
**Aerospace — Internal six-lobe drives —
Metric series**

Aéronautique et espace — Empreintes six lobes — Série métrique



Reference number
ISO 12257:2008(E)

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Published in Switzerland

Foreword

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International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 12257 was prepared by Technical Committee ISO/TC 20, *Aircraft and space vehicles*, Subcommittee SC 4, *Aerospace fastener systems*.

Aerospace — Internal six-lobe drives — Metric series

1 Scope

This International Standard specifies the dimensions of metric internal six-lobe drives used in metric screws in nominal thread diameter range 3 mm to 20 mm.

NOTE Pending publication of an International Standard relating to limit gauges, special care is required to ensure that the dimensions and tolerances specified in this International Standard are confirmed by alternative means.

2 Normative references

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

ISO 1101, *Geometrical Product Specifications (GPS) — Geometrical tolerancing — Tolerances of form, orientation, location and run-out*

3 Configuration and dimensions

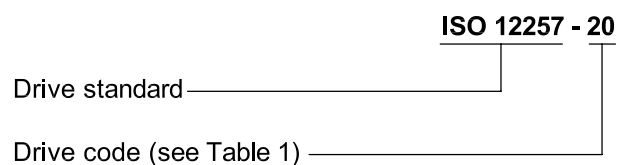
See Figure 1 and Table 1.

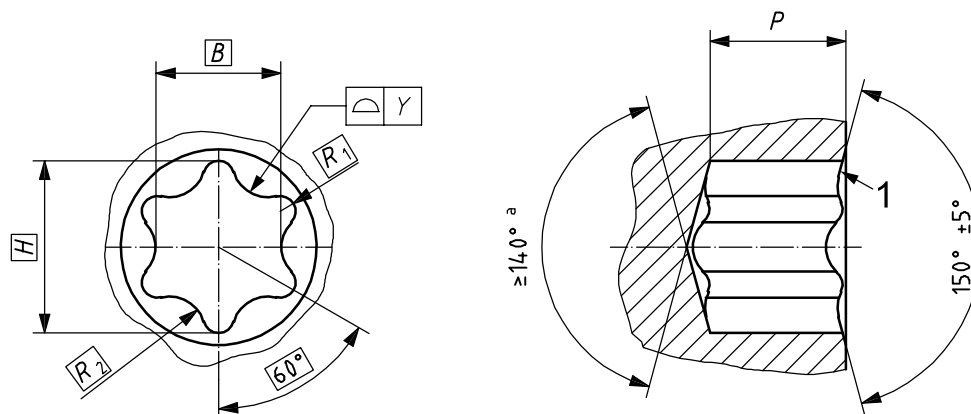
Dimensions and tolerances are expressed in millimetres.

The presentation of this International Standard conforms to ISO 1101.

4 Designation

The drive designation shall be as follows:





Key

- 1 chamfer (optional)
- a Shape optional.

Figure 1

Table 1

Dimensions in millimetres

Drive code	<i>B</i>	<i>H</i>	<i>P</i>	<i>R</i> ₁	<i>R</i> ₂	<i>Y</i>
06	1,27	1,75	According to bolt head, see product standard	0,16	0,36	0,025
07	1,5	2,07		0,18	0,42	
08	1,75	2,4		0,22	0,49	
09	1,85	2,6		0,23	0,53	
10	2,05	2,8		0,25	0,57	
15	2,4	3,35		0,3	0,69	
20	2,85	3,95		0,33	0,83	0,035
25	3,25	4,5		0,4	0,89	
27	3,65	5,1		0,42	1,08	
30	4,05	5,6		0,48	1,16	0,05
40	4,85	6,75		0,58	1,4	
45	5,64	7,93		0,61	1,76	
50	6,45	8,95		0,81	1,78	0,06
55	8,05	11,35		0,96	2,62	
60	9,6	13,45		1,12	2,83	

ICS 49.030.20

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