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Fasteners — Surface discontinuities —

Part 1:
Bolts, screws and studs for general requirements

Éléments de fixation — Défauts de surface —

Partie 1: Boulons, vis et goujons d'usage général

Reference number
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Foreword

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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. They are approved in accordance with ISO procedures requiring at least 75 % approval by the member bodies voting.

International Standard ISO 6157-1 was prepared by Technical Committee ISO/TC 2, *Fasteners*.

Users should note that all International Standards undergo revision from time to time and that any reference made herein to any other International Standard implies its latest edition, unless otherwise stated.

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Fasteners — Surface discontinuities —

Part 1:
Bolts, screws and studs for general requirements

1 Scope and field of application

1.1 This part of ISO 6157 establishes limits for various types of surface discontinuities on bolts, screws and studs for general requirements.

It applies to bolts, screws and studs with

- nominal thread diameters 5 mm and larger;
- product grades A and B;
- property classes up to and including 10.9, unless otherwise specified in product standards or agreed between supplier and purchaser.

1.2 Limits for surface discontinuities on bolts, screws and studs for special requirements (e.g. automatic assembly) are laid down in ISO 6157-3. When the engineering requirements of the application necessitate that surface discontinuities on bolts, screws and studs be more closely controlled, it should be specified in the respective product standard, or the purchaser shall specify the applicable limits in the inquiry and purchase order.

1.3 Where the permissible limits for surface discontinuities indicated in clause 3 occur, the minimum values for the mechanical and functional properties specified in ISO 898-1 should still be met.

NOTES

1 The figures in clause 3 are examples only. They apply correspondingly also to other types of bolts, screws and studs.

2 The individual figures show the surface discontinuities exaggerated in some cases for clarity.

2 References

ISO 468, *Surface roughness — Parameters, their values and general rules for specifying requirements.*

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

ISO 2859, *Sampling procedures and tables for inspection by attributes.*

ISO 3269, *Fasteners — Acceptance inspection.*

3 Types, causes, appearance and limits of surface discontinuities

3.1 Cracks

A crack is a clean (crystalline) fracture passing through or across the grain boundaries and may possibly follow inclusions of foreign elements. Cracks are normally caused by overstressing the metal during forging or other forming operations, or during heat treatment. Where parts are subjected to significant reheating, cracks usually are discoloured by scale.