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Standard Specification for Compressible-Washer-Type Direct Tension Indicators for Use with Structural Fasteners, Inch and Metric Series¹

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1. Scope*

1.1 This specification covers the requirements for compressible-washer-type direct tension indicators, (DTIs) capable of indicating the achievement of a specified minimum tension in a structural bolting assembly.

1.2 Eight types of DTIs in nominal diameter sizes ½ through 1 ½ in. as well as M16 through M36 are covered:

1.2.1 *Type 325-1*—DTIs for use with Specification **F3125** Grade **A325** Type 1 bolts or Grade **F1852** assemblies.

1.2.2 *Type 325-3*—DTIs for use with Specification **F3125** Grade **A325** Type 3 bolts or Grade **F1852** Type 3 assemblies.

1.2.3 *Type 490-1*—DTIs for use with Specification **F3125** Grade **A490** Type 1 bolts or Grade **F2280** assemblies.

1.2.4 *Type 490-3*—DTIs for use with Specification **F3125** Grade **A490** Type 3 bolts Grade **F2280** Type 3 assemblies.

1.2.5 *Type 8.8-1*—DTIs for use with Specification **F3125** Grade **A325M** Type 1 bolts.

1.2.6 *Type 8.8-3*—DTIs for use with Specification **F3125** Grade **A325M** Type 3 bolts.

1.2.7 *Type 10.9-1*—DTIs for use with Specification **F3125** Grade **A490M** Type 1 bolts.

1.2.8 *Type 10.9-3*—DTIs for use with Specification **F3125** Grade **A490M** Type 3 bolts.

1.3 DTIs are intended for installation with the protrusions against a hardened surface such as a bolt head, a hardened nut, or a hardened washer. (See Research Council on Structural Connections: Specification for Structural Joints Using High-Strength Bolts.)

1.4 This specification provides for furnishing Type 3 DTIs to a Chemical Composition Requirement or a Corrosion Resistance Index (CRI) at the manufacturer's discretion.

1.5 Terms used in this specification are defined in Terminology **F1789** unless otherwise specified.

¹ This specification is under the jurisdiction of ASTM Committee **F16** on Fasteners and is the direct responsibility of Subcommittee **F16.06** on Steel Washers and Rivets.

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1.6 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.7 The following precautionary statement pertains only to the test method portions, Section **10** and **Appendix X1** of this specification: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.8 *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

A325 Specification for Structural Bolts, Steel, Heat Treated, 120/105 ksi Minimum Tensile Strength (Withdrawn 2016)³

A325M Specification for Structural Bolts, Steel, Heat Treated 830 MPa Minimum Tensile Strength (Metric) (Withdrawn 2016)³

A490 Specification for Structural Bolts, Alloy Steel, Heat Treated, 150 ksi Minimum Tensile Strength (Withdrawn 2016)³

A490M Specification for High-Strength Steel Bolts, Classes 10.9 and 10.9.3, for Structural Steel Joints (Metric) (Withdrawn 2016)³

A1059 Specification for Zinc Alloy Thermo-Diffusion Coatings (TDC) on Steel Fasteners, Hardware, and Other Products

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at www.astm.org/contact. 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.

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



B695 Specification for Coatings of Zinc Mechanically Deposited on Iron and Steel

F436/F436M Specification for Hardened Steel Washers Inch and Metric Dimensions

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

F1789 Terminology for F16 Mechanical Fasteners

F1852 Specification for “Twist Off” Type Tension Control Structural Bolt/Nut/Washer Assemblies, Steel, Heat Treated, 120/105 ksi Minimum Tensile Strength (Withdrawn 2016)³

F2280 Specification for “Twist Off” Type Tension Control Structural Bolt/Nut/Washer Assemblies, Steel, Heat Treated, 150 ksi Minimum Tensile Strength (Withdrawn 2016)³

F3125 Specification for High Strength Structural Bolts and Assemblies, Steel and Alloy Steel, Heat Treated, Inch Dimensions 120 ksi, 144 ksi, and 150 ksi Minimum Tensile Strength, and Metric Dimensions 830 MPa and 1040 MPa Minimum Tensile Strength

G101 Guide for Estimating the Atmospheric Corrosion Resistance of Low-Alloy Steels

2.2 *Research Council on Structural Connections*:⁴
Specification for Structural Joints Using High-Strength Bolts

2.3 *ASME Standard*:⁵

ASME B18.2.6 Fasteners for Use in Structural Applications

ASME B18.2.6M Fasteners for Use in Structural Applications

3. Ordering Information

3.1 Orders for DTIs under this specification shall include the following:

- 3.1.1 Quantity (number of pieces);
- 3.1.2 Name of product (DTI);
- 3.1.3 Size, that is, nominal diameter;
- 3.1.4 ASTM designation and year of issue (if not specified, current issue shall be used);
- 3.1.5 Type required, 325-1, 325-3, 490-1, 490-3, 8.8-1, 8.8-3, 10.9-1, 10.9-3 (see 1.2);
- 3.1.6 Coating type, if required (4.4);
- 3.1.7 Source inspection, if required (Section 11);
- 3.1.8 Test reports, if required (Section 13); and
- 3.1.9 Any special requirements.

4. Materials and Manufacture

4.1 Steel used in the manufacture of DTIs shall be produced by the basic-oxygen or electric-furnace process.

4.2 *Design*:

4.2.1 DTIs shall have a configuration produced by extrusion, punching, pressing, or similar forming, to permit a measurable decrease in thickness when placed in compression.

4.2.2 The design shall be such that the degree of plastic deformation shall indicate the tension in a tightened structural bolt. Supplementary indications of tension are permissible.

4.3 *Heat Treatment*:

4.3.1 The heat treatment of DTIs is optional at the manufacturer's discretion, provided the DTIs meet all of the mechanical and performance requirements.

4.3.2 If heat treatment is performed, the process shall be through-hardening by heating to a temperature above the upper transformation temperature, quenching in a liquid medium, and tempering by reheating to not less than 800 °F/427 °C.

4.4 *Protective Coatings*:

4.4.1 Unless otherwise specified, the DTIs shall be furnished “plain” with the “as fabricated” surface finish without protective coatings.

4.4.2 When “zinc coated” or “galvanized” is specified, the DTIs shall be zinc coated by the mechanical deposition process in accordance with the requirements of Class 55 of Specification **B695**, or the DTIs shall be zinc coated by the thermal diffusion process in accordance with the requirements of Class 25 of Specification **A1059**.

4.4.3 Other coatings are to be used only when approved by the DTI manufacturer.

5. Chemical Composition

5.1 DTIs shall conform to the full Heat Analysis specified in **Table 1** or the requirements of 5.2.

5.1.1 For all types furnished to the chemical compositions in **Table 1**, Product Analysis may be made by the purchaser from finished DTIs representing each lot. The chemical composition shall conform to the requirements given in **Table 1**, Product Analysis.

5.2 Type 3 products having Copper, Phosphorus, and Sulfur conforming to **Table 1** and a Corrosion Resistance Index of 6 or higher calculated on the basis of the Heat Analysis as described in Guide **G101** shall be considered acceptable. See **Note 1**.

NOTE 1—The user is cautioned that the Guide **G101** predictive equation for calculation of an atmospheric corrosion index has been verified only for the composition limits stated in that guide.

5.2.1 Product Analyses are not applicable to Type 3 indicators furnished to a CRI of 6 or higher. Acceptance shall be based on the CRI of 6 or higher calculated from the Heat Analysis. Other specified Type 3 Steels with Copper, Phosphorus, and Sulfur conforming to the specified limits and a Corrosion Resistance of 6 or higher, are acceptable in lieu of compliance with the full specified Chemical Compositions.

6. Performance Requirements

6.1 *Compression Loads*—When the gap of inch series DTIs are compressed to 0.015 in. or metric series DTIs to 0.4 mm, the compression load shall conform to the requirements specified in **Table 2**.

⁴ Available from Research Council on Structural Connections at www.boltcouncil.org.

⁵ Available from American Society of Mechanical Engineers (ASME), ASME International Headquarters, Three Park Ave., New York, NY 10016-5990, <http://www.asme.org>.