

TC 2

INTERNATIONAL STANDARD



4028

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Hexagon socket set screws with dog point

Vis sans tête à six pans creux, à téton

First edition — 1977-09-15

iTeh STANDARD PREVIEW

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REWORD

(the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been set up 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.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 4028 was developed by Technical Committee ISO/TC 2, *Fasteners*, and was circulated to the member bodies in April 1976.



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INTERNATIONAL STANDARD ISO 4028-1977 (E)/ERRATUM

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ERRATUM

Page 2

Alter t max.⁴⁾ to read t min.⁴⁾

Page 2

Nominal length $l = 8$ alter 8,28 to read 8,29

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4028-1977 (E)

Dimensions in millimetres

Thread size d		M 1,6	M 2	M 2,5	M 3	M 4	M 5	M 6	M 8	M 10	M 12	M 16	M 20	M 24
P	1)	0,35	0,4	0,45	0,5	0,7	0,8	1,0	1,25	1,50	1,75	2,0	2,5	3,0
d_p	max.	0,8	1,0	1,5	2,0	2,5	3,5	4	5,5	7,0	8,5	12,0	15,0	18,0
	min.	0,55	0,75	1,25	1,75	2,25	3,2	3,7	5,2	6,64	8,14	11,57	14,57	17,57
d_f	≈	Minor thread diameter												
e	min. 2)	0,803	1,003	1,427	1,73	2,30	2,87	3,44	4,58	5,72	6,86	9,15	11,43	13,72
s	nominal	0,7	0,9	1,3	1,5	2,0	2,5	3,0	4,0	5,0	6,0	8,0	10,0	12,0
	min.	0,711	0,889	1,270	1,520	2,020	2,520	3,020	4,020	5,020	6,020	8,025	10,025	12,032
	max.	0,724	0,902	1,295	1,545	2,045	2,560	3,080	4,095	5,095	6,095	8,115	10,115	12,142
t	min. 3)	0,7	0,8	1,2	1,2	1,5	2,0	2,0	3,0	4,0	4,8	6,4	8,0	10,0
	max. 4)	1,5	1,7	2,0	2,0	2,5	3,0	3,5	5,0	6,0	8,0	10,0	12,0	15,0
short dog point ³⁾	min.	0,4	0,5	0,63	0,75	1,0	1,25	1,5	2,0	2,5	3,0	4,0	5,0	6,0
	max.	0,65	0,75	0,88	1,0	1,25	1,5	1,75	2,25	2,75	3,25	4,3	5,3	6,3
long dog point ⁴⁾	min.	0,8	1,0	1,25	1,5	2,0	2,5	3,0	4,0	5,0	6,0	8,0	10,0	12,0
	max.	1,05	1,25	1,5	1,75	2,25	2,75	3,25	4,3	5,3	6,3	8,36	10,36	12,43

l																				
nominal	min.	max.																		
2	1,80	2,20																		

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3 SPECIFICATIONS AND REFERENCE STANDARDS

Material		Steel	Stainless steel	Non-ferrous metal
Thread	Tolerances	5g6g for class 45H; for other classes : 6g		
	International Standards	ISO 261, ISO 965		
Mechanical properties	Class	45H	A2-2	...
	International Standards	ISO 898/V	ISO ... ¹⁾	ISO ... ¹⁾
Tolerances	Product grade	A		
	International Standard	ISO 4759/1 ²⁾		
Finish		black oxide (thermal or chemical)	plain	plain
		Requirements for electroplating are covered in ISO 4042 ²⁾ . If different electroplating requirements are desired or if requirements are needed for other finishes, they should be negotiated between customer and supplier.		
Acceptability		For acceptance procedure see ISO ... ¹⁾ .		

1) In preparation.

2) At present at the stage of draft.