



Designation: F901 – 20

Standard Specification for Aluminum Transmission Tower Bolts and Nuts¹

This standard is issued under the fixed designation F901; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

1. Scope*

1.1 This specification covers aluminum structural bolts and nuts for use in the construction of aluminum transmission towers, substations, and similar aluminum structures.

1.2 Diameters of bolts and nuts furnished to this specification are $\frac{5}{8}$, $\frac{3}{4}$, and $\frac{7}{8}$ in.

1.3 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:²

B565 Test Method for Shear Testing of Aluminum and Aluminum-Alloy Rivets and Cold-Heading Wire and Rods

D3951 Practice for Commercial Packaging

E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications

E34 Test Methods for Chemical Analysis of Aluminum and Aluminum-Base Alloys (Withdrawn 2017)³

E55 Practice for Sampling Wrought Nonferrous Metals and Alloys for Determination of Chemical Composition

E101 Test Method for Spectrographic Analysis of Aluminum and Aluminum Alloys by the Point-to-Plane Technique (Withdrawn 1996)³

¹ This specification is under the jurisdiction of ASTM Committee F16 on Fasteners and is the direct responsibility of Subcommittee F16.04 on Nonferrous Fasteners.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ The last approved version of this historical standard is referenced on www.astm.org.

E227 Test Method for Optical Emission Spectrometric Analysis of Aluminum and Aluminum Alloys by the Point-to-Plane Technique (Withdrawn 2002)³

F606/F606M Test Methods for Determining the Mechanical Properties of Externally and Internally Threaded Fasteners, Washers, Direct Tension Indicators, and Rivets

F1470 Practice for Fastener Sampling for Specified Mechanical Properties and Performance Inspection

2.2 *ASME Standards:*⁴

B1.1 Unified Inch Screw Threads (UN and UNR Thread Form)

B18.2.1 Square and Hex Bolts and Screws (Inch Series) Addenda A

B18.2.2 Square and Hex Nuts

2.3 *Military Standard:*

MIL-STD-A-8625 Anodic Coatings for Aluminum and Aluminum Alloys⁵

3. Ordering Information

3.1 Orders for bolts and nuts under this specification shall include the following:

3.1.1 Quantity (number of pieces of each item and size);

3.1.2 Name of item;

3.1.3 Size (diameter, threads per inch, length);

3.1.4 Alloy number;

3.1.5 Shipment lot testing, as required (see Supplementary Requirements S1);

3.1.6 Source inspection, if required (see Section 14);

3.1.7 Certificate of compliance or test report, if required (see Section 16);

3.1.8 Additional requirements, if any, to be specified on the purchase order (see 4.2.1, 4.2.3, 8.2.1, 8.2.2, 9.2, 12.1, and 13.1);

3.1.9 Supplementary requirements, if any; and

3.1.10 ASTM specification and year of issue.

NOTE 1—*Example:* 10 000 pieces Aluminum Transmission Tower Bolt, 0.750-10 by 2.00 in., Alloy 2024-T4, Furnish Certificate of Compliance, Supplementary Requirement S2, ASTM F901–XX.

⁴ Available from IHS, 15 Inverness Way East, Englewood, CO 80112, <http://www.global.ihs.com>.

⁵ Available from DLA Document Services, Building 4/D, 700 Robbins Ave., Philadelphia, PA 19111-5094, <http://quicksearch.dla.mil>.

*A Summary of Changes section appears at the end of this standard

4. Materials and Manufacture

4.1 *Materials*—Bolts shall be manufactured from Alloy 2024 and nuts from Alloy 6061 or 6262. The materials chemical composition shall be capable of developing the mechanical properties required by **Table 1**, when in the finished condition.

4.2 *Manufacture:*

4.2.1 *Forming*—Unless otherwise specified, the bolts and nuts shall be cold formed, hot formed, or machined from suitable material at the option of the manufacturer.

4.2.2 *Condition*—The fasteners shall be furnished in the following conditions:

Alloy	Fastener	Condition
2024-T4	bolts	solution treated and naturally aged
6061-T6	nuts	solution treated and artificially aged
6262-T9	nuts	solution treated, artificially aged, and cold worked

4.2.3 *Threads*—Unless otherwise specified, the threads shall be rolled or cut at the option of the manufacturer.

5. Chemical Composition

5.1 *Chemical Composition Limits*—The bolts and nuts shall conform to the requirements as to chemical composition prescribed in **Table 2**.

5.2 *Manufacturer’s Analysis*—When test reports are required on the inquiry or purchase order (see **3.1.7**), the manufacturer shall furnish a certificate of conformance certifying compliance with the chemical limits specified in **Table 2**.

5.3 *Product Analysis:*

5.3.1 Product analyses may be made by the purchaser from finished products representing each lot. The chemical composition thus determined shall conform to the requirements in **Table 2**.

5.3.2 In the event of disagreement, a referee chemical analysis shall be performed if agreed upon by both parties. A sample as required by **Table 3** shall be selected for each lot. Chemical analysis shall be performed to the requirements of **13.1** and the result shall conform to **Table 2**.

6. Mechanical Properties

6.1 *Bolts*—Bolts having a length three times the diameter or longer shall be tested full size as specified in **13.2.2**. At the manufacturer’s option, bolts of less than 3 diameters in length

may be tested in full size as specified in **13.2.2**. Bolts subjected to tension tests shall meet the tensile strength requirements specified in **Table 1**. Bolts of less than 3 diameters in length or for other reasons cannot be tested full size in tension, shall be subject to a shear test to be performed in accordance with **12.2.1**. The test results shall conform to the following minimum shear-strength requirements: 37 ksi (255 MPa) for 2024-T4.

6.2 *Nuts*—Nuts shall be tested in accordance with the mechanical requirements for the applicable type and shall meet the minimum proof-load requirements in **Table 1**.

7. Significance of Numerical Limits

7.1 For purposes of determining compliance with the specified limits for requirements of the properties listed in this specification, an observed value or calculated value shall be rounded in accordance with Practice **E29**.

8. Dimensions

8.1 *Bolts and Nuts:*

8.1.1 *Bolts*—Bolts shall be full-size body in accordance with the requirements of AMSE B18.2.1, except the full-body length listed in **Table 4** shall be the basis of manufacture and inspection. Unless otherwise specified, hex bolts shall be furnished. The ends of the bolts need not be chamfered or pointed.

8.1.2 *Nuts*—The dimensions of the nuts shall be in accordance with the requirements of ASME B 18.2.2. Unless otherwise specified, nuts are to be either the regular hex series or a recessed hex series that allows penetration of the bolt threads into the nut recess area.

8.2 *Threads:*

8.2.1 *Bolts*—Unless otherwise specified, the bolts shall be Class 2A threads in accordance with ASME B1.1.

8.2.2 *Nuts*—Unless otherwise specified, the nuts shall be Class 2B threads in accordance with ASME B1.1.

9. Workmanship, Finish, and Appearance

9.1 *Workmanship*—Bolts and nuts shall have a workmanlike finish free of injurious burrs, seams, laps, irregular surfaces, and other imperfections affecting serviceability.

9.2 *Finish:*

9.2.1 *Bolts*—Unless otherwise specified, bolts shall be furnished anodized per MIL-STD-A-8625, Type II, Class 2 and color coded for length as indicated in **Table 4**.

9.2.2 *Nuts*—Unless otherwise specified, nuts shall be furnished waxed.

10. Sampling

10.1 A lot, for the purposes of selecting test specimens, shall consist of no more than 100 000 pieces offered for inspection at one time having the following common characteristics:

- 10.1.1 One type of item (that is, bolts or nuts),
- 10.1.2 Same alloy and temper,
- 10.1.3 One nominal diameter and thread series, and
- 10.1.4 One nominal length or thickness.

TABLE 1 Tensile Strength of 2024-T4 Bolts and Proof Loads for 6061-T6 and 6262-T9 Nuts^A

Bolt Size, in.	Tensile Strength, min, lbf (kN)
5/8	12 400 (55)
3/4	18 400 (82)
7/8	25 400 (113)

^A Based on a tensile unit stress of 55 000 psi (380 MPa) and the thread stress area calculated as follows:

$$A_s = 0.7854 [D - (0.9743/n)]^2$$

where:

- A_s = stress area,
- D = nominal diameter, and
- n = threads/in.