



## BSI Standards Publication

**Aerospace — Nuts, hexagonal, slotted (castellated), reduced height, normal across flats, with MJ threads, classifications: 450 MPa (at ambient temperature)/120 °C, 450 MPa (at ambient temperature)/235 °C, 600 MPa (at ambient temperature)/425 °C, 900 MPa (at ambient temperature)/235 °C, 900 MPa (at ambient temperature)/315 °C, 900 MPa (at ambient temperature)/650 °C, 1 100 MPa (at ambient temperature)/235 °C, 1 100 MPa (at ambient temperature)/730 °C and 1 250 MPa (at ambient temperature)/600 °C —**

**National foreword**

This British Standard is the UK implementation of ISO 9618:2016. It supersedes BS A 315:1997 which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee ACE/12, Aerospace fasteners and fastening systems.

A list of organizations represented on this committee can be obtained on request to its secretary.

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Published by BSI Standards Limited 2016

ISBN 978 0 580 86450 6

ICS 49.030.30

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This British Standard was published under the authority of the Standards Policy and Strategy Committee on 31 March 2016.

**Amendments/corrigenda issued since publication**

Date	Text affected
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*Aéronautique et espace — Écrous hexagonaux à créneaux, hauteur réduite, surplats normaux, à filetage MJ, classifications: 450 MPa (à température ambiante)/120 °C, 450 MPa (à température ambiante)/235 °C, 600 MPa (à température ambiante)/425 °C, 900 MPa (à température ambiante)/235 °C, 900 MPa (à température ambiante)/315 °C, 900 MPa (à température ambiante)/650 °C, 1 100 MPa (à température ambiante)/235 °C, 1 100 MPa (à température ambiante)/730 °C et 1 250 MPa (à température ambiante)/600 °C — Dimensions*



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## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

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For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: [Foreword - Supplementary information](#).

The committee responsible for this document is ISO/TC 20, *Aircraft and space vehicles*, Subcommittee SC 4, *Aerospace fastener systems*.

This second edition cancels and replaces the first edition (ISO 9618:1996), of which it constitutes a minor revision.

## Introduction

The dimensions specified in this International Standard have been determined to satisfy the requirements of the procurement specification which will be the subject of a future International Standard.





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## **1 Scope**

This International Standard specifies the dimensions of hexagon slotted (castellated) nuts, reduced height, normal across flats, with MJ threads, of classifications: 450 MPa/120 °C, 450 MPa/235 °C, 600 MPa/425 °C, 900 MPa/235 °C, 900 MPa/315 °C, 900 MPa/650 °C, 1 100 MPa/235 °C, 1 100 MPa/730 °C, and 1 250 MPa/600 °C.

NOTE 1 450 MPa, 600 MPa, 900 MPa, 1 100 MPa and 1 250 MPa corresponds to the minimum tensile stress which the nut is able to withstand at ambient temperature without breaking or cracking when tested with a bolt of a higher strength class.

NOTE 2 120 °C, 235 °C, 425 °C, 315 °C, 650 °C, 730 °C and 600 °C corresponds to the maximum temperature that the nut is able to withstand without permanent alteration to its original characteristics, after ambient temperature has been restored. The maximum temperature is conditioned by the surface treatment.

These nuts are intended to be used with split pins in conformity with ISO 1234.

This International Standard is applicable for the compilation of aerospace product standards.

## **2 Normative references**

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

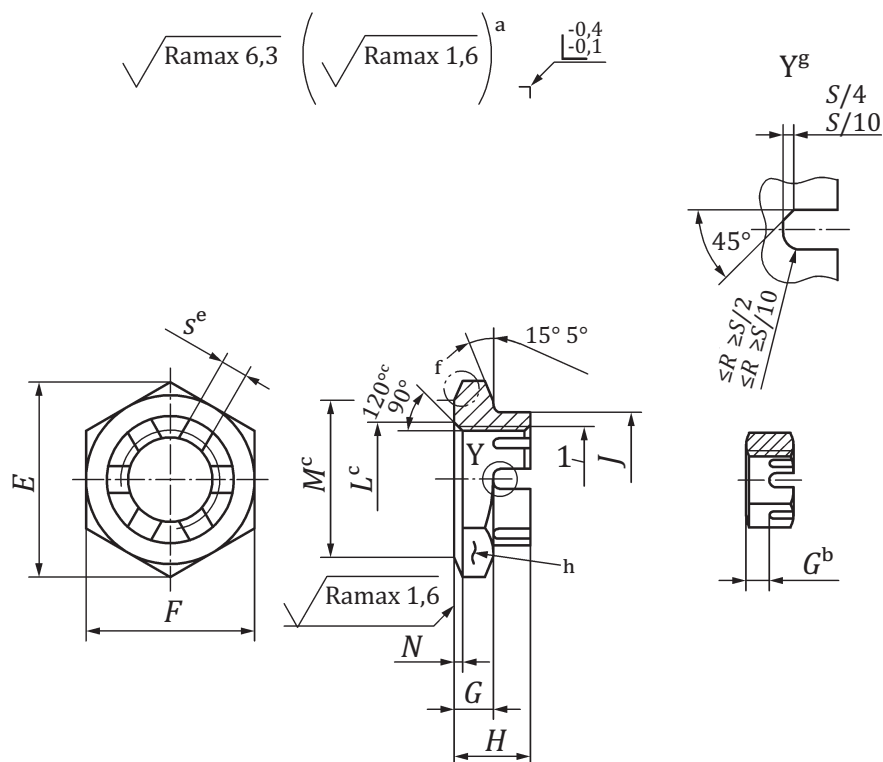
ISO 1234, *Split pins*

ISO 5855-2, *Aerospace — MJ threads — Part 2: Limit dimensions for bolts and nuts*

ISO 8788, *Aerospace — Nuts, metric — Tolerances of form and position*

## **3 Configuration and dimensions**

See [Figure 1](#) and [Table 1](#). Dimensions and tolerances are expressed in millimetres. They apply after any surface coating(s) but before the application of any lubricant.



**Key**

- a These values, in micrometres, apply before any surface coating(s) is/are applied. The values do not apply to threads the surface texture of which will be as achieved by the usual manufacturing methods
- b Applies to height below slots and height of flats (diameter codes 060 to 240).
- c This dimension also applies to the upper chamfer. All forms of entry (chamfer or radius) permissible within these limiting dimensions.
- d Diameter  $M$  may be tangential to, but shall not intrude on the flats.
- e 6 slots.
- f Form of contour within limiting dimensions at manufacturer's option
- g (4:1) Form (radius or chamfer) at bottom of slot at manufacturer's option.

NOTE Tolerances of form and position shall conform to those specified in ISO 8788. Details of form not stated are at the manufacturer's discretion.

**Figure 1 — Configurations and dimensions**

**Table 1 — Dimensions**

Dimensions in millimetres

Diameter code	Thread <sup>a</sup>	E	F	G	H	J	L	M	N	S	Maximum split pin diameter <sup>b</sup>
040	MJ4 × 0,7 – 4H6H	7,6	h12	2,1	4,1	—	4,2	6,4	0 −0,3	H14	1,0
050	MJ5 × 0,8 – 4H6H	8,7		8	2,4	4,8	—	5,2			
060	MJ6 × 1 – 4H5H	10,9	h13	3,0	5,4	9	6,3	9,3	0,5	1,7	1,4
070	MJ7 × 1 – 4H5H	12,0			11	5,8	10	7,3			
080	MJ8 × 1 – 4H5H	14,3	13	3,2	6,0	11	8,3	12,2	2,1	1,8	
100	MJ10 × 1,25 – 4H5H	18,9	17	4,0	7,6	13	10,3	16,0			
120	MJ12 × 1,25 – 4H5H	21,1	19	4,8	8,4	16	12,3	18,0	2,6	2,3	
140	MJ14 × 1,5 – 4H5H	24,5	22	5,6	10,0	18	14,4	21,0			
160	MJ16 × 1,5 – 4H5H	26,8	24	6,4	10,8	22	16,4	23,0	0,6	3,2	2,9
180	MJ18 × 1,5 – 4H5H	30,2	27	7,2	12,4	25	18,4	26,0			
200	MJ20 × 1,5 – 4H5H	33,6	30	8,0	13,2	28	20,4	29,0	4,0	3,7	
220	MJ22 × 1,5 – 4H5H	35,8	32	8,8	14,0	30	22,4	30,9			
240	MJ24 × 2 – 4H5H	40,4	36	9,6	14,8	32	24,5	34,9			

<sup>a</sup> In accordance with ISO 5855-2.

<sup>b</sup> For information, in conformity with ISO 1234 for the split pin maximum diameter but not for the split pin maximum diameter/thread diameter combination.





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