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# Hexagonal socket cylindrical head screw - 6AL-4V Titanium ISO thread - 4h class

BA4000

RECU 25 MAI 2009

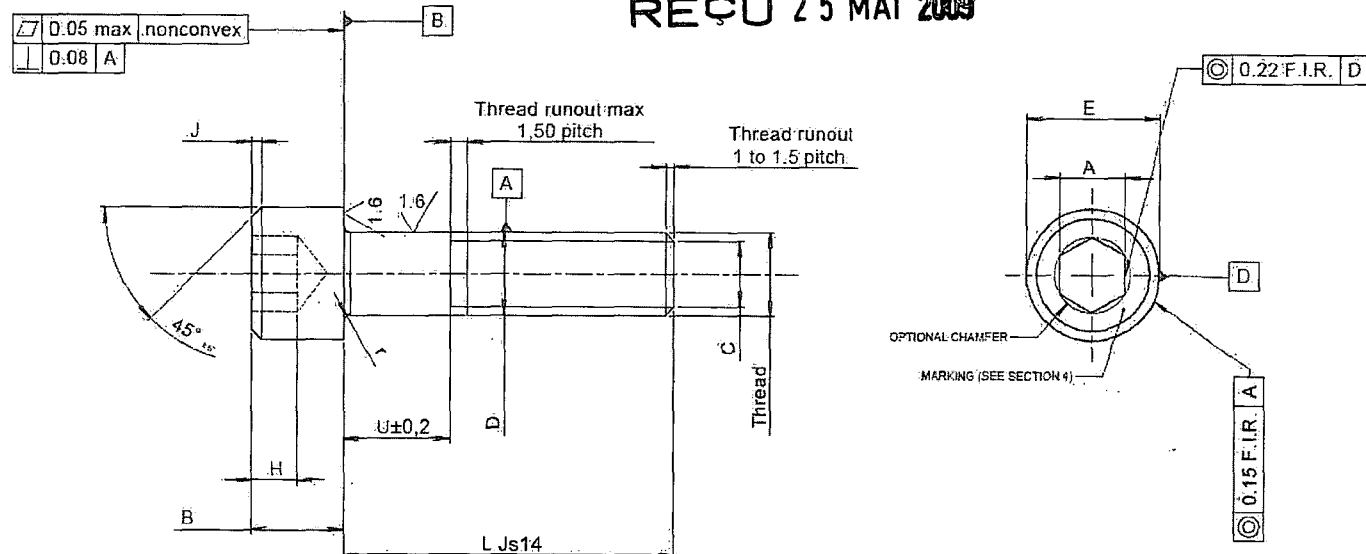


FIGURE 1: CONFIGURATION

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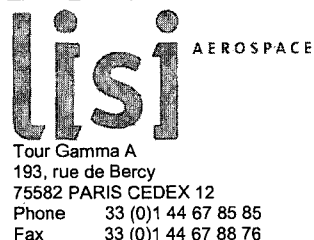
DIFFUSION CONTROLEE  
A-A1-C-E-H-I-L-M-P-S-T-V

## NOTES:

UNLESS OTHERWISE SPECIFIED

- I. Units  
Dimensions and tolerances are in millimeters. Dimensions apply after finish.
- II. Surface Texture  
As per ASME B46-1 before coating.  
-  $R_a$  max. =  $6,3\mu m$  (except thread)  
-  $R_a$  max. =  $1,6\mu m$  on shank diameter and head bearing surface  
Break sharp edges 0,1 to 0,4.
- III. Thread  
ISO M, 4h class, as per NF L 05-220.  
Thread is rolled

| Technical Center | Written by | Signature | Date      | Approved by | Signature | Date      | Issue |
|------------------|------------|-----------|-----------|-------------|-----------|-----------|-------|
| Page 1/4         | Y. DOUARD  |           | 22 May 09 | F. VERDIER  |           | 22 May 09 | A     |



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**BA4000**

## 1. APPLICATION

This product standard specifies the dimensions, tolerances and properties of a titanium screw for use in aerospace application at a maximum operating temperature of 315°C.

## 2. REQUIREMENTS

### 2.1. Material

Code TX: Titanium alloy 6AL-4V as per AIR9183 – Rm min. = 1100 MPa.

### 2.2. Finish

Code XA: Sulfuric acid anodizing as per ISO 8080 and solid film lubricant per EN2491.

### 2.3. Dimensions and tolerances

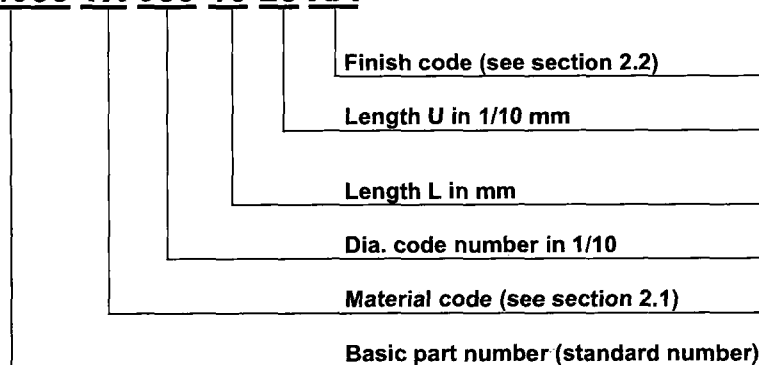
**Table 1 : Dimensions and tolerances**

| Thread Designation | A<br>+0,105<br>+0,030 | B<br>0<br>-0,18 | C<br>0<br>-0,5 | D<br>0<br>-0,12 | E <sup>(1)</sup><br>0<br>-0,15 | H<br>+0,5<br>0 | J<br>Max. | R<br>±0,1 |
|--------------------|-----------------------|-----------------|----------------|-----------------|--------------------------------|----------------|-----------|-----------|
| M6x1 - 4h          | 5                     | 6               | 4,5            | 6               | 10                             | 3,3            | 0,8       | 0,6       |

(1) Tolerance only applies to the bearing surface under the head, a draught is allowed on the external diameter.

## 3. DESIGNATION

**BA4000 TX 060-16-25 XA**



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**4. MARKING (see figure 1)**

As per NF L 22-036: Material code + manufacturer symbol.

**5. PROCUREMENT SPECIFICATION**

As per AIR9185.

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| Issue | Date         | Modifications | Justification |
|-------|--------------|---------------|---------------|
| A     | May 22, 2009 | New standard  | -             |
|       |              |               |               |
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