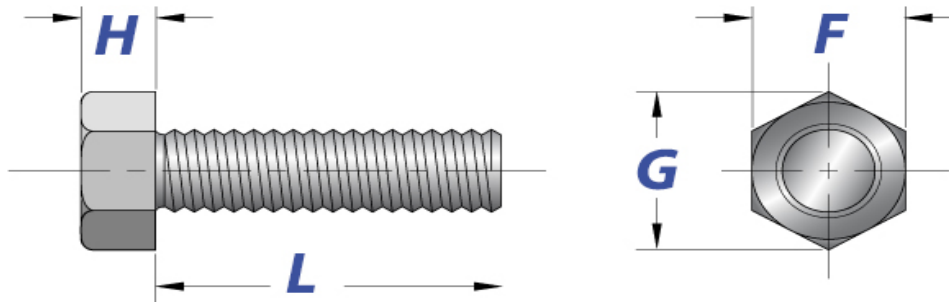


## PRODUCT DATA SHEET

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### Tap Bolts

#### 1.0 Dimensions: IFI -199



Nominal Size or Basic Product Diameter	F			G		H		
	Width Across Flats			Width Across Corners		Head Height		
	Basic	Min	Max	Min	Max	Basic	Min	Max
1/4	7/16	0.438	0.425	0.505	0.484	11/64	0.188	0.150
5/16	1/2	0.500	0.484	0.577	0.552	7/32	0.195	0.235
3/8	9/16	0.562	0.544	0.650	0.620	1/4	0.268	0.226
7/16	5/8	0.625	0.603	0.722	0.687	19/64	0.316	0.272
1/2	3/4	0.750	0.725	0.866	0.826	11/32	0.364	0.302
5/8	15/16	0.938	0.906	1.083	1.033	27/64	0.444	0.378
3/4	1-1/8	1.125	1.088	1.299	1.240	1/2	0.524	0.455
7/8	1-5/16	1.312	1.269	1.516	1.447	37/64	0.604	0.531
1	1-1/2	1.500	1.450	1.732	1.653	43/64	0.700	0.591
1-1/8	1-11/16	1.688	1.631	1.949	1.859	3/4	0.780	0.658
1-1/4	1-7/8	1.875	1.812	2.165	2.066	27/32	0.876	0.749

**Notes :**

**1.0** Tap bolts are hex head bolts which are fully threaded.

**2.0** Thread Class of Fit : Plain : 2A. Zinc Plated : 2A before zinc plating and after zinc plating must meet 3A GO & 2A NO GO thread ring gage condition. Hot Dip Galvanized : 2A before coating.



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### Tap Bolts

#### 2.0 Mechanical Properties (For Full Size Bolt Testing):

##### 2.1 Steel: ASTM A307 Grade A

Grade	Length	Hardness	Tensile Strength Minimum	Grade Marking
A	Less than 3 times the diameter	69 to 100 HRB	60,000 PSI	307A
	3 times the diameter and longer	100 HRB Max		

Notes: The bolts will also have manufacturer's marking on the head in addition to the grade marking as mentioned in the table.

##### 2.2 Steel: SAE J429 Grade 5

Grade	Classification		Rockwell Hardness	Proof Load Strength Minimum	Tensile Strength Minimum	Grade Marking
	Nominal Size					
5	1/4 thru 1		C25 to C34	85,000 PSI	120,000 PSI	3 Radial Lines 120 Degrees Apart
	Over 1 thru 1-1/2		C19 to C30	74,000 PSI	105,000 PSI	

#### 3.0 Surface Finish: Plain/Zinc/HDG. Zinc & HDG details given in table below:

Properties	Zinc Clear	Hot Dip Galvanized (HDG)
Type	Trivalent (Cr+3)	RoHS Complaint
Color	Clear	
Coating Thickness	0.0001"/3 Microns or 0.0002"/5 Microns Minimum	For sizes 3/8" & under : minimum 0.0017" (43 microns) and for sizes over 3/8" minimum 0.0020" (50 microns)
Specification	ASTM F1941/F1941M Fe/Zn 3AN or Fe/Zn 5AN	ASTM F2329/F2329M or ASTM A153/A153M