
**Hexalobular internal driving feature
for bolts and screws**

Empreinte à six lobes internes pour vis

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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

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Foreword

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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 10664 was prepared by Technical Committee ISO/TC 2, *Fasteners*.

This second edition cancels and replaces the first edition (ISO 10664:1999), which has been technically revised.

Hexalobular internal driving feature for bolts and screws

1 Scope

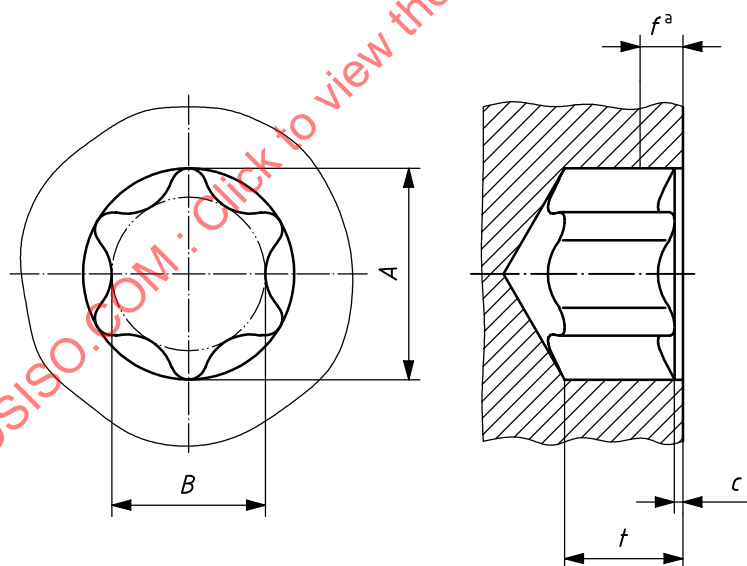
This International Standard specifies the shape and basic dimensions of the hexalobular internal driving feature for bolts and screws, including the gauging method.

The curvature of the contour of the hexalobular internal driving feature is defined by the gauges specified in Tables 3, 4 and 5. Additional information which can be used when drawing the contour is given in Annex A.

The intent of this International Standard is to provide the details necessary for inspection of the hexalobular driving feature. It is not suitable for, nor intended to be used as, a manufacturing standard.

2 Basic dimensions

See Figure 1 and Table 1.



Counterbore: $c \leq 0,13 \text{ mm}$ up to socket No. 15

$c \leq 0,25 \text{ mm}$ over socket No. 15

Penetration depth t : see relevant product standard.

NOTE The contour of the bottom of the socket beyond the gauge is at the option of the manufacturer.

^a See Table 2.

Figure 1 — Basic dimensions

Table 1 — Basic dimensions

Dimensions in millimetres

Hexalobular socket No.	Nominal dimensions ^a	
	<i>A</i>	<i>B</i>
6	1,75	1,27
8	2,4	1,75
10	2,8	2,05
15	3,35	2,4
20	3,95	2,85
25	4,5	3,25
30	5,6	4,05
40	6,75	4,85
45	7,93	5,64
50	8,95	6,45
55	11,35	8,05
60	13,45	9,6
70	15,7	11,2
80	17,75	12,8
90	20,2	14,4
100	22,4	16

^a The curvature of the contour of the hexalobular internal driving feature is defined by the gauges specified in Tables 3, 4 and 5.

3 Gauging

3.1 Principle

The hexalobular internal driving feature shall allow the GO gauge (see 3.2) to enter freely to the penetration depth t , as specified in the relevant product standards.

The NO GO gauges (see 3.3.1 and 3.3.2) shall not enter the hexalobular internal driving feature to a depth greater than the fallaway allowance specified in Table 2.

Table 2 — Fallaway allowance

Dimensions in millimetres

Socket No.	6	8	10	15	20	25	30	40	45	50	55	60	70	80	90	100
Fallaway allowance, f	0,35	0,48	0,56	0,67	0,79	0,90	1,12	1,18	1,39	1,56	1,98	2,35	2,75	3,11	3,53	3,92

All gauging is performed with reference to the top surface of the head. In the case of oval or round top heads, measurements are taken from the actual intersection of the top surface of the head and the hexalobular internal driving feature counterbore.

When using a dial penetration gauge, this should be adjusted to zero while the gauge is pressed against a flat surface, thereby compressing the plunger to make it flush with the gauge reference surface, see Figure 2.

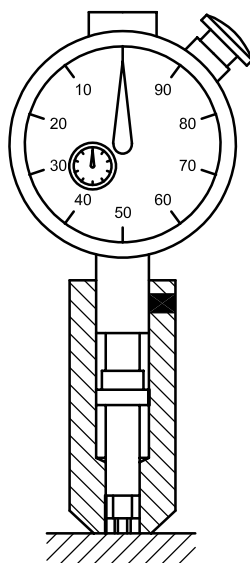
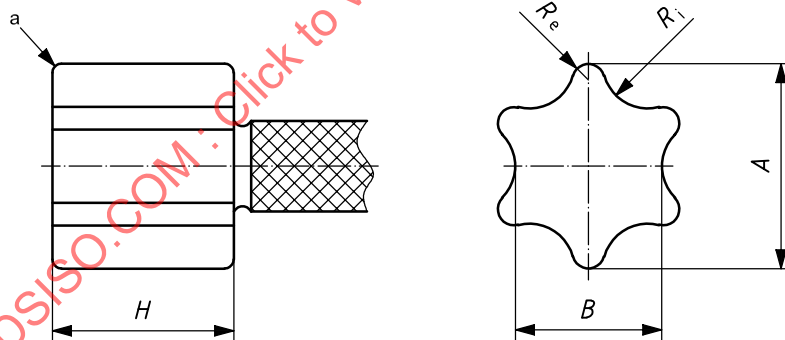


Figure 2 — Dial gauge (zero position)

3.2 GO gauge

The GO gauge dimensions (see Figure 3) shall be within the limits specified in Table 3.



- ^a Radius max. 0,076 mm at juncture of side and face to gauge sizes \geq No. 10 and max. 0,025 4 mm for gauge sizes $<$ No. 10.

Figure 3 — Dimensions of GO gauge

Table 3 — Limiting sizes of GO gauge dimensions

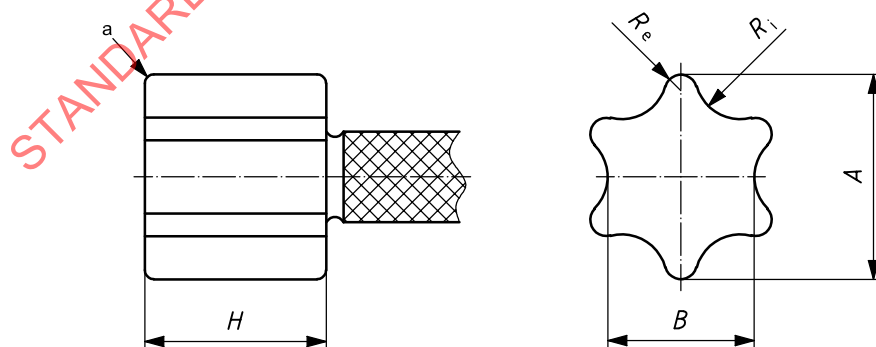
Dimensions in millimetres

Socket No.	A		B		R_i		R_e		H	
	min.	max.	min.	max.	min.	max.	min.	max.	min.	max.
6	1,695	1,709	1,210	1,224	0,371	0,396	0,130	0,134	1,33	1,82
8	2,335	2,349	1,672	1,686	0,498	0,523	0,188	0,193	2,54	3,05
10	2,761	2,776	1,979	1,993	0,585	0,609	0,227	0,231	3,05	3,56
15	3,295	3,309	2,353	2,367	0,704	0,728	0,265	0,269	3,30	3,81
20	3,879	3,893	2,764	2,778	0,846	0,871	0,303	0,307	3,56	4,07
25	4,451	4,465	3,170	3,185	0,907	0,932	0,371	0,378	3,94	4,45
30	5,543	5,557	3,958	3,972	1,182	1,206	0,448	0,454	4,44	4,95
40	6,673	6,687	4,766	4,780	1,415	1,440	0,544	0,548	5,08	5,59
45	7,841	7,856	5,555	5,570	1,784	1,808	0,572	0,576	5,71	6,22
50	8,857	8,872	6,366	6,380	1,804	1,828	0,773	0,777	5,97	6,48
55	11,245	11,259	7,930	7,945	2,657	2,682	0,765	0,769	6,22	6,73
60	13,302	13,317	9,490	9,504	2,871	2,895	1,065	1,069	7,68	8,17
70	15,588	15,603	11,085	11,099	3,465	3,489	1,192	1,196	8,46	8,96
80	17,619	17,635	12,646	12,661	3,625	3,629	1,524	1,529	9,4	9,9
90	20,021	20,035	14,232	14,246	4,456	4,480	1,527	1,534	10,06	10,56
100	22,231	22,245	15,820	15,834	4,913	4,937	1,718	1,724	10,85	11,35

3.3 NO GO gauges

3.3.1 Gauging the fallaway of dimensions A and R_e

The NO GO gauge for dimensions A and R_e (see Figure 4) shall have dimensions within the limits specified in Table 4.



- ^a Radius max. 0,076 mm at juncture of side and face for gauge sizes \geq No. 10 and max. 0,025 4 mm for gauge sizes $<$ No. 10

Figure 4 — NO GO gauge for dimensions A and R_e

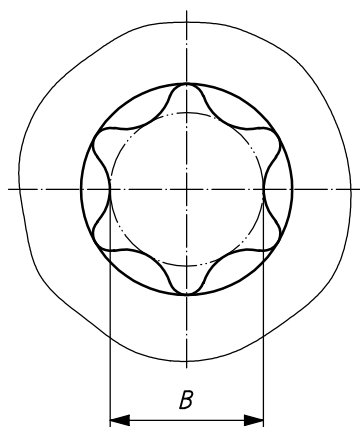
Table 4 — Limiting sizes of dimensions of NO GO gauge for dimensions A and R_e

Dimensions in millimetres

Socket No.	A		B	R_i		R_e		H $\pm 0,25$
	min.	max.	max.	min.	max.	min.	max.	
6	1,778	1,785	1,181	0,231	0,241	0,173	0,180	1,57
8	2,419	2,425	1,664	0,36	0,37	0,231	0,238	2,79
10	2,845	2,852	1,956	0,431	0,441	0,269	0,276	3,3
15	3,379	3,385	1,956	0,398	0,408	0,307	0,315	3,56
20	3,963	3,970	2,616	0,602	0,614	0,345	0,353	3,81
25	4,560	4,566	2,868	0,637	0,647	0,429	0,436	4,19
30	5,652	5,659	3,886	0,939	0,949	0,505	0,513	4,7
40	6,807	6,814	4,661	1,112	1,125	0,612	0,619	5,33
45	7,976	7,983	4,661	1,110	1,123	0,640	0,648	5,97
50	8,992	8,999	6,413	1,628	1,640	0,840	0,848	6,22
55	11,405	11,412	7,684	2,176	2,189	0,845	0,853	6,48
60	13,488	13,495	7,684	2,153	2,164	1,158	1,165	7,92
70	15,774	15,781	10,262	2,545	2,557	1,285	1,292	8,71
80	17,831	17,838	11,76	2,608	2,621	1,628	1,635	9,52
90	20,257	20,264	12,827	3,111	3,121	1,648	1,656	10,31
100	22,467	22,473	15,24	4,006	4,018	1,839	1,847	11,1

3.3.2 Gauging the fallaway of dimension B

See Figure 5.

**Figure 5 — Cylindrical zone to be gauged**

A cylindrical NO GO gauge with diameter as specified in Table 5 shall not enter the hexalobular internal driving feature to a depth greater than the fallaway allowance specified in Table 2.