



Designation: ~~F879M—02a (Reapproved 2008)~~ F879M – 02a (Reapproved 2015)

Standard Specification for Stainless Steel Socket Button and Flat Countersunk Head Cap Screws (Metric)¹

This standard is issued under the fixed designation F879M; 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.

1. Scope

1.1 This specification covers the chemical and mechanical requirements for stainless steel metric hexagon socket button (SBHCS) and flat countersunk (SFHCS) head cap screws with nominal thread M 3 through M 20 intended for use in applications requiring general corrosion resistance.

1.2 The following three property classes are covered:

1.2.1 Austenitic Class A1-50 in an annealed condition at 585 MPa maximum,

1.2.2 Austenitic Class A1-55 in a cold worked condition at 550 MPa minimum, and

1.2.3 Austenitic Class A1-70 in a cold-worked condition at 700 MPa minimum.

1.3 *Units*—The values stated in SI units are to be regarded as standard. No other units of measurement are included in this standard.

1.4 The following hazard caveat pertains only to Section 12, Test Methods: *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*:²

A262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels

A342/A342M Test Methods for Permeability of Weakly Magnetic Materials

A380 Practice for Cleaning, Descaling, and Passivation of Stainless Steel Parts, Equipment, and Systems

A555/A555M Specification for General Requirements for Stainless Steel Wire and Wire Rods

A751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products

A967 Specification for Chemical Passivation Treatments for Stainless Steel Parts - 7d704837cbbf/astm-f879m-02a2015

D3951 Practice for Commercial Packaging

E18 Test Methods for Rockwell Hardness of Metallic Materials

E92 Test Method for Vickers Hardness of Metallic Materials (Withdrawn 2010)³

E384 Test Method for Knoop and Vickers Hardness of Materials

F606M Test Methods for Determining the Mechanical Properties of Externally and Internally Threaded Fasteners, Washers, and Rivets (Metric)

F738M Specification for Stainless Steel Metric Bolts, Screws, and Studs (Withdrawn 2014)³

F788/F788M Specification for Surface Discontinuities of Bolts, Screws, and Studs, Inch and Metric Series

F1470 Practice for Fastener Sampling for Specified Mechanical Properties and Performance Inspection

2.2 *ASME Standards*:

B 18.3.4M Hexagon Socket Button Head Cap Screws (Metric Series)⁴

B 18.3.5M Hexagon Socket Flat Countersunk Head Cap Screws (Metric Series)⁴

¹ This specification is under the jurisdiction of ASTM Committee F16 on Fasteners and is the direct responsibility of Subcommittee F16.04 on Nonferrous Fasteners. Current edition approved May 1, 2008; Sept. 1, 2015. Published August 2008; November 2015. Originally approved in 1984. Last previous edition approved in 2002 as F879 – 02a; F879 – 02a(2008). DOI: 10.1520/F0879M-02AR08; 10.1520/F0879M-02AR15.

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 The last approved version of this historical standard is referenced on www.astm.org.

⁴ Available from Global Engineering Documents, 15 Inverness Way, East Englewood, CO 80112-5704, http://www.global.ihs.com.

3. Classification

3.1 The designation of the property class and conditions of this specification shall be consistent with the stainless steel designations in Specification **F738M**.

3.2 The austenitic stainless steel socket screw shall be designated F879M A1-50, F879M A1–55, or F879M A1-70.

4. Ordering Information

4.1 Orders for material under this specification shall include the following information:

4.1.1 Quantity (number of pieces of each item).

4.1.2 Name of the screw, SBHCS or SFHCS.

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

4.1.4 Property Class A1-50, A1–55, or A1-70.

4.1.5 Certification, if required (see Section 15).

4.1.6 ASTM specification and year of issue.

4.1.7 Any special or supplemental requirements (see Supplementary Requirements S1 through S3).

5. Materials and Manufacture

5.1 Screws shall be formed by upsetting or extruding, or both.

5.2 Screws shall be roll threaded.

5.3 *Heat Treatment*—Austenitic alloys Class A1-50 screws, following manufacture, shall be annealed by heating to $1040 \pm 30^\circ\text{C}$ to obtain maximum corrosion resistance and minimum permeability. The screws shall be held for a sufficient time at temperature, then cooled at a rate sufficient to prevent precipitation of the carbide and provide the properties specified in **Table 1**.

5.4 When Property Class A1-55 or A1-70 is specified, the austenitic alloys shall be annealed as specified in 5.3, generally by the raw material manufacturer, then cold worked to develop specific properties.

6. Chemical Composition

6.1 It is the intent of this specification that screws shall be ordered by property class. The chemical composition of the screws shall conform to the requirements of **Table 2**.

6.2 Unless otherwise specified in the inquiry and purchase order (see Supplementary Requirement S2), the choice of stainless steel used shall be that of the fastener manufacturer as determined by his fabrication methods and material availability. The specific stainless steel used by the manufacturer shall be clearly identified on all certification required in the purchase order and shall have a chemical composition conforming to the limits specified in **Table 2**.

6.3 When chemical analysis is performed by the purchaser using finished fasteners, the chemical composition obtained shall conform to the limits specified in **Table 2** for the specific alloy. Chemical composition shall conform to the tolerances specified in Specification **A555/A555M**.

6.3.1 In the event of a discrepancy, a referee analysis of the samples for each lot as specified in 12.1, shall be made in accordance with 11.3.

7. Mechanical Properties

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

7.2 Screws having a nominal length equal to or greater than three diameters shall be tensile tested full size and shall meet the full size breaking strength requirements specified in **Table 3**. Tensile failures through the head are acceptable providing the load requirements are satisfied.

TABLE 1 Mechanical Property Requirements

Property Class	Nominal Thread Diameter ^A	Full Size Product Tests		Machined Specimen Tests			Core Hardness ^B	
		Tensile Strength, MPa	Minimum Extension ^C	Tensile Strength, MPa	Yield Strength, MPa	Elongation, % min	Vickers	Rockwell
A1-50	M3–M20	585 max	0.6D	585 max	380 max	40	210 max	95 HRB max
A1–55	M3–M20	550 min	0.4D	550 min	270 min	25	160 min	50 HRA min
A1–70	M3–M20	700 min	0.4D	600 min	450 min	20	220 min	59 HRA min

^A Actual full-size testing of Class A1–55 and A1–70 may result in decreased tensile strength because of the head configuration (see **Table 3**). For fasteners with nominal thread diameters larger than M20, the mechanical properties shall be agreed upon between the user and manufacturer.

^B Core hardness is only required when full-size product tensile testing cannot be accomplished.

^C D denotes nominal thread size.

TABLE 2 Chemical Requirements

UNS Designation	Alloy	Composition, % maximum except as shown								
		Carbon	Manganese	Phosphorus	Sulfur	Silicon	Chromium	Nickel	Copper	Molybdenum
S30400	304	0.08	2.00	0.045	0.030	1.00	18.0 to 20.0	8.0 to 10.5	1.00	...
S30403	304L	0.030	2.00	0.045	0.030	1.00	18.0 to 20.0	8.0 to 12.0	1.00	...
S30500	305	0.12	2.00	0.045	0.030	1.00	17.0 to 19.0	10.5 to 13.0	1.00	...
S38400	384	0.08	2.00	0.045	0.030	1.00	15.0 to 17.0	17.0 to 19.0		...
S30430	18–9LW	0.10	2.00	0.045	0.030	1.00	17.0 to 19.0	8.0 to 10.0	3.00 to 4.00	...
S30433	302HQ	0.03	2.00	0.045	0.030	1.00	17.0 to 19.0	8.0 to 10.0	3.0 to 4.0	...
S31600	316	0.08	2.00	0.045	0.030	1.00	16.0 to 18.0	10.0 to 14.0		2.00 to 3.00
S31603	316L	0.03	2.00	0.045	0.030	1.00	16.0 to 18.0	10.0 to 14.0		2.00 to 3.0

TABLE 3 Breaking Strength Values for Full Size Fasteners

NOTE 1—Breaking loads are based on tensile stress area and strengths of 585 MPa max for A1-50, 550 MPa for A1-55, and 700 MPa min A1-70. The minimum loads for property classes A1-55 and A1-70 are reduced by 20 % to allow for the head critical nature of these configurations. See Note A in Table 1. Actual strength of the threaded section, if size permits, may be determined by removing the head and testing the threaded section as a stud.

Nominal Size and Thread Pitch	Stress Area, mm ²	Property Class		
		A1-50	A1-55	A1-70
		kN, max	kN, min	kN, min
M3 × 0.5	5.03	2.94	2.21	2.82
M4 × 0.7	8.78	5.14	3.86	4.92
M5 × 0.8	14.2	8.30	6.24	7.94
M6 × 1.0	20.1	11.8	8.9	11.3
M8 × 1.25	36.6	21.4	16.1	20.5
M10 × 1.5	58.0	33.9	25.5	32.5
M12 × 1.75	84.3	49.3	37.1	47.2
M14 × 2.0	115.0	67.5	50.8	64.6
M16 × 2.0	157.0	91.7	68.9	87.7
M20 × 2.5	245.0	143	108	137

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7.3 Screws that are too short (lengths less than specified in 7.2 or that have insufficient threads for tension testing) shall not be subject to tension tests, but shall conform to the hardness requirements of Table 1.

8. Corrosion Resistance Requirements

8.1 Carbide Precipitation:

8.1.1 Austenitic alloy rod, bar, and wire used to make fasteners in accordance with this specification shall be capable of passing the test for susceptibility to intergranular corrosion as specified in Practice E of Practice A262.

8.1.2 As stated in Practices A262, samples may be subjected to the faster and more severe screening test in accordance with Practice A. Failing Practice A, specimens shall be tested to Practice E and be considered satisfactory if passing Practice E.

8.1.3 If the fasteners pass the requirements of 8.1.1, they shall be considered acceptable. If they fail, they shall be tested in accordance with Practice C of Practices A262 and shall show a corrosion rate not exceeding 0.05 mm/month.

9. Dimensions

9.1 Unless otherwise specified, the dimensions shall conform to the requirements of ASME B 18.3.4M or ASME B 18.3.5M, as specified.

10. Workmanship, Finish, and Appearance

10.1 *Surface Treatment*—Unless otherwise specified, screws shall be cleaned, descaled and passivated in accordance with Practice A380 or Specification A967 at the option of the manufacturer.

10.2 Surface Discontinuities:

10.2.1 The surface discontinuities for these products shall conform to Specification F788/F788M and the additional limitations specified herein.

10.2.1.1 Forging defects that connect the socket to the periphery of the head are not permissible. Defects originating on the periphery and with a traverse indicating a potential to intersect are not permissible. Other forging defects are permissible provided those located in the bearing area, fillet, and top surfaces shall not have a depth exceeding $0.03 D$ or 0.13 mm , whichever is greater. For peripheral discontinuities, the maximum depth may be $0.06 D$ (see Fig. 1).

10.2.1.2 Forging defects located in the socket wall within 0.1 times the actual key engagement, T , from the bottom of the socket are not permissible. Discontinuities located elsewhere in the socket shall not have a length exceeding $0.25 T$, or a maximum depth of $0.03 D$ not to exceed 0.13 mm (see Fig. 2).

10.2.1.3 Seams in the shank shall not exceed a depth of $0.03 D$ or 0.2 mm , whichever is greater.

10.2.1.4 No transverse discontinuities shall be permitted in the head-to-shank fillet area.

10.2.1.5 Threads shall have no laps at the root or on the flanks, as shown in Fig. 3. Laps are permitted at the crests (Fig. 3(c)) that do not exceed 25% of the basic thread depth, and on the flanks outside the pitch cylinder. Longitudinal seams rolled beneath the root of the thread and across the crests of the threads are acceptable within the limits of 10.2.1.3.

11. Number of Tests

11.1 The requirements of this specification shall be met in continuous mass production for stock and the manufacturer shall make sample inspection to ensure that the product conforms to the specified requirements. Additional tests of individual shipments of fasteners are not ordinarily necessary. A record of the individual heat of steel in each lot shall be maintained. The containers shall be coded to permit identification of the lot.

11.2 When specified in the purchase order, the manufacturer shall furnish a test report of the last complete set of chemical analysis and mechanical tests for each stock size in each shipment.

11.3 When tests of individual shipments are required, Supplementary Requirement S1 must be specified in the inquiry and order.

11.3.1 When the purchaser does not specify the sampling plan and basis of acceptance, the following shall apply:

11.3.1.1 The lot, for purposes of selecting samples, shall consist of all products offered for inspection and testing at one time, that are of the same type, style, nominal diameter, thread pitch, nominal length, material, property class, and surface finish.

11.3.1.2 From each lot, samples shall be selected at random and tested for each requirement in accordance with the following:

Number of Pieces in Lot	Number of Samples
800 and less	1
Over 800 to 8000, incl	2
Over 8000 to 22 000, incl	3
Over 22 000	5

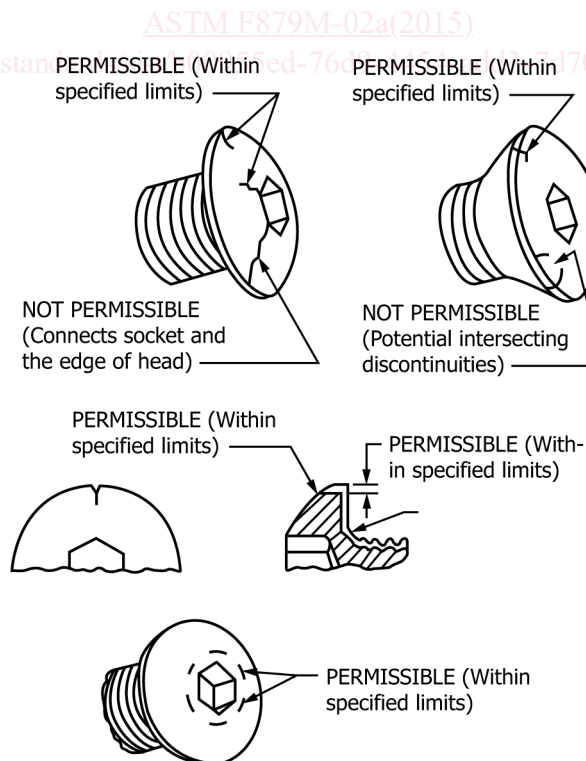


FIG. 1 Head Discontinuities (See 10.2.1)