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FOREIGN TECHNOLOGY DIV WRIGHT-PATTERSON AFB OHIO
DEEP COUNTERSUNK HEAD BOLTS (STANDARD PRECISION) SIZES.(U)
SEP 78

F/G 11/5

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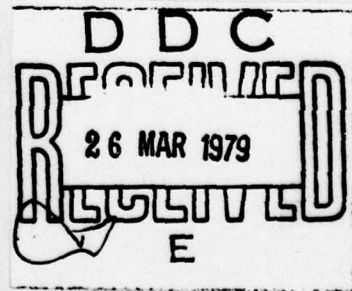
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FOREIGN TECHNOLOGY DIVISION



DEEP COUNTERSUNK HEAD BOLTS (STANDARD PRECISION). Sizes



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EDITED TRANSLATION

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28 September 1978

MICROFICHE NR: *FD-78-C-001318*

DEEP COUNTERSUNK HEAD BOLTS (STANDARD PRECISION).
SIZES

English pages: 5

Source: USSR State Standard GOST 7787-62

Country of Origin: USSR

Translated by: Marilyn Olaechea

Requester: ASD/ENFSS

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NTIS	White Section <input checked="" type="checkbox"/>
DDC	Buff Section <input type="checkbox"/>
UNANNOUNCED	<input type="checkbox"/>
JUSTIFICATION _____	
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DISTRIBUTION/AVAILABILITY CODES	
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WP-afb, OHIO.

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Date 28 Sept 19 78

U. S. BOARD ON GEOGRAPHIC NAMES TRANSLITERATION SYSTEM

Block	Italic	Transliteration	Block	Italic	Transliteration
А а	А а	A, a	Р р	Р р	R, r
Б б	Б б	B, b	С с	С с	S, s
В в	В в	V, v	Т т	Т т	T, t
Г г	Г г	G, g	У у	У у	U, u
Д д	Д д	D, d	Ф ф	Ф ф	F, f
Е е	Е е	Ye, ye; E, e*	Х х	Х х	Kh, kh
Ж ж	Ж ж	Zh, zh	Ц ц	Ц ц	Ts, ts
З э	З э	Z, z	Ч ч	Ч ч	Ch, ch
И и	И и	I, i	Ш ш	Ш ш	Sh, sh
Й й	Й й	Y, y	Щ щ	Щ щ	Shch, shch
К к	К к	K, k	Ъ ъ	Ъ ъ	"
Л л	Л л	L, l	Ы ы	Ы ы	Y, y
М м	М м	M, m	Ь ь	Ь ь	'
Н н	Н н	N, n	Э э	Э э	E, e
О о	О о	O, o	Ю ю	Ю ю	Yu, yu
П п	П п	P, p	Я я	Я я	Ya, ya

*ye initially, after vowels, and after ь, ы; e elsewhere.
When written as ë in Russian, transliterate as yë or ë.

RUSSIAN AND ENGLISH TRIGONOMETRIC FUNCTIONS

Russian	English	Russian	English	Russian	English
sin	sin	sh	sinh	arc sh	sinh ⁻¹
cos	cos	ch	cosh	arc ch	cosh ⁻¹
tg	tan	th	tanh	arc th	tanh ⁻¹
ctg	cot	cth	coth	arc cth	coth ⁻¹
sec	sec	sch	sech	arc sch	sech ⁻¹
cosec	csc	csch	csch	arc csch	csch ⁻¹

Russian	English
rot	curl
lg	log

1427

USSR State Standard

GOST 77877-62, replaces GOST 7787-57

Deep Countersunk Head Bolts (Standard precision). Sizes

Approved by the Committee on Standards, Measures, and Measuring Instruments under the auspices of the Council of Ministers USSR 27/3 1962. Date of introduction established at 1/1 1964

Nonobservance of standard punishable by law.

1. The dimensions of the bolts must correspond to those indicated on the drawing in Tables 1 and 2 of the present standard.

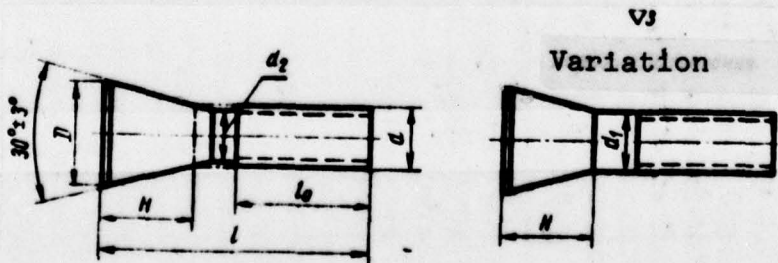


Table 1.

		6	8	10	12	16	
1	Номинальные диаметры резьбы d	6	8	10	12	16	
2	Шаг резьбы	1	1,25	1,5	1,75	2	
3	Диаметр головки D	7 Номи.	11	14	17	21	28
		8 Доп. откл.	±0,70		±0,84		
4	Высота головки H	7 Номи.	9	11	13	16	22
		8 Доп. откл.	±0,9		±1,1		±1,3
5	Диаметр стержня d_1	7 Номи.	6	8	10	12	16
		8 Доп. откл.	-0,48		-0,58		-0,70
6	Допускаемое смещение оси головки	0,4		0,5		0,7	

Key: 1 - Nominal diameter of thread d , 2 - screw pitch, 3 - Diameter of head D , 4 - Height of head H , 5 - Diameter of shaft d_1 , 6 - Permissible shift in axis of head, 7 - Nominal. 8 - Permissible deviation.

Table 2.

		мм					
1		6	8	10	12	16	
2	3		4				
	Допускаемое отклонение на l при диаметрах болтов						
Число болтов l	3a	16	Длина резьбы l_0 , включая срез резьбы				
	от 6 до 12						
40	±0,8	—	18	—	—	—	—
45			18	22	—	—	—
50			18	22	26	—	—
55			18	22	26	—	—
60	±1,5	±1,8	18	22	26	30	—
70			18	22	26	30	—
80			—	22	26	30	38
90			—	22	26	30	38
100			—	22	26	30	38
110			—	22	26	30	38
120	±1,8	±2,0	—	—	26	30	38
130			—	—	26	30	38
140			—	—	26	30	38
150			—	—	26	30	38
5 Допускаемое отклонение на l_0			+2,0	+2,5	+3,0	+3,5	+4,0

Key: 1 - Nominal diameters of thread d , 2 - Length of bolt l , 3 - Permissible deviation for l with bolt diameters of: 3a - from 6 to 12, 4 - Length of thread l_0 , including thread taper, 5 - Permissible deviation for l_0 .

Examples of symbols for both of thread diameter $d = 12$ mm, length $l = 60$ mm, strength class 3.6, without coating:

Bolt M12 x 60.36 GOST 7787-62.

The same, strength class 4.8 with coating of 01 and thickness of 9 μ m:

Bolt M12 x 60.48.019 GOST 7787-62.

(Altered edition - "Information Directory of Standards" No 8
1971).

2. Diameter d_2 lies within the limits of the average thread diameter and is established by the producing enterprise.

3. The bolt variation is established by the producing enterprise.

4. Thread - per GOST 9150-59.

5. Thread tolerances - per GOST 9253-59, accuracy class 3.

6. Technical specifications per GOST 1759-70.

(Altered edition - "Information Directory of Standards" No 8
1971).

Replacement

GOST 1759-70 replaces GOST 1759-62.

APPENDIX

Reference Table for Bolt Weight.

1 Длина болта <i>l</i> в мм	2 Номинальные диаметры резьбы <i>d</i> в мм				
	6	8	10	12	16
	3 Вес 1000 шт. стальных болтов основного исполнения в кг				
40	9,69	—	—	—	—
45	10,57	19,45	—	—	—
50	11,45	21,04	33,68	—	—
55	12,33	22,63	36,18	—	—
60	13,21	24,22	38,68	58,94	—
70	14,98	27,39	43,69	65,83	—
80	—	30,56	48,70	72,72	145,7
90	—	33,73	53,71	79,61	159,0
100	—	36,90	58,72	86,49	172,3
110	—	40,07	63,73	93,38	185,6
120	—	—	68,74	100,2	199,0
130	—	—	73,75	107,1	212,3
140	—	—	78,76	114,0	225,6
150	—	—	83,77	120,9	238,9

Key: 1 - Length of bolt *l* in mm. 2 - Nominal bolt diameters *d* in mm.

3 - Weight of 1000 items of steel bolts of basic variation in kg.

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A210 DMAAC	2	E017 AF/RDXTR-W	1
P344 DIA/RDS-3C	9	E403 AFSC/INA	1
C043 USAMIIA	1	E404 AEDC	1
C509 BALLISTIC RES LABS	1	E408 AFWL	1
C510 AIR MOBILITY R&D LAB/FIO	1	E410 ADTC	1
C513 PICATINNY ARSENAL	1	E413 ESD	2
C535 AVIATION SYS COMD	1	FTD	
C591 FSTC	5	CCN	1
C619 MIA REDSTONE	1	ASD/FTD/NIIS	3
D008 NISC	1	NIA/PHS	1
H300 USAICE (USAREUR)	1	NIIS	2
P005 DOE	1		
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