



**Designation: F 835M – 00  
METRIC**

## **Standard Specification for Alloy Steel Socket Button and Flat Countersunk Head Cap Screws [Metric]<sup>1</sup>**

This standard is issued under the fixed designation F 835M; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

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

### **1. Scope \***

1.1 This specification covers the requirements for quenched and tempered alloy steel hexagon socket button (SBHCS) and flat countersunk (SFHCS) head cap screws M3 through M20 thread sizes having material properties of ISO 898/1 Property Class 12.9.

1.2 Fasteners meeting this specification are intended for shear type applications and have tensile requirements equivalent to ISO 898/1 Property Class 10.9.

1.3 The hazard statement pertains only to the test method section, Section 11 of this specification. *This standard does not purport to address all of the safety problems, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

### **2. Referenced Documents**

#### **2.1 ASTM Standards:**

- A 751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products<sup>2</sup>
- D 3951 Practice for Commercial Packaging<sup>3</sup>
- E 3 Methods of Preparation of Metallographic Specimens<sup>4</sup>
- E 18 Test Methods for Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials<sup>4</sup>
- E 112 Test Methods for Determining Average Grain Size<sup>4</sup>
- E 384 Test Method for Microhardness of Materials<sup>4</sup>
- F 606M Test Methods for Determining the Mechanical Properties of Externally and Internally Threaded Fasteners, Washers, and Rivets [Metric]<sup>5</sup>
- F 788/F 788M Specification for Surface Discontinuities of Bolts, Screws, and Studs, Inch and Metric Series<sup>5</sup>

#### **2.2 ANSI/ASME Standards:**

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee F16 on Fasteners and is the direct responsibility of Subcommittee F 16.02 on Steel Bolts, Nuts, Rivets, and Washers.

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<sup>2</sup> *Annual Book of ASTM Standards*, Vol 01.03.

<sup>3</sup> *Annual Book of ASTM Standards*, Vol 15.09.

<sup>4</sup> *Annual Book of ASTM Standards*, Vol 03.01.

<sup>5</sup> *Annual Book of ASTM Standards*, Vol 01.08.

B18.3.4M Hexagon Socket Button Head Cap Screws<sup>6</sup>

B18.3.5M Hexagon Socket Flat Countersunk Head Cap Screws<sup>6</sup>

B18.24.1 Part Identifying Number (PIN) Code System<sup>7</sup>

#### **2.3 ISO Standard:**

898/1 Mechanical Properties of Fasteners, Bolts, Screws and Studs<sup>6</sup>

### **3. Ordering Information**

3.1 Orders for material under this specification shall include:

3.1.1 Quantity (number of screws).

3.1.2 Dimensions, including nominal thread designation, thread pitch and nominal screw length (millimetres). A standard part number may be used for this definition.

3.1.3 Name of the screw: SBHCS or SFHCS.

3.1.4 Coating, if required. If a protective finish other than black oxide is required, it must be specified on the order or product standard.

3.1.5 Lot testing, if required (see 10.3).

3.1.6 Certification, if required (see 14.1).

3.1.7 ASTM designation and year of issue, and

3.1.8 Any special requirements.

3.1.9 For establishment of a part identifying system, see ASME B18.24.1.

3.2 *Example*—1000 pieces M6  $\times$  1  $\times$  25 SBHCS lot tensile test, ASTM F 835M – XX.

### **4. Materials and Manufacture**

4.1 The screws shall be fabricated from alloy steel made to fine grain practice. In the event of controversy over grain size, referee tests on finished screws conducted in accordance with Test Methods E 112 shall prevail.

4.2 Screws shall be cold upset or extruded, or both.

4.3 Screws shall be roll threaded.

4.4 Screws shall be heat treated by quenching in oil from above the transformation temperature and then tempering by

<sup>6</sup> Available from American National Standards Institute, 11 W. 42nd St., 13th Floor, New York, NY 10036.

<sup>7</sup> Available from American Society of Mechanical Engineers, Three Park Avenue, New York, NY 10016-5990.

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

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reheating to at least 380°C to be within the hardness range specified in Table 1.

4.4.1 The minimum tempering temperature may be verified by submitting screws to 370°C for 30 min at temperature. The average cross section hardness of three readings on the screw before and after retempering shall not differ by more than 20 DPH.

4.5 When protective or decorative coatings are applied to the screws, precautions as required by the coating, shall be taken to prevent embrittlement.

**5. Chemical Composition**

5.1 The chemical composition of the screw material shall conform to the heat analysis specified in Table 2.

5.2 One or more of the following alloying elements, chromium, nickel, molybdenum, or vanadium, shall be present in the steel in sufficient quantity to assure the specific strength properties are met after oil quenching and tempering. The steel shall meet the AISI definition of alloy steel, that is, maximum and minimum element content requirement or minimum element limits specified.

5.3 Steel to which bismuth, selenium, tellurium, or lead has been added intentionally shall not be permitted.

5.4 Material analysis may be made by the purchaser from finished products and the chemical composition thus determined shall conform to the requirements specified for the product analysis in Table 2.

**6. Mechanical Properties**

6.1 The finished screws shall conform to the mechanical requirements specified in Table 1.

6.2 Screws having a nominal thread diameter-length combination equal to or greater than that in Table 1 of Test Methods F 606M shall be tested full size and shall conform to the full size tensile requirements specified in Table 3. Tensile failures through the head are acceptable provided the load requirements are satisfied.

6.3 Screws having a nominal thread diameter-length combination as specified in 6.2 and a breaking load exceeding 535 kN preferably shall be tested full size and shall meet the full-size tensile properties in Table 3. When equipment of sufficient capacity for such tests is not available, or if excessive length of the screws makes full-size testing impractical, standard round machined specimens may be used which shall meet the “machined test specimen tensile properties” in Table 1. If discrepancy between full-size and machined specimen results, full-size tests shall be used as the referee method to determine acceptance.

**TABLE 1 Mechanical Requirements**

<i>Full-size Screws:</i>	
Tensile, min, MPa	980
<i>Machined Test Specimen:</i>	
Yield strength at 0.2 % offset, min, MPa	1100
Tensile strength, min, MPa	1220
Elongation in 5D, min, %	8
Reduction of area, min, %	35
<i>Product Hardness:</i>	
Rockwell	38 to 44 HRC
Vickers	372 to 434 DPH

**TABLE 2 Chemical Requirements<sup>A</sup>**

Element	Composition, %	
	Heat Analysis	Product Analysis
Carbon	0.30 to 0.48	0.28 to 0.50
Phosphorus, max	0.035	0.040
Sulfur, max	0.040	0.045

<sup>A</sup> See for alloy requirements.

**TABLE 3 Minimum Ultimate Tensile Loads**

NOTE 1—All values are rounded to 3 significant digits.

Thread Size	Stress Area, mm <sup>2</sup>	Tensile Load, min, kN <sup>A</sup>
M3 × 0.5	5.03	4.93
M4 × 0.7	8.78	8.60
M5 × 0.8	14.2	13.9
M6 × 1	20.1	19.7
M8 × 1.25	36.6	35.9
M10 × 1.5	58.0	56.8
M12 × 1.75	84.3	82.6
M14 × 2	115	109
M16 × 2	157	155
M20 × 2.5	245	240

<sup>A</sup> Because of the head critical configuration of these parts, the full-size tensile loads are based on 80 % of the machined specimen tensile strength and the applicable stress areas. (Loads based on 980 MPa).

6.4 Screws that are too short (lengths less than that specified in 6.2 (see also Test Methods F 606M) or that have insufficient threads for tension testing shall not be subject to tension tests but shall conform to the hardness (minimum and maximum) requirements of Table 1.

6.5 All screws, regardless of size, shall conform to the hardness specified in Table 1. Hardness shall be met anywhere on the cross section through the threaded portion one diameter from the screw point.

**7. Other Requirements**

**7.1 Decarburization:**

7.1.1 There shall be no evidence of carburization or gross decarburization on the surfaces of the heat-treated screws when measured in accordance with 11.5.

7.1.2 The depth of partial decarburization shall be limited to the values in Table 4 when measured as shown in Fig. 1, and in accordance with 11.5.

7.2 *Embrittlement*—Coated screws shall withstand the embrittlement test for 24 h in accordance with 11.4 without

**TABLE 4 Decarburization Limits for Threads<sup>A</sup>**

Thread-Pitch, P, mm	Basic Thread Height, $h_s = 0.6135P$ mm	$N = \frac{3}{4}h_s$ , min, mm	Root = $0.1h_s$ , mm
0.7	0.429	0.322	0.043
0.8	0.491	0.368	0.049
1	0.613	0.460	0.061
1.25	0.767	0.575	0.077
1.5	0.920	0.690	0.092
1.75	1.074	0.806	0.107
2	1.227	0.920	0.123
2.5	1.534	1.151	0.153

<sup>A</sup> See Fig. 1.