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Specification for

Machine tool components —

Part 1: Locknuts (“C” type, socket set screw locking)

Co-operating organizations

The Mechanical Engineering Industry Standards Committee, under whose supervision this British Standard was prepared, consists of representatives from the following Government departments and scientific and industrial organizations:

Associated Offices' Technical Committee	Institution of Civil Engineers
Association of Consulting Engineers	Institution of Gas Engineers
Association of Mining Electrical and Mechanical Engineers	Institution of Heating and Ventilating Engineers
Board of Trade	Institution of Mechanical Engineers*
British Chemical Plant Manufacturers' Association	Institution of Mechanical Engineers (Automobile Division)
British Compressed Air Society	Institution of Production Engineers*
British Electrical and Allied Manufacturers' Association	Locomotive and Allied Manufacturers' Association of Great Britain
British Gear Manufacturers' Association	London Transport Board
British Internal Combustion Engine Manufacturers' Association	Machine Tool Trades Association*
British Iron and Steel Federation	Ministry of Defence,
British Mechanical Engineering Federation	Ministry of Labour (H.M. Factory Inspectorate)
British Pump Manufacturers Association	Ministry of Power
Crown Agents for Oversea Governments and Administrations	Ministry of Public Building and Works*
Electricity Council, the Central Electricity Generating Board and the Area Boards in England and Wales	Ministry of Technology — National Engineering Laboratory*
Engineering Equipment Users' Association	Ministry of Transport
Gas Council	National Coal Board
Institute of Marine Engineers	National Physical Laboratory (Ministry of Technology)
	Radio Industry Council
	Royal Institute of British Architects

The Government departments and scientific and industrial organizations marked with an asterisk in the above list, together with the following, were directly represented on the committee entrusted with the preparation of this British Standard:

Association of Supervisory Staffs, Executives and Technicians	Production Engineering Research Association
Ministry of Defence, Air Force Department	Society of Motor Manufacturers and Traders limited
Ministry of Defence, Army Department	Trades Union Congress
Ministry of Defence, Navy Department	
National Federation of Engineers' Tool Manufacturers	

This British Standard, having been approved by the Mechanical Engineering Industry Standards Committee and endorsed by the Chairman of the Engineering Divisional Council, was published under the authority of the General Council on 31 July 1967

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The following BSI references relate to the work on this standard:
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Amendments issued since publication

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1563	September 1974	Indicated by a sideline in the margin

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Foreword

This standard makes reference to the following British Standards:

BS 308, *Engineering drawing practice*.

BS 970, *Wrought steels in the form of blooms, billets, bars and forgings — Part 1: Carbon and carbon manganese steels including free cutting steels*.

BS 1134, *Centre-line-average height method for the assessment of surface texture*.

BS 1580, *Unified screw threads*.

BS 1916, *Limits and fits for engineering — Part 1: Limits and tolerances*.

BS 2090, *Hook spanners, peg spanners, coupling wrenches and the related slots, holes and horns*.

BS 2470, *Hexagon socket screws and wrench keys*.

BS 3643, *ISO metric screw threads*.

BS 4168, *Hexagon socket screws and wrench keys. Metric series*.

This standard is based on proposals made by the Machine Tool Trades Association and is one of a series dealing with components of machine tools.

Others in this series are:

- *Part 2: Collars;*
- *Part 3: Rolling bearing end caps and retaining plates;*
- *Part 4: Shaft spacers;*
- *Part: Locknuts for use with tab washers.* } in course of preparation.

The locknuts specified in this standard are those secured by a socket set screw. Double locknuts and lock washers are not included in this specification.

The slots of both the millimetre and inch series of locknuts are suitable for use with hook spanners conforming to BS 2090¹⁾. That standard gives a series of hook spanner blanks and dimensions of hook spanners which may be made from them for different sizes of nut. Column 16 of Table 1 and Table 2 of this standard gives the number of the hook spanner blank appropriate to each size of locknut; a hook spanner made from this blank to dimensions given in BS 2090 is suitable for that locknut, whether it is in the millimetre series or the inch.

A marking requirement has been included in the standard so that a standard locknut may be distinguished from a special and its size readily identified.

A British Standard does not purport to include all the necessary provisions of a contract. Users of British Standards are responsible for their correct application.

Compliance with a British Standard does not of itself confer immunity from legal obligations.

Summary of pages

This document comprises a front cover, an inside front cover, pages i and ii, pages 1 to 6, an inside back cover and a back cover.

This standard has been updated (see copyright date) and may have had amendments incorporated. This will be indicated in the amendment table on the inside front cover.

¹⁾ BS 2090, "Hook spanners, peg spanners, coupling wrenches and the related slots, holes and horns".