
**Aerospace — Internal six-lobe drives —
Metric series**

Aéronautique et espace — Empreintes six lobes — Série métrique

STANDARDSISO.COM : Click to view the full PDF of ISO 12257:2008



PDF disclaimer

This PDF file may contain embedded typefaces. In accordance with Adobe's licensing policy, this file may be printed or viewed but shall not be edited unless the typefaces which are embedded are licensed to and installed on the computer performing the editing. In downloading this file, parties accept therein the responsibility of not infringing Adobe's licensing policy. The ISO Central Secretariat accepts no liability in this area.

Adobe is a trademark of Adobe Systems Incorporated.

Details of the software products used to create this PDF file can be found in the General Info relative to the file; the PDF-creation parameters were optimized for printing. Every care has been taken to ensure that the file is suitable for use by ISO member bodies. In the unlikely event that a problem relating to it is found, please inform the Central Secretariat at the address given below.

STANDARDSISO.COM : Click to view the full PDF of ISO 12257:2008



COPYRIGHT PROTECTED DOCUMENT

© ISO 2008

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
Web www.iso.org

Published in Switzerland

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 12257 was prepared by Technical Committee ISO/TC 20, *Aircraft and space vehicles*, Subcommittee SC 4, *Aerospace fastener systems*.

STANDARDSISO.COM : Click to view the full PDF of ISO 12257:2008

Aerospace — Internal six-lobe drives — Metric series

1 Scope

This International Standard specifies the dimensions of metric internal six-lobe drives used in metric screws in nominal thread diameter range 3 mm to 20 mm.

NOTE Pending publication of an International Standard relating to limit gauges, special care is required to ensure that the dimensions and tolerances specified in this International Standard are confirmed by alternative means.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 1101, *Geometrical Product Specifications (GPS) — Geometrical tolerancing — Tolerances of form, orientation, location and run-out*

3 Configuration and dimensions

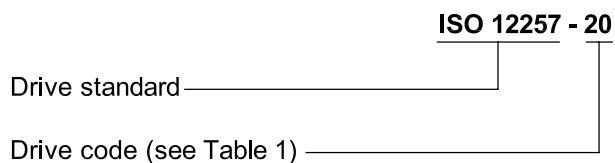
See Figure 1 and Table 1.

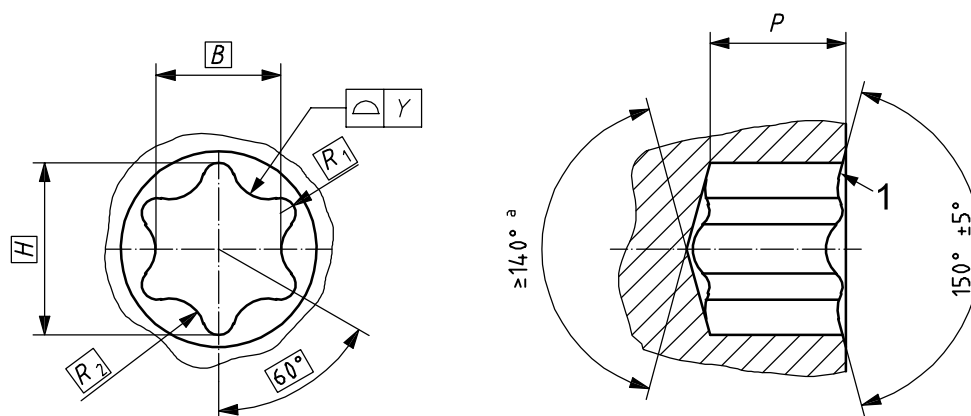
Dimensions and tolerances are expressed in millimetres.

The presentation of this International Standard conforms to ISO 1101.

4 Designation

The drive designation shall be as follows:



**Key**

- 1 chamfer (optional)
a Shape optional.

Figure 1**Table 1**

Dimensions in millimetres

Drive code	<i>B</i>	<i>H</i>	<i>P</i>	<i>R</i> ₁	<i>R</i> ₂	<i>Y</i>
06	1,27	1,75	According to bolt head, see product standard	0,16	0,36	0,025
07	1,5	2,07		0,18	0,42	
08	1,75	2,4		0,22	0,49	
09	1,85	2,6		0,23	0,53	
10	2,05	2,8		0,25	0,57	
15	2,4	3,35		0,3	0,69	
20	2,85	3,95		0,33	0,83	0,035
25	3,25	4,5		0,4	0,89	
27	3,65	5,1		0,42	1,08	
30	4,05	5,6		0,48	1,16	0,05
40	4,85	6,75		0,58	1,4	
45	5,64	7,93		0,61	1,76	
50	6,45	8,95		0,81	1,78	0,06
55	8,05	11,35		0,96	2,62	
60	9,6	13,45		1,12	2,83	