DIN 7500-1:2009-06 (E)

Thread rolling screws for ISO metric thread - Part 1: Technical delivery conditions for case hardened and tempered screws

Contents

Page

Foreword 4

1 Scope 5

2 Normative references 5

3 Terms and definitions 6

4 Requirements 6
4.1 General requirements 6
4.2 Design and dimensional accuracy 6
4.3 Materials 6
4.4 Mechanical properties 6
4.4.1 Overview 6
4.4.2 Heat treatment 7
4.4.3 Hardness 7
4.4.4 Case depth 8
4.4.5 Breaking torque 8
4.4.6 Ductility 8
4.4.7 Ability to form a mating thread 8
4.4.8 Lubrication of thread rolling screws 9
4.4.9 Embrittlement 9
4.4.10 Core hardness after retempering 9

5 Test method 9
5.1 Core hardness test 9
5.2 Case hardness test 10
5.3 Case depth test 10
5.4 Torsional test 10
5.5 Ductility test 10
5.6 Driveability test 11
5.6.1 Thread rolling capability 11
5.6.2 Test plate 12
5.7 Embrittlement test 12
5.8 Retempering test 12

6 Torque meter 12

7 Acceptance inspection 12

8 Marking 12
8.1 Symbol 12
8.2 Identification 13
8.3 Manufacturer's identification mark 13

9 Types and designation 13

Bibliography 15

Figures Figure 1 -- Length of the thread rolling section 9

Figure 2 -- Points at which the case hardness may be measured 10

Figure 3 -- Points at which the case depth may be measured 10

Figure 4 -- Ductility test 11

Tables Table 1 -- Chemical composition 6

Table 2 -- Mechanical properties 7

Table 3 -- Mechanical and performance requirements 7

Table 4 -- Case depth 8

Table 5 -- Test plate thickness and hole diameter 12

Table 6 -- Screw types and designations 13