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Fasteners — Slotted set screws with cone point

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Foreword

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This document was prepared by Technical Committee ISO/TC 2, *Fasteners*, Subcommittee SC 11, *Fasteners with metric external thread*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 185, *Fasteners*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This second edition cancels and replaces the first edition (ISO 7434:1983), which has been technically revised.

The main changes are as follows:

- the point angle with tolerance of $\pm 2^\circ$ has been changed to a reference angle β_{ref} of 90° or 120° , without tolerance;
- the values of d_t for cone point have been added in Table 1;
- for M1,6, $l = 2$ mm has been classified as too short length; the lengths for M2 ($l = 3$ mm), M3 ($l = 4$ mm), M3,5 ($l = 5$ mm), M4 ($l = 5$ mm) and M5 ($l = 6$ mm) have been classified separately as short standard lengths with l_{nom} calculated in order to get at least 2,5 full pitches; regular standard lengths have been calculated in order to get at least 4 full pitches up to M3,5 and 3 full pitches above M3,5;

- for stainless steel screws, grades A2 and A4 with hardness classes 12H and 21H have been added;
- non-ferrous metal screws have been deleted (as a consequence of the withdrawal of ISO 8839);
- mechanical properties of steel and stainless steel screws have been added for $d < 1,6$ mm (“As agreed”) in Table 3;
- for steel fasteners, “plain” has been changed to “as processed”, and non-electrolytically applied zinc flake coating has been added in Table 3;
- for stainless steel fasteners, “plain” has been changed to “Clean and bright”, and “Passivated” has been added in Table 3;
- the requirement of surface integrity has been added for steel screws in Table 3;
- specifications for marking and labelling have been added as Clause 6.

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.

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