1. SCOPE

The fasteners defined by this standard are Pan, Flat, Oval and Hexagon Washer Headed Machine Screws.

2. GENERAL

2.1 This standard may differ in some respects with certain segments of ISO and national standards. In recognition of these differences, the sizes and tolerance ranges used were established in an effort to enable the use of commercially available items, dimensionally interchangeable worldwide.

2.2 Pan Head Machine Screw with yellow ZND finish is preferred for general usage. Flat and Oval Countersunk Head machine screws maybe used in countersunk applications where material flows over the head and for appearance purposes such as a cab application.

3. RELATED DOCUMENTS

STPA020—Fastener Finishes and Material Specifications
MAT0310—Zinc Plating
ISO 898/1—Mechanical Properties of Fasteners
ISO 965/2—ISO General Purpose Metric Screw Threads-Tolerances
ISO 4757—Cross Recesses for Screws
ISO 1580—Slotted Pan Head Screws
ISO 7045—Cross Recess Pan Head Screws
ISO 7046—Cross Recess Flat Head
ISO 7047—Cross Recess Oval Head
ISO 7380-1—Hexagon Socket Button Head Screws
ISO 7721—Countersunk Head Screws Head Configuration and Gauging
ISO 10664—Hexalobular Internal Driving Feature for Bolts and Screws
ISO 14581— Hexalobular Socket Countersunk Flat Head Screws
ISO 14583— Hexalobular Socket Pan Head Screws
SAE J1061—Surface Discontinuities on General Application Bolts, Screws, and Studs
IFI 524—Industrial Fasteners Institute – Test Procedure for Prevailing Torque Non-Metallic Lock Screws
IFI 525—Industrial Fasteners Institute – Test Procedure for Chemical Coated Lock Screws
Iveco 18-1103—Zinc-Nickel Electrolytic Coating for Ferrous Metal Parts
Fiat 10530—Cross Recessed Pan Head Screws
Fiat 10530/20—PZ Cross Recessed Pan Head Screws with Cone Point.
Fiat 10532—PZ Cross Recessed Countersunk Head Screws
Fiat 10534—PZ Cross Recessed Oval Head Screws

4. REQUIREMENTS

4.1 MATERIAL

Class 4.8 according to ISO 898/1 low or medium carbon steel with the following chemical composition of max. .55% Carbon max. .05% Phosphorus and max. .06% Sulfur is preferred. Certain zinc electroplated and mechanical plated high hardness fasteners have been identified as being highly susceptible to Hydrogen

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Assisted Cracking (HAC). Use of these fasteners is restricted: they shall not be used in new designs after 01OCT2011.

4.2 PLATING

The preferred plating is ZND per STPA020.

4.3 DRIVE TYPE

The preferred drive type is the standard Phillips Type H per ISO 4757.

4.4 MECHANICAL DIMENSIONS

The screw thread geometry shall be coarse pitch, tolerance class 6g (medium class) according to ISO 965/2 before plating. The general dimensions shall meet the requirements in the appropriate tables listed.

4.5 SURFACE DISCONTINUITIES

All screws listed in this standard shall meet the Surface Discontinuities on General Applications Bolts, Screws and Studs per SAE J1061 requirement.

5. CROSS REFERENCE

For cross reference listing of company part numbers, go to PARTsolutions.

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6. GENERAL SPEC. REQUIREMENTS

6.1 DIMENSIONS:

All unspecified detail shall conform to the ISO standards referred to in this standard.

6.2 THREADS:

Thread form, diameters, and associated pitches are in accordance with ISO recommendations for coarse pitch series, as shown in ISO 262 General Purpose Screw Threads. Threads shall be made to the tolerances of the medium class of fit (6g) external threads for plain or unplated screws as shown in ISO 965/2 - General Purpose Metric Screw Threads.

6.3 LENGTH OF THREADS:

For screws having nominal lengths equal to or shorter than listed in Column "L" of the table below, the full thread shall extend close to the head within limits specified in Column "A". Screws of longer nominal lengths shall have a minimum length of full-formed threads as specified in Column "B".

Nominal Size	L			A	B
	Nominal Length			Max. Unthreaded Length Under Head	Min. Full Form Thread Length
	Pan (Slotted) Head	Countersunk Head	(Pan C/R, Hex Wash, Torx) Flat Under Head		
M2.5	30	30	25	0.9	25
M3	30	30	25	1	25
M3.5	40	45	40	1.2	38
M4	40	45	40	1.4	38
M5	40	45	40	1.6	38
M6	40	45	40	2	38
M8	40	45	40	2.5	38
M10	40	45	40	3	38

6.4 DIN REFERENCE

Due to worldwide availability of these types of fasteners listed in this Standard Document per DIN Standards, certain sizes have been allowed to use the DIN Standards where it has been determined there is no impact in the design or the assembly of the part. However, all sizes cannot be supplied to DIN Standards due to differences between DIN & ISO Head Dimensions and minimum thread length requirements. As a result table footnotes are added to indicate the applicable DIN Standard that is allowed for a specific part.

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Pan Head Machine Screws Metric Series

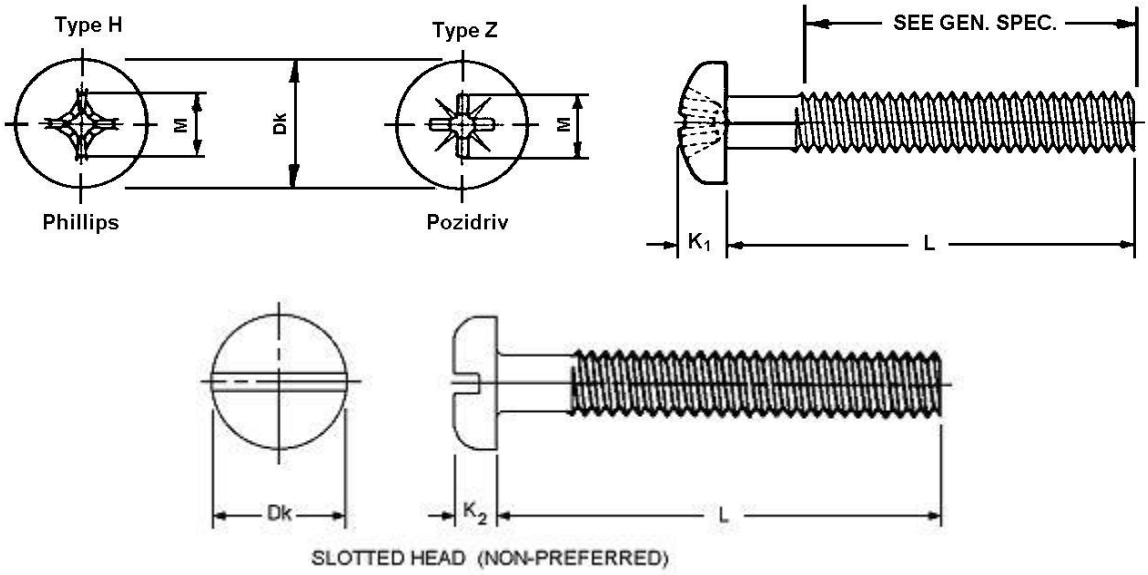

Table 1a: Dimensional Requirements

Nominal Size	Pitch	Dk		K_1	K_2	M Ref		Drive Point No.
		Head Diameter		Head Ht. Cross Res.	*Head Ht. Slotted	Recess Diameter		
		Max.	Min.	Max.	Max.	Type H	Type Z	
M2.5	0.45	5.0	4.7	2.12	1.5	2.7	2.6	1
M3	0.5	6.0	5.3	2.52	1.8	3.0	2.8	1
M3.5	0.6	7.0	6.64	2.82	1.9	3.9	3.9	2
M4	0.7	8.0	7.64	3.25	2.4	4.4	4.3	2
M5	0.8	10.0	9.14	3.95	3.0	4.9	4.7	2
M6	1.0	12.0	11.57	4.75	3.6	6.9	6.7	3
M8	1.2	16.0	15.57	6.15	4.8	9.0	8.8	4
M10	1.5	20.0	19.48	7.65	6.0	10.1	9.9	4

*SLT - Slotted Pan Head Screws can be provided per DIN 85 Dimensions.

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Table 1b: Pan Head Type H 4.8 ZND Coarse – Preferred

Parts can be provided per DIN 7985 dimensions

Shaded area denotes screws with shanks, all other are fully threaded

	Diameter						
Length	**M2.5**	**M3**	**M4**	**M5**	**M6**	**M8**	**M10**
4							
5						Non-Preferred Sizes	
6			87016455		87752092		
8		86511815	86511823		44669		
10			86585706	86585709	86585711		
12	84180933	86599775	44334	80043982	86511828	86511834	
14			86639261				
16		86511816	86511042	86511826	86511829	44317	
20		86511817	86511824	86511827	86511830	86585703	87036807
25			86050251	86585710	86511831	86585704	
30		86511818	86511825	86502967	86511832	86507088	
35			86585707	86546084			
40			86585708		86511833	86585705	
45							
60							
70							

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Table 1c: Pan Head – Non-Preferred

Diameter	Length	Thread Length	Drive	Material	Finish	Part Number
M3	6	FULL	Z	5.8	ZND	%13270211
M3	6	FULL	Z	5.8	BZN	%13270219
M3	8	FULL	H	4.8	BZN	%87022296
M3	8	FULL	H	4.8	POL	%87303784
M3	8	FULL	Z	5.8	ZND	%13270411
M3	8	FULL	Z	5.8	BZN	%13270417
M3	8	FULL	H	SST	POL	%84214042
M3	10	FULL	Z	5.8	ZND	%13270511
M3	10	FULL	H	5.8	ZND	%13296111
M3	14	FULL	Z	5.8	DAC	%13270714
M3	16	FULL	H	4.8	BZN	%87619755
M3	25	FULL	SLT	4.8	ZND	301571
M3	30	FULL	Z	4.8	BGM	%47624849
M3	35	19	H	4.8	ZND	%9839301
M3.5	8	FULL	H	4.8	ZND	%86511819
M3.5	12	FULL	H	4.8	ZND	%86511820
M3.5	20	FULL	H	4.8	ZND	%86511821
M3.5	35	20	H	4.8	ZND	%86511822
M4	8	FULL	H	4.8	PHC	%87664046
M4	8	FULL	Z	5.8	BZN	%13271817
M4	8	FULL	Z	8.8	ZND	%13271821
M4	8	FULL	Z	8.8	DAC	%13271824
M4	10	FULL	Z	5.8	ZN-NI-6	%92030906
M4	10	FULL	Z	5.8	ZND	%13271911
M4	10	FULL	Z	5.8	DAC	%13271914
M4	10	FULL	Z	5.8	BZN	%13271917
M4	10	FULL	Z	8.8	DAC	%13271924
M4	10	FULL	H	4.8	BZN	%84058989
M4	12	FULL	H	4.8	DAC	%90374443
M4	12	FULL	Z	5.8	ZND	%13272011
M4	12	FULL	Z	5.8	DAC	%13272014
M4	12	FULL	Z	8.8	DAC	%13272024
M4	14	FULL	Z	5.8	DAC	%13272114
M4	14	FULL	Z	5.8	ZND	%13272111
M4	14	FULL	Z	5.8	BZN	%13272117
M4	14	FULL	Z	8.8	ZND	%13272121
M4	14	FULL	Z	8.8	DAC	%13272124
M4	16	FULL	H	4.8	BZN	%412475
M4	16	FULL	H	4.8	DAC	%90418985
M4	16	FULL	Z	5.8	ZND	%13272211
M4	16	FULL	Z	5.8	BZN	%13272217
M4	16	FULL	Z	5.8	DAC	%13272214
M4	18	FULL	Z	5.8	BZN	%13272319
M4	20	FULL	Z	5.8	ZND	%13272411
M4	20	FULL	Z	5.8	DAC	%13272414
M4	20	FULL	Z	5.8	BZN	%13272417
M4	20	FULL	Z	8.8	DAC	%13272424
M4	20	FULL	Z	SST	PLN	%13272470
M4	20	FULL	Z	SST	BLO	%13272477

% Parts can also be provided per DIN 7985 dimensions

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Table 1c: Pan Head – Non-Preferred (Cont'd)

Diameter	Length	Thread Length	Drive	Material	Finish	Part Number
M4	20	FULL	H	4.8	BZN	%84411959
M4	20	FULL	SLT	4.8	ZND	47753840
M4	22	FULL	H	4.8	ZND	%47754562
M4	22	FULL	Z	5.8	ZND	%13272511
M4	25	FULL	H	4.8	DAC	%90479206
M4	25	FULL	H	4.8	ZN-NI-3	%92841955
M4	25	FULL	H	5.8	DOR	%84527306
M4	25	FULL	Z	5.8	ZND	%13272611
M4	25	FULL	Z	5.8	DAC	%13272614
M4	25	FULL	Z	5.8	BZN	%13272617
M4	25	FULL	Z	8.8	DAC	%13272624
M4	30	22	Z	5.8	ZND	%13272811
M4	30	22	Z	8.8	DAC	%13272824
M4	35	22	Z	8.8	ZND	%13272921
M4	35	FULL	Z	9.8	ZND	81866075
M4	45	FULL	H	4.8	ZND	51504045
M4	60		H	4.8	ZND	86050228
M4	70		H	4.8	ZND	86528740
M4	75		H	4.8	ZND	84271086
M4	90		H	4.8	BZN	412473
M5	8	FULL	Z	8.8	DAC	%13273824
M5	10	FULL	Z	5.8	ZND	%13273911
M5	10	FULL	Z	5.8	18-1103 Fe/ZnNi 7 IV	%90455986
M5	10	FULL	Z	5.8	DAC	%13273914
M5	10	FULL	Z	5.8	BZN	%13273917
M5	10	FULL	Z	8.8	ZND	%13273921
M5	10	FULL	Z	8.8	DAC	%13273924
M5	12	FULL	Z	5.8	ZND	%13274011
M5	12	FULL	Z	5.8	DAC	%13274014
M5	12	FULL	Z	5.8	BZN	%13274017
M5	12	FULL	Z	8.8	DAC	%13274024
M5	14	FULL	Z	5.8	ZND	%13274111
M5	14	FULL	Z	8.8	DAC	%13274124
M5	16	FULL	H	4.8	18-1103 Fe/ZnNi 7 IV	%90403045
M5	16	FULL	H	4.8	DOR	%87343600
M5	16	FULL	Z	5.8	ZND	%13274211
M5	16	FULL	Z	5.8	DAC	%13274214
M5	16	FULL	Z	5.8	BZN	%13274217
M5	16	FULL	Z	8.8	DAC	%13274224
M5	16	FULL	Z	A2-70	BLO	%13274277
M5	16	FULL	Z	5.8	DAC	%13283714#
M5	18	FULL	Z	5.8	DAC	%13283814#
M5	18	FULL	H	10.9	ZND	%84340200
M5	20	FULL	H	4.8	DOR	%87343602
M5	20	FULL	H	4.8	BGM	%84263393
M5	20	FULL	Z	5.8	ZND	%13274411

\# Cone Point per Fiat 01380/01

% Parts can be provided per DIN 7985 dimensions

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Table 1c: Pan Head – Non-Preferred (Cont'd)

Diameter	Length	Thread Length	Drive	Material	Finish	Part Number
M5	20	FULL	Z	8.8	ZND	%13274421
M5	25	FULL	Z	5.8	DAC	%13274614
M5	25	FULL	Z	5.8	BZN	%13274617
M5	25	FULL	H	4.8	DOR	%87343604
M5	25	FULL	H	4.8	BZN	%87026656
M5	25	FULL	H	4.8 w/chem lock&	ZND	%51558708
M5	30	FULL	H	4.8	DOR	%87343612
M5	30	25	H	SST	BLO	%13274877
M5	35	25	Z	5.8	BGM	%92039582
M5	35	25	Z	5.8	DAC	%13274914
M5	35	FULL	H	4.8	DOR	%87343613
M5	35		H	5.8 w/chem lock*	BZN	87675526
M5	40		H	8.8 w/chem lock*	ZND	87673581
M5	40		H	8.8 w/chem lock*	18-1103 Fe/ZnNi 7 IV	90403046
M5	40	25	Z	8.8	ZND	%13275021
M5	40	25	Z	8.8	DAC	%13275024
M5	40	25	Z	A2-70	BLO	%13275077
M5	50		H	4.8	18-1103 Fe/ZnNi 7 IV	90403483
M5	50		H	4.8	DOR	87343617
M5	50		H	4.8	ZND	87016457
M5	50		H	8.8 w/chem lock*	ZND	87673580
M5	60		H	4.8	BZN	86529074
M5	110		H	8.8	ZND	86584767
M6	8	FULL	Z	8.8	DAC	%13275824
M6	10	FULL	Z	5.8	BZN	%13275917
M6	10	FULL	Z	5.8	DAC	%13275914
M6	10	FULL	Z	5.8	BGM	%5182270
M6	10	FULL	Z	8.8	DAC	%13275924
M6	12	FULL	H	4.8	BZN	%3124039
M6	12	FULL	Z	4.8	ZND	%83998908
M6	12	FULL	Z	5.8	DAC	%13276014
M6	12	FULL	Z	5.8	BZN	%13276017
M6	12	FULL	Z	8.8	ZND	%13276021
M6	12	FULL	Z	8.8	DAC	%13276024
M6	14	FULL	Z	5.8	BZN	%13276117
M6	14	FULL	Z	8.8	DAC	%13276124
M6	16	FULL	H	4.8	BZN	%412491
M6	16	FULL	Z	4.8	ZND	%81853129
M6	16	FULL	Z	5.8	BZN	%13276217
M6	16	FULL	Z	5.8	DAC	%13276214
M6	16	FULL	Z	5.8	ZND	%13276211

& With chemical coating per IFI 525; ND Microspheres 593S (Blue) or Precote 85; Minimum of 5 pitches, entire circumference starting 2 pitches from end.

* For Chem lock use Precote 80 (Minimum of 5 pitches, entire circumference starting 2 pitches from end)

% Parts can also be provided per DIN 7985 dimensions.

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Table 1c: Pan Head – Non-Preferred (Cont'd)

Diameter	Length	Thread Length	Drive	Material	Finish	Part Number
M6	16	FULL	Z	8.8	ZND	%13276221
M6	16	FULL	Z	8.8	DAC	%13276224
M6	20	FULL	H	4.8	BZN	%86016585
M6	20	FULL	H	4.8	PHC	%86500687
M6	20	FULL	H	4.8	BZN	%87560750
M6	20	FULL	Z	5.8	ZND	%13276411
M6	20	FULL	Z	5.8	DAC	%13276414
M6	20	FULL	Z	5.8	BGM	%47372445
M6	20	FULL	Z	8.8	DAC	%13276424
M6	20	FULL	Z	8.8	ZND	%13276421
M6	20	FULL	Z	5.8	BZN	%13276417
M6	20	FULL	H	4.8	DOR	%87343618
M6	20	FULL	Z	4.8	ZND	%83962783
M6	20	FULL	Z	SST	BLO	%13276477
M6	20	FULL	H	SST	PLN	%84129709
M6	25	FULL	H	SST	PLN	%47372449
M6	25	FULL	H	4.8	DOR	%87343619
M6	25	FULL	Z	4.8	BZN	%84007540
M6	25	FULL	Z	4.8	BGM	%84263394
M6	25	FULL	Z	5.8	DAC	%13276614
M6	25	FULL	Z	5.8	BZN	%13276617
M6	25	FULL	Z	8.8	ZND	%13276621
M6	30	FULL	H	4.8	BZN	%87560737
M6	30	FULL	H	4.8	BGM	%84263396
M6	35	FULL	Z	8.8	BGM	%13276924
M6	35	FULL	H	4.8	BZN	%86514457
M6	40	FULL	H	4.8	BZN	%86015538
M6	45	28	Z	5.8	BZN	%13277117
M6	50		H	4.8	BZN	86018908
M6	55	28	Z	5.8	BZN	%13277317
M8	14	FULL	Z	8.8	ZND	%13279121
M8	16	FULL	Z	5.8	ZND	%13279211
M8	16	FULL	Z	5.8	DAC	%13279214
M8	16	FULL	Z	5.8	BZN	%13279217
M8	16	FULL	Z	8.8	ZND	%13279221
M8	16	FULL	Z	8.8	DAC	%13279224
M8	16	FULL	Z	A2-70	BLO	%13279277
M8	16	FULL	Z	8.8	BGM	%47455775
M8	20	FULL	Z	4.8	BZN	%84353724
M8	20	FULL	Z	5.8	ZND	%13279411
M8	20	FULL	H	4.8	DOR	%86981492
M8	20	FULL	Z	4.8	DOR	%87343620
M8	20	FULL	Z	8.8	DAC	%13279424
M8	25	FULL	H	4.8	BZN	%87648718
M8	25	FULL	Z	5.8	BZN	%13279617
M8	25	FULL	Z	8.8	ZND	%13279621
M8	30	FULL	Z	4.8	BZN	%84361275
M8	35	FULL	SLT	4.8	ZND	87395354
M8	35	FULL	Z	4.8	BZN	%84353725

% Parts can also be provided per DIN 7985 dimensions.

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Table 1c: Pan Head – Non-Preferred (Cont'd)

Diameter	Length	Thread Length	Drive	Material	Finish	Part Number
M10	20	FULL	H	4.8	PHC	%87036806
M10	30	FULL	HEX-SOC	8.8	ZND	87610712
M10	30	FULL	HEX-SOC	10.9	ZND	84591616

% Parts can also be provided per DIN 7985 dimensions.

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Hex Socket Button Head Machine Screws

Metric Series ISO 7380-1

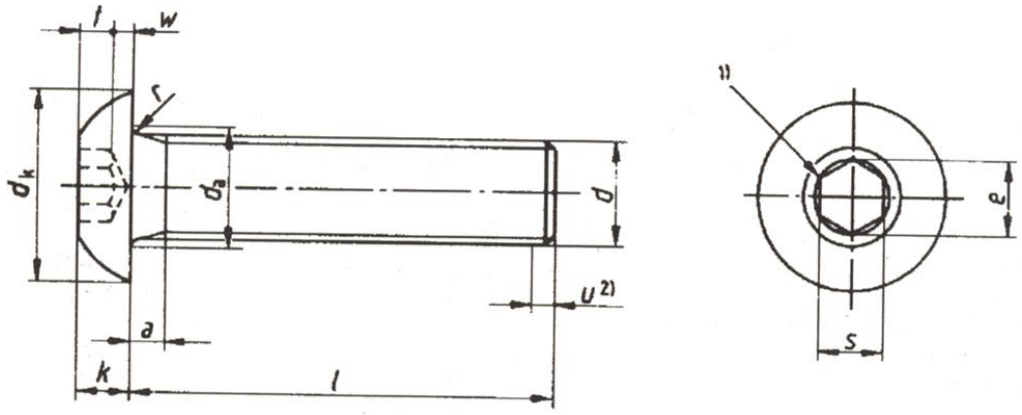

Table 2a: Dimensional Requirements

Thread	M2	M3	M4	M5	M6	M8	M10	M12	M16
P (Pitch)	0.4	0.5	0.7	0.8	1	1.25	1.5	1.75	2
a max		1.0	1.4	1.6	2	2.50	3.0	3.50	4
a min		0.5	0.7	0.8	1	1.25	1.5	1.75	2
d_a max		3.6	4.7	5.7	6.8	9.2	11.2	14.2	18.2
d_k max	3.5	5.7	7.60	9.5	10.50	14.00	17.50	21.00	28
d_k min		5.4	7.24	9.14	10.07	13.57	17.07	20.48	27.48
e min	1.501	2.3	2.87	3.44	4.58	5.72	6.86	9.15	11.43
k max	1.3	1.65	2.20	2.75	3.30	4.40	5.50	6.60	8.80
k min		1.40	1.95	2.50	3.00	4.10	5.20	6.24	8.44
r min		0.1	0.2	0.2	0.25	0.4	0.4	0.6	0.6
s nom.	1.3	2	2.5	3	4	5	6	8	10
s max.		2.080	2.580	3.080	4.095	5.140	6.140	8.175	10.175
s min.		2.020	2.520	3.020	4.020	5.020	6.020	8.025	10.025
t min.	0.91	1.04	1.30	1.56	2.08	2.60	3.12	4.16	5.20

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Table 2b: Hex Socket Button Head Machine Screws - Metric Series ISO 7380-1

Thread Diameter d	Pitch P	Length l	Mat'l	Finish	Part Number
2	0.4	22	SST	PLN	92034120
4	0.7	6	8.8	ZND	47634606
4	0.7	8	8.8	ZND	47872947
4	0.7	10	8.8	ZND	47511292
4	0.7	12	8.8	ZND	87682417
4	0.7	12	SST	PLN	90391146
4	0.7	18	10.9	ZND	92711937
5	0.8	10	10.9	ZND	91822066
5	0.8	12	10.9	ZND	48032005
5	0.8	25	10.9	BZN	47919306
5	0.8	25	SST	BLO	48025028
5	0.8	30	10.9	BZN	47973241
5	0.8	30	SST	BLO	48025029
6	1	10	8.8	ZND	84139321
6	1	10	SST	PLN	90454786
6	1	16	8.8	BZN	84299265
6	1	16	& 8.8	ZND	48144734
6	1	16	10.9	ZND	48127861
6	1	18	8.8	BZN	91709628
6	1	20	8.8	BZN	90329989
6	1	20	10.9	DOR	92237478
6	1	30	10.9	ZND	87697843
6	1	35	8.8	ZND	90492394
8	1.25	12	12.9	BLO	87747295
8	1.25	12	&8.8	ZND	47907507
8	1.25	12	&10.9	BLO	47368446
8	1.25	16	8.8	ZND	87360874
8	1.25	16	10.9	ZND	84406845
8	1.25	16	10.9	BGM	48061006
8	1.25	16	10.9	ZN-NI-6	92788932
8	1.25	20	10.9	BZN	48155469
8	1.25	20	10.9	ZND	48096951
8	1.25	20	12.9	ZNM	#87675525
8	1.25	25	8.8	ZND	87028323
8	1.25	25	10.9	ZND	47456376
8	1.25	30	10.9	BLO	84299395
8	1.25	30	10.9	ZND	86512788
8	1.25	30	10.9	ZNM	730335
8	1.25	35	8.8	ZND	92675469
8	1.25	35	10.9	ZND	92677649
8	1.25	40	10.9	ZND	84292038
8	1.25	65	10.9	ZND	84292041
10	1.5	20	8.8	ZND	87028324
10	1.5	20	10.9	ZND	84405128
10	1.5	25	8.8	BGM	84382749
10	1.5	30	8.8	ZND	84476726

Do not use on new designs after 01OCT2011 (Hydrogen Assisted Cracking–HAC)

& With chemical coating per IFI 525; ND Microspheres 593S (Blue) or Precote 85; Minimum of 5 pitches, entire circumference starting 2 pitches from end.

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Table 2b: Hex Socket Button Head Machine Screws - Metric Series ISO 7380-1 (cont'd)

Thread Diameter d	Pitch P	Length l	Mat'l	Finish	Part Number
10	1.5	30	10.9	ZND	47437572
10	1.5	35	8.8	ZND	84129712
10	1.5	35	12.9	DAC	84232472
10	1.5	40	10.9	DOR	92213048
10	1.5	50	10.9	DOR	92213049
10	1.5	50	10.9	ZND	47437579
10	1.5	60	10.9	ZND	47437581
10	1.5	80	10.9	ZND	47437584
12	1.75	25	12.9	BLO	86836488
12	1.75	25	10.9	BZN	84173775
12	1.75	25	10.9	ZND	48185575
12	1.75	30	10.9	ZND	47443987
12	1.75	35	10.9	BLO	84299393
12	1.75	35	10.9	ZND	47456940
12	1.75	45	8.8	DAC	47933900
12	1.75	50	10.9	ZND	84129702
12	1.75	80	10.9	ZND	90424049

Do not use on new designs after 01OCT2011 (Hydrogen Assisted Cracking–HAC)

& With chemical coating per IFI 525; ND Microspheres 593S (Blue) or Precote 85; Minimum of 5 pitches, entire circumference starting 2 pitches from end.

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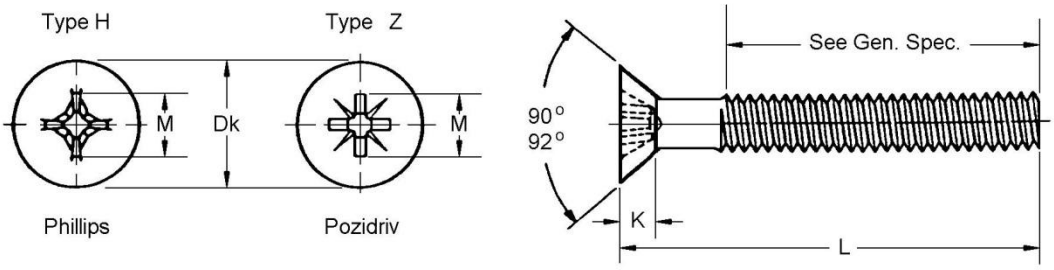
Flat Countersunk Head Machine Screws Metric Series



Dimensions are in Millimeters

Table 3a Dimensional Requirements

Nominal Size	Pitch	Dk		K	M Ref		Drive Point No.
		Head Diameter		Head Height	Recess Diameter		
		Max.	Min.	Max.	Type H	Type Z	
M3	0.5	5.6	5.2	1.65	3.2	3	1
M4	0.7	8.4	8.0	2.7	4.6	4.4	2
M5	0.8	9.3	8.64	2.7	5.2	4.9	2
M6	1.0	11.3	10.57	3.3	6.8	6.6	3
M8	1.25	15.8	15.37	4.65	8.9	8.8	4
M10	1.5	18.3	17.57	5.0	10.0	9.8	4

Table 3b: Flat countersunk head Type H 4.8 ZND Coarse – Preferred

Parts can also be provided per DIN 965 dimensions

Shaded area denotes screws with shanks; all others are fully threaded

	Diameter					
Length	**M3**	**M4**	**M5**	**M6**	**M8**	**M10**
4						
5					Non-Preferred Sizes	
6			51418830			
8	84476728					
10		72181877		120027		
12	47692859	43645		86511855		
14						
16			84421930	300580	86511856	86511858
20		43646		43653	86511857	379616
25			86523015	86512463	374897	379528
30			43650	120029	300351	86511859
35			47477900			
40		86571783		43655	300352	120204
50			86509204		366003	378862
60	Non-Preferred Sizes			86585886		
70						

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Table 3c: Flat countersunk head – Non-Preferred

Parts can also be provided per DIN 965 dimensions

Diameter	Length	Thread length	Drive	Material	Finish	Part No.
M4	10	FULL	Z	4.8	ZND	83956457
M4	20	FULL	Z	4.8	BZN	86555127
M4	25	FULL	Z	4.8	BZN	48184705
M4	25	FULL	Z	4.8	ZND	90395207
M4	30	FULL	H	4.8	BGM	48186720
M4	30	FULL	H	SST	PLN	48080643
M5	16	FULL	H	4.8	DOR	84364039
M5	25	FULL	H	4.8	BZN	84474999
M6	12	FULL	H	8.8	ZND	47777682
M6	12	FULL	H	4.8 w/chem lock &	ZND	90417437
M6	16	FULL	H	4.8	BZN	84411955
M6	16	FULL	H	SST	PLN	84411957
M6	20	FULL	Z	4.8	BZN	82880719
M6	20	FULL	Z	5.8	ZND	87015849
M6	25	FULL	H	4.8	DAC	90331336
M6	25	FULL	H	8.8	ZND	90478115
M6	25	FULL	H	SST	PLN	47365943
M6	40	FULL	H	SST	PLN	48112344

& With chemical coating per IFI 525; ND Microspheres 593S (Blue) or Precote 85; Minimum of 5 pitches, entire circumference starting 2 pitches from end.

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Flat Countersunk Head Machine Screws Metric Series - Fiat 10532

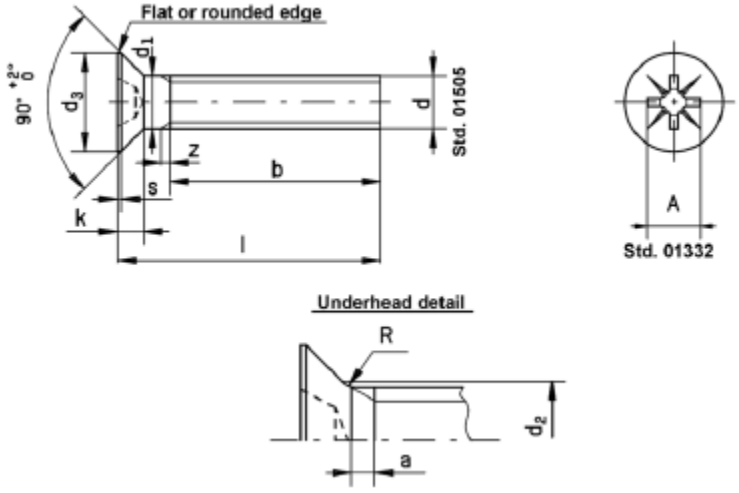

Table 3d: Dimensional Requirements

Nominal Size	Pitch	Dk Head Diameter (mm)		k Head Height	A (Type Z) Recess Diameter	Thread Length b mm	z max mm	Drive Point No.
		Max.	Min.	Max. (mm)	Ref. (mm)			
M3	0.5	5.6	5.3	1.65	3	19	1.2	1
M4	0.7	7.5	7.14	2.2	4.2	22	1.8	2
M5	0.8	9.3	8.84	2.5	4.4	25	2.0	2
M6	1.0	11.3	10.57	3	6.1	28	2.5	3
M8	1.25	14.50	14.07	4	8.5	34	3.1	4
M10	1.25	18.3	17.57	5	9.4	40	3.1	4

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Table 3e: Flat Countersunk Head Machine Screws Metric Series - Fiat 10532

Diameter	Length mm	Thrd len.	Drive	a max. mm	Material	Finish	Part No.
M3	6	FULL	Z	1	5.8	BZN	*13295717
M3	16	FULL	Z	1.2	5.8	ZND	*13296418
M4	16	FULL	Z	1.8	5.8	ZND	13297611
M4	16	FULL	Z	1.8	5.8	DAC	13297614
M4	16	FULL	Z	1.8	5.8	BZN	13297617
M4	20	FULL	Z	1.8	5.8	BZN	13297817
M4	30	FULL	Z	1.8	5.8	DAC	91776810
M4	35	FULL	Z	1.8	5.8	DAC	91776812
M5	12	FULL	Z	2	5.8	DAC	*13299214
M5	12	FULL	Z	2	5.8	ZND	*13299218
M5	12	FULL	Z	2	5.8	BZN	*13299219
M5	16	FULL	Z	2	5.8	DAC	*13299414
M5	35		Z		5.8	ZND	13300211
M5	40		Z		5.8	ZND	13300311
M6	12	FULL	Z	2	5.8	ZND	*13301111
M6	14	FULL	Z	2.5	5.8	ZND	*13301211
M6	16	FULL	Z	2.5	5.8	DAC	*13301314
M6	25	FULL	Z	2.5	5.8	BZN	*13301717
M8	16	FULL	Z	2.5	5.8	ZND	13303311
M8	20	FULL	Z	3.1	5.8	ZND	13303511
M8	20	FULL	Z	3.1	5.8	DAC	13303514
M8	40	FULL	Z	3.1	5.8	BZN	13304117
M10X1.25	20	FULL	Z	2.5	5.8	ZND	*13305311

*Parts can also be provided per ISO 7046

% All parts in Table 3e can also be provided per DIN 965 dimensions

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Oval Countersunk Head Machine Screws Metric Series

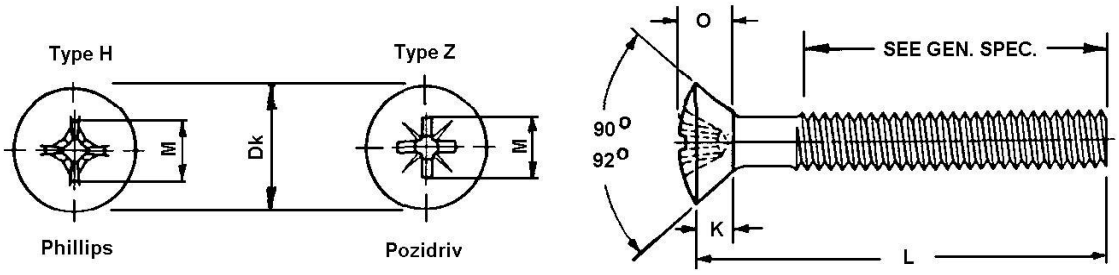

Table 4a: Dimensional Requirements

Nominal Size	Pitch	Dk		K	O	M Ref		Drive Point No.
		Head Diameter		Head Side Height	Total Head Height	Recess Diameter		
		Max.	Min.	Max.	Max.	Type H	Type Z	
M3	0.5	5.6	5.2	1.65	2.4	3.4	3.1	1
M4	0.7	8.4	8.04	2.7	3.7	5.2	5.0	2
M5	0.8	9.3	8.64	2.7	4.0	5.4	5.3	2
M6	1.0	11.3	10.57	3.3	4.8	7.3	7.1	3
M8	1.25	15.8	15.37	4.65	6.65	9.6	9.5	4
M10	1.5	18.3	17.57	5.0	7.5	10.4	10.3	4

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Table 4b: Oval Countersunk Head – Non-Preferred

Diameter	Length	Thread Length	Drive	Material	Finish	Part Number
M4	8	FULL	H	4.8	ZND	%81867891
M4	8	FULL	H	4.8	ZND/W *	%9844207
M4	14	FULL	H	4.8	BZN	%9844205
M4	16	FULL	H	4.8	POL	%87307799
M4	16	FULL	H	4.8	**	%87300034
M4	20	FULL	H	4.8	BZN	%87752068
M4	25	FULL	H	4.8	ZND	%782935
M4	25	FULL	H	4.8	BZN	%412477
M4	30	FULL	H	4.8	BZN	%84281056
M4	100	FULL	H	4.8	BZN	%412476
M5	10	FULL	H	4.8	ZND	%82880737
M5	10	FULL	Z	SST	BLO	%13310777
M5	14	FULL	Z	SST	BLO	%13310977
M5	16	FULL	Z	5.8	BZN	%13311017
M5	20	FULL	Z	5.8	ZND	%13311217
M5	20	FULL	Z	5.8	PHC	%87629047
M5	20	FULL	Z	5.8	BGM	%13311214
M5	35	FULL	H	4.8	ZND	%412482
M5	40	25	Z	5.8	BZN	%13311817
M6	10	FULL	H	4.8	BZN	%82861101
M6	10	FULL	H	4.8	ZND	%83959742
M6	16	FULL	Z	5.8	BZN	%13313017
M6	20	FULL	H	4.8	BZN	%86017957
M6	20	FULL	H	4.8	PHC	%86502680
M6	20	FULL	Z	5.8	BZN	%13313217
M6	25	FULL	H	4.8	BZN	%86020047
M6	25	FULL	Z	5.8	ZND	%13313411
M6	25	FULL	Z	5.8	BZN	%13313417
M6	30	FULL	H	4.8	PHC	%86503049
M6	30	FULL	H	4.8	BGM	%84263392
M6	30	FULL	Z	5.8	BZN	%13313617
M6	50	28	Z	5.8	BZN	%13314017
M6	50	FULL	H	4.8	BZN	87615096
M6	65	38	H	4.8	BZN	%86017950
M6	70	38	H	4.8	BZN	%86015539
M8	20	FULL	H	4.8	PHC	86502688
M8	30	FULL	H	4.8	ZND	47780006

* ZND/W ZND with a supplementary lubricant clean and dry to the touch as agreed by supplier and engineer.
** Black Zinc Nickel, two hours to red rust
% Parts can also be provided per DIN 966 dimensions

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Oval Countersunk Head Machine Screws Metric Series Fiat 10534

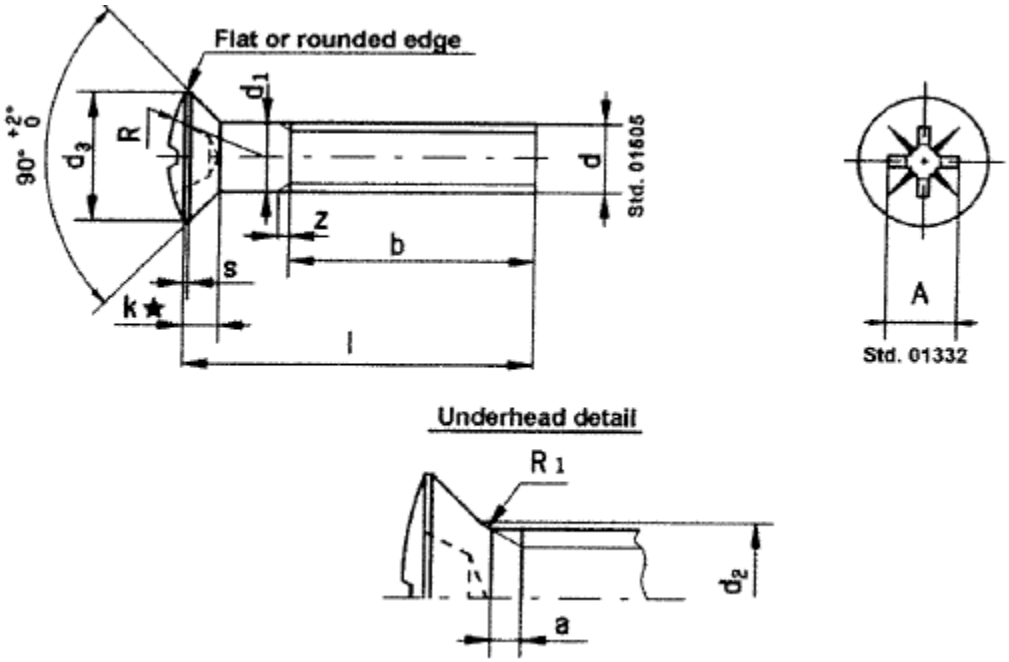

Table 4c: Dimensions Requirements

Nominal Size	Pitch	Dk		K	A (Type Z)	Drive Point No.
		Head Diameter		Head Side Height	Recess Diameter	
		Max.	Min.	Max.	Ref	
M4	0.7	7.5	7.14	2.2	4.6	2

Table 4d: Oval Countersunk Head – Fiat 10534 - Non-Preferred

Diameter	Length	Thread Length	Drive	a max	Material	Finish	Part Number
M4	8	FULL	Z	1.4	5.8	DAC	%13308714
M4	12	FULL	Z	1.8	5.8	ZND	%13309011
M4	14	FULL	Z	1.8	A2-70	BLO	%13309177
M4	16	FULL	Z	1.8	5.8	BZN	%13309217
M4	16	FULL	Z	1.8	A2-70	BLO	%13309277
M4	20	FULL	Z	1.8	5.8	BZN	%13309417

% Parts can also be provided per DIN 966 dimensions

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Hexagon Washer Head Machine Screws
Metric Series

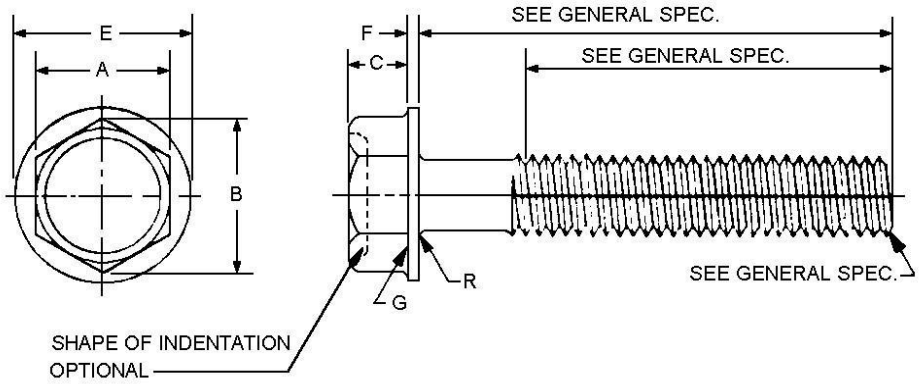

Table 5a: Dimensional Requirements

Nom Size	Nom Pitch	A		B	C		R	E		F		G
		Width Across Flats		Width Across Corners	Head Height		Fillet Radius	Washer Diameter		Washer Thickness		Junction Radius
		Max.	Min.	Min.	Max.	Min.	Min.	Max.	Min.	Max.	Min.	Max.
M3	0.5	5	4.82	5.36	1.52	1.24	0.2	6.2	5.8	0.5	0.3	0.5
M4	0.7	7	6.78	7.55	2.79	2.44	0.2	9.2	8.5	0.7	0.5	0.7
M5	0.8	8	7.78	8.66	3.05	2.67	0.3	10.5	9.8	0.8	0.5	0.8
M6	1	10	9.78	10.89	4.83	4.37	0.3	13.2	12.2	1.3	0.8	1
M8	1.25	13	12.73	14.17	5.84	5.28	0.4	17.2	15.9	1.4	0.9	1.2
M10	1.5	15	14.73	16.41	7.49	6.86	0.5	19.8	18.3	1.6	0.9	1.5

There are no national or international standards for hexagon washer head machine screws. The specifications are based on user requirements only. The ISO standards referred to in this section for other types of machine screws should only be used as a guide.

Table 5b: Hex Washer Head – Non-Preferred

Diameter	Length	Thread Length	Material	Finish	Part Number
M4	10	FULL	4.9	DOR	87343621
M4	16	FULL	4.8	ZND	87036224
M4	16	FULL	9.8	BZN	9824839
M4	20	FULL	9.8	BZN	9628076
M5	12	FULL	4.8	ZND	86639263

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Flat Head Machine Screws Metric Series (Torx® or Equivalent)

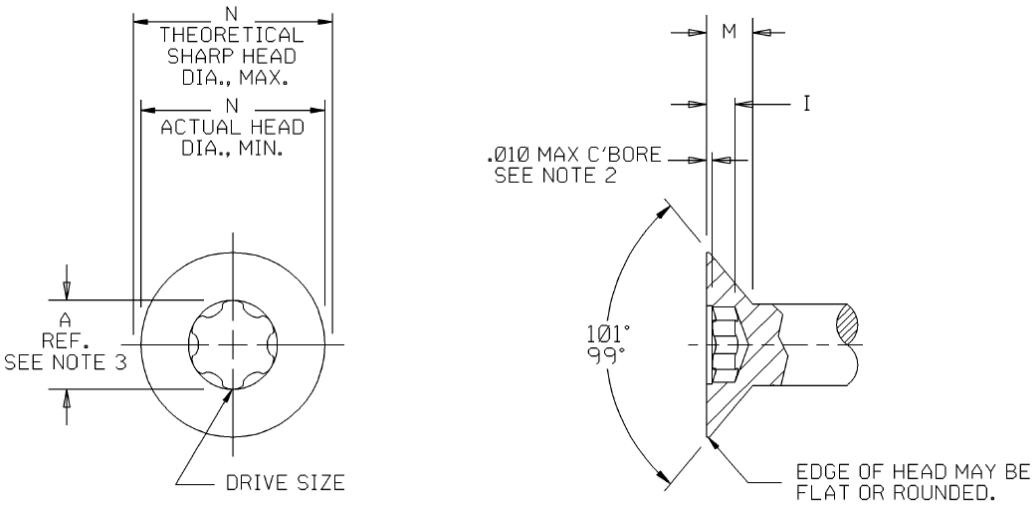

Table 6a: Dimensional Requirements

Screw Size	A	I	N Head Dia			M Head Height
			Theoretical Sharp		Actual	
			Max	Min	Min	
M3.5	3.35	1.14	8.2	7.7	6.9	2.3
M4	3.94	1.27	9.4	8.9	8.0	2.7
M5	4.52	1.39	10.4	9.8	8.9	2.7
M6	5.61	1.77	12.6	11.9	10.9	3.3
M8	6.76	2.46	17.3	16.5	15.4	4.6
M10	8.94	2.79	20.0	19.2	17.8	5.0

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Table 6b: Flat Head (Torx® or Equivalent) – Non-Preferred

Head Type	Diameter	Length	Material	Finish	Part Number
FLAT	M4	10	8.8	BGM	@90347044
FLAT	M4	25	8.8	BGM	92184718
FLAT	M4	25	8.8	ZND	92683365
FLAT	M6	12	5.8	POL	84187819
FLAT	M6	16	SST	PLN	48180643
FLAT	M6	16	8.8	ZND	51495259
FLAT	M6	40	SST	PLN	48168755
FLAT	M8	16	10.9	ZND	51493964
FLAT	M8	30	8.8	DOR	92816842
FLAT	M10	20	8.8	ZND	@51595112

@ With non-metallic patch per IFI 524; patch to be applied to minimum of 5 pitches, min 90° of circumference starting 2 pitches from end.

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Pan Head Machine Screws Metric Series (Torx® or Equivalent)

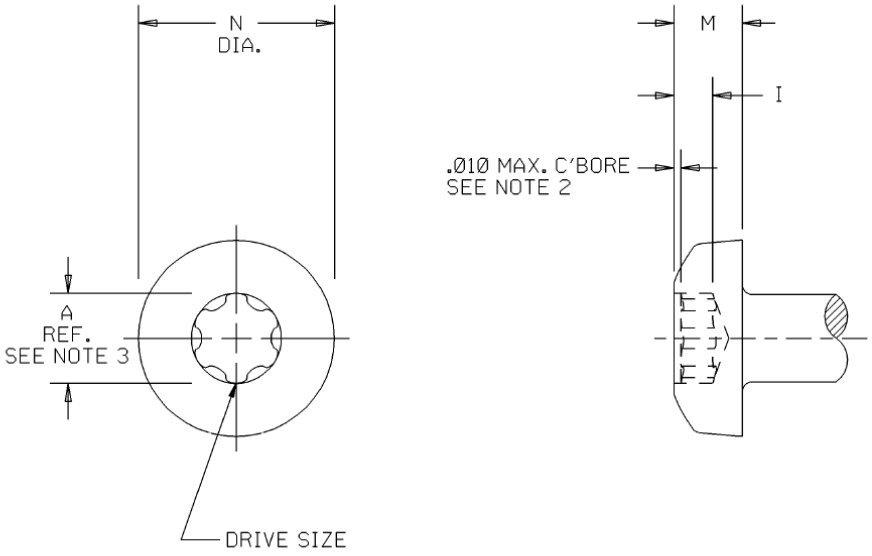

Table 7a: Dimensional Requirements

Screw Size	A Dia.	I	N Head Dia.		M Head Height	
			Max.	Min.	Max.	Min.
M2	1.75	0.63	4.0	3.7	1.6	1.4
M2.5	2.39	0.83	5.0	4.7	2.1	1.9
M3	2.82	0.88	5.6	5.3	2.4	2.2
M3.5	3.35	1.14	7.0	6.6	2.6	2.3
M4	3.94	1.27	8.0	7.6	3.1	2.8
M5	4.52	1.52	9.5	9.1	3.7	3.4
M5	4.52	1.52	11.0	10.5	4.0	3.7
M6	5.61	1.90	12.0	11.5	4.5	4.3
M8	6.76	2.79	16.0	15.5	6.0	5.6
M10	8.94	3.04	20.0	19.4	7.5	7.1

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Table 7b: Pan Head (Torx® or Equivalent)

Head Type	Diameter	Length	Material	Finish	Part Number
PAN	M2	12	4.8	ZND	91777281
PAN	M2.5	6	4.8	ZND	48083210
PAN	M2.5	8	4.8	ZND	92228430
PAN	M3	18	4.8	ZND	90340123
PAN	M3	20	4.8	ZND	90339245
PAN	M4	6	4.8	ZND	91891169
PAN	M4	8	4.8	ZND	87672179
PAN	M4	8	4.8	ZND	&92823933
PAN	M4	10	4.8	BGM	84193286
PAN	M4	12	4.8	ZND	92195240
PAN	M4	12	4.8	DOR	92677622
PAN	M4	20	4.8	POL	84183818
PAN	M4	25	4.8	BGM	84187831
PAN	M4	35	4.8	ZND	47878197
PAN	M4	45	4.8	BZN	92145901
PAN	M4	55	4.8	BZN	84346912
PAN	M4	60	4.8	ZND	47761815
PAN	M5	8	4.8	ZND	92134689
PAN	M5	8	4.8	ZND	&92823932
PAN	M5	16	8.8	BGM	92138729
PAN	M5	16	5.8	BZN	47422633
PAN	M5	16	5.8	18-1103 Fe/ZnNi 7 IV	90391699
PAN	M5	20	4.8	POL	84475422
PAN	M5	20	4.8	18-1103 Fe/ZnNi 7 IV	90405614
PAN	M5	25	4.8	POL	84187829
PAN	M5	25	4.8	18-1103 Fe/ZnNi 7 IV	90391695
PAN	M6	12	8.8	POL	84187816
PAN	M6	12	8.8	BGM	51678168
PAN	M6	12	4.8	ZND	92817339
PAN	M6	14	4.8	BGM	84193289
PAN	M6	15	8.8	BZN	48058164
PAN	M6	16	4.8	POL	84187812
PAN	M6	20	4.8	POL	84187817
PAN	M6	20	8.8	BZN	48058168

& With chemical coating per IFI 525; ND Microspheres 593S (Blue) or Precote 85; chemical coating to be applied minimum of 5 pitches, entire circumference starting 2 pitches from end.

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Table 7b: Pan Head (Torx® or Equivalent)

Head Type	Diameter	Length	Material	Finish	Part Number
PAN	M6	#20	8.8	BZN	81870066
PAN	M6	#20	8.8	BZN	&47881642
PAN	M6	20	8.8	BZN	&47881646
PAN	M6	25	4.8	BGM	84187823
PAN	M6	30	4.8	BZN	84129691
PAN	M6	30	8.8	BZN	48058170
PAN	M6	35	8.8	POL	84187820
PAN	M6	50	8.8	BZN	48058171
PAN	M6	60	8.8	BZN	48058172
PAN	M6	70	8.8	BZN	48058183
PAN	M6	140	8.8	BZN	48058189
PAN	M8	16	8.8	POL	84187810
PAN	M8	20	8.8	ZNM	48180488
PAN	M8	25	8.8	BGM	84188431
PAN	M8	25	8.8	BGM	@51646149
PAN	M8	30	8.8	BGM	@51421294
PAN	M8	35	8.8	BGM	84187827
PAN	M8	40	8.8	BGM	84193284
PAN	M8	40	8.8	BGM	@48063092
PAN	M10	16	4.8	BGM	84270866

Includes 8mm Paint Clearing Dog pt
@ With non-metallic patch per IFI 524; patch to be applied to minimum of 5 pitches, min 90° of circumference starting 2 pitches from end.
& With chemical coating per IFI 525; ND Microspheres 593S (Blue) or Precote 85; chemical coating to be applied minimum of 5 pitches, entire circumference starting 2 pitches from end.

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Round Washer Head Machine Screws (TORX® or Equivalent) Metric Series

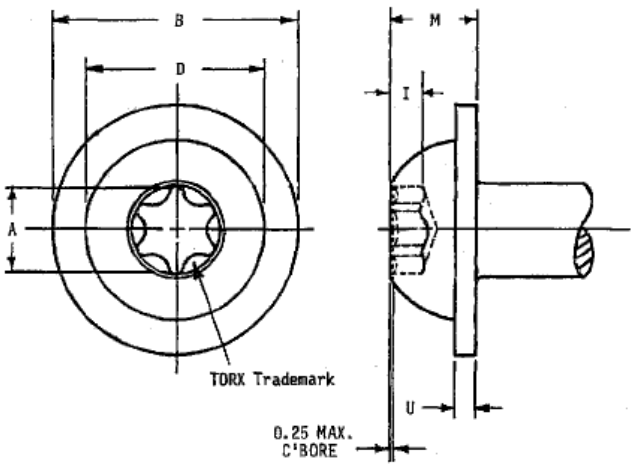

Table 8a: Dimensional Requirements

	A	I	B	D	M	U
M2	1.75	0.63	4.2	3.36	1.42	0.4
M2.5	2.39	0.76	5.3	4.25	1.62	0.5
M3	2.82	0.88	6.2	5.36	2.02	0.5
M3.5	3.35	1.27	7.5	5.92	2.63	0.6
M4	3.94	1.27	9.2	7.55	3.14	0.7
M5	4.52	1.39	10.5	8.66	3.47	0.8
M6	5.61	1.9	13.2	10.89	5.67	1.3
M8	6.76	2.3	17.2	14.17	6.68	1.4

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Table 8b: Round Washer Head Machine Screws – Non-Preferred (TORX® or Equivalent)

Diameter	Length	Thread Length	Material	Finish	Part Number
M3	10	FULL	8.8	ZND	92070405
M4	15	FULL	10.9	ZND	92148916
M5	12	FULL	10.9	ZND	84340194
M5	14	FULL	10.9	ZND	84340196
M5	15	FULL	10.9	ZND	84340199
M6	10	FULL	10.9	ZND	92733206
M6	12	FULL	10.9	ZND	84349415
M6	16	FULL	10.9	ZND	87682398
M6	16	FULL	10.9 w/chem lock &	ZND	90407661
M6	16	FULL	8.8	BZN	84349421
M6	25	FULL	8.8	BZN	47895978
M6	25	FULL	10.9	ZND	84305556
M6	25	FULL	10.9 w/chem lock *	ZND	84375323
M6	30	FULL	10.9	ZND	51468790
M6	35	FULL	10.9	ZND	84359102
M6	40	FULL	8.8	ZND	90342078
M6	55	FULL	8.8	BZN	47437479
M6	55	FULL	8.8	BGM	90368384
M6	70	FULL	10.9	ZND	47584167
M6	80	FULL	8.8	BZN	47437498
M6	80	FULL	8.8	BGM	91716000
M8	12	FULL	8.8	BGM	92176435
M8	16	FULL	8.8	BZN	47771375
M8	20	FULL	8.8	POL	84187826
M8	20	FULL	8.8	BGM	91825827
M8	25	FULL	8.8	BZN	47570438
M8	30	FULL	8.8	BZN	47570446
M8	30	FULL	10.9	ZND	48056758
M8	35	FULL	8.8	BZN	47570448
M8	40	FULL	8.8	BZN	47570449
M8	45	FULL	8.8	BZN	47570450
M8	85	FULL	8.8	BZN	47451824

& With chemical coating per IFI 525; ND Microspheres 593S (Blue) or Precote 85; chemical coating to be applied minimum of 5 pitches, entire circumference starting 2 pitches from end.

* For Chem lock use Precote 80 (Minimum of 5 pitches, entire circumference starting 2 pitches from end)

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Truss Head Machine Screws Metric Series (TORX® or Equivalent)

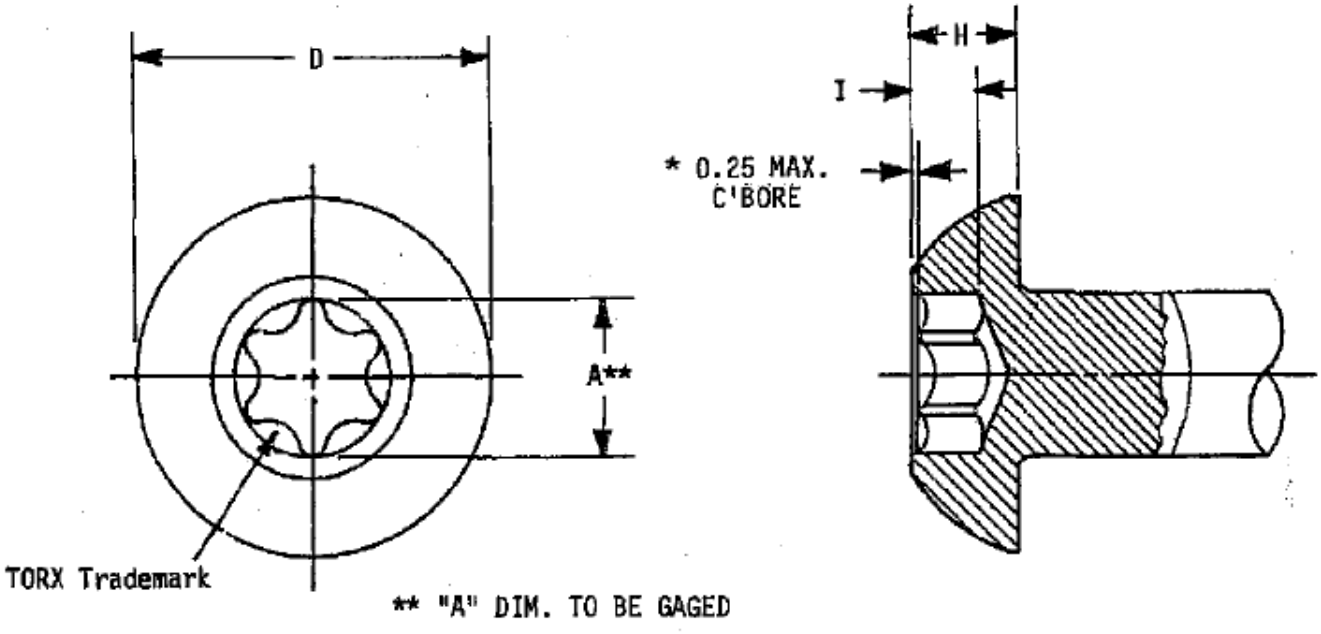

Table 9a: Dimensional Requirements Truss Head (TORX® or Equivalent)

Screw Size	A	I	H		D	
			MAX	MIN	MAX	MIN
M3.5	2.82	0.88	2.60	2.15	8.16	7.69
M4	3.35	1.27	3.15	2.65	9.76	9.24
M5	3.94	1.27	3.70	3.10	11.38	10.78
M6	5.61	1.90	4.65	4.00	14.56	13.86
M8	6.76	2.28	5.50	4.95	17.73	16.92
M10	8.94	3.04	7.20	6.30	20.91	19.98
M12	11.32	3.93	8.38	8.00	26.50	25.00

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Table 9b: Truss Head (TORX® or Equivalent) – Non-Preferred
(see Table 9a for dimensions)

Diameter	Length	Thread Length	Material	Finish	Part Number
M4	20	FULL	8.8	BZN	48185005
M6	16	FULL	8.8	BZN	87742364
^M6	16	FULL	8.8	BZN	51642962
M6	18	FULL	8.8	BZN	51497921
^M6	20	FULL	12.9	BGM	*84270430
^M6	25	FULL	8.8	BZN	51642977
M10	14	FULL	8.8	ZND	51596699
M10	25	FULL	10.9	ZND	87698765
M10	50	FULL	10.9	ZND	51499527
M12	20	FULL	8.8	ZND	51596700
M12	25	FULL	8.8	ZND	51596701
M12	35	FULL	10.9	ZND	92056734

^Chemical lock per IFI 525; ND Microspheres 593S (Blue) or Precote 85; Minimum of 5 pitches, entire circumference starting 2 pitches from end.
*T30 Drive

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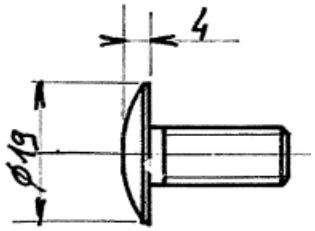
Table 10: Truss Head (TORX® or Equivalent)
Head Dimensions- 4 +/- 0.15 mm Height; 19 +/- 0.40 mm Head Diameter
Drive Type Per Standard NFE 27-185 or ISO 10664
Material – A2-70 Stainless Steel



Diameter	Length mm	Thread Length	Material	Finish	Part Number
M8	16 (+/-0.35)	FULL	SST (A2-70)	PLN	920017517
M8	20 (+/-0.42)	FULL	SST (A2-70)	PLN	920017518
M8	25 (+/-0.42)	FULL	SST (A2-70)	PLN	920017519
M8	30 (+/-0.42)	FULL	SST (A2-70)	PLN	920017520

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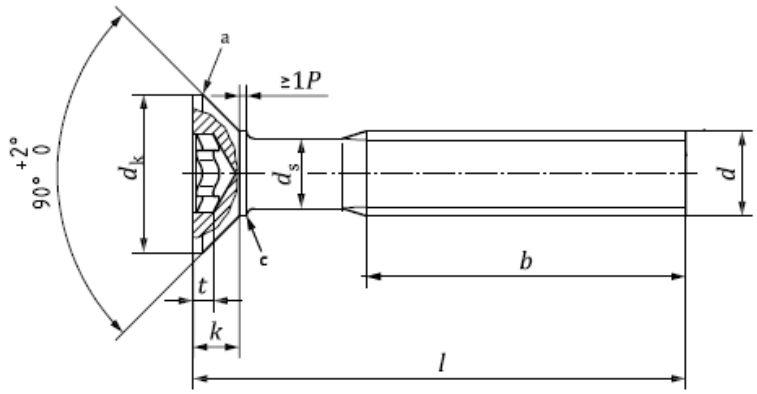

Table 11a: Dimensional Requirements Hexalobular Socket Countersunk Flat Head Screws – ISO 14581

Screw Size	P Pitch	b min. thread length	Hexalobular socket A Ref	d_k Head Dia		k Head Height
				Actual		
				Max	Min	
M4	0.7	38	3.95	8.4	8.04	2.7
M5	0.8	38	4.5	9.3	8.94	2.7
M6	1	38	5.6	11.3	10.87	3.3
M8	1.25	38	7.95	15.8	15.37	4.65
M10	1.5	38	8.95	18.3	17.78	5

Table 11b: Hexalobular Socket Countersunk Flat Head Screws – ISO 14581 – Non-Preferred

Head Type	Diameter	Length	Thread Length	Material	Finish	Part Number
FLAT	M6	16	FULL	A2-50	PLN	51617121
FLAT	M6	30	FULL	8.8	ZND	92817338
FLAT	M8	30	FULL	8.8	DOR	92875027

Stainless Steel Material Property Class A2-50 per ISO 3506-1

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