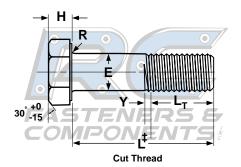
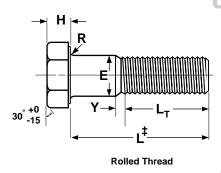
Cap Screws & Bolts

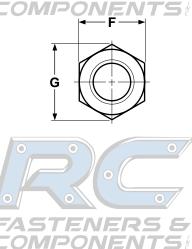
Head and Thread Dimensions

A325 & A490 Structural Bolts

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‡Length of a structural bolt is measured from the underhead bearing surface to the extreme end of the bolt.

			• e	TRUCT	URAL	BOLT	s, A3	25 &	A490					ASM	E 18.2.6- 1996
			° È					G		Н		R		L _T	Y
Nominal Size or Basic Product Diameter		Body Diameter		Width Across Flats			Width Across Corners		Head Height		Radius of Fillet		Thread Length	Transi- tion Thread Length	
		Max	Min	Basic	Max	Min	Max	Min	Basic	Max	Min	Max	Min	Ref	Max, Ref
1/2	0.5000	0.515	0.482	7/8	0.875	0.850	1.010	0.969	5/16	0.323	0.302	0.031	0.009	1.00	0.19
5/8	0.6250	0.642	0.605	1-1/16	1.062	1.031	1.227	1.175	25/64	0.403	0.378	0.062	0.021	1.25	0.22
3/4	0.7500	0.768	0.729	1-1/4	1.250	1.212	1.443	1.383	15/32	0.483	0.455	0.062	0.021	1.38	0.25
7/8	0.8750	0.895	0.852	1-7/16	1.438	1.394	1.660	1.589	35/64	0.563	0.531	0.062	0.031	1.50	0.28
1	1.0000	1.022	0.976	1-5/8	1.625	1.575	1.876	1.796	39/64	0.627	0.591	0.093	0.062	1.75	0.31
1 1/8	1.1250	1.149	1.098	1-13/16	1.812	1.756	2.093	2.002	11/16	0.718	0.658	0.093	0.062	2.00	0.34
1 1/4	1.2500	1.277	1.223	2	2.000	1.938	2.309	2.209	25/32	0.813	0.749	0.093	0.062	2.00	0.38
1 3/8	1.3750	1.404	1.345	2-3/16	2.188	2.119	2.526	2.416	27/32	0.878	0.810	0.093	0.062	2.25	0.44
1 1/2	1.5000	1.531	1.470	2-3/8	2.375	2.300	2.742	2.622	15/16	0.974	0.902	0.093	0.062	2.25	0.44
0	<u> </u>	<u> 1PO</u>	NE	NTS								(0
Tolerance on Length			Nominal Screw Size			Nominal Screw Length									
						Through 6 in.				Over 6 in.					
			1/2			-0.12				-0.19					
			5/8			-0.12					FASTE 0.25 DS E				
			3/4 through 1			-0.19					-0.25				
			1 1/8 through 1 1/2			-0.25					-0.25				



Mechanical & Performance Data

Bolts & Cap Screws

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FASTENERS

COMPONENT

OMPONEN



A490

ASTM A325 BOLTS, Type 1

Description	A heavy hex bolt made of medium carbon steel. The bearing surface shall be flat and washer faced, and the point is chamfered					
Applications/ Advantages	Commonly used in structural steel joints in heavy construction.					
Material	Type 1 bolts shall be made from a carbon steel which conforms to the following chemical composition requirements Carbon: 0.25-0.58%; Manganese: 0.57% minimum; Phosphorus: 0.048% maximum; Sulfur: 0.058% maximum					
Heat Treatment	Type 1 bolts shall be heat treated by quenching in a liquid medium from above the austenitizing temperature and then tem reheating to a temperature of at least 800°F.					
Hardness	1/2" through 1" diameter, inclusive: Rockwell C24 - 35 1-1/8" through 1-1/2" diameter, inclusive: Rockwell C19 - 31					
Proof Load	1/2" through 1" diameter, inclusive: 85,000 psi. 1-1/8" through 1-1/2" diameter, inclusive: 74,000 psi.					
Yield Strength	1/2" through 1" diameter, inclusive: 92,000 psi. minimum 1-1/8" through 1-1/2" diameter, inclusive: 81,000 psi. minimum					
Tensile Strength	1/2" through 1" diameter, inclusive: 120,000 psi. minimum 1-1/8" through 1-1/2" diameter, inclusive: 105,000 psi. minimum					
Plating	See Appendix-A for plating information.					



Type_1	Type 3
Description	A heavy hex bolt made of alloy steel. The bearing surface shall be flat and washer-faced, and the point is chamfered.
Applications/ Advantages	Used in structural steel joints in heavy construction when greater yield and tensile strengths than those of an A325 bolt are required. A Type 3 bolt is approximately twice as resistant to corrosion as a Type 1 bolt.
Material	Type 1 bolts shall be made from an alloy steel which conforms to the following chemical composition requirements <i>Carbon:</i> 0.28-0.50% (for 1-1/2" diameter: 0.33-0.55%); <i>Phosphorus:</i> 0.045% maximum; <i>Sulfur:</i> 0.045% maximum. Type 3 bolts shall be made from a corrosion resistant steel which conforms to the following chemical composition requirements <i>Carbon:</i> 0.19-0.55%; <i>Manganese:</i> 0.37% minimum; <i>Phosphorus:</i> 0.045% maximum; <i>Sulfur:</i> 0.055% maximum; <i>Copper:</i> 0.63% maximum; <i>Chromium:</i> 0.42% minimum; <i>Nickel:</i> 0.17% minimum; <i>Molybdenum:</i> 0.14% minimum.
Heat Treatment	Type 1 bolts shall be heat treated by quenching in oil from above the transformation temperature. Type 3 bolts shall be quenched in a suitable liquid from above the transformation temperature. Type 1 and Type 3 bolts shall be tempered by reheating to a temperature of at least 800°F.
Hardness	Rockwell C33 - 38
Proof Load	120,000 psi.
Yield Strength	130,000 psi. minimum
Tensile Strength	0 150,000 - 170,000 psi.
Plating	See Appendix-A for plating information.

** Product standards require the manufacturer's head marking to appear on the top of all cap screws 1/4" diameter and larger. "X" represents one location such a marking may appear.

Please contact us at: (623) 516-1551 | www.rcfastener.com | sales@rcfastener.com