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Befæstelselementer – Sekskantskruer med fingevind – Produktklasse A og B

Fasteners – Hexagon head bolts, with fine pitch thread – Product grades A and B (ISO 8765:2022)

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DS projekt: M343668

ICS: 21.060.10

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EUROPÄISCHE NORM

July 2022

ICS 21.060.10

Supersedes EN ISO 8765:2011

English Version

Fasteners - Hexagon head bolts, with fine pitch thread - Product grades A and B (ISO 8765:2022)

Fixations - Vis à tête hexagonale partiellement
filetées, à pas fin - Grades A et B (ISO 8765:2022)

Mechanische Verbindungselemente -
Sechskantschrauben mit Schaft und
metrischem Feingewinde - Produktklassen
A und B (ISO 8765:2022)

This European Standard was approved by CEN on 25 September 2021.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN-CENELEC Management Centre or to any CEN member.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
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European foreword

This document ([EN ISO 8765:2022](#)) has been prepared by Technical Committee ISO/TC 2 "Fasteners" in collaboration with Technical Committee CEN/TC 185 "Fasteners" the secretariat of which is held by BSI.

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of an identical text or by endorsement, at the latest by January 2023, and conflicting national standards shall be withdrawn at the latest by January 2023.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes [EN ISO 8765:2011](#).

Any feedback and questions on this document should be directed to the users' national standards body/national committee. A complete listing of these bodies can be found on the CEN website.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Türkiye and the United Kingdom.

Endorsement notice

The text of [ISO 8765:2022](#) has been approved by CEN as [EN ISO 8765:2022](#) without any modification.

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Fourth edition
2022-06

Fasteners — Hexagon head bolts, with fine pitch thread — Product grades A and B

*Fixations — Vis à tête hexagonale partiellement filetées, à pas fin —
Grades A et B*



Reference number
ISO 8765:2022(E)

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established 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. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 2, *Fasteners*, Subcommittee SC 11, *Fasteners with metric external thread*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 185, *Fasteners*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This fourth edition cancels and replaces the third edition ([ISO 8765:2011](http://www.iso.org/iso/8765:2011)), which has been technically revised.

The main changes are as follows:

- tables for dimensions have been entirely restructured, so that the user can find the specified values in a reliable manner (no risk of picking the wrong dimension), see [Clause 4](#) and [Annex A](#);
- M18×2 has been added;
- $d_{w,min}$ for M14×1,5 has been corrected to 19,64 mm;
- the rules for the shortest and greatest standard lengths have been added, and they have been amended accordingly;
- for steel bolts, property class 5.6 has been deleted and property class 12.9/12.9 has been added;
- for stainless steel bolts, grades D4 and D6 and property class 80 have been added;
- non-ferrous metal bolts have been deleted;
- specifications for marking and labelling have been added as [Clause 6](#).

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

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Fasteners — Hexagon head bolts, with fine pitch thread — Product grades A and B

1 Scope

This document specifies the characteristics of hexagon head bolts, in steel and stainless steel, with metric fine pitch threads M8×1 to M64×4, and with product grades A and B.

If in certain cases other specifications are requested, property classes and stainless steel grades can be selected from [ISO 898-1](#) or [ISO 3506-1](#), and dimensional options from [ISO 888](#) or [ISO 4753](#).

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

[ISO 225](#), *Fasteners — Bolts, screws, studs and nuts — Symbols and descriptions of dimensions*

[ISO 262](#), *ISO general purpose metric screw threads — Selected sizes for screws, bolts and nuts*

[ISO 888](#), *Fasteners — Bolts, screws and studs — Nominal lengths and thread lengths*

[ISO 898-1](#), *Mechanical properties of fasteners made of carbon steel and alloy steel — Part 1: Bolts, screws and studs with specified property classes — Coarse thread and fine pitch thread*

[ISO 965-1](#), *ISO general purpose metric screw threads — Tolerances — Part 1: Principles and basic data*

[ISO 1891-4](#), *Fasteners — Vocabulary — Part 4: Control, inspection, delivery, acceptance and quality*

[ISO 3269](#), *Fasteners — Acceptance inspection*

[ISO 3506-1](#), *Fasteners — Mechanical properties of corrosion-resistant stainless steel fasteners — Part 1: Bolts, screws and studs with specified grades and property classes*

[ISO 4042](#), *Fasteners — Electroplated coating systems*

[ISO 4753](#), *Fasteners — Ends of parts with external ISO metric thread*

[ISO 4759-1](#), *Tolerances for fasteners — Part 1: Bolts, screws, studs and nuts — Product grades A, B and C*

[ISO 6157-1](#), *Fasteners — Surface discontinuities — Part 1: Bolts, screws and studs for general requirements*

[ISO 6157-3](#), *Fasteners — Surface discontinuities — Part 3: Bolts, screws and studs for special requirements*

[ISO 8991](#), *Designation system for fasteners*

[ISO 8992](#), *Fasteners — General requirements for bolts, screws, studs and nuts*

[ISO 10683](#), *Fasteners — Non-electrolytically applied zinc flake coating systems*