



**International  
Standard**

**ISO 7689**

**Aerospace series — Bolts, with  
MJ threads, made of alloy steel,  
strength class 1 100 MPa —  
Procurement specification**

*Série aérospatiale — Vis à filetages MJ, en acier allié, de classe de  
résistance 1 100 MPa — Spécification d'approvisionnement*

**Third edition  
2025-05**

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# Contents

Page

<b>Foreword</b>	<b>iv</b>
<b>1 Scope</b>	<b>1</b>
<b>2 Normative references</b>	<b>1</b>
<b>3 Terms and definitions</b>	<b>1</b>
<b>4 Quality assurance</b>	<b>3</b>
4.1 General	3
4.2 Qualification inspection conditions	3
4.3 Acceptance inspection conditions	4
4.4 Use of "statistical process control (SPC)"	4
<b>5 Requirements</b>	<b>4</b>
<b>Annex A (informative) Cross sectional areas and formulae for tensile loads</b>	<b>18</b>
<b>Annex B (informative) Cross sectional areas and formulae for double shear loads</b>	<b>20</b>
<b>Bibliography</b>	<b>21</b>

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## Foreword

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This document was prepared by Technical Committee ISO/TC 20, *Aircraft and space vehicles*, Subcommittee SC 4, *Aerospace fastener systems*.

This third edition cancels and replaces the second edition (ISO 7689:2008), which has been technically revised.

The main changes compared to the previous edition are as follows:

- new tables for sampling;
- additional requirements in [Table 1](#), item no 2 "Dimensions";
- additional requirements in [Table 1](#), item no .4-1 "Tensile strength";
- additional requirements in [Table 1](#), item no 4-3 "Hardness";
- additional requirements in [Table 1](#), item no 4-4 "Recess removal torque";
- additional values in [Table 8](#) "Minimum loads for tensile and double shear tests" for protruding head;
- update of normative references.

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