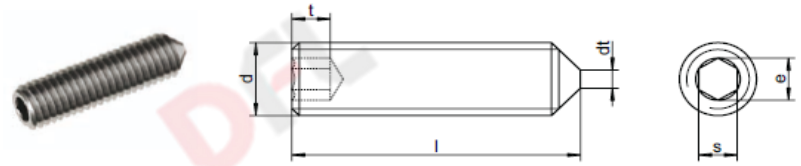
DIN 914 - sim. ISO 4027

Viti senza testa (grani) esagono incassato
con punta conica
hexagon socket set screws
with cone point

disponibile in AISI 304 / AISI 316
available in AISI 304 / AISI 316



d	M2	M2,5	M3	M4	M5	M6
dt	-	-	-	-	-	0,9
t min.	0,8	1,2	1,2	1,5	2	2
t max.	1,7	2	2	2,5	3	3,5
s	0,9	1,3	1,5	2	2,5	3
e	1,003	1,427	1,73	2,3	2,87	3,44
l	da 2 a 16	da 3 a 16	da 3 a 30	da 3 a 40	da 5 a 50	da 5 a 60

d	M8	M10	M12	M16	M20	
dt	1,4	1,9	2,4	3,25	4,25	
t min.	3	4	4,8	6,4	8	
t max.	5	6	8	10	12	
s	4	5	6	8	10	
e	4,58	5,72	6,86	9,15	11,43	
l	da 6 a 60	da 10 a 80	da 12 a 90	da 16 a 100	da 20 a 100	

"l" lunghezza ≤ "d" diametro: conicità punta 120° (es. 8x8, 8x6 = 120°)
"l" lunghezza > "d" diametro : conicità punta 90° (es. 8x10 = 90°)

"l" length ≤ "d" diameter: conicity point 120° (es. 8x8, 8x6 = 120°)
"l" length > "d" diameter: conicity point 90° (es. 8x10 = 90°)

Poiché i grani non hanno la testa, i test di qualità non prevedono la misurazione della resistenza. Pertanto i nostri produttori seguono la norma ISO 3506-3 con classe 12H.

Set screws do not have the head and quality tests do not provide for the measurement of resistance. Therefore our producers follow the ISO 3506-3 class 12H.

Table 3 — Proof torque requirements

Nominal thread diameter *d*	Minimum length[a] of set screws for test mm				Hardness class	
					12H	21H
	Flat point	Cone point	Dog point	Cup point	**Proof torque**, min. Nm	
1,6	2,5	3	3	2,5	0,03	0,05
2	4	4	4	3	0,06	0,1
2,5	4	4	5	4	0,18	0,3
3	4	5	6	5	0,25	0,42
4	5	6	8	6	0,8	1,4
5	6	8	8	6	1,7	2,8
6	8	8	10	8	3	5
8	10	10	12	10	7	12
10	12	12	16	12	14	24
12	16	16	20	16	25	42
16	20	20	25	20	63	105
20	25	25	30	25	126	210
24	30	30	35	30	200	332

[a] The minimum lengths to be tested are the lengths below the dotted line in the product standard, i.e. the lengths having the normal hexagon socket depth.

5.3 Hardness

Set screws shall conform to the hardness requirements given in Table 4.

Table 4 — Hardness

Test method	Hardness class	
	12H	21H
	Hardness	
Vickers hardness HV	125 to 209	210 min.
Brinell hardness HB	123 to 213	214 min.
Rockwell hardness HRB	70 to 95	96 min.

6 Test methods

6.1 Proof torque test for hexagon socket set screws

The set screw shall be inserted in a test block as shown in Figure 2 until the top surface of the screw face is flush with the test block and the point bears on a firm base, for example a backing screw inserted from the other side.