UDC 621.882.215.1.092.4

September 1986

Slotted shoulder screws

DIN 927

Zapfenschrauben mit Schlitz

Supersedes August 1972 edition

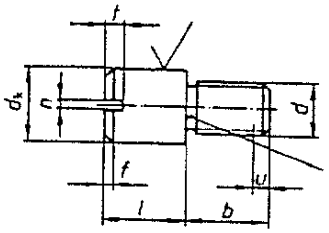
In keeping with current practice in standards published by the International Organization for Standardization (ISO), a comma has been used throughout as the decimal marker.

1 Dimensions

Dimensions in mm

$\sqrt{} = \sqrt{R_z\ 6{,}3}$ for sizes up to M 3

$\sqrt{R_z\ 16}$ for sizes exceeding M 3



DIN 78-K or DIN 78-L thread ends, at the manufacturer's discretion.

DIN 76-A thread undercut

u (incomplete thread): 1,5 P maximum

Thread size d		M 1	M 1,2	M 1,4	M 1,6	M 2	M 2,5	M 3	(M 3,5)	M 4	M 5	M 6
P[1]		0,25	0,25	0,3	0,35	0,4	0,45	0,5	0,6	0,7	0,8	1
b	min. = nominal size	1,8	1,8	2,2	2,5	2,8	3,5	4,5	5,5	6	7	8
	max.	2,05	2,05	2,45	2,75	3,05	3,8	4,8	5,8	6,3	7,36	8,36
d_k	max. = nominal size	1,6	1,8	2	2,2	2,8	3,5	4	4,5	5,5	6,5	8
	min.	1,575	1,775	1,975	2,175	2,775	3,47	3,97	4,47	5,47	6,464	7,964
f[2]	max.	0,2	0,2	0,25	0,3	0,4	0,5	0,5	0,7	0,8	0,8	1
n	Nominal size	0,2	0,25	0,25	0,3	0,3	0,4	0,5	0,5	0,6	0,8	1
	min.	0,26	0,31	0,31	0,36	0,36	0,46	0,56	0,56	0,66	0,86	1,06
	max.	0,4	0,45	0,45	0,5	0,5	0,6	0,7	0,7	0,8	1	1,2
t	min.	0,4	0,4	0,48	0,56	0,64	0,72	0,8	0,96	1,12	1,28	1,6
	max.	0,52	0,52	0,63	0,74	0,84	0,95	1,05	1,21	1,42	1,63	2

l Nominal size	Tolerance
0,8	js 15 for l and b
1	
1,2	
1,6	
2	
2,5	
3	
4	
5	
6	
8	
10	

Sizes and intermediate lengths given in brackets should be avoided if possible.

Slotted shoulder screws are normally manufactured in the range indicated by stepped lines.

[1]) P = pitch of thread (coarse pitch thread)

[2]) $f_{min} = 0{,}5\ f_{max}$

Continued on pages 2 and 3

2 Technical delivery conditions

Material		Steel	Stainless steel	Non-ferrous metal
General requirements		As specified in DIN 267 Part 1		
Thread	Tolerance class	For sizes up to and including M 1,4: 4h, from size M 1,6: 6g		
	Standard	DIN 13 Part 15		
Mechanical properties [1]	Property class (material)	14H [1]	A1-50 C4-50	CuZn = copper-zinc alloy [2]
	Standard	ISO 898 Part 5	DIN 267 Part 11	DIN 267 Part 18
Permissible dimensional deviations and deviations of form	Product grade	For sizes up to and including M 1,4: F; from size M 1,6: A		
	Standard	DIN 267 Part 6; ISO 4759 Part 1		
Types and finishes with additional information to be stated on ordering		As specified in DIN 962.		
Surface finish		As processed.	Bright.	Bright.
		DIN 267 Part 2 shall apply with regard to surface roughness. DIN 267 Part 19 shall apply with regard to permissible surface discontinuities. DIN 267 Part 9 shall apply with regard to electroplating.		
Acceptance inspection		DIN 267 Part 5 shall apply with regard to acceptance inspection.		

[1] Where cold drawn steels as specified in DIN 1651 are used, the following values of elongation at break, A_5, are permissible:
for sizes not exceeding M 4, 5 %;
for sizes exceeding M 4, 6 %.

[2] CuZn = CU2 or CU3 (as specified in DIN 267 Part 18), at the manufacturer's discretion.

[3] Other property classes or materials shall be subject to agreement.

3 Designation

Designation of an M 2 slotted shoulder screw, of shoulder length $l = 2{,}5$ mm, assigned to property class 14H [1]:

Shoulder screw DIN 927 – M 2 × 2,5 – 14H

[1] Where no property class or type of material is given in existing documentation, property class 14H shall apply.

Standards referred to

DIN 13 Part 15	ISO metric screw threads; fundamental deviations and tolerances for screw threads of 1 mm and larger
DIN 76 Part 1	Thread run-outs and thread undercuts for ISO metric threads as specified in DIN 13
DIN 78	Thread ends; lengths of projection of thread ends for ISO metric screw threads as defined in DIN 13
DIN 267 Part 1	Fasteners; technical delivery conditions; general requirements
DIN 267 Part 2	Fasteners; technical delivery conditions; types of finish and dimensional accuracy
DIN 267 Part 5	Fasteners; technical delivery conditions; acceptance inspection (modified version of ISO 3269, 1984 edition)
DIN 267 Part 6	Fasteners; technical delivery conditions; types of finish and dimensional accuracy for product grade F
DIN 267 Part 9	Fasteners; technical delivery conditions; components with electroplated coatings
DIN 267 Part 11	Fasteners; technical delivery conditions (with additions to ISO 3506); corrosion-resistant stainless steel fasteners
DIN 267 Part 18	Fasteners; technical delivery conditions; components made of non-ferrous metals
DIN 267 Part 19	Fasteners; technical delivery conditions; surface discontinuities on bolts and screws
DIN 962	Screws, bolts, studs and nuts; designations, types and finishes
DIN 1651	Free cutting steels; technical delivery conditions
ISO 898 Part 5	Mechanical properties of fasteners; set screws and similar threaded fasteners not under tensile stresses
ISO 4759 Part 1	Tolerances for fasteners; bolts, screws and nuts with thread diameters between 1,6 (inclusive) and 150 mm (inclusive) and product grades A, B and C

Previous editions

10.42, 01.43, 08.53, 08.72.

Amendments

The following amendments have been made in comparison with the August 1972 edition.

a) Size M 1,8 has been deleted because there is no demand for it.

b) The previous design m as specified in DIN 267 Part 2, April 1968 edition, has been replaced by product grade F as specified in DIN 267 Part 6 and product grade A as specified in ISO 4759 Part 1.

c) Limiting dimensions calculated from the permissible tolerances have been included.

d) Some values of slot depth have been amended.

e) Property class 5.8 has been replaced by property class 14H.

f) The technical delivery conditions have been amended.

g) The content of the standard has been editorially revised.

h) The example of designation has been amended.

International Patent Classification

F 16 B 23/00
F 16 B 35/00