	85	90	81,75	88	71,25	80	66	76	86	66	76	62	45,5	40,5	62	67	54
130	129,2	130,8	-	-	90	95	86,75	93	76,25	84	71	81	91	71	81	67	50,5	45,5	67	72	64
140	139,2	140,8	-	-	95	100	91,75	98	81,25	90	76	86	96	76	86	72	55,5	50,5	72	77	78
150	149,2	150,8	-	-	100	105	96,75	103	86,25	94	81	91	101	81	91	77	60,5	55,5	77	82	88
160	159,2	160,8	158	162	105	110	101,75	108	91,25	100	86	96	106	86	96	82	65,5	60,5	82	87	98
170	169,2	170,8	168	172	110	115	106,75	113	96,25	104	91	101	111	91	101	87	70,5	65,5	87	92	106
180	179,2	180,8	178	182	115	120	111,75	118	101,25	109	96	106	116	96	106	92	75,5	70,5	92	97	118
190	189,08	190,92	187,7	192,3	120	125	116,75	123	106,25	114	101	111	121	101	111	97	80,5	75,5	97	102	138
200	199,08	200,92	197,7	202,3	125	130	121,75	128	111,25	119	106	116	126	106	116	102	85,5	80,5	102	107	148

For 1) to 4), see page 5. Product grade A has been given above, product grade B below the stepped line.

Table. (concluded)

P	Thread size		(M 22)		M 24		(M 27)		M 30		(M 33)		M 36		(M 39)	
	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.
b	70.6	75.6	70.6	75.6	70.6	75.6	70.6	75.6	70.6	75.6	70.6	75.6	70.6	75.6	70.6	75.6
c	88.25	91.75	88.25	91.75	88.25	91.75	88.25	91.75	88.25	91.75	88.25	91.75	88.25	91.75	88.25	91.75
d <sub>s</sub>	21.48	23.67	21.48	23.67	21.48	23.67	21.48	23.67	21.48	23.67	21.48	23.67	21.48	23.67	21.48	23.67
d <sub>w</sub>	30	33.6	30	33.6	30	33.6	30	33.6	30	33.6	30	33.6	30	33.6	30	33.6
e	35.03	39.98	35.03	39.98	35.03	39.98	35.03	39.98	35.03	39.98	35.03	39.98	35.03	39.98	35.03	39.98
k	13.78	14.78	13.78	14.78	13.78	14.78	13.78	14.78	13.78	14.78	13.78	14.78	13.78	14.78	13.78	14.78
k'	17.35	19.12	17.35	19.12	17.35	19.12	17.35	19.12	17.35	19.12	17.35	19.12	17.35	19.12	17.35	19.12
r	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8
s	31.61	35.38	31.61	35.38	31.61	35.38	31.61	35.38	31.61	35.38	31.61	35.38	31.61	35.38	31.61	35.38
	31	35	31	35	31	35	31	35	31	35	31	35	31	35	31	35
Shank length, l <sub>s</sub> , and grip length, l <sub>g</sub> *)																
Nominal size	Product grade A		Product grade B		l <sub>s</sub> min.	l <sub>s</sub> max.	l <sub>s</sub> min.	l <sub>s</sub> max.	l <sub>s</sub> min.	l <sub>s</sub> max.	l <sub>s</sub> min.	l <sub>s</sub> max.	l <sub>s</sub> min.	l <sub>s</sub> max.	l <sub>s</sub> min.	l <sub>s</sub> max.
	min.	max.	min.	max.												
70	69.4	70.6	-	-	7.5	20	-	-	-	-	-	-	-	-	-	-
(75)	74.4	75.6	-	-	12.5	25	-	-	-	-	-	-	-	-	-	-
80	79.4	80.6	-	-	17.5	30	-	-	-	-	-	-	-	-	-	-
(85)	84.3	85.7	-	-	22.5	35	-	-	-	-	-	-	-	-	-	-
90	89.3	90.7	88.25	91.75	27.5	40	15	30	6.5	24	11.5	29	12	32	16	36
(95)	94.3	95.7	93.25	96.75	32.5	45	20	35	11.5	29	16.5	34	22	42	20	40
100	99.3	100.7	98.25	101.75	37.5	50	25	40	16.5	34	21.5	39	26	46	24	48
110	109.3	110.7	108.25	111.75	47.5	60	35	50	26.5	44	30.5	48	36	56	30	60
120	119.3	120.7	118.25	121.75	57.5	70	45	60	36.5	54	40.5	58	46	66	40	70
130	129.2	130.8	128	132	61.5	74	49	64	40.5	58	44.5	62	50	70	44	76
140	139.2	140.8	138	142	71.5	84	59	74	50.5	68	54.5	72	60	80	54	84
150	149.2	150.8	148	152	81.5	94	69	84	60.5	78	64.5	82	70	90	64	96
160	-	-	158	162	91.5	104	79	94	70.5	88	74.5	92	80	100	74	104
(170)	-	-	168	172	101.5	114	89	104	80.5	98	84.5	102	90	110	84	110
180	-	-	178	182	111.5	124	99	114	90.5	108	94.5	112	100	120	94	120
(190)	-	-	187.7	192.3	121.5	134	109	124	100.5	118	104.5	122	110	130	104	130
200	-	-	197.7	202.3	131.5	144	119	134	110.5	130	114.5	132	120	140	114	140
220	-	-	217.7	222.3	138.5	151	126	141	117.5	135	121.5	139	126	147	121	147
240	-	-	237.7	242.3	-	-	146	161	137.5	155	141.5	159	146	167	141	167
260	-	-	257.4	262.6	-	-	166	181	157.5	175	161.5	179	166	191	161	191
280	-	-	277.4	282.6	-	-	-	-	177.5	195	181.5	199	177	203	181	203
300	-	-	297.4	302.6	-	-	-	-	197.5	215	191.5	209	197	217	197	217

For \*) to \*), see page 5.

Product grade A has been given above, product grade B below the stepped line.

### 3 Technical delivery conditions

Material		Steel	Stainless steel	Non-ferrous metal
General requirements		As specified in DIN 267 Part 1.		
Thread	Tolerance	6 g		
	Standard	DIN 13 Parts 12 and 15.		
Mechanical properties	Property class (material)	5.6, 8.8, 10.9	$\leq M 20$ : A2-70, A4-70 $> M 20$ : A2-50, A4-50 C3, C4	Subject to agreement.
	Standard	ISO 898 Part 1	DIN 267 Part 11	DIN 267 Part 18
Limit deviations, geometrical tolerances	Product grade	A for products up to size M 24 and $l \leq 10 d$ or 150 mm <sup>1)</sup> . B for products exceeding size M 24 or $l > 10 d$ or 150 mm <sup>1)</sup> .		
	Standard	ISO 4759 Part 1		
Surface finish		As processed. Property class 8.8 and above: (thermally or chemically) blackened.	Bright.	Bright.
		DIN 267 Part 2 shall apply with regard to surface roughness. DIN 267 Part 19 shall apply with regard to permissible surface discontinuities. DIN 267 Part 9 shall apply with regard to electroplating. DIN 267 Part 10 shall apply with regard to hot dip galvanizing.		
Acceptance inspection		DIN 267 Part 5 shall apply with regard to acceptance inspection.		
<sup>1)</sup> Whichever is shorter (see stepped line in the dimension table).				

### 4 Designation

Designation of an M12 hexagon head bolt of nominal length,  $l = 80$  mm, with material assigned to property class 8.8:

Hexagon head bolt DIN 931 – M 12 × 80 – 8.8

If product grade A is required for sizes up to M 24 with lengths over 150 mm or with  $l$  greater than  $10 d$ , or for sizes above M 24, then this shall be indicated in the designation by adding 'A', e.g.

Hexagon head bolt DIN 931 – M 30 × 100 – 8.8 – A

DIN 962 shall apply with regard to the designation of designs and types, with additional details to be given when ordering.

DIN 6900 shall apply with regard to the designation of types with captive components.

DIN 7500 Part 1 shall apply with regard to the designation of types with thread rolling properties.

The DIN 4000-2-1 tabular layout of article characteristics shall apply to bolts covered in this standard.

Footnotes for the tables on pages 2 to 4:

- <sup>1)</sup>  $P$  = pitch of thread (coarse pitch thread).
- <sup>2)</sup> For  $l \leq 125$  mm.
- <sup>3)</sup> For  $l > 125$  mm  $\leq 200$  mm.
- <sup>4)</sup> For  $l > 200$  mm.

**Appendix A****Additional thread sizes for spare parts**

The previous thread sizes M 1,7, M 2,3 and M 2,6, which are not included in the international selection of screw threads for bolts, screws and nuts, shall no longer be used. In consideration of existing documents and of the demand for spare parts, they may, however, still be ordered in accordance with DIN 931, November 1970 edition\*). The table below shall apply with regard to the dimensions of bolts (DIN 13 Parts 1 and 15 applying with regard to screw threads).

Thread size	M 1,7	M 2,3	M 2,6
<i>b</i>	9	11	11
<i>c</i>	-	-	-
<i>d<sub>a</sub></i> max.	2,1	2,9	3,2
<i>e</i> min.	3,82	4,95	5,51
<i>k</i> js14	1,2	1,6	1,8
<i>r</i> min.	0,1	0,1	0,1
<i>s</i> h13	3,5	4,5	5
<i>l</i> ± ½ IT 15	Mass (7,85 kg/dm <sup>3</sup> ) for 1000 units, in kg, approximately		
12	0,28		
14	0,315	0,61	0,79
16	0,35	0,675	0,87
18		0,74	0,95
20		0,805	1,03
22			1,11
25			1,24

**Standards referred to and other documents**

- DIN 13 Part 1 ISO metric screw threads; 1 mm to 68 mm diameter coarse pitch threads; nominal sizes
- DIN 13 Part 12 ISO metric screw threads; coarse and fine pitch threads with diameters from 1 to 300 mm; selection for diameters and pitches
- DIN 13 Part 15 ISO metric screw threads; fundamental deviations and tolerances for screw threads of 1 mm diameter and larger
- DIN 78 Thread ends and ends of projection of bolt ends for ISO metric threads in accordance with DIN 13
- DIN 267 Part 1 Fasteners; technical delivery conditions; general requirements
- DIN 267 Part 2 Fasteners; technical delivery conditions; finish and dimensional accuracy
- DIN 267 Part 5 Fasteners; technical delivery conditions; acceptance inspection
- DIN 267 Part 9 Fasteners; technical delivery conditions; electroplated components
- DIN 267 Part 10 Fasteners; technical delivery conditions; hot-dip galvanized components
- DIN 267 Part 11 Fasteners; technical delivery conditions, with addenda to ISO 3506; corrosion-resistant stainless steel components
- DIN 267 Part 18 Fasteners; technical delivery conditions; non-ferrous metal components
- DIN 267 Part 19 Fasteners; technical delivery conditions; surface discontinuities on bolts
- Supplement 1 to  
DIN 931 Part 1 Hexagon head bolts with shank; masses
- DIN 962 Bolts, screws, studs and nuts; designations; types and finishes
- DIN 4000 Part 2 Tabular layout of article characteristics for bolts, screws and nuts
- DIN 6900 Screw and washer assemblies
- DIN 7500 Part 1 Thread rolling screws for ISO metric threads; dimensions, requirements, testing
- ISO 898 Part 1 Mechanical properties of fasteners; bolts, screws and studs
- ISO 4759 Part 1 Tolerances for fasteners; bolts, screws, and nuts with thread diameters  $\geq 1,6$  and  $\leq 150$  mm and product grades A, B and C

\*) Withdrawn in 1982.

### Previous editions

DIN 932 Part 1 and Part 2: 01.26; DIN 600: 10.26x; DIN 532: 11.29x; DIN Kr 551: 11.35, 11.36;  
DIN 931 Part 2: 01.26, 04.42; DIN 931: 12.67, 11.70; DIN 931 Part 1: 01.26, 04.42, 12.52, 03.63, 07.82.

### Amendments

The following amendments have been made to the July 1982 edition.

- A note on the period of validity of this standard has been included.
- The specification regarding the underhead fillet has been deleted.
- For sizes M 10, M 12, M 14 and M 22, the widths across flats specified in ISO 272 have been deleted.
- A reference line for the determination of the bearing face diameter,  $d_w$ , has been included.

### Explanatory notes

For more than 20 years efforts have been directed towards the achievement of the international interchangeability of fasteners by preparing international standards for the product concerned. ISO Standards have now been published for the most important types of fasteners (see ISO Standards Handbook 18).

However, international efforts only serve a useful purpose if national standards are adapted as far as possible to international standards, or, ideally, replaced by them. Current DIN Standards already agree in substance with the relevant ISO Standards, but still differ in some respects, as for instance in the widths across flats for hexagon products.

The Federal Republic of Germany adopted International Standard ISO 272 on widths across flats as national standard DIN ISO 272 in October 1979. Nevertheless, widths across flats deviating from DIN ISO 272 are still being used in Germany for nominal sizes M 10, M 12, M 14 and M 22. The table below compares the previous widths across flats with the new ones specified for the four nominal sizes referred to.

Thread size	M 10	M 12	M 14	M 22
Previous width across flats, in mm	17	19	22	32
New width across flats as in ISO 272, in mm	16	18	21	34

The manufacturers and users of hexagon products participating in the work of the *Normenausschuß Mechanische Verbindungselemente* (Fasteners Standards Committee), together with representatives of the dealers in fasteners, have decided to introduce the new widths across flats in all relevant product standards. Since experience has shown, that the introduction of the new widths across flats has not been advanced by their inclusion in DIN Standards merely as preferred alternatives to the previous widths across flats, the following decisions have been reached to accelerate the changeover procedure.

Supplementary to current DIN Standards specifying the previous widths across flats, DIN ISO Standards dealing with the same products will, wherever ISO Standards are

available, be published which, besides introducing a number of other minor amendments, will specify the new widths across flats conforming to ISO 272. In both DIN and DIN ISO Standards attention will be drawn to the fact that the relevant ISO Standards are to be preferred and that the DIN Standard is to be replaced after a transition period of 5 years.

If no relevant ISO Standard is available, the DIN Standard will contain a foreword stating that the previous width across flats specifications are to be withdrawn after a transition period of 5 years and replaced by those specified in ISO 272.

This sets a time limit for both manufacturer and user of hexagon products by which the changeover to the new widths across flats must be effected. The responsible committee is of the opinion, that it will still be possible after this period to obtain fasteners complying with the superseded specifications as spare parts.

In some cases, the replacement of the previous DIN Standards by the relevant ISO Standards will have further consequences, besides the changeover to the new widths across flats, attention being drawn to this circumstance in the national foreword of the relevant DIN ISO Standards. These consequences result from the fact that the ISO Standards have not yet reached the same level of completeness as the DIN Standards. Thus a number of nominal sizes, as well as several product specifications for fine pitch threads are not found in the ISO product standards. Furthermore, ISO Standards on technical delivery conditions are still in the initial stages, so that specific requirements are still subject to separate agreement when ordering products in accordance with ISO Standards, as they are not included in the designation for order purposes.

Besides these consequences, which are of importance when applying the new ISO Standards, the amendment of the widths across flats also have a number of consequences as regards the use of the new products which the designer must take into consideration. Besides the amended assembly sizes, this applies above all to the different surface pressure for the bearing area of the nut or the heads of the bolts. These difficulties are discussed in Recommendation VDA 262\* published by the *Verband der Automobilindustrie e.V.* (German Automobile Manufacturers Association).

### International Patent Classification

F 16 B 35/00

\*) Obtainable from: *Dokumentation Kraftfahrwesen e.V.*, Grönerstraße 5, D-7140 Ludwigsburg.