

Socket Set Screws Full and Half Dog Point

Metric



Fasten collars, sheaves, gears, knobs on shafts. Locate machine parts. Self-locking knurled cup point is standard. Special Points like Flat, Dog, Cone & Plain Cup are also available.

Equivalent Standards

	BS 4168, ASME B18.3.6M
Flat Point	DIN 913, ISO 4026
Cone Point	DIN 914, ISO 4027
Dog Point	DIN 915, ISO 4028
Plain Cup	DIN 916, ISO 4028 ISO 898-5

Mechanical Properties

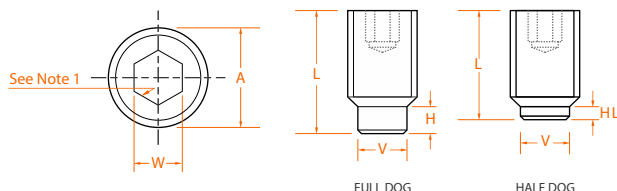
Unbrako High Grade Alloy Steel
Hardness: Rc 45 Minimum

Notes

1. Corner of recess must have fillets to minimise stress concentrations.
2. Thread Class: 6g
3. Working Temperature: -50°C to +300°C
4. Screws with lengths L or smaller will have half dog point H. Screws with lengths larger than L will have full dog point HL.
5. Torques calculated at 75% of the torsional shear strength of the respective Unbrako wrenches.

Length Tolerance

Screws Over	Up to and including	Tolerance
-	Screw Dia	+0.25 - 0.00
Screw Dia	50	±0.25
50	80	±0.50
80	120	±0.70
120	250	±0.80



Product Dimensions

Thread size A nom.	Pitch	Hex Socket Size W nom.	L (See Note 4)	Dog Point		
				H-Full Dog max	HL-Half Dog max	V max
M3	0.50	1.5	5.00	1.75	1.00	2.00
M4	0.70	2.0	6.00	2.25	1.25	2.50
M5	0.80	2.5	6.00	2.75	1.50	3.50
M6	1.00	3.0	8.00	3.25	1.75	4.00
M8	1.25	4.0	10.00	4.30	2.25	5.50
M10	1.50	5.0	12.00	5.30	2.75	7.00
M12	1.75	6.0	16.00	6.30	3.25	8.50
(M14)	2.00	6.0	20.00	7.36	3.80	10.00
M16	2.00	8.0	20.00	8.36	4.30	12.00
(M18)	2.50	10.0	25.00	9.36	4.80	13.00
M20	2.50	10.0	25.00	10.36	5.30	15.00
(M22)	2.50	12.0	30.00	11.43	5.80	17.00
M24	3.00	12.0	30.00	12.43	6.30	18.00

Application Data

Thread size	Maximum Tightening Torque	
	Nm	lbf.in.
M3	0.87	7.7
M4	2.20	19.5
M5	4.60	41.0
M6	7.80	69.0
M8	18.00	160.0
M10	36.00	320.0
M12	62.00	550.0
(M14)	62.00	550.0
M16	150.00	1,330.0
(M18)	290.00	2,570.0
M20	290.00	2,570.0
(M22)	475.00	4,200.0
M24	475.00	4,200.0

Sizes in brackets are non-preferred standards.