



Designation: **A66–07 (Reapproved 2013) A66 – 21**

Standard Specification for Steel Screw Spikes¹

This standard is issued under the fixed designation A66; 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 steel screw spikes used as fastenings between railroad rails, tie plates, and ties.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

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](#)

[A700 Guide for Packaging, Marking, and Loading Methods for Steel Products for Shipment](#)

3. Ordering Information

3.1 Orders for screw spikes under this specification shall include the following information as appropriate:

3.1.1 *Quantity* (weight),

3.1.2 *Style of Head*—A, B, or C³ or other, including drawings if necessary,

3.1.3 *Type of Point*—pilot point or not pointed,

3.1.4 *Dimensions*—diameter and length, under head,

¹ This specification is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel and Related Alloys and is the direct responsibility of Subcommittee A01.01 on Steel Rails and Accessories.

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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.

³ Consult manufacturer's literature for design details for A, B, and C-style heads.

3.1.5 *Supplementary Requirement* if to apply (see S1)

3.1.6 *Certification and Test Report* (see 11.1).

4. Manufacture

4.1 The steel shall be made by any of the following processes: electric-furnace or basic-oxygen.

4.2 The steel may be cast by a continuous process, or in ingots.

4.3 The heads and threads of the spikes may be formed by hot- or cold-forming methods.

4.4 The composition of the steel shall be consistent with that shown in Table 1. The manufacturer may add other alloying elements at their discretion to meet mechanical properties of Table 2 but must report such elements in the material test report of chemical composition and mechanical properties.

5. Mechanical Requirements

5.1 *Tensile Requirements:*

5.1.1 The material as represented by a tension test of a full-size finished spike, or a specimen machined from a finished spike, shall conform to the requirements prescribed in Table 42.

5.1.2 Tension tests of full-size spikes shall be performed using a 10° wedge as described in Test Methods and Definitions A370, Supplement S11.1.5.

5.1.3 Where the design of the spike is such that full-size testing is impracticable, the tension test may be made on a specimen machined from a finished spike. Dimensions of the test specimen shall conform to the requirements of Test Methods and Definitions A370.

5.1.4 When a machined specimen test is performed, the elongation requirement prescribed in Table 42 shall apply. If a screw spike is machined and the specimen is tested and reported, the elongation meets or exceeds 18 %, the bend test is not required. See 5.2.

5.1.5 The yield point shall be determined by the drop of the beam or halt in the gage of the testing machine.

5.2 *Bend Requirement*—The body of a full-size finished spike shall withstand the bend test described in Table 23 without cracking on the outside of the bent portion.

TABLE 1 Chemical Requirements^A

NOTE 1—All alloy contents shown are in weight percent unless otherwise stated.

Element	Content
Carbon	0.18 to 0.23
Manganese	0.60 to 0.90
Phosphorous	0.04 max
Sulfur	0.05 max
Silicon	... ^B
Copper	... ^C
Chromium	...
Nickel	...
Molybdenum	...
Vanadium	...

^A If the manufacturer of the spikes intentionally adds an alloying element to a heat, these elements shall be reported.

^B Where an ellipses is shown, there is no requirement, but the element shall be reported in the test analysis.

^C The purchaser can specify a minimum copper content of 0.20 %. However, if copper exceeds 0.5 %, a nickel addition of Ni = 0.5 × (Cu) shall be added to the heat to prevent hot shortness.

TABLE 12 Tension Test Requirements

	Specimen	
	Full size	Machined
Tensile strength, min, psi (MPa)	60 000 (415)	60 000 (415)
Yield point, min	30 000 (205)	30 000 (250)
Elongation in 2 in. or 50 mm, min, %	18

TABLE 23 Bend Test Requirement

Body bend, cold	90°—around pin 3 times spike diameter
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6. Dimensions and Permissible Variations

6.1 The finished spikes shall conform to the dimensions specified by the purchaser, subject to the permissible variations prescribed in [Table 34](#).

6.2 The threads shall be sharp and true to gage and of the design specified by the purchaser.

7. Workmanship, Product Quality, Finish, and Appearance

7.1 The head of the finished spikes shall be concentric with and firmly joined to the body.

7.2 The starting material shall be free of injurious imperfections and shall have a workmanlike finish. ~~defects, such as laps, seams, cracks, or excessive oxide scale. Threads shall have no breaks in them or presence of cracks in thread roots and the average surface roughness shall not exceed 300 μ m.~~

8. Number of Tests and Retests

8.1 One tension test and one bend test shall be made from each lot of 100 kegs or fraction thereof.

8.2 If the percentage of elongation of a machined tension test specimen is less than that specified in [Table 12](#) and any part of the fracture is more than $\frac{3}{4}$ in. (19 mm) from the center of the gage length, as indicated by scribe scratches marked on the specimen before testing, a retest shall be allowed.

8.3 If, during the tension or bend tests, a previously undiscovered material or manufacturing flaw should be disclosed that interferes with the test or the interpretation of results, the substitution of another sample spike shall be permitted after it is demonstrated to the satisfaction of the purchaser or his representative, that the condition is not typical of the remainder of the lot.

8.4 If any test specimen fails because of mechanical reasons such as failure of testing equipment or improper specimen preparation, it may be discarded and another specimen taken.

9. Inspection

9.1 The manufacturer shall afford the purchaser's inspector all reasonable facilities necessary to satisfy that the material is being

TABLE 34 Permissible Variations in Dimensions

	Over		Under	
	in.	mm	in.	mm
Diameter, unthreaded portion	$\frac{1}{32}$	0.8
Diameter, threaded portion	$\frac{1}{32}$	0.8
Reach of head	$\frac{1}{8}$	3.2	$\frac{1}{16}$	1.6
Width across flats	0	0.0	$\frac{1}{32}$	0.8
Length	$\frac{1}{8}$	3.2	$\frac{1}{8}$	3.2