

ASTM A563

CARBON STEEL

GRADE 1

BOLTING MATERIAL FOR STRUCTURAL PURPOSE

The ASTM A563 specification covers the chemical and mechanical requirements for carbon and alloy steel nuts used on bolts, studs, and threaded fasteners. According to the A563 specification, . Additionally, the specification allows for the substitution of ASTM A194 grade 2H nuts in lieu of A563 grade DH nuts due to the lack of availability of grade DH nuts in nominal sizes 3/4" and larger.

Hot-dip galvanized nuts must be tapped oversize to allow for the added thickness of the zinc on the threads of the externally threaded fastener. These allowances are addressed in the chart below and a more detailed explanation of this issue can be found in the Frequently Asked Questions section of this site.

Chemical Properties

C	P
0.58	0.13 Max

Characteristic Standard

Materials&Manufacture	ASTM A563M Class 10S
Finish(SelfColour/Black)	ASTM A563M
Mechanical Properties	ASTM A563M Class 10S
Dimensions&Tolerances	ANSI B18.2.6M
Threads	ASME B1.13M tolerance class 6H
Workmanship	ASTM F812/F812M
Product marking	ASTM A563M Class 10S

A563M Nut Proof Loads & Nut Hardness

Nominal Size, & Thread Pitch d,	Proof Loads		Hardness	
	10 S		10 S	
	Self Colour/Black (6H fit)	Self Colour/Black (6H fit)	min	max
M16 x 2	195	26	26	38
M20 x 2.5	305	26	26	38
M22 x 2.5	377	26	26	38
M24 x 3	439	26	26	38
M27 x 3	571	26	26	38
M30 x 3.5	698	26	26	38
M36 x 4	1020	26	26	38

Mechanical Properties Nuts with UNC, 8 UN, 6 UN and Coarser Pitch Threads

Proof Load Stress, ksi(A)

TYPE	1/4" TO 1 1/2"		1/4" TO 1 1/2"		Hardness		
	Non-Zinc Coated	Zinc Coated	Non-Zinc Coated	Zinc Coated	BHN	HRB	HRC
SQUARE	90	68	-	-	116-302	68 Min	32 Max
HEX	90	68	-	-	116-302	68 Min	32 Max
HEAVY HEX	-	-	100	75	116-302	68 Min	32 Max
HEX THICK	100	75	-	-	116-302	68 Min	32 Max

Mechanical Properties Nuts with UNF, 12 UN and Finer Pitch Threads

Proof Load Stress, ksi(A)

TYPE	1/4" TO 1 1/2"		1/4" TO 1 1/2"		Hardness		
	Non-Zinc Coated	Zinc Coated	Non-Zinc Coated	Zinc Coated	BHN	HRB	HRC
HEX	80	60	-	-	116-302	68 Min	32 Max
Qnchd & Temp	-	-	90	68	116-302	68 Min	32 Max
HEX THICK	90	68	-	-	116-302	68 Min	32 Max

A563M Nut Dimension

Nominal Size, & Thread Pitch d,	s		e		m		dw ¹⁾	c		Total runout of bearing surface
	Width across flats		Width across corners		Thickness			Washer face thickness		
	max	min	max	min	max	min	min	max	min	
M16 x 2	27.00	26.16	31.18	29.56	17.1	16.4	24.9	0.8	0.4	0.47
M20 x 2.5	34.00	33.00	39.26	27.29	20.7	19.4	31.4	0.8	0.4	0.58
M22 x 2.5	36.00	35.00	41.57	39.55	23.6	22.3	33.3	0.8	0.4	0.63
M24 x 3	41.00	40.00	47.34	45.20	24.2	22.9	38.0	0.8	0.4	0.72
M27 x 3	46.00	45.00	53.12	50.85	27.6	26.3	42.8	0.8	0.4	0.80
M30 x 3.5	50.00	49.00	57.74	55.37	30.7	29.1	46.6	0.8	0.4	0.87
M36 x 4	60.00	58.00	69.28	66.44	36.6	35.0	55.9	0.8	0.4	1.05

Heat Treatment

Quenched & Tempered @ 425° C Min

CUSTOMER ASSISTANCE : customer@TorqBolt.com