
**Aerospace — Nuts, metric —
Tolerances of form and position**

*Aéronautique et espace — Écrous métriques — Tolérances de forme
et de position*

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Published in Switzerland

Contents

	Page
Foreword.....	iv
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Types of nuts, illustration of tolerances of form and position, values	1
Annex A (informative) Plain nuts	10
Annex B (informative) Slotted nuts	11
Annex C (informative) Self-locking nuts with wrenching feature, with plastic locking ring	12
Annex D (informative) Self-locking hexagonal nuts, with wrenching feature, formed out-of-round	13
Annex E (informative) Self-locking bihexagonal nuts, with wrenching feature, formed out-of-round	14
Annex F (informative) Self-locking clinch/shank nuts	15
Annex G (informative) Self-locking anchor nuts, two lug	16
Annex H (informative) Self-locking anchor nuts, single lug	17
Annex I (informative) Self-locking anchor nuts, corner	18
Bibliography	19

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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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 20, *Aircraft and space vehicles*, Subcommittee SC 4, *Aerospace fastener systems*. <https://standards.iteh.ai/catalog/standards/sist/cbd70719-1691-4ba4-bb82-138-78174111-8788-2020>

This third edition cancels and replaces the second edition (ISO 8788:2000), of which it constitutes a minor revision.

The changes compared to the previous edition are as follows:

- informative references changed from dated to undated and moved to the Bibliography;
- the document editorially revised.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Aerospace — Nuts, metric — Tolerances of form and position

1 Scope

This document defines the tolerances of form and position of metric nuts meant for aerospace construction. These tolerances comply with ISO 1101, ISO 2692 and ISO 5459.

2 Normative references

There are no normative references in this document.

3 Terms and definitions

No terms and definitions are listed in this document.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

4 Types of nuts, illustration of tolerances of form and position, values

See [Table 1](#) for the tolerances of form and position to be applied in relation to the type of nut, [Table 2](#) to [Table 11](#) for the illustration of tolerances of form and position for different types of nut. See [Tables 12](#) and [Table 13](#) for the values of the tolerances. In the “illustration” column, only one type of nut has been shown as an example, but the corresponding tolerance applies to all types of nut specified in the third column.

Table 1 — Tolerances of form and position to be applied in relation to the type of nut

Table	Tolerance of former position	Sequence number													
		Plain nuts		Slotted nuts	with wrenching feature			Self-locking nuts			anchor				
		1	2		with plastic locking ring	formed hexagonal	out-of-round	clinch/shank	two-lug	single-lug	corner				
2	Flatness of bearing surface	1	1	1	1	1	1								
3	Squareness of bearing surface	2	2	2	2	2	2	2	2	2	2	3	3	3	3
4	Across flats symmetry	4	4	4	4	5	6								
5	Symmetry of slots		7												
6	Locking wire hole position	8													
7	Flange run-out			9		9	9								
8	Counterbore coaxiality			10		10	10					10	10	10	10
9	Symmetry of flange of the clinch/shank nuts								11						
10	Clinching shank coaxiality								12						
11	Rivet hole position											13	14	15	15
Annex															
A		X													
B			X												
C															
D															
E										X					
F									X						
G												X			
H													X		
I															X

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Table 2 — Flatness of bearing surface

Tolerances in millimetres

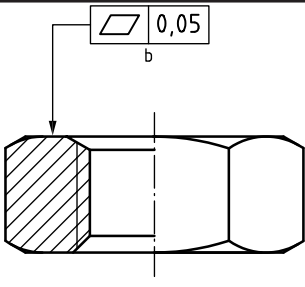
Sequence number	Illustration	Type of nut
1		Plain ^a , slotted and self-locking nuts with wrenching feature
<p>^a The flatness tolerance applies to both faces of plain nuts.</p> <p>^b Not convex.</p>		

Table 3 — Squareness of bearing surface

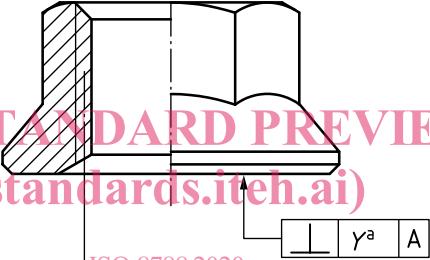
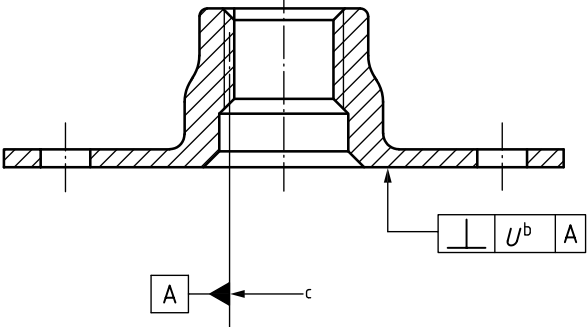
Sequence number	Illustration	Type of nut
2	 <p style="text-align: center;">iTeH STANDARD PREVIEW (standards.ieh.ai)</p> <p style="text-align: center;">ISO 8788:2020 https://standards.ieh.ai/catalog/standards/sist/cbd70719-1691-4ba4-bb82-1138a1f8d741/iso-8788-2020</p>	Plain, slotted and self-locking nuts with wrenching feature, and clinch/shank nuts
3		Anchor nuts
<p>^a See Table 13. The squareness tolerance applies to both faces of plain nuts.</p> <p>^b Applicable over a diameter equal to K, see Table 13. For floating anchor nuts and gang channels, this requirement applies to the floating element only over a diameter equal to the width of this element.</p> <p>^c Pitch diameter.</p>		

Table 4 — Across flats symmetry

Sequence number	Illustration	Type of nut
4		<p>Hexagonal nuts:</p> <ul style="list-style-type: none"> — plain — slotted — with plastic locking ring
5	<p style="text-align: center; color: red; font-weight: bold;">iTeh STANDARD PREVIEW (standards.iteh.ai)</p> <p style="text-align: center; color: red; font-size: small;">ISO 8788:2020 https://standards.iteh.ai/catalog/standards/sist/cbd70719-1691-4ba4-bb82-1158a78d7417/iso-8788-2020</p>	<p>Self-locking hexagonal nuts formed out-of-round</p>

^a See Table 12.
^b See Table 13. Values apply before forming out-of-round.
^c Value applies before forming out-of-round.
^d Pitch diameter.

Table 4 (continued)

Sequence number	Illustration	Type of nut
6	<p style="text-align: center;">iTeh STANDARD PREVIEW (standards.iteh.ai)</p>	Bihexagonal nuts
<p>a See Table 12.</p> <p>b See Table 13. Values apply before forming out-of-round.</p> <p>c Value applies before forming out-of-round. ISO 8788:2020</p> <p>d Pitch diameter. https://standards.iteh.ai/catalog/standards/sist/cbd70719-1691-4ba4-bb82-f138a7f8d741/iso-8788-2020</p>		

Table 5 — Symmetry of slots

Sequence number	Illustration	Type of nut
7		Slotted nuts
<p>a See Table 12.</p> <p>b Pitch diameter.</p>		

Table 6 — Locking wire hole position

Tolerances in millimetres

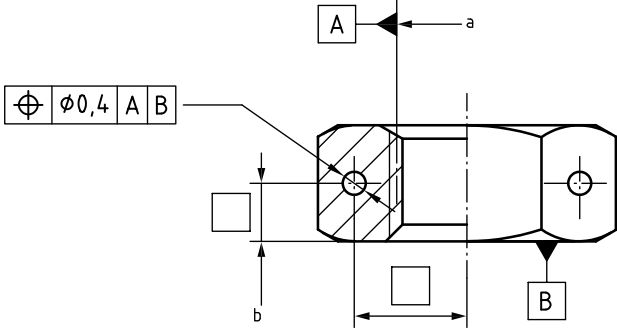
Sequence number	Illustration	Type of nut
8		Plain hexagonal nuts
<p>^a Pitch diameter. ^b From one face.</p>		

Table 7 — Flange run-out

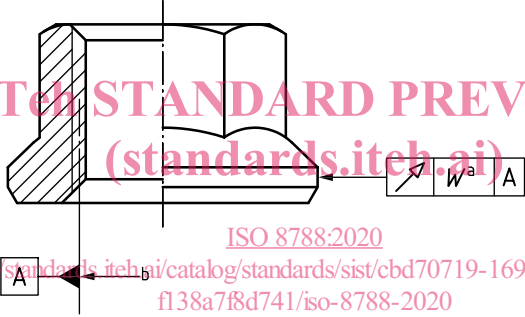
Sequence number	Illustration	Type of nut
9		Hexagonal and bihexagonal nuts
<p>^a See Table 12. ^b Pitch diameter.</p>		

Table 8 — Counterbore coaxiality

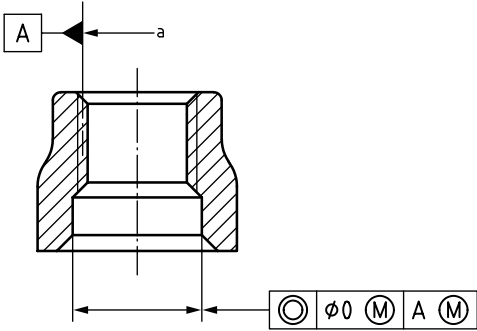
Sequence number	Illustration	Type of nut
10		Anchor nuts and nuts with wrenching feature
<p>^a Pitch diameter.</p>		

Table 9 — Symmetry of flange of the clinch/shank nuts

Tolerances in millimetres

Sequence number	Illustration	Type of nut
11		Clinch/Shank nuts, self-locking
<p>^a Datum A is the thread pitch diameter.</p>		

Table 10 — Clinching shank coaxiality

Tolerances in millimetres

Sequence number	Illustration	Type of nut
12		Clinch/Shank nuts, self-locking
<p>^a Pitch diameter.</p>		