



# Standard Specification for Stainless Steel Socket Head Cap Screws<sup>1</sup>

This standard is issued under the fixed designation F837; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reappraisal. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reappraisal.

*This standard has been approved for use by agencies of the U.S. Department of Defense.*

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<sup>ε1</sup> NOTE—S9 Mechanical Property Requirements was editorially corrected in March 2014.

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## 1. Scope\*

1.1 This specification covers the chemical and mechanical requirements for stainless steel inch socket head cap screw (SHCS) with nominal thread 0.060 through 1.500 in. and intended for use in applications requiring general corrosion resistance.

1.2 Three groups of stainless steel alloys are covered, austenitic Group 1 and 2 and martensitic Group 5.

1.3 Four property conditions are covered: austenitic Alloy Groups 1 and 2 in an annealed condition (AF) at 85 ksi maximum, in two cold worked conditions (CW) at 80 ksi minimum, (CW1) at 102 ksi minimum, and martensitic Alloy Group 5 in a heat treated condition (HT) at 160 ksi minimum.

1.4 The values stated in inch-pound units are to be regarded as standard. No other units of measurement are included in this standard.

1.5 The following precautionary caveat pertains only to the test method portion, Section 13, of this specification: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

## 2. Referenced Documents

### 2.1 ASTM Standards:<sup>2</sup>

[A262 Practices for Detecting Susceptibility to Intergranular Attack in Austenitic Stainless Steels](#)

[A342/A342M Test Methods for Permeability of Weakly Magnetic Materials](#)

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<sup>1</sup> This specification is under the jurisdiction of ASTM Committee F16 on Fasteners and is the direct responsibility of Subcommittee F16.04 on Nonferrous Fasteners.

Current edition approved Nov. 1, 2013. Published December 2013. Originally approved in 1988. Last previous edition approved in 2008 as F837–08. DOI: 10.1520/F0837-13E01.

<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

[A380 Practice for Cleaning, Descaling, and Passivation of Stainless Steel Parts, Equipment, and Systems](#)

[A555/A555M Specification for General Requirements for Stainless Steel Wire and Wire Rods](#)

[A751 Test Methods, Practices, and Terminology for Chemical Analysis of Steel Products](#)

[A967 Specification for Chemical Passivation Treatments for Stainless Steel Parts](#)

[D3951 Practice for Commercial Packaging](#)

[E18 Test Methods for Rockwell Hardness of Metallic Materials](#)

[E92 Test Method for Vickers Hardness of Metallic Materials \(Withdrawn 2010\)<sup>3</sup>](#)

[E384 Test Method for Knoop and Vickers Hardness of Materials](#)

[F606 Test Methods for Determining the Mechanical Properties of Externally and Internally Threaded Fasteners, Washers, Direct Tension Indicators, and Rivets](#)

[F788/F788M Specification for Surface Discontinuities of Bolts, Screws, and Studs, Inch and Metric Series](#)

[F1470 Practice for Fastener Sampling for Specified Mechanical Properties and Performance Inspection](#)

### 2.2 ASME Standard:

[ASME B18.3 Socket Cap, Shoulder, and Set Screws—Inch Series<sup>4</sup>](#)

### 2.3 JIS Standard:

[JIS G 4311 Heat Resisting Steel Bar and Wire Rods<sup>4</sup>](#)

## 3. Classification

3.1 The austenitic stainless steel socket head cap screw shall be designated F837 Group 1 or 2 Condition AF, F837 Group 1 or 2 Condition CW, or F837 Group 1 or 2 Condition CW1.

3.2 The martensitic stainless steel socket head cap screw shall be designated F837 Group 5 Condition HT.

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<sup>3</sup> The last approved version of this historical standard is referenced on [www.astm.org](http://www.astm.org).

<sup>4</sup> Available from Global Engineering Documents, 15 Inverness Way, East Englewood, CO 80112-5704, <http://www.global.ihs.com>.

\*A Summary of Changes section appears at the end of this standard

#### 4. Ordering Information

4.1 Orders for socket head cap screws under this specification shall include:

- 4.1.1 Quantity (number of pieces of each item).
- 4.1.2 Name of the item (socket head cap screws, SHCS).
- 4.1.3 Size (nominal diameter, thread pitch, thread class, screw length) or part number.
- 4.1.4 Alloy Group (see 7.1) and Condition (Group 1 or 2 AF, Group 1 or 2 CW, Group 1 or 2 CW1, or Group 5 HT).
- 4.1.5 ASTM specification and year of issue. When year of issue is not specified, fasteners shall be furnished to the latest issue.
- 4.1.6 Supplementary requirements, if any, (see S1 through S7).
- 4.1.7 Additional special requirements, if any, to be specified on the purchase order:
  - 4.1.7.1 Forming (see 5.1).
  - 4.1.7.2 Threading (see 5.2).
  - 4.1.7.3 Surface finish (see 11.1).
  - 4.1.7.4 Alloy selection (see 7.2).
  - 4.1.7.5 Test report (see 12.2).
  - 4.1.7.6 Additional testing (see 12.3).
  - 4.1.7.7 Inspection (see 14.1).
  - 4.1.7.8 Rejection (see 15.1).
  - 4.1.7.9 Certification (see 16.1).
  - 4.1.7.10 Special packaging requirements (see 18.3).
  - 4.1.7.11 Supplementary requirements as needed.

#### 5. Materials and Manufacture

5.1 *Heads*—Unless otherwise specified the head and socket recess of the screw may be hot forged, cold forged, or machined at the option of the manufacturer. Users requiring cold forged heads should specify Supplementary Requirements S6.

5.2 *Threads*—Unless otherwise specified, screws in sizes up to 1.00 in. inclusive and product lengths up to 6 in. inclusive, shall have threads formed by rolling, except by special agreement with the purchaser. Larger products may be rolled, cut, or ground at the option of the manufacturer.

#### 6. Heat Treatment

6.1 Austenitic alloys Group 1 or 2 Condition AF screws, following manufacture, shall be annealed by heating to 1900 ± 50°F to obtain maximum corrosion resistance and minimum permeability. The screws shall be held for a sufficient time at temperature and then cooled at a rate sufficient to prevent precipitation of the carbide and to provide the properties specified in Table 1.

6.2 When Condition CW or CW1 is specified, the austenitic alloys shall be annealed as specified in 6.1 generally by the raw material manufacturer, then cold worked to develop specific properties.

6.3 Martensitic alloy Group 5 Condition HT screws shall be hardened and tempered by heating to 1800 ± 50°F sufficient for austenitization, holding for at least ½ h, rapid air or oil quenching, reheating to 525°F minimum and holding for at least 1 h and then air cooling to provide the properties specified in Table 1.

#### 7. Chemical Properties

7.1 It is the intent of this specification that screws shall be ordered by alloy group and condition. The chemical composition of the screw material shall conform to the requirements of Table 2.

7.2 Unless otherwise specified in the inquiry and purchase order (see Supplementary Requirements S2) the choice of an alloy from within a group shall be at the discretion of the fastener manufacturer as required by their method of fastener fabrication and material availability. The specific alloy used by the manufacturer shall be clearly identified on all certification required in the purchase order and shall have chemical composition conforming to the limits specified in Table 2.

7.3 When chemical analysis is performed by the purchaser using finished fasteners representing each lot, the chemical contents obtained shall conform to the limits specified in Table 2 for the specific alloy. Chemical contents shall conform to the tolerances specified in Specification A555/A555M.

**TABLE 1 Mechanical Property Requirements**

Alloy Group	Condition	Alloy Mechanical Property Marking	Nominal Thread Diameter <sup>A</sup>	Full-Size Product		Machine Specimen			Core Hardness <sup>B</sup>	
				Tensile Strength, ksi	Minimum Extension <sup>C</sup>	Tensile Strength, ksi	Yield Strength, ksi	Minimum Elongation, %	Vickers	Rockwell
1	AF	F837A	0.060–1.500	85 max	0.6D	85 max	55 max	40	210 max	95 HRB max
1	CW	F837B	0.060–0.750	80 min	0.4D	80 min	40 min	25	150 min	50 HRA min
1	CW1	F837C	0.060–0.750	102 min	0.4D	87 min	65 min	20	220 min	59 HRA min
2	AF	F837D	0.060–1.500	85 max	0.6D	85 max	55 max	40	210 max	95 HRB max
2	CW	F837E	0.060–0.750	80 min	0.4D	80 min	40 min	25	150 min	50 HRA min
2	CW1	F837F	0.060–0.750	102 min	0.4D	87 min	65 min	20	220 min	59 HRA min
5	HT	F837G	0.060–0.190	180 min	...	...	...	...	350–423	36–43 HRC
5	HT	F837H	0.250–1.500	180 min	0.2D	160 min	120 min	12	350–423	36–43 HRC

<sup>A</sup> For CW and CW1 condition fasteners with nominal thread diameter larger than 0.750 in., the mechanical properties and marking shall be agreed upon between the user and manufacturer.

<sup>B</sup> Core hardness is only required when full-size product tensile testing cannot be accomplished.

<sup>C</sup> D denotes nominal thread size.

**TABLE 2 Chemical Requirements**

Alloy Group	UNS Designation	Alloy	Composition, % maximum except as shown								
			Carbon	Manganese	Phosphorus	Sulfur	Silicon	Chromium	Nickel	Copper	Molybdenum
Austenitic Alloys											
1	S30300	303 <sup>A</sup>	0.15	2.00	0.20	0.15 min	1.00	17.0 to 19.0	8.0 to 10.0	...	0.60 max <sup>B</sup>
1	S30400	304	0.08	2.00	0.045	0.030	1.00	18.0 to 20.0	8.0 to 10.5	1.00	...
1	S30403	304L	0.030	2.00	0.045	0.030	1.00	18.0 to 20.0	8.0 to 12.0	1.00	...
1	S30500	305	0.12	2.00	0.045	0.030	1.00	17.0 to 19.0	10.5 to 13.0	1.00	...
1	S38400	384	0.08	2.00	0.045	0.030	1.00	15.0 to 17.0	17.0 to 19.0	...	...
1	S20300	XM1 <sup>A</sup>	0.08	5.0 to 6.5	0.040	0.18 to 0.35	1.00	16.0 to 18.0	5.0 to 6.5	1.75 to 2.25	0.50 max <sup>B</sup>
1	S30430	18-9LW	0.10	2.00	0.045	0.030	1.00	17.0 to 19.0	8.0 to 10.0	3.00 to 4.00	...
1	S30433	302HQ	0.03	2.00	0.045	0.030	4.00	17.0 to 19.0	8.0 to 10.0	3.0 to 4.0	...
1	...	304J3 <sup>C</sup>	0.08	2.00	0.045	0.030	1.00	17.0 to 19.0	8.0 to 10.5	1.00 to 3.00	...
2	S31600	316	0.08	2.00	0.045	0.030	1.00	16.0 to 18.0	10.0 to 14.0	...	2.0 to 3.0
2	S31603	316L	0.03	2.00	0.045	0.030	1.00	16.0 to 18.0	10.0 to 14.0	...	2.0 to 3.0
Martensitic Alloys											
5	UNS41000	410	0.15	1.00	0.040	0.030	1.00	11.5 to 13.5	...	...	...

<sup>A</sup> Free machining grades are not recommended for forged product. These grades may be furnished only when approved by the purchaser.

<sup>B</sup> At manufacturer's option, determined only when intentionally added.

<sup>C</sup>304J3 from JIS standard G 4311.

7.3.1 In the event of discrepancy, a referee analysis as specified in 13.1 of samples for each lot shall be made in accordance with 12.3.1.

## 8. Mechanical Properties

8.1 Screws shall be tested in accordance with the mechanical testing requirements for the alloy group and condition nominal thread diameter, length, and specified minimum tensile strength as specified in Table 3 and shall meet the mechanical requirements specified for that product in Table 1.

8.2 For products on which both hardness and tension tests are performed, acceptance based on tensile requirements shall take precedence over low hardness readings (see Table 4).

## 9. Corrosion Resistance

### 9.1 Carbide Precipitation:

9.1.1 Rod, bar, and wire in the austenitic alloy groups 1 and 2 (not including the free-machining grade 303) used to make fasteners in accordance with this specification shall be capable of passing the test for susceptibility to intergranular corrosion as specified in Practice E of Practice A262.

9.1.2 As stated in Practices A262, samples may be subjected to the faster and more severe screening test in accordance with Practice A. Failing Practice A, specimens shall be tested to Practice E and be considered satisfactory if passing Practice E.

## 10. Dimensions

10.1 Unless otherwise specified, the products shall conform to the requirements of ASME B18.3.

## 11. Workmanship, Finish, and Appearance

11.1 *Surface Treatment*—Unless otherwise specified, screws shall be cleaned, descaled and passivated in accordance with Practice A380 or Specification A967 at the option of the manufacturer.

11.2 The surface discontinuities for these products shall conform to Specification F788/F788M and the additional limitations specified herein.

11.2.1 Forging defects that connect the socket to the periphery of the head are not permissible. Defects originating on the periphery and with a traverse indicating a potential to intersect are not permissible. Other forging defects are permissible provided those located in the bearing area, fillet, and top surfaces shall not have a depth exceeding 0.03 *D* or 0.005 in, whichever is greater. For peripheral discontinuities, the maximum depth may be 0.06 *D* (see Fig. 1).

11.2.2 Forging defects located in the socket wall within 0.1 times the actual key engagement, *T*, from the bottom of the socket are not permissible. Discontinuities located elsewhere in the socket shall not have a length exceeding 0.25 *T*, or a maximum depth of 0.03 *D* not to exceed 0.005 in. (see Fig. 2).

**TABLE 3 Mechanical Testing Requirements**

Item	Product Length	Hardness		Test Conducted Using Full Size Product		Test Conducted Using Machined Test Specification		
		max	min	Extension	Axial Tensile Strength	Yield Strength 0.2 % offset	Tensile Strength	Elongation
1	≤3 <i>D</i> <sup>A</sup>	<i>B</i>	<i>B</i>	...	<i>B</i>	...	...	...
2	>3 <i>D</i> -12 in.	<i>B</i>	...	<i>B</i>	<i>B</i>	...	...	...
3	Over 12 in.	<i>B</i>	...	A	A	B	B	B

<sup>A</sup> *D* denotes nominal diameter of product.

<sup>B</sup> Denotes mandatory test. In addition, either all tests denoted by A or all tests denoted by B shall be performed. In case of arbitration full size tests, denoted A, shall be decisive.

**TABLE 4 Tensile Strength Values for Full-Size Fasteners, lbs**

Nominal Size	Stress Area	Alloy Groups 1 and 2			Alloy Group 5
		AF max	CW min	CW1 min	HT min
0.060-80	0.00180	153	144	183	288
0.073-64	0.00263	223	210	267	420
0.073-72	0.00278	236	222	283	444
0.086-56	0.00370	314	296	377	592
0.086-64	0.00394	334	315	401	630
0.099-48	0.00487	414	390	497	779
0.099-56	0.00523	445	418	533	837
0.112-40	0.00604	513	483	615	966
0.112-48	0.00661	562	529	674	1 060
0.125-40	0.00796	676	636	811	1 270
0.125-44	0.00830	706	665	848	1 330
0.138-32	0.00909	772	727	927	1 450
0.138-40	0.01015	862	811	1 035	1 620
0.164-32	0.0140	1 191	1 121	1 429	2 240
0.164-36	0.01474	1 252	1 178	1 502	2 360
0.190-24	0.0175	1 490	1 403	1 788	2 800
0.190-32	0.0200	1 699	1 600	2 039	3 200
0.250-20	0.0318	2 705	2 546	3 246	5 090
0.250-28	0.0364	3 092	2 910	3 710	5 820
0.312-18	0.0524	4 457	4 194	5 348	8 380
0.312-24	0.0580	4 936	4 645	5 923	9 280
0.375-16	0.0775	6 587	6 199	7 904	12 400
0.375-24	0.0878	7 465	7 026	8 958	14 000
0.437-14	0.1063	9 036	8 505	10 843	17 000
0.437-20	0.1187	10 091	9 497	12 109	19 000
0.500-13	0.1419	12 061	11 352	14 474	22 700
0.500-20	0.1599	13 596	12 796	16 315	25 600
0.625-11	0.226	19 210	18 080	23 052	36 200
0.625-18	0.256	21 756	20 477	26 108	41 000
0.750-10	0.334	28 429	26 757	34 115	53 400
0.750-16	0.373	31 702	29 837	38 042	59 700
0.875-9	0.462	39 247	...	...	73 900
0.875-14	0.509	43 305	...	...	81 400
1.000-8	0.606	51 488	...	...	97 000
1.000-12	0.663	56 359	...	...	106 000
1.125-7	0.763	64 878	...	...	122 000
1.125-12	0.856	72 736	...	...	137 000
1.250-7	0.969	82 374	...	...	155 000
1.250-12	1.073	91 200	...	...	172 000
1.375-6	1.155	98 165	...	...	185 000
1.375-12	1.315	111 751	...	...	210 000
1.500-6	1.405	119 446	...	...	225 000
1.500-12	1.581	134 387	...	...	253 000

11.2.3 Seams in the shank shall not exceed a depth of 0.03 *D* or 0.008 in., whichever is greater.

11.2.4 No transverse discontinuities shall be permitted in the head-to-shank fillet area.

11.2.5 Threads shall have no laps at the root or on the flanks located below the pitch line. Laps are permitted at the crests (Fig. 3) that do not exceed 25 % of the basic thread depth, and on the flanks outside the pitch cylinder. Longitudinal seams rolled beneath the root of the thread and across the crests of cut threads are acceptable within the limits of 11.2.3.

## 12. Number of Tests

12.1 The requirements of this specification shall be met in continuous mass production for stock, and the manufacturer shall make sample inspections to ensure that the product conforms to the specified requirements. Additional tests of individual shipments of fasteners are not ordinarily necessary. A record of the individual heat of steel in each lot shall be maintained. The containers shall be coded to permit identification of the lot.

12.2 When specified in the purchase order, the manufacturer shall furnish a test report of the last complete set of chemical analysis and mechanical tests for each stock size in each shipment.

12.3 When tests of individual shipments are required, Supplementary Requirement S1 must be specified in the inquiry and order.

12.3.1 When the purchaser does not specify the sampling plan and basis of acceptance, the following shall apply:

12.3.1.1 The lot, for purposes of selecting samples, shall consist of all products offered for inspection and testing, at one time, that are the same type, style, nominal diameter, thread pitch, nominal length, material (alloy), condition, and surface finish.

12.3.1.2 From each lot, samples shall be selected at random and tested for each requirement in accordance with the following plan:

Number of Pieces in Lot	Number of Samples
800 and less	1
Over 800 to 8000, incl	2
Over 8000 to 22 000, incl	3
Over 22 000	5

12.3.1.3 Should any sample fail to meet the requirements of a specified test, double the number of samples from the same lot shall be retested for the requirement(s) in which it failed. All of the additional samples shall conform to the specification or the lot shall be rejected.

12.3.1.4 If the failure of a test specimen is due to improper preparation of the specimen or an incorrect testing technique, the specimen shall be discarded and another test specimen submitted.

## 12.4 Corrosion Resistance Tests:

12.4.1 Unless otherwise specified, inspection for corrosion resistance shall be in accordance with the manufacturer's standard quality control practices. No specific method of inspection is required, but the screws shall be produced from suitable raw material and manufactured by properly controlled practices to maintain resistance to corrosion. When corrosion tests are required, Supplementary Requirement S7 must be specified in the inquiry and order, except as noted in 12.4.2.

12.4.2 Products that have been hot worked shall be solution annealed and tested to determine freedom from precipitated carbides. Not less than one corrosion test shall be made from each lot. Corrosion test shall be performed in accordance with Practice A262, Practices A or E as applicable.

## 13. Test Methods

13.1 *Chemical Analysis*—The chemical composition shall be determined in accordance with Test Method A751.

13.1.1 The fastener manufacturer may accept the chemical analysis of each heat of raw material purchased and reported on the raw material certification furnished by the raw material producer. The fastener manufacturer is not required to do any further chemical analysis testing, provided that precise heat lot traceability has been maintained throughout the manufacturing process on each lot of fasteners produced and delivered.

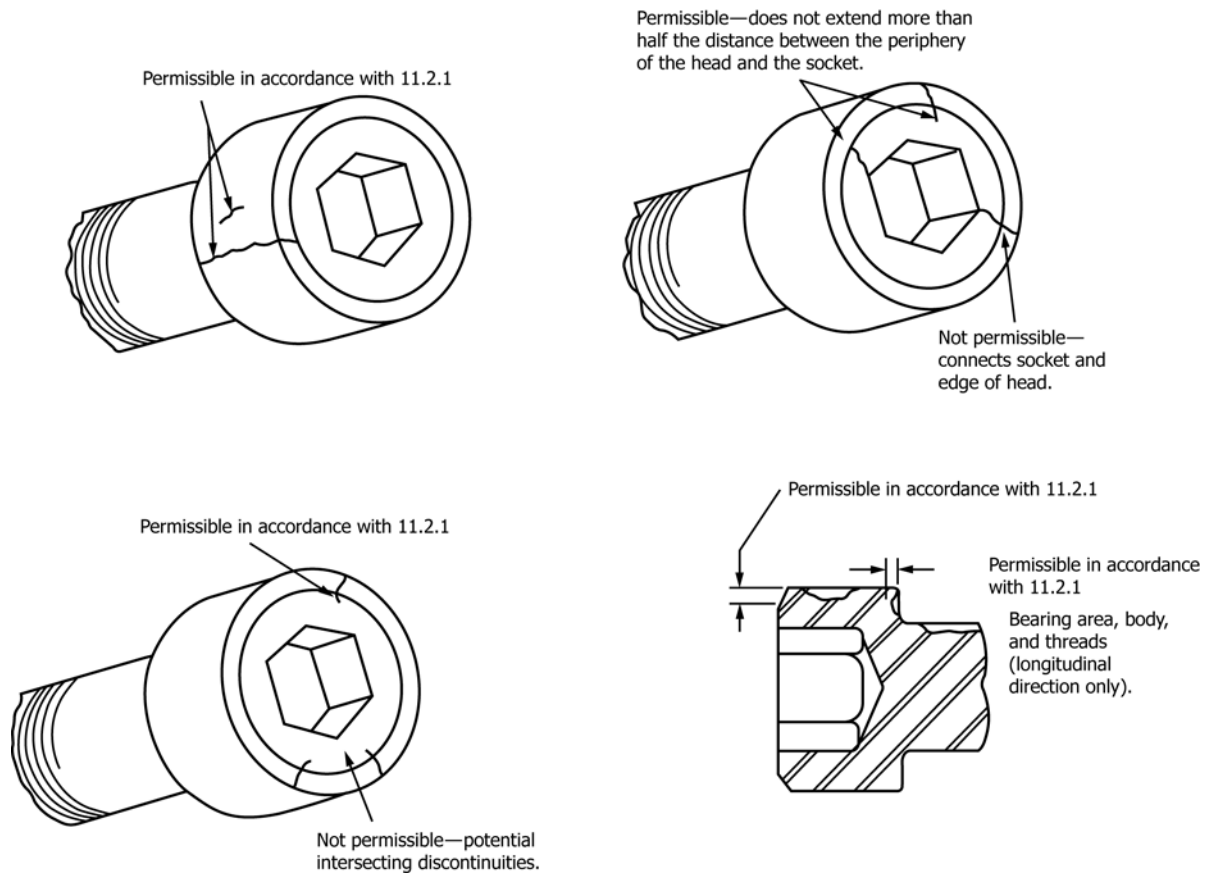


FIG. 1 Head and Body Discontinuity Location and Limits

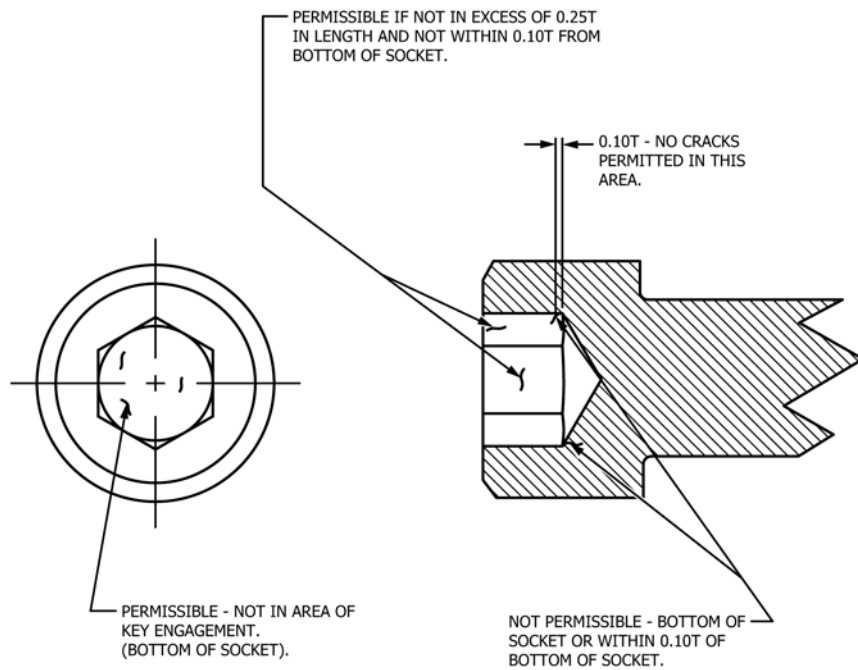


FIG. 2 Socket Discontinuity Location and Limits

13.2 Mechanical Tests:

13.2.1 Screws tested full size for axial strength, screw extension, and hardness shall be tested in accordance with the

methods described in Test Methods F606 and of this specification. The hardness shall be determined using Test Methods E18, E92, or Test Method E384, as appropriate.

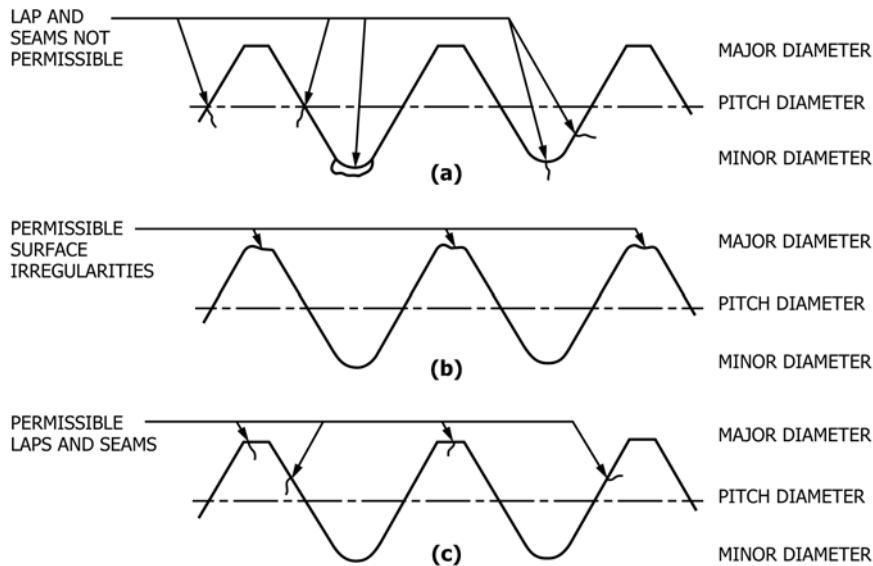


FIG. 3 Thread Discontinuities

13.2.2 Machined test specimens tested for tensile strength, yield strength at 0.2 % offset, and elongation shall be tested in accordance with the methods described in Test Methods F606.

13.2.3 Extension Test is applicable only to full size products. The overall length of the test specimen ( $L_1$ ) shall be measured within  $\pm 0.005$  in. The head and reference surface for length measurement may be the bottom of the hex socket for measuring purposes. The specimen shall be assembled into a threaded adapter to a depth of one nominal diameter and then axial tensile tested in accordance with 13.2.1 to failure. The two broken pieces shall be fitted closely together and the overall length ( $L_2$ ) measured again. The total extension shall be computed by subtracting the original overall length from the length following fracture (Fig. 4). The product is acceptable

when the extension equals or exceeds the minimum value for extension specified in Table 1.

13.3 Corrosion Resistance—When specified on the purchase order or inquiry, corrosion tests to determine freedom from precipitated carbides shall be performed in accordance with Practices A262, Practice A or E as applicable.

**14. Inspection**

14.1 If the inspection described in 14.1 is required by the purchaser, it shall be specified in the inquiry, order, or contract.

14.2 The inspector representing the purchaser shall have free entry to all parts of the manufacturer’s works that concern the manufacture of the material ordered. The manufacturer shall afford the inspector all reasonable facilities to satisfy that the material is being furnished in accordance with this specification. All tests and inspection required by the specification that are requested by the purchaser’s representative and purchase order shall be made prior to shipment, and shall be so conducted as not to interfere unnecessarily with the operation of the work.

**15. Rejection and Rehearing**

15.1 Screws that fail to conform to the requirements of this specification may be rejected by the purchaser. Rejection shall be reported to the supplier promptly and in writing. In case of dissatisfaction with the results of tests or inspection authorized by the purchaser, the supplier may claim for a rehearing.

**16. Certification**

16.1 Test Report— The manufacturer shall maintain on file for a period of 5 years, the original test report, including a copy of the certified chemical analysis of the heat of material used and the results of the required testing for the lot of fasteners.

16.2 Manufacturer’s Certificate of Conformance—The manufacturer shall maintain on file for a period of 5 years, a certificate indicating that the lot of fasteners was manufactured

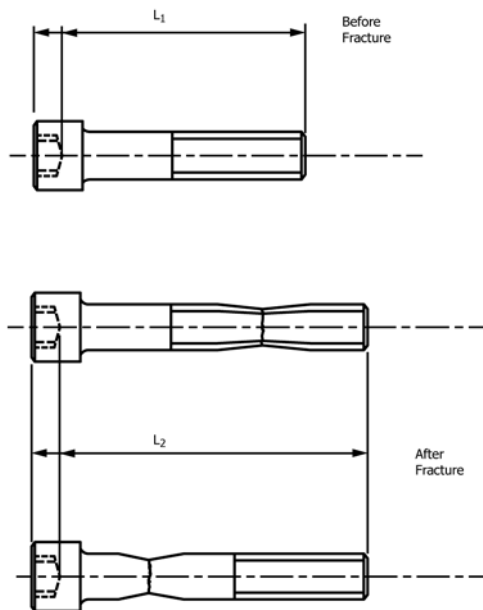


FIG. 4 Comparison of Overall Length Before and After Fracture

and tested in accordance with this specification and conforms to all specified requirements.

16.3 When requested by the purchaser, submission of copies of the test report, manufacturer's certificate, or an extension of the 5-year document retention period shall be performed as agreed between the manufacturer and the purchaser at the time of the inquiry or order.

## 17. Product Marking

17.1 *Individual Products*—All products  $\frac{1}{4}$  in. diameter and larger, shall be marked with a symbol to identify the manufacturer. In addition, they shall be marked with the alloy/mechanical property marking in accordance with [Table 1](#). The manufacturer may at their opinion add the specific stainless alloy designation from [Table 2](#). The marking shall be raised or depressed at the option of the manufacturer.

## 18. Packaging and Package Marking

18.1 Unless otherwise specified packaging shall be in accordance with Practice [D3951](#).

18.2 When special packaging requirements are required by the purchaser, they shall be defined at the time of inquiry and order.

18.3 *Package Marking*—Each shipping unit shall include or be plainly marked with the following:

18.3.1 ASTM specification,

18.3.2 Alloy group and condition,

18.3.3 Alloy number,

18.3.4 Size,

18.3.5 Name and brand or trademark of the manufacturer,

18.3.6 Country of origin,

18.3.7 Number of pieces, and

18.3.8 Purchase order number.

## 19. Keywords

19.1 corrosion resistant; stainless steel; socket head cap screws

## SUPPLEMENTARY REQUIREMENTS

The following supplementary requirements shall apply only when specified by the purchaser in the contract or order. Details of these supplementary requirements shall be agreed upon in writing between the manufacturer and purchaser. Supplementary requirements shall in no way negate any requirement of the specification itself.

### S1. Shipment Lot Testing

S1.1 When Supplementary Requirement S1 is specified on the order, the manufacturer shall make sample tests on the individual lots for shipment to ensure that the product conforms to the specified requirements.

S1.2 The manufacturer shall make an analysis of a randomly selected finished fastener from each lot of product to be shipped. Heat or lot control shall be maintained. The analysis of the starting material from which fasteners have been manufactured may be reported in place of the product analysis.

S1.3 The manufacturer shall perform mechanical property tests in accordance with this specification and Guide [F1470](#) on the individual lots for shipment.

S1.4 The manufacturer shall furnish a test report for each lot in the shipment showing the actual results of the chemical analysis and mechanical property tests performed in accordance with Supplementary Requirement S1.

### S2. Alloy Control

S2.1 When Supplementary Requirement S2 is specified on the inquiry and order, the manufacturer shall supply that alloy specified by the customer on the order with no group substitutions permitted without the written permission of the purchaser.

### S3. Permeability

S3.1 When Supplementary Requirement S3 is specified on the inquiry and order, the permeability of Group 1 or 2 condition AF screws shall not exceed 1.05 at 100 oersteds

when determined by Test Method [A342/A342M](#). Screws in Group 1 or 2 condition CW or CW1 may not be capable of meeting permeability and strength requirements simultaneously. Consultation with the raw material manufacturer should be considered for critical permeability requirements.

### S4. Material Identification

S4.1 When Supplementary Requirement S4 is specified on the inquiry and order, the fasteners shall be marked with the specific alloy number to identify the material in accordance with the purchaser's instructions.

### S5. Manufacturer Identification

S5.1 When Supplementary Requirement S5 is specified on the inquiry and order for nominal sizes  $\frac{1}{4}$  (0.250) in. and larger, the fasteners shall be marked with the manufacturer's insignia. The manufacturer's identification insignia shall be of the design, placed on the side or top of the head and recognizable to the purchaser. The insignia shall be readable with no greater than 10× magnification.

### S6. Forged Heads

S6.1 When Supplementary Requirement S6 is specified on the inquiry and order, screw heads shall be cold forged by upset, extrusion, or both. The hexagon socket may be forged or machined at the manufacturer's option. This requirement may be inappropriate for large sizes.

## S7. Corrosion Resistance Tests

S7.1 When Supplementary Requirement S7 is specified on the inquiry and order, corrosion test(s) shall be performed as agreed between the manufacturer and the purchaser at the time of the inquiry or order.

## S8. Passivation

S8.1 When Supplementary Requirement S8 is specified on the inquiry and order, the finished product shall be passivated in accordance with Specification **A380**.

## S9. Mechanical Property Requirements

S9.1 When Supplementary Requirement S9 is specified on the inquiry or order, the finished product shall have been tested to and be capable of meeting the mechanical requirements as listed in S9 (**Table S9.1**). These mechanicals were in effect prior to the Specification F837–02a revision and are necessary to support designs based upon those mechanical properties.

**TABLE S9.1 S9 Mechanical Property Requirements**

Alloy Group	Condition	Nominal Diameter	Full Sized Product		Mechanical Specimen				Hardness		
			Tensile Strength, ksi	Extension, min	Tensile Strength, ksi	Yield Strength, ksi	Elongation, %	Vickers, min.	max	Rockwell, min.	max
	CW	0.060–0.625	95 min	0.4D	90 min	30 min	10	159	330	B80	C33
		0.750–1.500	70 min <sup>†</sup>	0.2D	70 min	26 min	20	157	310	B74	C30

<sup>†</sup> Editorially corrected in March 2014.

## SUMMARY OF CHANGES

Committee F16 has identified the location of selected changes to this standard since the last issue (F837–08) that may impact the use of this standard.

- (1) **Table 2**—added chemistry composition to Alloy Group 1.      (3) Added Supplemental Requirement S9.  
 (2) Corrected Supplemental Requirement references in **12.4.1**,  
**S5.1**, **S6.1**, **S7.1**, and **S8.1**.

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