

DIN 267-31:2020-02 (E)

Fasteners - Technical specifications - Part 31: Metric thread rolling screws of property class 10.9 with additionally hardened thread forming zone

Contents	Page
Foreword	3
1 Scope	4
2 Normative references	4
3 Terms and definitions.....	4
4 Materials	4
5 Mechanical properties.....	5
5.1 General	5
5.2 Heat treatment.....	5
5.2.1 Quenching and tempering.....	5
5.2.2 Partial hardening	6
5.3 Breaking torque.....	7
5.4 Ability to form a mating thread	8
5.5 Insertion of replacement metric screw.....	8
5.6 Protective surface finish	8
5.7 Lubrication of thread rolling screws	8
6 Testing	8
6.1 General	8
6.2 Torsional test.....	8
6.3 Driveability test	9
6.3.1 Thread rolling ability.....	9
6.3.2 Test plate	9
7 Torque meter.....	9
8 Marking	9
9 Designation	10
Bibliography	11