

Mechanical properties of fasteners —

Part 7: Torsional test and minimum torques for bolts and screws with nominal diameters 1 mm to 10 mm

The European Standard EN 20898-7:1995 has the status of a
British Standard



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- British Constructional Steelwork Association Ltd.
- British Industrial Fasteners Federation
- British Steel Industry
- British Steel Industry (Wire Section)
- Gauge and Tool Makers' Association
- National Association of Fastener Stockholders
- Society of Motor Manufacturers and Traders Ltd.
- Washer Manufacturers, Association of Great Britain

The following bodies also participated in the preparation of the standard, through subcommittees and panels:

- British Stainless Steel Association
- British Turned-parts Manufacturers' Association
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- Institute of Metal Finishing
- Metal Finishing Association
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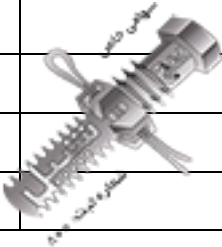
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National foreword

This British Standard has been prepared by Technical Committee GME/9 and is the English language version of EN 20898-7:1995 *Mechanical properties of fasteners — Part 7: Torsional test and minimum torques for bolts and screws with nominal diameters 1 mm to 10 mm* published by the European Committee for Standardization (CEN). It is identical with ISO 898-7:1992, published by the International Organization for Standardization (ISO). EN 20898-7:1995 was produced as a result of international discussions in which the United Kingdom took an active part.

Cross-reference

Publication referred to	Corresponding British Standard
ISO 898-1:1988	BS EN 20898 <i>Mechanical properties of fasteners</i> Part 1:1992 <i>Specification for bolts, screws and studs</i>

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Summary of pages

This document comprises a front cover, an inside front cover, pages i and ii, the EN title page, pages 2 to 6, a inside back cover and a back cover.

This standard has been updated (see copyright date) and may have had amendments incorporated. These will be indicated in the amendment table on the inside front cover.

ICS 21.060.10

Descriptors: Fasteners, breaking torque, bolts, specification, mechanical properties, testing, torsion testing

English version

**Mechanical properties of fasteners —
Part 7: Torsional test and minimum torques for bolts and
screws with nominal diameters 1 mm to 10 mm**

(ISO 898-7:1992)

Caractéristiques mécaniques des éléments de
fixation —

Partie 7: Essai de torsion et couples minimaux
de rupture des vis de diamètre nominal de
filetage de 1 mm à 10 mm
(ISO 898-7:1992)

Mechanische Eigenschaften von
Verbindungselementen —

Teil 7: Torsionsversuch und
Mindest-Bruchdrehmomente für Schrauben
mit Nenndurchmessern 1 mm bis 10 mm
(ISO 898-7:1992)

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Ref. No. EN 20898-7:1995 E

Foreword

This European Standard has been taken over by the Technical Committee CEN/TC 185, *Threaded and non-threaded mechanical fasteners and accessories*, from the work of ISO/TC 2, *Fasteners*, of the International Organization for Standardization (ISO).

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by July 1995, and conflicting national standards shall be withdrawn at the latest by July 1995.

According to the CEN/CENELEC Internal Regulations, the following countries are bound to implement this European Standard: Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, United Kingdom.

NOTE Normative references to international publications are listed in Annex ZA (normative).



1 Scope

This part of ISO 898 specifies a torsional test for the determination of the breaking torque of bolts and screws with nominal diameters 1 mm to 10 mm with property classes 8.8 to 12.9 in accordance with ISO 898-1. The test applies to bolts and screws with thread less than M3 for which no breaking and proof loads are indicated in ISO 898-1, as well as to short bolts and screws with nominal diameters 3 mm to 10 mm which cannot be subjected to a tensile test. The minimum breaking torques are not valid for hexagon socket set screws.

2 Normative reference

The following standard contains provisions which, through reference in this text, constitute provisions of this part of ISO 898. At the time of publication, the edition indicated was valid. All standards are subject to revision, and parties to agreements based on this part of ISO 898 are encouraged to investigate the possibility of applying the most recent edition of the standard indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 898-1:1988, *Mechanical properties of fasteners — Part 1: Bolts, screws and studs.*

3 Torsional test

3.1 Principle

Determination of the breaking torque by clamping the bolt or screw to be tested into a test device.

3.2 Apparatus

3.2.1 Test device for torsional test, such as is shown in Figure 1.

3.2.2 Torquemeter, with a scale which shall not exceed to quintuple of the respective minimum breaking torque. The minimum inaccuracy of the torquemeter shall be $\pm 7\%$ of the minimum breaking torque to be tested.

3.3 Test conditions

The bolt or screw shall be exclusively subjected to torsion whereby the respective minimum breaking torque according to Table 2 shall be reached before rupture occurs. The test result shall not be influenced by head friction or by thread friction.

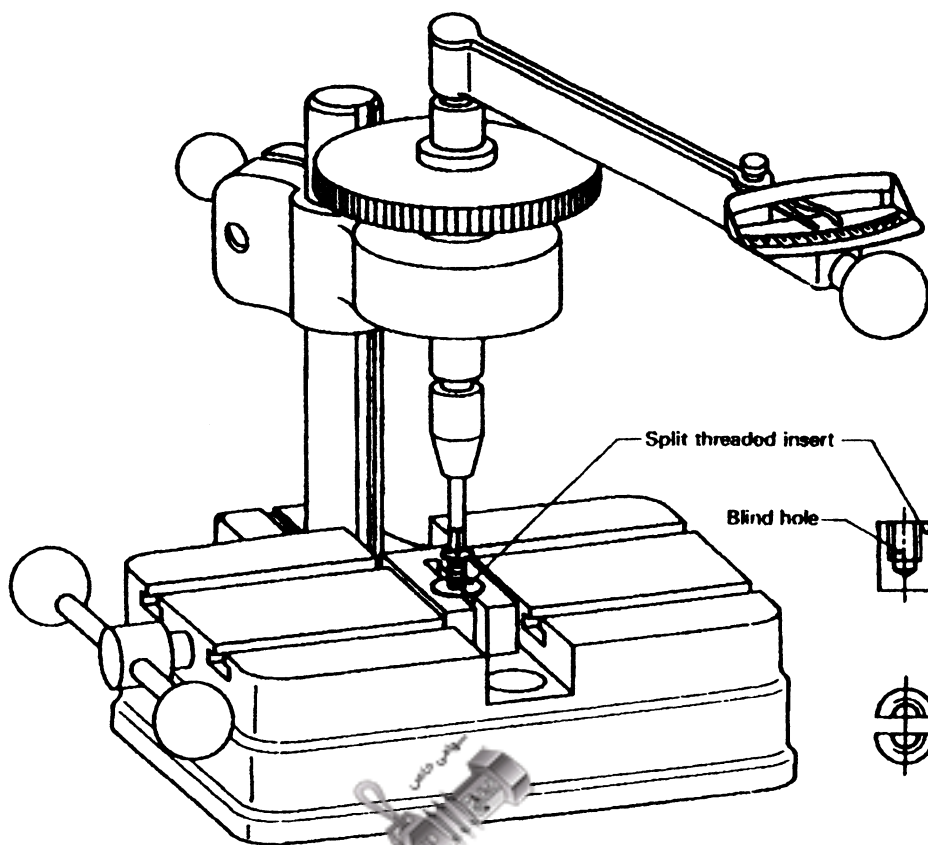


Figure 1 — Example of a device for the torsional test

3.4 Procedure

Clamp the bolt or screw into the test device over at least two full threads, having a free thread length of at least one thread diameter present between the head of the bolt or screw and the threaded insert (see Figure 1). Apply the torque in a continuously increasing manner.

4 Minimum breaking torques

The following formula applies to the determination of the minimum breaking torques:

$$M_{B \min} = \tau_{B \min} \cdot W_{p \min}$$

with

$$W_{p \min} = \frac{\pi}{16} \cdot d_{3 \min}^3$$

and

$$\tau_{B \min} = X \cdot R_{m \min}$$

where

$M_{B \min}$ is the minimum breaking torque (see Table 2);

τ_B is the torsional strength;

W_p is the polar moment of resistance;

$d_{3 \min}$ is the minimum value of the minor diameter of the external thread;

R_m is the tensile strength; and

X is the strength ratio τ_B/R_m (see Table 1).

5 Evaluation of the torque test

The tested bolt or screw is regarded as having passed the torque test if no rupture occurs before the minimum breaking torques specified in Table 2 are reached.

Table 1 — Strength ration X

Property class	8.8	9.8	10.9	12.9
Ratio X	0,84	0,815	0,79	0,75

Table 2 — Minimum breaking torques

Thread	Pitch mm	Minimum breaking torque ^a			
		$M_{B \min}$ N m			
		Property class			
		8.8	9.8	10.9	12.9
M1	0,25	0,033	0,036	0,040	0,045
M1,2	0,25	0,075	0,082	0,092	0,10
M1,4	0,3	0,12	0,13	0,14	0,16
M1,6	0,35	0,16	0,18	0,20	0,22
M2	0,4	0,37	0,40	0,45	0,50
M2,5	0,45	0,82	0,90	1,0	1,1
M3	0,5	1,5	1,7	1,9	2,1
M3,5	0,6	2,4	2,7	3,0	3,3
M4	0,7	3,6	3,9	4,4	4,9
M5	0,8	7,6	8,3	9,3	10
M6	1	13	14	16	17
M7	1	23	25	28	31
M8	1,25	33	36	40	44
M8 × 1	—	38	42	46	52
M10	1,5	66	72	81	90
M10 × 1	—	84	92	102	114
M10 × 1,25	—	75	82	91	102

^a These minimum breaking torques are valid for bolts and screws with the thread tolerances 6g, 6f and 6e.



Annex A (informative)

Explanatory note

ISO 898-1 contains property classes for bolts and screws but only indicates minimum breaking loads and proof loads for threads equal to or greater than M3 because in the case of smaller bolts and screws the influence of the thread tolerances and the tolerances of the test device is such that an exact determination of breaking loads and proof loads is not possible.

Also since bolts and screws with threads greater than M3 up to approximately M10 often cannot be subjected to a tensile test (or proof load test) due to their short lengths, minimum breaking torques have been specified for bolts and screws M1 to M10 (including the fine pitch threads $M8 \times 1$, $M10 \times 1$ and $M10 \times 1,25$) which allow an evaluation of the functional properties of the bolts and screws. For the time being, minimum breaking torques can be specified for property classes 8.8 to 12.9 only, because for lower property classes the test results are widely scattered and therefore more studies are required.

The indicated minimum breaking torques are to be applied without taking account of friction and the type of test device is optional according to this part of ISO 898. Figure 1 is only an example of a suitable test device.

The minimum breaking torques have been determined on the basis of cross-sections resulting from the minimum values of the minor diameter of the thread tolerance 6g. Tests have shown that the torques can also be used for bolts and screws with thread tolerances 6f and 6e.

Annex ZA (normative)

Normative references to international publications with their relevant European publications

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies (including amendments).

Publication	Year	Title	EN	Year
ISO 898-1	1988	<i>Mechanical properties of fasteners — Part 1: Bolts, screws and studs</i>	EN 20898-1	1991



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List of references

See national foreword.

1. 2. 3. 4. 5. 6. 7. 8. 9. 10. 11. 12. 13. 14. 15. 16. 17. 18. 19. 20. 21. 22. 23. 24. 25. 26. 27. 28. 29. 30. 31. 32. 33. 34. 35. 36. 37. 38. 39. 40. 41. 42. 43. 44. 45. 46. 47. 48. 49. 50. 51. 52. 53. 54. 55. 56. 57. 58. 59. 60. 61. 62. 63. 64. 65. 66. 67. 68. 69. 70. 71. 72. 73. 74. 75. 76. 77. 78. 79. 80. 81. 82. 83. 84. 85. 86. 87. 88. 89. 90. 91. 92. 93. 94. 95. 96. 97. 98. 99. 100.



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