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GB/T 822-2016

Replacing GB/T 822-2000

Cheese Head Screws with Cross Recess

(ISO 7048:2011, Cross-Recessed Cheese Head Screws,
MOD)

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Foreword

This Standard is one of the serial national standards of “Slotted Screws and Cross Recessed Screws”, which include:

- GB/T 65 Slotted Cheese Head Screws;
- GB/T 67 Slotted Pan Head Screws;
- GB/T 68 Slotted Countersunk Head Screws;
- GB/T 69 Slotted Raised Countersunk Head Screws;
- GB/T 818 Cross Recessed Pan Head Screws;
- GB/T 819.1 Cross Recessed Countersunk Head Screws – Part 1: Class 4.8;
- GB/T 819.2 Cross Recessed Countersunk Head Screws – Part 2: Steel of Property Class 8.8, Stainless Steel Screws and Non-ferrous Metal Screws;
- GB/T 820 Cross Recessed Raised Countersunk Head Screws;
- GB/T 822 Cross Recessed Cheese Head Screws;
- GB/T 823 Cross Recessed Small Pan Head Screws;
- GB/T 13806.1 Fasteners for Fine Mechanics – Cross Recessed Screws.

This Standard was drafted as per the rules specified in GB/T 1.1-2009.

This Standard replaced GB/T 822-2000 *Cheese Head Screws with Cross Recess*; the major technical changes are as follows:

- Delete “if other technical requirements are needed, ... the selection in GB/T 3098.6 and GB/T 3098.10.” (Chapter 1 of Edition 2000);
- Unify the reference screw standards to be GB/T 193, GB/T 9145 (see Chapter 2);
- Increase the property class of steel and non-ferrous metal screws of “ $d < 3\text{mm}$, as per agreement” (see Table 2);
- Increase the steel screws non-electrolytically applied zinc flake coating technical requirements as per GB/T 5267.2 (see Table 2);
- Increase the stainless-steel screws passivation treatment technical requirements as per GB/T 5267.4 (see Table 2);
- Increase the non-ferrous metal screws electroplating technical requirements as

Drafting organizations of this Standard: China Productivity Center for Machinery.

Participating drafting organizations of this Standard: Machinery Industry General Parts Product Quality Supervision and Inspection Center, and Ningbo Zhongji Machine Parts Inspection Co., Ltd..

This Standard shall be interpreted by the Secretariat of National Technical Committee for Standardization of Fastener.

The historical editions replaced by this Standard are as follows:

--- GB/T 822-1967, GB/T 822-1976, GB/T 822-1988, GB/T 822-2000.

Cheese Head Screws with Cross Recess

1 Scope

This Standard specifies the type and dimension, technical conditions and markings of cheese head screws with cross recess.

This Standard is applicable to Type-H and Type-Z cheese head screws with cross recess for Thread Specification M2.5~M8, Property Class 4.8, 5.8, A2-70, CU2, CU3 and AL4, Product Grade A.

NOTE: the screw head dimension specified in this Standard equals to slotted cheese head screws specified in GB/T 65.

2 Normative References

The following documents are essential to the application of this document. For the dated documents, only the versions with the dates indicated are applicable to this document; for the undated documents, only the latest version (including all the amendments) are applicable to this document.

GB/T 90.1 Fasteners – Acceptance Inspection (GB/T 90.1-2002, ISO 3269:2000, IDT)

GB/T 90.2 Fasteners – Marking and Packaging

GB/T 193 General Purpose Screw Threads – Diameters and Pitches (GB/T 193-2003, ISO 261:1998, MOD)

GB/T 944.1 Cross Recesses for Screws (GB/T 944.1-1985, eqv ISO 4757:1983)

GB/T 1237 Designation System for Fasteners (GB/T 1237-2000, eqv ISO 8991:1986)

GB/T 3098.1 Mechanical Properties of Fasteners - Bolts, Screws and Studs (GB/T 3098.1-2010, ISO 898-1:2009, MOD)

GB/T 3098.6 Mechanical Properties of Fasteners – Stainless Steel Bolts, Screws and Studs (GB/T 3098.6-2014, ISO 3506-1:2009, MOD)

GB/T 3098.10 Mechanical Properties of Fasteners –Bolts, Screws and Studs Made of Non-Ferrous Metals (GB/T 3908.10-1993, eqv ISO 8839:1986)

GB/T 3103.1 Tolerances for Fasteners – Bolts, Screws and Nuts (GB/T 3103.1-2002, idt ISO 4759-1:2000)

GB/T 5267.1 Fasteners – Electroplated Coatings (GB/T 5267.1-2002, ISO 4042:1999, IDT)

GB/T 5267.2 Fasteners – Non-Electrolytically Applied Zinc Flake Coatings (GB/T 5267.2-2002, ISO 10683:2000, IDT)

GB/T 5267.4 Passivation of Corrosion – Resistant Stainless – Steel Fasteners (GB/T 5267.4-2009, ISO 16048:2003, IDT)

GB/T 5276 Fasteners - Bolts, Screws, Studs and Nuts - Symbols and Descriptions of Dimensions (GB/T 5276-2015, ISO 225:2010, MOD)

GB/T 5779.1 Fastener – Surface Discontinues – Bolts, Screws and Studs for General Requirements (GB/T 5779.1-2000, idt ISO 6157-1:1988)

GB/T 9145 General Purpose Metric Screw Threads - Limits of Sizes for the Screw Threads of Medium Quality and Preferable Plan (GB/T 9145-2003, ISO 965-2:1998, MOD)

GB/T 16938 Fasteners – General Requirements for Bolts, Screws, Studs and Nuts (GB/T 16938-2008, ISO 8992:2005, IDT)

3 Dimension

The types and dimensions of screws can refer to Figure 1 and Table 1.

The dimension codes and markings shall conform to GB/T 5276.

The stem diameter of the part without thread equals to the medium diameter of thread or allows equaling to the large diameter of thread.

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