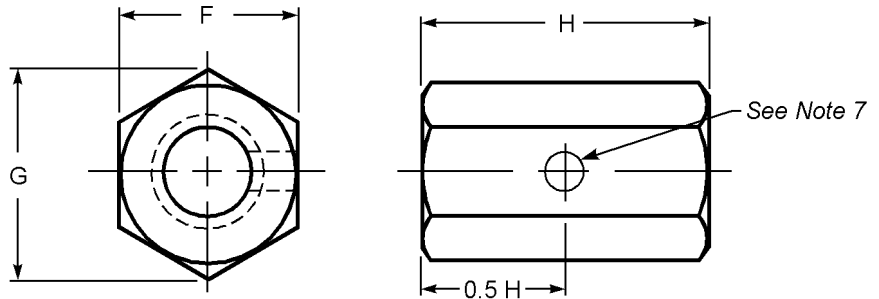


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IFI NOTE:

IFI-128 was first published in 1978 and reaffirmed, without technical change, in 1986 and in 2000.



Dimensions of Hex Coupling Nuts

Nominal Size or Basic Major Dia of Thread		F			G		H		
		Width Across Flats			Width Across Corners		Thickness		
		Basic	Max	Min	Max	Min	Basic	Max	Min
1/4	0.2500	3/8	0.375	0.365	0.433	0.416	3/4	0.76	0.74
5/16	0.3125	1/2	0.500	0.489	0.577	0.557	15/16	0.95	0.93
3/8	0.3750	9/16	0.562	0.551	0.650	0.628	1-1/8	1.13	1.11
7/16	0.4375	11/16	0.688	0.675	0.794	0.769	1-5/16	1.32	1.30
1/2	0.5000	3/4	0.750	0.736	0.866	0.839	1-1/2	1.51	1.49
9/16	0.5625	7/8	0.875	0.861	1.010	0.981	1-11/16	1.70	1.67
5/8	0.6250	15/16	0.938	0.922	1.083	1.051	1-7/8	1.89	1.86
3/4	0.7500	1-1/8	1.125	1.088	1.299	1.240	2-1/4	2.27	2.22
7/8	0.8750	1-5/16	1.312	1.269	1.516	1.447	2-5/8	2.65	2.60
1	1.0000	1-1/2	1.500	1.450	1.732	1.653	3	3.03	2.97
1-1/8	1.1250	1-11/16	1.688	1.631	1.949	1.859	3-3/8	3.40	3.34
1-1/4	1.2500	1-7/8	1.875	1.812	2.165	2.066	3-3/4	3.78	3.71
1-3/8	1.3750	2-1/16	2.062	1.994	2.382	2.273	4-1/8	4.16	4.09
1-1/2	1.5000	2-1/4	2.250	2.175	2.598	2.480	4-1/2	4.54	4.46
1-5/8	1.6250	2-9/16	2.562	2.481	2.959	2.828	4-7/8	4.91	4.83
1-3/4	1.7500	2-3/4	2.750	2.662	3.175	3.035	5-1/4	5.29	5.21
1-7/8	1.8750	2-15/16	2.938	2.844	3.392	3.242	5-5/8	5.67	5.58
2	2.0000	3-1/8	3.125	3.025	3.608	3.448	6	6.04	5.95
2-1/4	2.2500	3-1/2	3.500	3.388	4.041	3.862	6-3/4	6.80	6.70
2-1/2	2.5000	3-7/8	3.875	3.750	4.474	4.275	7-1/2	7.55	7.44
2-3/4	2.7500	4-1/4	4.250	4.112	4.907	4.688	8-1/4	8.31	8.19
3	3.0000	4-5/8	4.625	4.475	5.340	5.101	9	9.06	8.94
3-1/4	3.2500	5	5.000	4.838	5.773	5.515	9-3/4	9.81	9.68
3-1/2	3.5000	5-3/8	5.375	5.200	6.206	5.928	10-1/2	10.57	10.43
3-3/4	3.7500	5-3/4	5.750	5.562	6.639	6.340	11-1/4	11.32	11.17
4	4.0000	6-1/8	6.125	5.925	7.072	6.754	12	12.08	11.92
4-1/4	4.2500	6-1/2	6.500	6.288	7.506	7.168	12-3/4	12.83	12.67
4-1/2	4.5000	6-7/8	6.875	6.650	7.939	7.581	13-1/2	13.58	13.42
4-3/4	4.7500	7-1/4	7.250	7.012	8.372	7.994	14-1/4	14.34	14.16
5	5.0000	7-5/8	7.625	7.375	8.805	8.408	15	15.09	14.91
5-1/4	5.2500	8	8.000	7.738	9.238	8.821	15-3/4	15.85	15.65
5-1/2	5.5000	8-3/8	8.375	8.100	9.671	9.234	16-1/2	16.60	16.40
5-3/4	5.7500	8-3/4	8.750	8.462	10.104	9.647	17-1/4	17.35	17.15
6	6.0000	9-1/8	9.125	8.825	10.537	10.060	18	18.11	17.89
See Notes					3				

IFI
STANDARD ®

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HEX COUPLING NUTS

IFI-128

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NOTES TO TABLE:

1. All dimensions are in inches.
2. **Top Surfaces of Nuts.** Nuts shall be double chamfered. The diameter of chamfer circle shall be equal to the maximum width across flats within a tolerance of minus 15 percent. The length of chamfer at hex corners shall be from 5 to 15 percent of the basic thread diameter. The surface of the chamfer may be slightly convex or rounded.
3. **Corner Fill.** A rounding or lack of fill at junction of hex corners with chamfer shall be permissible provided the width across corners is within specified limits at and beyond a distance equal to 17.5 percent of the basic thread diameter from the chamfered faces.
4. **Concentricity of Tapped Hole.** Axis of tapped hole shall be concentric with axis of nut body within a tolerance equal to 3 percent (6 percent FIM) of the maximum width across flats.
5. **Countersink.** Tapped hole may be countersunk on both faces.
6. **Threads.** Threads shall be Unified coarse or 8 thread series (UNC or 8 UN series), Class 2B, in accordance with ASME B1.1.
7. In some applications it may be desirable to assure that the threaded parts joined by a coupling nut are each engaged to approximately one-half nut thickness. As a visual inspection aid, a hole drilled through one side of the nut is recommended. The hole should be located at mid nut thickness, and have a diameter of 0.2 to 0.4 times nominal nut size for sizes 2-1/2 in. and smaller, and 1 in., for sizes 2-3/4 in. and larger. Nuts shall be furnished without a hole, unless specially ordered by the purchaser.
8. **Material.** Unless otherwise specified, chemical and mechanical properties of steel nuts shall conform with ASTM A563, Grade A. Other materials shall be as agreed upon by manufacturer and purchaser.
9. For wrench openings, refer to Appendix III, ASME/ANSI B18.2.2.

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