

INTERNATIONAL STANDARD

ISO
4759-1

Second edition
2000-11-15

Tolerances for fasteners —

Part 1:

Bolts, screws, studs and nuts — Product grades A, B and C

Tolérances des éléments de fixation —

Partie 1: Vis, goujons et écrous — Grades A, B et C



Reference number
ISO 4759-1:2000(E)

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this part of ISO 4759 may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

International Standard ISO 4759-1 was prepared by Technical Committee ISO/TC 2, *Fasteners*, Subcommittee SC 7, *Reference Standards for fasteners (mainly covering terminology, dimensioning, sizes and tolerancing)*.

This second edition cancels and replaces the first edition (ISO 4759-1:1978), which has been technically revised.

ISO 4759 consists of the following parts, under the general title *Tolerances for fasteners*:

- *Part 1: Bolts, screws, studs and nuts — Product grades A, B and C*
- *Part 3: Plain washers for bolts, screws and nuts — Product grades A and C*

Annexes A to C of this part of ISO 4759 are for information only.

Tolerances for fasteners —

Part 1:

Bolts, screws, studs and nuts — Product grades A, B and C

1 Scope

This part of ISO 4759 specifies a selection of tolerances for bolts, screws, studs and nuts with ISO metric threads and with product grades A, B and C and for tapping screws with product grade A.

NOTE The product grades refer to the size of the tolerances where grade A is the most precise and grade C is the least precise.

The tolerances, except tolerances for threads, are selected from the system of limits and fits specified in ISO 286-1 and ISO 286-2. The tolerances for metric threads are taken from the series of tolerance classes specified in ISO 965-3. The tolerances for tapping screw threads are covered in ISO 1478.

The tolerances of form and position are specified and indicated in accordance with ISO 1101, ISO 8015 and ISO 2692.

The tolerances specified in this part of ISO 4759 apply to fasteners prior to coating unless otherwise specified. See also ISO 4042.

Deviations from the tolerances specified in this part of ISO 4759 are only permitted in product standards where there are valid technical reasons. In cases where there is a difference between the tolerance requirements in this part of ISO 4759 and the product standard, the product standard takes precedence.

It is recommended that these tolerances also be used for non-standard fasteners.

Dimensions and tolerances given in this part of ISO 4759 are in millimetres.

2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this part of ISO 4759. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this part of ISO 4759 are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

ISO 225:1983, *Fasteners — Bolts, screws, studs and nuts — Symbols and designation of dimensions*.

ISO 286-1:1988, *ISO system of limits and fits — Part 1: Bases of tolerances, deviations and fits*.

ISO 286-2:1988, *ISO system of limits and fits — Part 2: Tables of standard tolerance grades and limit deviations for holes and shafts*.

ISO 885:2000, *General purpose bolts and screws — Metric series — Radii under the head*.

ISO 965-3:1998, *ISO general purpose metric screw threads — Tolerances — Part 3: Deviations for constructional screw threads*.

ISO 1101:2000, *Geometrical Product Specifications (GPS) — Geometrical tolerancing — Tolerances of form, orientation, location and run-out*.

ISO 1478:1999, *Tapping screws thread*.

ISO 1479:1983, *Hexagon head tapping screws*.

ISO 2692:1988, *Technical drawings — Geometrical tolerancing — Maximum material principle*.

ISO 4032:1999, *Hexagon nuts, style 1 — Product grades A and B*.

ISO 4042:1999, *Fasteners — Electroplated coatings*.

ISO 4757:1983, *Cross recesses for screws*.

ISO 7053:1992, *Hexagon washer head tapping screws*.

ISO 7721:1983, *Countersunk head screws — Head configuration and gauging*.

ISO 8015:1985, *Technical drawings — Fundamental tolerancing principle*.

ISO 10509:1992, *Hexagon flange head tapping screws*.

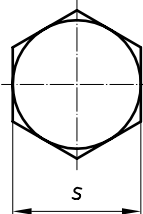
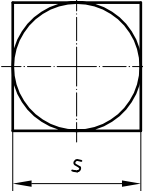
ISO 10642:1997, *Hexagon socket countersunk head screws*.

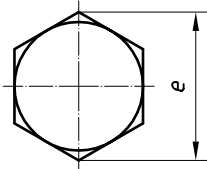
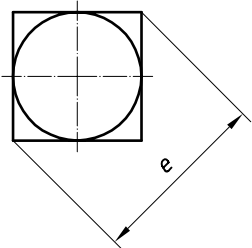
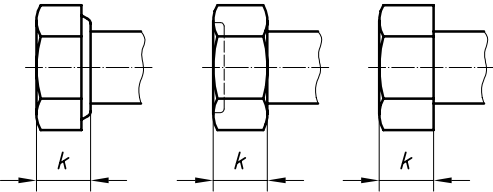
ISO 10664:1999, *Hexalobular internal driving feature for bolts and screws*.

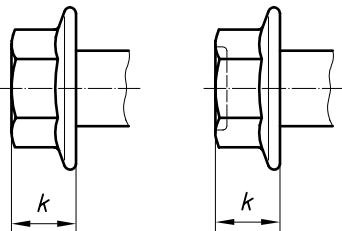
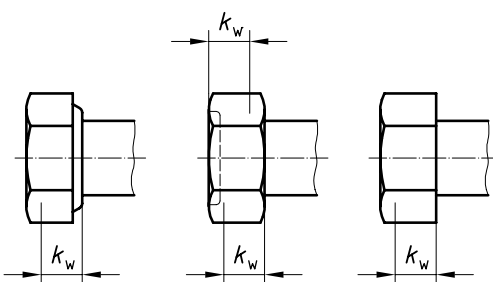
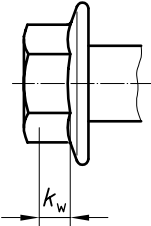
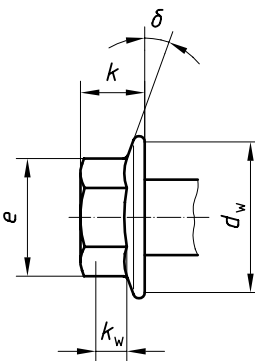
3 Tolerances for metric bolts, screws and studs

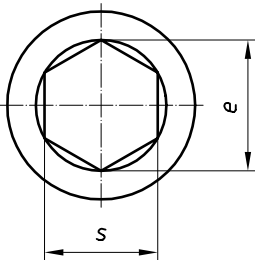
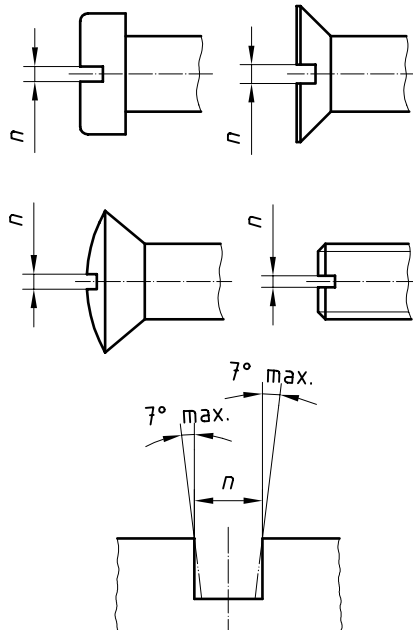
3.1 Dimensional tolerances

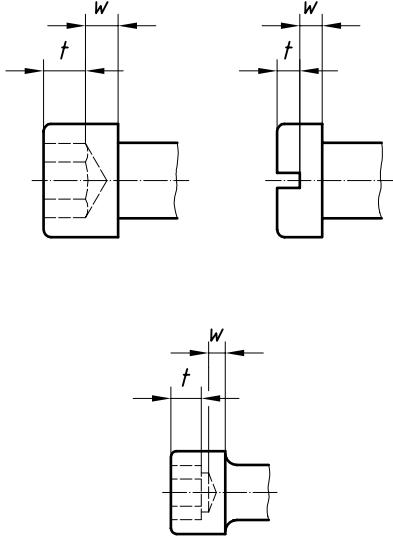
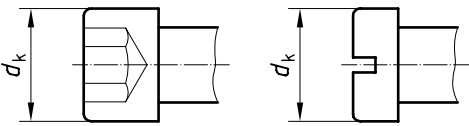
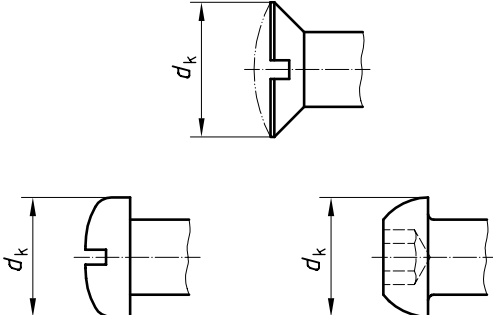
Symbols and designations of dimensions are specified in ISO 225.

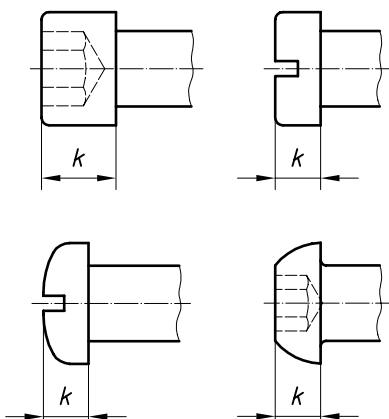
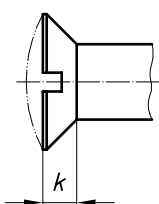
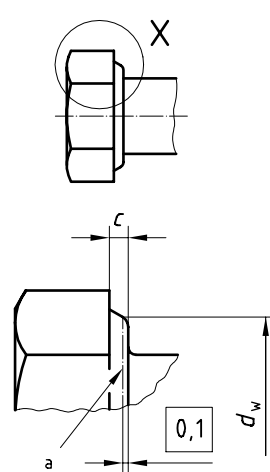
Feature	Tolerance for product grades			Notes
	A	B	C	
3.1.1 Tolerance level				
Shank and bearing surface	close	close	wide	
Other features	close	wide	wide	
3.1.2 External thread	6g	6g	8g (but 6g for property class 8.8 and higher)	For certain products and coatings, other tolerance classes for threads may be specified in the relevant product and coating standards.
3.1.3 Driving features				
3.1.3.1 External	s	Tolerance	s	Tolerance
3.1.3.1.1 Width across flats	≤ 30 > 30	h13 h14	≤ 18 > 18 ≤ 60 > 60 ≤ 180 > 180	h14 h15 h16 h17
 Figure 1  Figure 2				

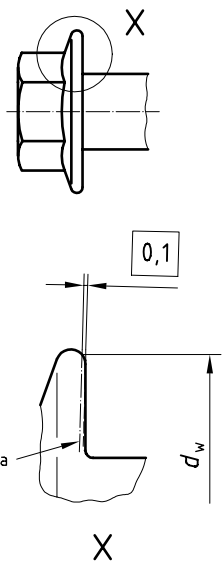
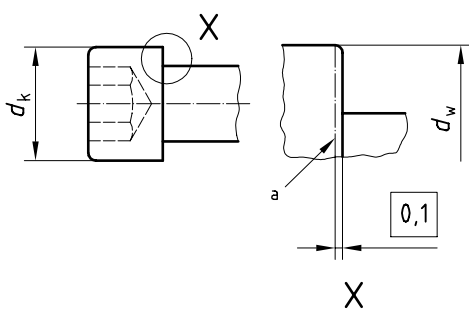
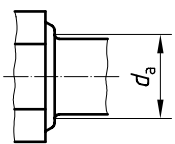
Feature	Tolerance for product grades			Notes
	A	B	C	
3.1.3.1.2 Width across corners  Figure 3	$e_{\min} = 1,13 s_{\min}$ $e_{\min} = 1,12 s_{\min}$ for bolts and screws with flange and other cold forged heads without trimming operation			
 Figure 4	$e_{\min} = 1,3 s_{\min}$			
3.1.3.1.3 Height of head  Figure 5	js14	js15	k	Tolerance
			< 10 ≥ 10	js16 js17

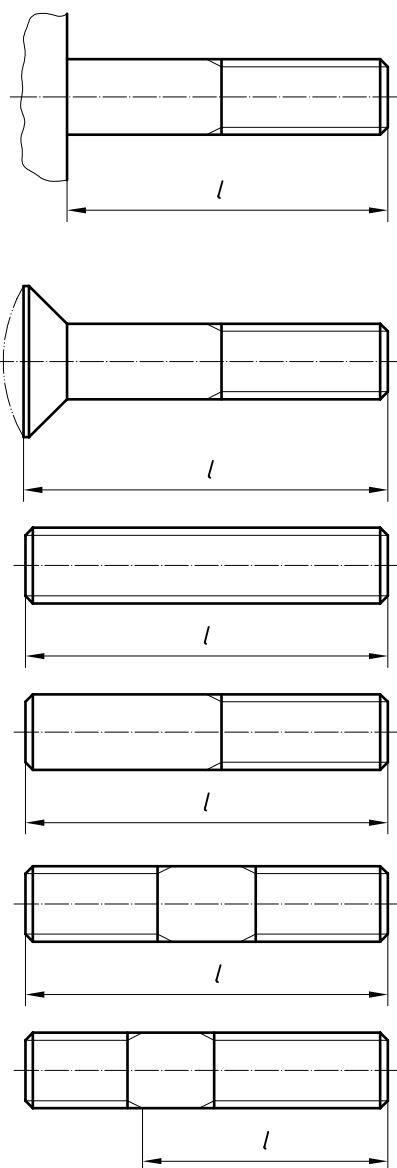
Feature	Tolerance for product grades			Notes
	A	B	C	
 Figure 6	For hexagon bolts and screws with flange, k is defined only as a maximum			
3.1.3.1.4 Wrenching height  Figure 7	$k_{w \min}^a = 0,7 k_{\min}$			k_w defines the length over which $e_{\min}$ applies but excluding any chamfer, washer face or radius specified in the appropriate product standard. The formulae for $k_{w \min}$ only apply to the products illustrated. ^a The symbol k_w replaces the previously used k'.
 Figure 8	$k_{w \min}^b = 0,7 \left[(k_{\max} - IT15) - \left(x + \frac{d_{w \min} - e_{\min}}{2} \tan \delta_{\max} \right) \right]$ x is the greater of $c_{\min} \times 1,25$ or $c_{\min} + 0,4$ δ is the flange angle Dimensions k_w^a, k, d_w, e and δ are in accordance with ISO 225.  Figure 8 a)			^b For gauging, see annex A of the product standards

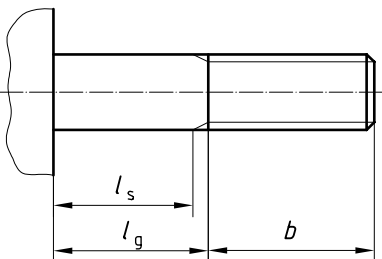
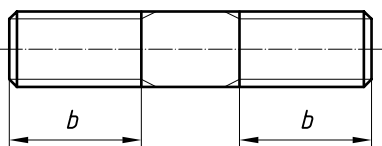
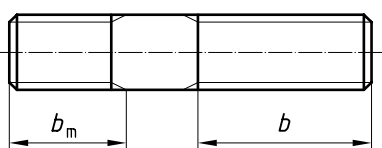
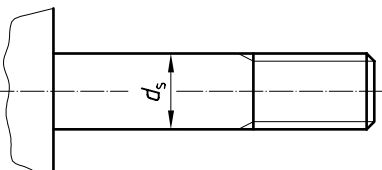
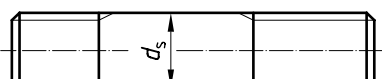
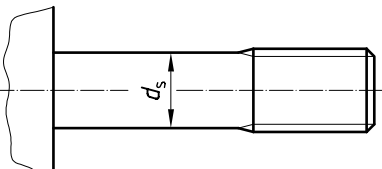
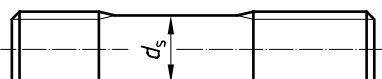
Feature	Tolerance for product grades			Notes
	A	B	C	
3.1.3.2 Internal				
3.1.3.2.1 Hexagon sockets				
 Figure 9	$e_{\min} = 1,14 s_{\min}$			
	s	Tolerance		
	0,7	EF8		
	0,9	JS9		
	1,3	K9		
	1,5	D11	—	—
	2			
	2,5			
	3			
	4	E11		
	5	E12		
6				
8				
10				
12				
14				
> 14	D12			
3.1.3.2.2 Slots				
 Figure 10	n	Tolerance		Tolerance field
	≤ 1	+ 0,20 + 0,06		C13 for $n \leq 1$
	> 1 ≤ 3	+ 0,31 + 0,06		C14 for $n > 1$
	> 3 ≤ 6	+ 0,37 + 0,07	—	—

Feature	Tolerance for product grades			Notes
	A	B	C	
3.1.3.2.3 Depth of hexagon sockets and slots  Figure 11	The depth of hexagon sockets and slots is specified in product standards only as a minimum. It is restricted by the minimum wall thickness w .	—	—	For the time being generally applicable tolerances cannot be specified.
3.1.3.2.4 Cross recesses	See ISO 4757 for all dimensions except penetration depths. For penetration depths see appropriate product standard.			
3.1.3.2.5 Hexalobular recesses	See ISO 10664 for all dimensions except penetration depths. For penetration depths see appropriate product standard.			
3.1.4 Other features 3.1.4.1 Head diameter  Figure 12	$h13^a$	—	—	$^a \pm IT13$ for knurled heads
 Figure 13	$h14$	—	—	Combined control of diameter and height for counter-sunk head screws in accordance with ISO 7721 or ISO 10642.

Feature	Tolerance for product grades			Notes
	A	B	C	
3.1.4.2 Head height (except for hexagon heads)  Figure 14	$\leq M5: h13$ $> M5: h14$	—	—	
 Figure 15	For countersunk head screws k is defined in product standards only as a maximum.			Combined control of diameter and height for countersunk head screws in accordance with ISO 7721 or ISO 10642.
3.1.4.3 Bearing face diameter and height of washer-faced portion  Figure 16 a Reference datum for d_w	$d_{w \min} = s_{\min} - IT16$ for width across flats < 21 mm $d_{w \min} = 0,95 s_{\min}$ for width across flats ≥ 21 mm $d_{w \max} = s_{\text{actual}}$			For product grade C a washer face is not mandatory.
Thread diameter		c min. max.		
$\geq 1,6$ to 2,5		0,10	0,25	
$> 2,5$ to 4		0,15	0,40	
> 4 to 6		0,15	0,50	
> 6 to 14		0,15	0,60	
> 14 to 36		0,20	0,80	
> 36		0,30	1,0	

Feature	Tolerance for product grades			Notes																											
	A	B	C																												
 a Reference datum for d_w Figure 17	d_w is defined in product standards only as a minimum.																														
 a Reference datum for d_w Figure 18	<table><tr><th colspan="2">Thread diameter</th><th>d_w</th></tr><tr><th>></th><th>≤</th><th>min.</th></tr><tr><td></td><td>2,5</td><td>$d_k \text{ min} - 0,14$</td></tr><tr><td>2,5</td><td>5</td><td>$d_k \text{ min} - 0,25$</td></tr><tr><td>5</td><td>10</td><td>$d_k \text{ min} - 0,4$</td></tr><tr><td>10</td><td>16</td><td>$d_k \text{ min} - 0,5$</td></tr><tr><td>16</td><td>24</td><td>$d_k \text{ min} - 0,8$</td></tr><tr><td>24</td><td>36</td><td>$d_k \text{ min} - 1$</td></tr><tr><td>36</td><td>—</td><td>$d_k \text{ min} - 1,2$</td></tr></table>			Thread diameter		d_w	>	≤	min.		2,5	$d_k \text{ min} - 0,14$	2,5	5	$d_k \text{ min} - 0,25$	5	10	$d_k \text{ min} - 0,4$	10	16	$d_k \text{ min} - 0,5$	16	24	$d_k \text{ min} - 0,8$	24	36	$d_k \text{ min} - 1$	36	—	$d_k \text{ min} - 1,2$	For product grade A only
Thread diameter		d_w																													
>	≤	min.																													
	2,5	$d_k \text{ min} - 0,14$																													
2,5	5	$d_k \text{ min} - 0,25$																													
5	10	$d_k \text{ min} - 0,4$																													
10	16	$d_k \text{ min} - 0,5$																													
16	24	$d_k \text{ min} - 0,8$																													
24	36	$d_k \text{ min} - 1$																													
36	—	$d_k \text{ min} - 1,2$																													
 Figure 19	d_a for products without undercut is specified in ISO 885.			d_a for undercut products, see the appropriate product standard.																											

Feature	Tolerance for product grades			Notes
	A	B	C	
3.1.4.4 Length  Figure 20	js15	js17	$l \leq 150$: js17 $l > 150$: $\pm IT17$	

Feature	Tolerance for product grades			Notes
	A	B	C	
3.1.4.5 Thread length Bolt  Tie rod  Stud  Figure 21	$b + 2P$ 0	$b + 2P$ 0	$b + 2P$ 0	P is the pitch of thread. l_s is the minimum length of the unthreaded (plain) shank. l_g is the maximum length of the unthreaded shank (thread run-out included) and is therefore the minimum clamping length. Tolerance $+ 2 P$ related to dimension b applies only where l_s and l_g are not specified in the product standard. b_m refers to metal end of studs only.
3.1.4.6 Shank diameter     Figure 22	h13	h14	$\pm IT 15$	The tolerance is not applicable in the areas of the underhead fillet and thread run-out.
	Reduced shank diameter $\approx$ pitch diameter			

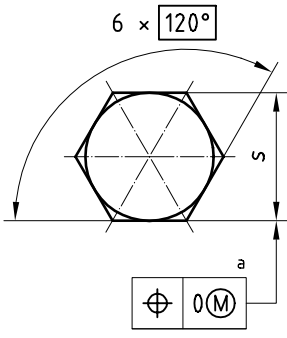
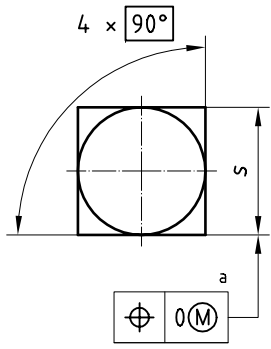
3.2 Geometrical tolerances

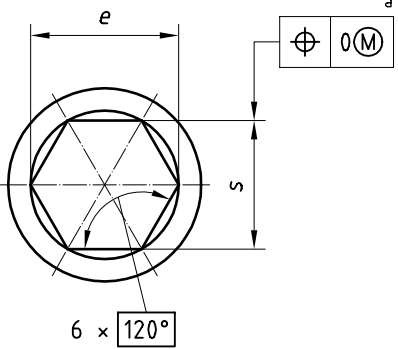
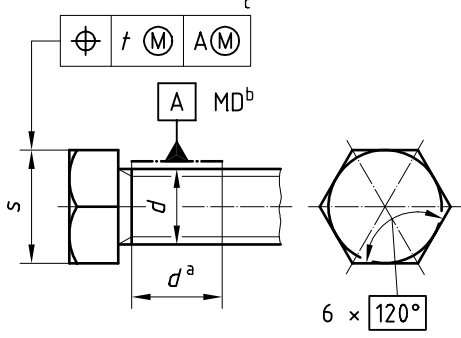
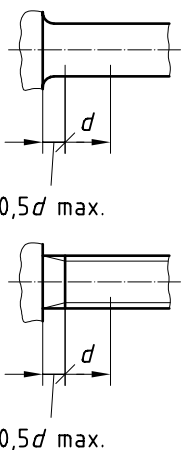
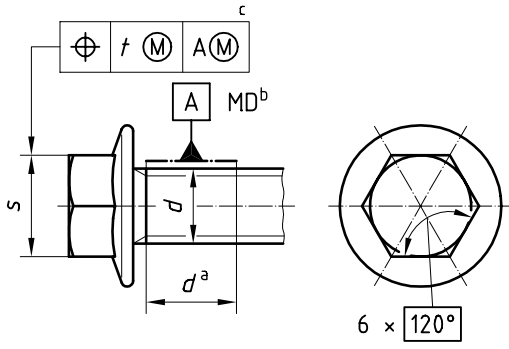
In accordance with ISO 1101 and ISO 2692 the tolerances specified in Figures 23 to 57 do not necessarily imply the use of any particular method of production, measurement or gauging.

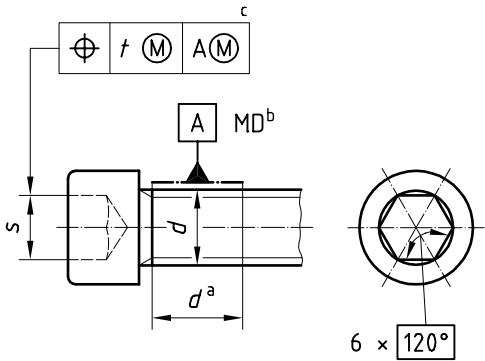
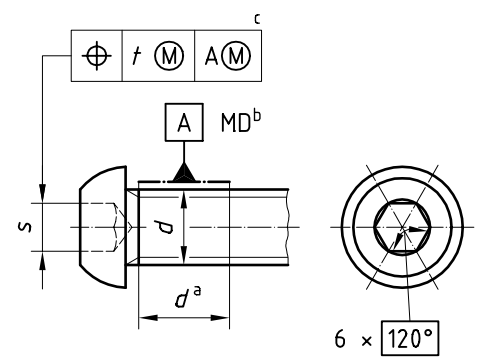
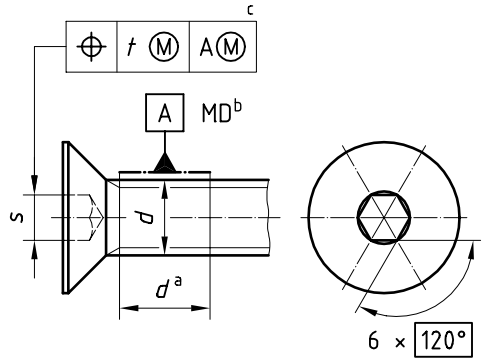
When the pitch diameter axis is specified as the datum and the coaxiality deviation of the major diameter axis relative to the pitch diameter axis is negligible, e.g. normally with rolled threads, the major diameter axis may be taken as the datum.

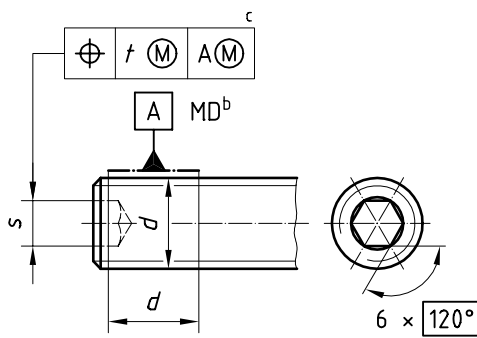
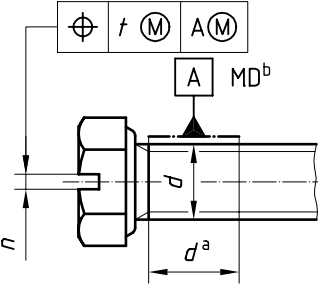
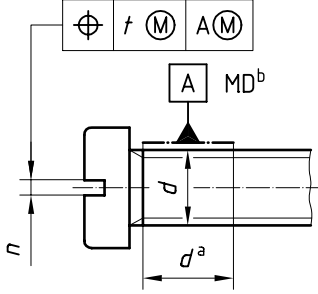
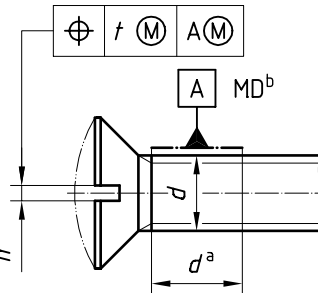
According to ISO 1101 when the datum is the thread axis the letters MD indicate that the datum reference is the major diameter axis.

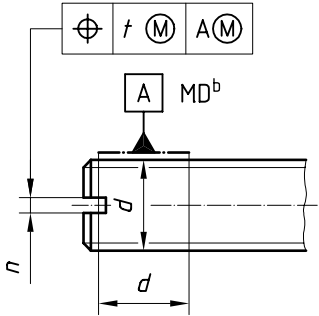
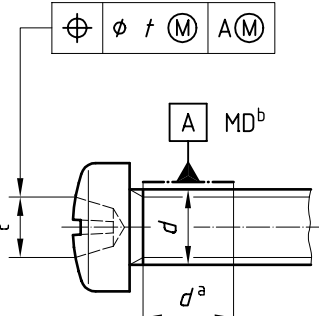
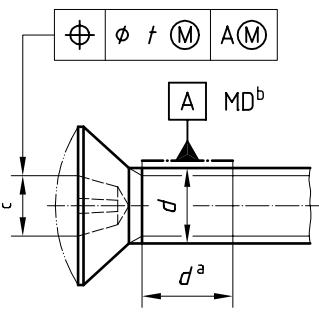
The maximum material principle in accordance with ISO 2692 is used.

Feature	Tolerance t for product grades			Notes
	A	B	C	
3.2.1 Driving feature 3.2.1.1 Tolerances of form 3.2.1.1.1 External  a 3 × simultaneously. Figure 23  a 2 × simultaneously. Figure 24				

Feature	Tolerance t for product grades			Tolerance t based on dimensions	Notes
	A	B	C		
3.2.1.1.2 Internal  $6 \times 120^\circ$ ^a 3 × simultaneously. Figure 25					
3.2.1.2 Tolerances of position  $6 \times 120^\circ$ ^a The datum A shall be as close to the head as possible but within $0,5d$ distance of the head and shall be either wholly plain or wholly threaded but shall not include the thread run-out or underhead fillet. ^b MD means that tolerance applies in relation to the axis of the cylinder derived from the major thread diameter. ^c 3 × simultaneously. Figure 26	2 IT13	2 IT14	2 IT15	s	 $0,5d$ max. $0,5d$ max.
 $6 \times 120^\circ$ a, b, c See Figure 26. Figure 27	2 IT13	2 IT14	—	s	

Feature	Tolerance t for product grades			Tolerance t based on dimensions	Notes
	A	B	C		
 a, b, c See Figure 26 Figure 28	2 IT13	—	—	d	
 a, b, c See Figure 26. Figure 29	2 IT13	—	—	d	
 a, b, c See Figure 26. Figure 30	2 IT13	—	—	d	

Feature	Tolerance t for product grades			Tolerance t based on dimensions	Notes
	A	B	C		
 b, c See Figure 26. Figure 31	2 IT12	—	—	d	
 a, b See Figure 26 Figure 32	2 IT12	2 IT13	2 IT14	d	
 a, b See Figure 26. Figure 33	2 IT12	2 IT13	2 IT14	d	
 a, b See Figure 26. Figure 34	2 IT12	2 IT13	2 IT14	d	

Feature	Tolerance t for product grades			Tolerance t based on dimensions	Notes
	A	B	C		
 b See Figure 26. Figure 35	2 IT12	—	—	d	
 a, b See Figure 26. c For referee purposes coaxiality of cross recess shall be assessed by means of a penetration gauge point in accordance with ISO 4757. Figure 36	2 IT13	—	—	d	
 a, b See Figure 26. c See Figure 36. Figure 37	2 IT13	—	—	d	