



Designation: F541 – 12 (Reapproved 2020)

Standard Specification for Alloy Steel Eyebolts¹

This standard is issued under the fixed designation F541; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the U.S. Department of Defense.

1. Scope*

1.1 This specification covers forged, quenched and tempered, alloy steel threaded eyebolts with improved toughness properties and intended primarily for low temperature applications. The eyebolts are chemically and metallurgically constituted to produce a low transition temperature to minimize brittle failure. Maximum thread size is 2.500 in. (63.50 mm).

1.2 The eyebolts are furnished in two types, as follows:

1.2.1 *Type 1*—Straight Shank Eyebolt.

1.2.2 *Type 2*—Shoulder Eyebolt.

1.3 The values stated in inch-pound units are to be regarded as the standard. The values in parentheses are for information only.

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[A370 Test Methods and Definitions for Mechanical Testing of Steel Products](#)

[A574 Specification for Alloy Steel Socket-Head Cap Screws](#)

[A751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products](#)

[E10 Test Method for Brinell Hardness of Metallic Materials](#)

[E18 Test Methods for Rockwell Hardness of Metallic Materials](#)

[E112 Test Methods for Determining Average Grain Size](#)

[E340 Practice for Macroetching Metals and Alloys](#)

¹ This specification is under the jurisdiction of ASTM Committee F16 on Fasteners and is the direct responsibility of Subcommittee F16.02 on Steel Bolts, Nuts, Rivets and Washers.

Current edition approved Dec. 1, 2020. Published December 2020. Originally approved in 1977. Last previous edition approved in 2012 as F541 – 12. DOI: 10.1520/F0541-12R20.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

[E709 Guide for Magnetic Particle Testing](#)

[F606/F606M Test Methods for Determining the Mechanical Properties of Externally and Internally Threaded Fasteners, Washers, Direct Tension Indicators, and Rivets](#)

[F1470 Practice for Fastener Sampling for Specified Mechanical Properties and Performance Inspection](#)

2.2 *ASME Standards:*³

[B1.1 Unified Screw Threads](#)

[B18.15 Forged Eyebolts](#)

[B18.24 Part Identifying Number \(PIN\) Code System Standard for B18 Fastener Products](#)

3. Ordering Information

3.1 Orders for eyebolts under this specification shall include the following information to adequately describe the part:

3.1.1 ASTM specification number and date of issue,

3.1.2 Name of part (alloy steel eyebolts),

3.1.3 Regular or shoulder pattern (8.1),

3.1.4 Size (nominal diameter and threads),

3.1.5 Number of pieces,

3.1.6 Certification or test reports (if required) (14.1),

3.1.7 Additional requirements (if required), and

3.1.8 Supplementary requirements (if required).

3.1.9 For establishment of a part identifying system, see ASME B18.24.

4. Materials and Manufacture

4.1 *Melting Process*—The steel shall be made to a fine-grain practice using a melting process yielding a product conforming to the requirements of this specification.

4.2 *Forging*—Eyebolts shall be forged without welds.

4.3 *Heat Treatment*—The eyebolts shall be quenched and tempered in accordance with proper practice to yield a product conforming to the requirements of this specification.

4.4 *Machining*—The eyebolt shall be machined prior to or after heat treatment at the manufacturer's option.

³ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Two Park Ave., New York, NY 10016-5990, <http://www.asme.org>.

*A Summary of Changes section appears at the end of this standard

5. Chemical Composition

5.1 *Limits*—The eyebolts shall be manufactured from steels having a heat analysis conforming to the requirements in **Table 1**.

5.2 Product Analysis:

5.2.1 The purchaser reserves the right to conduct product analyses on the finished eyebolts or request the manufacturer to conduct product analyses tests. The composition thus determined shall conform to the requirements specified in **Table 1** subject to the product analysis tolerances.

5.2.2 Chemical analyses shall be performed in accordance with Test Methods, Practices, and Terminology **A751**.

6. Metallurgical Requirements

6.1 Grain Size:

6.1.1 *Requirements*—The finished eyebolts shall have an apparent heat-treated grain size of Test Methods **E112** No. 5 or finer.

6.1.2 *Specimen*—Grain size shall be rated on specimens taken from the eyebolt after final heat treatment.

6.1.3 *Test Method*—Grain size on the finished eyebolt shall be determined in accordance with Test Methods **E112**.

6.2 Macroetch Test:

6.2.1 *Requirement*—When ground and etched, the cross section of the eyebolt shall be free of injurious surface seams, internal cracks, pipe, segregation, and other imperfections detrimental to the intended application.

6.2.2 *Specimen*—Macroetch test specimens shall consist of the full transverse cross section of a finished eyebolt shank.

6.2.3 *Test Method*—Macroetch tests shall be performed in accordance with Test Method **E340**.

6.3 Decarburization:

6.3.1 *Requirement*—The depth of decarburization (total + partial), as measured on the eyebolts after heat treatment, shall not exceed the requirements in **Table 2**.

6.3.2 *Specimen*—The test specimens shall consist of the unmachined surface of the heat-treated eyebolts in an area where threads would normally be machined.

6.3.3 *Test Method*—The depth of decarburization shall be determined by metallographic etching. The edge of the specimen shall be suitably prepared to preserve the original surface

TABLE 1 Chemical Requirements, %

	Heat Analysis	Permissible Variation on Product Analysis, Over or Under
Carbon, max	0.33	0.02 over
Manganese	0.30 to 1.10	0.04
Phosphorus, max	0.025	0.005 over
Sulfur, max	0.025	0.005 over
Silicon	0.15 to 0.35	0.02
Chromium, max ^A	0.90	0.05 over
Molybdenum ^A	0.10 to 0.60	0.02
Nickel ^A	0.40 to 3.75	0.03

^A The composition shall contain at least two of the elements shown.

TABLE 2 Decarburization Limits

Nominal Size, In.	Depth of Decarburization, Total + Partial, max	
	in.	mm
0.250 to 0.375	0.030	0.762
0.4375 to 0.625	0.040	1.02
0.750 to 1.000	0.050	1.27
1.125 to 1.500	0.060	1.52
1.750 to 2.500	0.070	1.78

and the sample shall then be polished for metallographic examination. The section shall be etched in 4 % nital and the samples examined under a microscope at 100× using an eyepiece graduated in 0.001-in. (0.025-mm) increments. The measured depth of any light etched band shall be taken as the decarburization depth.

6.3.4 When the metallographic etch method of **6.3.3** for decarburization renders results that are inconclusive, then the microhardness traverse method of Specification **A574** shall be employed. The depth of decarburization shall be denoted by that radial depth where the hardness decrease is more than the equivalent of 3 points HRA, when compared to the average microhardness of undecarburized locations beyond this site. The average microhardness of undecarburized locations of the eyebolt shall be determined for depths not exceeding 25 % of its shank diameter.

7. Mechanical Properties

7.1 Hardness:

7.1.1 *Requirements*—The eyebolts shall have a Brinell Hardness of 197 to 248 (equivalent Rockwell B93 to 101). Hardness tests are subject to confirmation by tensile tests.

7.1.1.1 In case of controversy, acceptance based on tensile requirements shall take precedence over low readings of hardness tests.

7.1.2 *Specimens*—For routine inspection, hardness tests shall be made on a properly prepared surface of the finished eyebolt. For referee purposes tests shall be made on a transverse section through the threads one diameter from the end.

7.1.3 *Test Method*—Hardness tests shall be made in accordance with Test Methods **E10** or **E18**, as applicable.

7.2 Tensile Strength:

7.2.1 *Requirement*—Test specimens machined from finished eyebolts shall conform to the tensile properties specified in **Table 3**.

7.2.2 *Specimens*—Eyebolts for tensile tests shall be selected from the eyebolts subjected to the hardness test to represent the high and low end of the hardness test results. The specimens

TABLE 3 Tensile Requirements

Tensile strength, min, psi (MPa)	95 000 (660)
Yield strength, min (0.2 % offset), psi (MPa)	70 000 to 100 000 (485 to 690)
Elongation in 2 in. (50 mm), min, %	22
Reduction of area, min, %	55
Brinell hardness ^A	197 to 248
Rockwell B hardness ^A	93 to 101

^A Hardness tests are subject to confirmation by tension tests.

shall be machined from the finished eyebolts whenever possible. When the eyebolts are too small to remove machined specimens, they shall be taken from test coupons from the same heat of steel, subjected to the same reduction, and heat treated with the eyebolts represented.

7.2.3 *Test Methods*—Tension tests shall be made in accordance with Test Methods **F606/F606M**.

7.3 *Breaking Strength:*

7.3.1 *Requirements*—The eyebolt shall conform to the breaking strength specified in **Table 4**.

7.3.2 *Specimens*—Eyebolts for breaking strength tests shall be selected from the eyebolts subjected to the hardness test to represent the high and low end of the hardness test results. The eyebolts shall be tested full size.

7.3.3 *Test Methods*—The breaking strength shall be determined by exerting an in-line pull upon the eyebolt which has had its threaded shank screwed into a block and secured in one jaw of the testing machine. The eye shall be loaded by a round section no greater than 50 % of eye diameter and secured in the other jaw of the testing machine.

7.4 *Proof of Load:*

7.4.1 *Requirements*—The eyebolts, when tested in accordance with Section **10**, shall withstand the proof load specified in **Table 4**.

7.4.2 *Specimens*—Eyebolts for proof load tests shall be selected in accordance with **7.3.2** and may be the same specimens used for the breaking strength tests.

7.4.3 *Test Methods*—The proof load shall be defined as the load that can be applied without causing permanent deformation exceeding 1.5 % when measured between punch marks located across the diameter of the eye and 90° to the direction of the pull. The fixture for testing shall be as specified in **7.3.3**.

7.5 *Impact:*

7.5.1 *Requirements:*

7.5.1.1 Eyebolts sufficiently large to remove full-size impact specimens shall have a Charpy V-notch impact strength of

35 ft·lbf (47.5 J) average minimum when tested at –40 °C (–40 °F). The impact value shall be taken as the average of three specimens tested with not more than one value below 35 ft·lbf but in no case below 23 ft·lbf (31.0 J).

7.5.1.2 Subsize Charpy V-notch specimens shall be obtained from eyebolts with section sizes not suitable for full size standard specimens. Impact strength shall be reported for information only. However, the fracture surface shall show a fine-grain fibrous structure characteristic of a shear fracture.

7.5.2 *Test Specimens*—Eyebolts for impact tests shall be selected from the eyebolts subjected to the hardness test to represent the high and low end of the hardness test results. Test specimens shall conform to the standard 10 by 10-mm Charpy V-notch Type A specimen shown in Test Methods and Definitions **A370**. Eyebolts too small for standard impact test specimens shall be tested using the largest possible subsize square specimen with the standard 45° V-notch adjusted in depth to be proportional to the standard specimen.

7.5.3 *Test Method*—Impact tests shall be made in accordance with Test Methods and Definitions **A370** at –40 °C (–40 °F).

7.6 *Bend:*

7.6.1 *Requirements*—Type 1 straight-shank eyebolts 1½ in. diameter and smaller, when tested in accordance with Section **10**, shall withstand bending through 45° at room temperature without visible ruptures in the threaded or unthreaded portions when examined at 10× magnification.

7.6.2 *Specimens*—Eyebolts for bend tests shall be selected from the eyebolts subjected to the hardness test to represent the high and low end of the hardness test results. The eyebolts shall be tested full size.

7.6.3 *Test Method*—The eyebolts shall be screwed into a steel block a minimum of one diameter to ensure bending primarily in the threaded section. Bending shall be accomplished by pressure or blows.

TABLE 4 Breaking Strength and Proof Load

Nominal Size and Number of Threads	Tension Stress Area, in. ²	Breaking Strength, min		Proof Load, min	
		lb	Mg	lb	Mg
0.250—20	0.0318	3 020	1.37	1 220	0.55
0.3125—18	0.0524	5 000	2.27	2 000	0.91
0.375—16	0.0775	7 400	3.35	2 960	1.34
0.4375—14	0.1063	10 100	4.60	4 040	1.84
0.500—13	0.1419	13 500	6.1	5 400	2.44
0.625—11	0.226	21 500	9.8	8 600	3.92
0.750—10	0.334	32 000	14.5	12 800	5.8
0.875—9	0.462	44 000	20.0	17 600	8.0
1.000—8	0.606	58 000	26.5	23 200	10.6
1.125—7	0.763	72 000	32.5	28 800	13.0
1.250—7	0.969	92 000	42.0	36 800	16.8
1.500—6	1.405	133 000	60.0	53 200	24.0
1.750—5	1.90	180 000	82	72 000	32.8
2.000—4.5	2.50	238 000	108	95 200	43.2
2.500—4	4.00	380 000	172	152 000	68.8

8. Dimensions and Permissible Variations

8.1 *Dimensions*—The dimensions of the eyebolts shall conform to the requirements specified in the latest issue of B18.15, Type 1 Regular Pattern, or Type 2 Shoulder Pattern, as specified by the purchaser.

8.2 *Threads*—The eyebolts shall be threaded. Threads shall conform to the Unified Coarse Thread Series as specified in B1.1, and shall have Class 2A tolerances.

9. Workmanship, Finish, and Appearance

9.1 The eyebolts shall be descaled.

9.2 The eyebolts shall be of uniform quality consistent with good manufacturing and inspection practices. They shall be free of fins, cracks, seams, laps, nicks, pipe, segregation, rough surfaces, and other injurious internal or surface imperfections which, due to their nature, degree, or extent, would make the eyebolts unsuitable for the intended use.

9.3 Threads shall be undamaged upon the receipt of eyebolts by the purchaser.

10. Number of Tests

10.1 General Requirements:

10.1.1 The manufacturer shall make sample inspections of every lot of eyebolts to ensure that the properties of the eyebolts are in conformance with the requirements of this specification. All eyebolts shall be inspection tested prior to shipment in accordance with one of the two procedures described in 10.2 and 10.3. Unless otherwise specified by the purchaser, the manufacturer shall have the option of which procedure will be followed when furnishing eyebolts to any single purchase order.

10.1.2 The purpose of a lot inspection testing program is to ensure that each lot conforms to the requirements of the specification and that delivered eyebolts are free of known defects. For such a plan to be fully effective, it is essential that following delivery the purchaser continue to maintain the identification and integrity of each lot until the product is released for use.

10.2 Production Lot Method:

10.2.1 All eyebolts shall be processed in accordance with a production lot quality assurance plan. A production lot from which test samples shall be selected shall consist of all eyebolts of the same size, from the same heat, same part number, heat treated in a continuous run and tempered at one time. The minimum number of tests shall be in accordance with 10.2.2 through 10.2.8.

10.2.2 *Grain Size*—One grain size test shall be made from each production lot.

10.2.3 *Macroetch and Decarburization*— The number of tests shall be in accordance with the manufacturer’s standard quality control practices. The eyebolts shall be produced by manufacturing practices and subjected to mill tests and inspection procedures to ensure compliance with the specified requirements. Disposition of eyebolts and the lots they represent, when tested by the purchaser that fail to meet the specified requirements, shall be in accordance with Guide F1470 (Disposition of Nonconforming Lots, Purchasers Options).

10.2.4 *Hardness*—The number of hardness tests from each production lot shall be in accordance with Table 5.

10.2.5 *Tensile Strength*—Two tension tests, one representing the high and the low end of the hardness tests, shall be made to represent each production lot.

10.2.6 *Breaking Strength and Proof Load*—Four breaking strength and four proof load tests, two each representing the high and two the low end of the hardness tests, shall be made to represent each production lot.

10.2.7 *Impact*—Two impact tests, one representing the high and one the low end of the hardness tests, shall be made to represent each production lot.

10.2.8 *Bend*—Two bend tests, one representing the high and one the low end of the hardness tests, shall be made to represent each production lot.

10.3 Shipping Lot Method:

10.3.1 In-process inspection during all manufacturing operations and treatments and storage of manufactured eyebolts shall be in accordance with the practices of the individual manufacturer.

10.3.2 Before packing eyebolts for shipment, the manufacturer shall make tests of sample eyebolts taken at random from each shipping lot. A shipping lot, for purposes of selecting test samples, is defined as that quantity of eyebolts of the same nominal size and same nominal length necessary to fill the requirements of a single purchase order.

10.3.3 The manufacturer shall make tests for grain size, hardness, tensile strength, breaking strength, proof load, impact, and bend tests. Tests for macroetch and decarburization shall be in accordance with 10.2.3.

10.3.4 The number of hardness tests from each shipping lot shall be in accordance with Table 5. The number of grain size, tensile strength, breaking strength, proof load, impact, and bend tests shall be in accordance with Table 6 and shall be selected to represent the high and low end of the hardness tests.

11. Retesting

11.1 If the results of the hardness, tensile strength, breaking strength, impact, or proof load tests do not conform to the requirements specified, the lot, at the option of the manufacturer, shall be reheat treated, and the lot retested using

TABLE 5 Number of Hardness Tests

NOTE 1—Excerpt from MIL-STD-105^A, Inspection Level II.

Number of Pieces in Lot	Number of Hardness Tests	Number of Pieces in Lot	Number of Hardness Tests
2 to 8	2	501 to 1 200	80
9 to 15	3	1 201 to 3 200	125
16 to 25	5	3 201 to 10 000	200
26 to 50	8	10 001 to 35 000	315
51 to 90	13	35 001 to 150 000	500
91 to 150	20	150 001 to 500 000	800
151 to 280	32	500 000 and over	1 250
281 to 500	50		

^A This table from this military standard is available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.