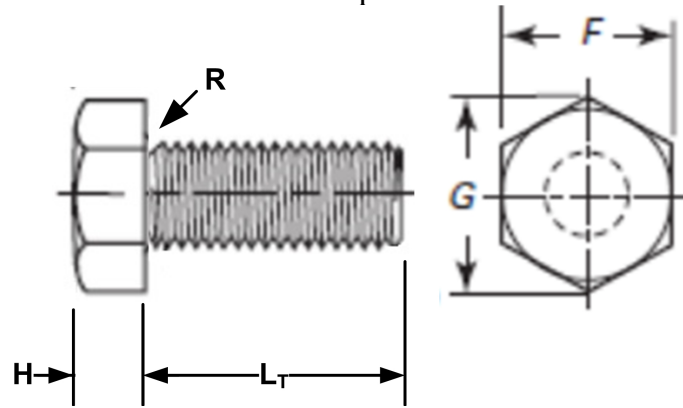


Hex Tap Bolts



307A

GRADE MARK

| THREAD DATA | | |
|---|---|--|
| Size: 5/8 | Threads per in.: 11 | Series Designation: UNC |
| Thread Class or Type: 2A | Major Diameter: 0.6233 - 0.6112 | Pitch and Functional Dia.: 0.5643 - 0.5588 |
| Tensile Stress Area: 0.2260 | Standard: ASME B1.1 - 2003 (R2008) | |
| DIMENSIONAL DATA | | |
| Type: Hex Tap Bolts | Standard: IFI - 199 | Nominal Diameter: 0.625 |
| F - Width Across Flats: 0.938 - 0.906 | G - Width Across Corners: 1.083 - 1.033 | R - Fillet Radius: 0.060 - 0.020 |
| H - Head Height: 0.444 - 0.378 | L _T - Thread Length for Screw Length 6 in. or less: Fully Threaded | Point Type: Non-pointed |
| L - Length: 1-1/2 | Length Tolerance: +0.06/-0.08 | |
| PHYSICAL REQUIREMENTS | | |
| Nominal: 0.625 | Standard: ASTM A307A-2014 | Typical Materials: low carbon steel, 1006 through 1022 |
| Hardness: HRB 69 - 100 | Tensile Load, Min. (lbf): 13,560 | Yield PSI, 2% Offset, Machined Specimen: 36,000 |
| Elongation, min. %, Machined Specimen: 18 | Tensile Strength, Min. (psi): 60,000 | Calculated Shear Load-BODY (ref.)(lbf): 8,136 |
| Calculated Shear Load-THREADS (ref.)(lbf): 6,780 | Straightness Factor: N/A | Calculated Pretension ² (lbf) : 6,102 |
| Tightening Torque ¹ : 70 ft.lbf, 839 in.lbf, 94.8 Nm | | |
| FINISH DATA | | |
| Finish: Zinc & Clear, non-hexavalent/Cr(VI) free - .0001" / 3µm | K factor (ref. DIN 946): 0.22 | Standard: ASTM F1941/F1941M-2016, Fe/Zn 3AN |

¹ These torque values are based on K factors determined using DIN 946, tightening tension of 75% of the yield strength, and the calculation formula T=KDP. These values are advisory only. The torque for assembling critical joints should be determined and/or verified through actual experimentation by the user. The IFI is not responsible for any losses or claims resulting from the use of these values.² Calculated Pretension is equal to 75% of the bolt's yield strength achieved when using the indicated Tightening Torque.

