

UNBRAKO Metric Fasteners

UNBRAKO Metric Fasteners are the strongest off-the-shelf threaded fasteners you can buy. Their exclusive design features and closely controlled manufacturing processes insure the dimensional accuracy, strength and fatigue resistance needed for reliability in today's advanced technology. They are manufactured with the same methods and features as their inch-series counterpart.

Strength

UNBRAKO metric socket head cap screws are made into property class 12.9 with a minimum ultimate tensile strength of 1300 or 1250 MPa depending on screw diameter. Precision in manufacturing and careful control in stress areas insure strength in such critical areas as heads, sockets, threads, fillets, and bearing areas.

When you purchase UNBRAKO metric socket screw products, you can be sure that they meet or exceed the strength levels of all current standards, including the three most common-ANSI, ISO and DIN. Unbrako is represented on several ASME, ANSI, ASTM and ISO committees.

- ANSI (American National Standards Institute) documents are published by ASME (The American Society of Mechanical Engineers) and are familiar to almost all users of socket screw products in the U.S.A.
- ASTM (American Society for Testing and Materials). Many ANSI documents list dimensional information but refer to ASTM specifications for materials, mechanical properties, and test criteria.

- ISO (International Standards Organization) is a standards group comprising 70 member nations. Its objective is to provide standards that will be completely universal and common to all countries subscribing.

- DIN (Deutsche Industries Normen) is the German standards group.

NOTE: The proper tightening of threaded fasteners can have a significant effect on their performance.

A WARNING TO METRIC FASTENER USERS

Metric socket cap screws are NOT sold in a single strength level like U.S. inch socket screws.

Property Class	General Material	Strength Level, UTS min. MPa (KSI)
	International Standards Organization, ISO	
Property Class 8.8	Carbon Steel	800 (116) < M16 830 (120) ≥ M16
Property Class 10.9	Alloy Steel	1040 (151)
Property Class 12.9	Alloy Steel	1220 (177)
USA Standards ASTM A574M	Alloy Steel	1220 (177)
Unbrako Standards ASTM A574M	Alloy Steel	1300 (189) ≤ M16 1250 (181) > M16

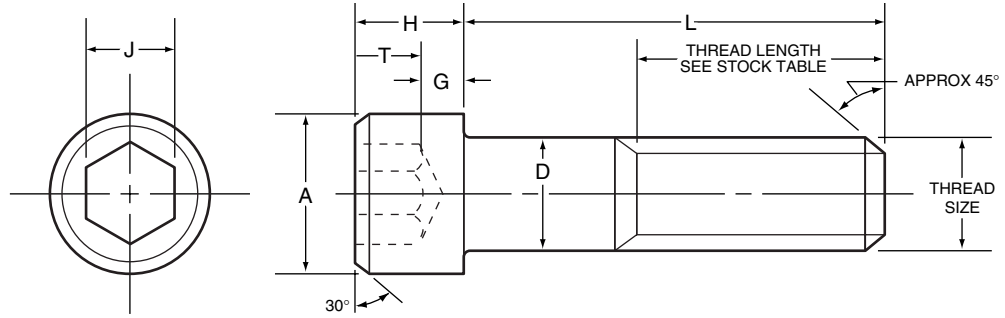
STANDARDS

The use of metric fasteners in the worldwide market has led to the creation of many standards. These standards specify the fastener requirements: dimensions, material, strength levels, inspection, etc. Different standards are the responsibility of various organizations and are not always identical. Unbrako supplies metric fasteners for maximum interchangeability with all standards. This Engineering Guide was published with the most current values, which are however subject to change by any standards organization at any time.

METRIC SOCKET HEAD CAP SCREWS

Dimensions

Threads: ANSI B1.13M, ISO 261, ISO 262 (coarse series only)
Property Class: 12.9-ISO 898/1



NOTES

- Material:** ASTM A574M, DIN ENISO4762-alloy steel
- Hardness:** Rc 38-43
- Tensile Stress:** 1300 MPa thru M16 size.
1250 MPa over M16 size.
- Yield Stress:** 1170 MPa thru M16 size.
1125 MPa over M16 size.
- Thread Class:** 4g 6g

LENGTH TOLERANCE

nominal screw length	nominal screw diameter		
	M1.6 thru M10	M12 thru M20	over 20
	tolerance on lgth., mm		
Up to 16 mm, incl.	±0.3	±0.3	-
Over 16 to 50 mm, incl.	±0.4	±0.4	±0.7
Over 50 to 120 mm, incl.	±0.7	±1.0	±1.5
Over 120 to 200 mm, incl.	±1.0	±1.5	±2.0
Over 200 mm	±2.0	±2.5	±3.0

DIMENSIONS

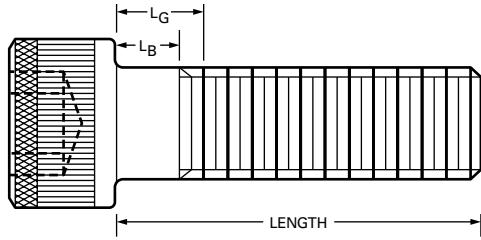
MECHANICAL PROPERTIES

APPLICATION DATA

thread size nom.	pitch	A max.	D max.	H max.	J nom.	G min.	T min.	UTS min. MPa	tensile strength min.		single shear strength of body min.		recommended ** seating torque plain finish	
									kN	lbs.	kN	lbs.	N-m	in-lbs.
M1.6	0.35	3.0	1.6	1.6	1.5	0.54	0.80	1300	1.65	370	1.57	352.5	0.29	2.6
M2	0.40	3.8	2.0	2.0	1.5	0.68	1.0	1300	2.69	605	2.45	550	0.60	5.3
M2.5	0.45	4.5	2.5	2.5	2.0	0.85	1.25	1300	4.41	990	3.83	860	1.21	11
M3	0.5	5.5	3.0	3.0	2.5	1.02	1.5	1300	6.54	1,470	5.5	1240	2.1	19
M4	0.7	7.0	4.0	4.0	3.0	1.52	2.0	1300	11.4	2,560	9.8	2,205	4.6	41
M5	0.8	8.5	5.0	5.0	4.0	1.90	2.5	1300	18.5	4,160	15.3	3,445	9.5	85
M6	1.0	10.0	6.0	6.0	5.0	2.28	3.0	1300	26.1	5,870	22.05	4,960	16	140
M8	1.25	13.0	8.0	8.0	6.0	3.2	4.0	1300	47.6	10,700	39.2	8,800	39	350
M10	1.5	16.0	10.0	10.0	8.0	4.0	5.0	1300	75.4	17,000	61	13,750	77	680
M12	1.75	18.0	12.0	12.0	10.0	4.8	6.0	1300	110	24,700	88	19,850	135	1,200
*(M14)	2.0	21.0	14.0	14.0	12.0	5.6	7.0	1300	150	33,700	120	27,000	215	1,900
M16	2.0	24.0	16.0	16.0	14.0	6.4	8.0	1300	204	45,900	157	35,250	330	2,900
M20	2.5	30.0	20.0	20.0	17.0	8.0	10.0	1250	306	68,800	235.5	53,000	650	5,750
M24	3.0	36.0	24.0	24.0	19.0	9.6	12.0	1250	441	99,100	339	76,500	1100	9,700
*M30	3.5	45.0	30.0	30.0	22.0	12.0	15.0	1250	701	158,000	530	119,000	2250	19,900
*M36	4.0	54.0	36.0	36.0	27.0	14.4	18.0	1250	1020	229,000	756	171,500	3850	34,100
*M42	4.5	63.0	42.0	42.0	32.0	16.8	21.0	1250	1400	315,000	1040	233,500	6270	55,580
*M48	5.0	72.0	48.0	48.0	36.0	19.2	24.0	1250	1840	413,000	1355	305,000	8560	75,800

All dimensions in millimeters.
 Sizes in brackets not preferred for new designs.
 *Non-stock diameter.
 **Torque calculated in accordance with VDI 2230, "Systematic Calculation of High Duty Bolted Joints," to induce approximately 800 MPa stress in screw threads. Torque values listed are for plain screws. (See Note, page 1.)

SOCKET HEAD CAP SCREWS ■ Metric ■ Body and Grip Lengths



L_G is the maximum grip length and is the distance from the bearing surface to the first complete thread.

L_B is the minimum body length and is the length of the unthreaded cylindrical portion of the shank.

BODY and GRIP LENGTHS

BODY AND GRIP LENGTH DIMENSIONS FOR METRIC SOCKET HEAD CAP SCREWS

Nominal Size	M1.6		M2		M2.5		M3		M4		M5		M6		M8		M10		M12		M14		M16		M20		M24		
	L_G	L_B	L_G	L_B	L_G	L_B	L_G	L_B	L_G	L_B	L_G	L_B	L_G	L_B	L_G	L_B	L_G	L_B	L_G	L_B	L_G	L_B	L_G	L_B	L_G	L_B	L_G	L_B	
20	4.8	3.0	4.0	2.0																									
25	9.8	8.0	9.0	7.0	8.0	5.7	7.0	4.5																					
30	14.8	13.0	14.0	12.0	13.0	10.7	12.0	9.5	10.0	6.5																			
35	19.0	17.0	18.0	15.7	17.0	14.5	15.0	11.5	13.0	9.0	11.0	6.0															
40	24.0	22.0	23.0	20.7	22.0	19.5	20.0	16.5	18.0	14.0	16.0	11.0															
45	28.0	25.7	27.0	24.5	25.0	21.5	23.0	19.0	21.0	16.0	17.0	10.7													
50	33.0	30.7	32.0	29.5	30.0	26.5	28.0	24.0	26.0	21.0	22.0	15.7	18.0	10.5											
55	37.0	34.5	35.0	31.5	33.0	29.0	31.0	26.0	27.0	20.7	23.0	15.5											
60	42.0	39.5	40.0	36.5	38.0	34.0	36.0	31.0	32.0	25.7	28.0	20.5	24.0	15.2									
65	47.0	44.5	45.0	41.5	43.0	39.0	41.0	36.0	37.0	30.7	33.0	25.5	29.0	20.2	25.0	15.0							
70	50.0	46.5	48.0	44.0	46.0	41.0	42.0	35.7	38.0	30.5	34.0	25.2	30.0	20.0	26.0	16.0					
80	60.0	56.5	58.0	54.0	56.0	51.0	52.0	45.7	48.0	40.5	44.0	35.2	40.0	30.0	36.0	26.0					
90	68.0	64.0	66.0	61.0	62.0	55.7	58.0	50.5	54.0	45.2	50.0	40.0	46.0	36.0	38.0	25.5			
100	78.0	74.0	76.0	71.0	72.0	65.7	68.0	60.5	64.0	55.2	60.0	50.0	56.0	46.0	48.0	35.5	40.0	25.0	
110	86.0	81.0	82.0	75.7	78.0	70.5	74.0	65.2	70.0	60.0	66.0	56.0	58.0	45.5	50.0	35.0
120	96.0	91.0	92.0	85.7	88.0	80.5	84.0	75.2	80.0	70.0	76.0	66.0	68.0	55.5	60.0	45.0
130	102.0	95.7	98.0	90.5	94.0	85.2	90.0	80.0	86.0	76.0	78.0	65.5	70.0	55.0
140	112.0	105.7	108.0	100.5	104.0	95.2	100.0	90.0	96.0	86.0	88.0	75.5	80.0	65.0
150	122.0	115.7	118.0	110.5	114.0	105.2	110.0	100.0	106.0	96.0	98.0	85.5	90.0	75.0
160	132.0	125.7	128.0	120.5	124.0	115.2	120.0	110.0	116.0	106.0	108.0	95.5	100.0	85.0
180	148.0	140.5	144.0	135.2	140.0	130.0	136.0	126.0	128.0	115.5	120.0	105.0
200	168.0	160.5	164.0	155.2	160.0	150.0	156.0	146.0	148.0	135.5	140.0	125.0
220	184.0	175.2	180.0	170.0	176.0	166.0	168.0	155.5	160.0	145.0
240	204.0	195.2	200.0	190.0	196.0	186.0	188.0	175.5	180.0	165.0
260	220.0	210.0	216.0	206.0	208.0	195.5	200.0	185.0	
300	256.0	246.0	248.0	235.5	240.0	225.0	

SOCKET HEAD CAP SCREWS (METRIC SERIES)

PER ASME/ANSI B18.3.1M-1986