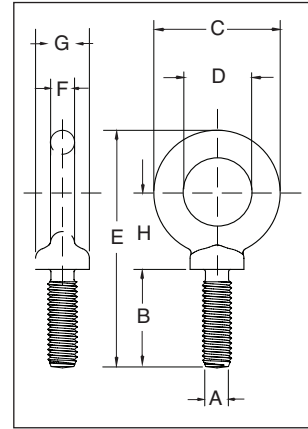


# Forged Machinery Eye Bolts



**S-279 / M-279**  
Shoulder Type  
Machinery  
Eye Bolts

- Forged Steel - Quenched & Tempered.
- Working Load Limits shown are for in-line pull. For angle loading, see page 200.
- Fatigue rated at 1-1/2 times the Working Load Limit at 20,000 cycles.
- Recommended for in-line pull.
- S-279 threaded UNC.
- M-279 metric threaded.
- Meets or exceeds all requirements of ASME B30.26 including identification, ductility, design factor, proof load and temperature requirements. Importantly, these bolts meet other critical performance requirements including fatigue life, impact properties and material traceability, not addressed by ASME B30.26.



**Fatigue Rated**



## S-279 UNC Shoulder Type Machinery Eye Bolts

Size (in.)	S-279 Stock No.	Working Load Limit (lbs.)*	Weight Per 100 (lbs.)	Dimensions (in.)							
				A** Thread	B	C	D	E	F	G	H
1/4 x 1	9900182	650	5.00	1/4 - 20	1.02	1.13	.75	2.29	.19	.53	.77
5/16 x 1-1/8	9900191	1200	9.00	5/16 - 18	1.15	1.38	.88	2.74	.25	.59	.95
3/8 x 1-1/4	9900208	1550	15.00	3/8 - 16	1.27	1.62	1.00	3.07	.31	.69	1.05
1/2 x 1-1/2	9900217	2600	28.00	1/2 - 13	1.53	1.95	1.19	3.70	.38	.91	1.27
5/8 x 1-3/4	9900226	5200	55.00	5/8 - 11	1.79	2.38	1.38	4.45	.50	1.13	1.53
3/4 x 2	9900235	7200	96.00	3/4 - 10	2.05	2.76	1.50	5.07	.63	1.38	1.71
7/8 x 2-1/4	9900244	10600	154.00	7/8 - 9	2.31	3.25	1.75	5.87	.75	1.56	2.00
1 x 2-1/2	9900253	13300	238.00	1 - 8	2.57	3.76	2.00	6.66	.88	1.81	2.30
1-1/8 x 2-3/4	9900257	15000	320.00	1-1/8 - 7	2.75	4.19	2.25	7.20	.97	2.06	2.35
1-1/4 x 3	9900262	21000	399.00	1-1/4 - 7	3.09	4.50	2.50	7.95	1.00	2.28	2.73
1-1/2 x 3-1/2	9900271	24000	720.00	1-1/2 - 6	3.60	5.50	3.00	9.49	1.25	2.75	3.28
1-3/4 x 3-3/4	9900280	34000	1040.00	1-3/4 - 5	3.75	6.26	3.50	10.48	1.38	3.00	3.60
2 x 4	9900289	42000	1880.00	2 - 4-1/2	4.00	7.62	4.00	12.31	1.81	3.38	4.50
2-1/2 x 5	9900298	65000	3250.00	2-1/2 - 4	5.00	8.76	4.50	14.88	2.12	4.25	5.50

\*Ultimate Load is 5 times the Working Load Limit. Maximum Proof Load is 2 times the Working Load Limit. \*\* All bolts threaded UNC.



## M-279 Metric

Size (mm)	M-279 Stock No.	Working Load Limit (kg)*	Weight Each (kg)	Dimensions (mm)							
				A** Thread	B	C	D	E	F	G	H
M6 x 13	1045753	200	.03	M6 x 1.0	13.0	28.7	19.1	47.0	4.9	13.5	19.6
M8 x 13	1045789	400	.05	M8 x 1.25	13.0	35.1	22.4	54.6	6.4	15.0	24.1
M10 x 17	1045833	640	.07	M10 x 1.5	17.0	41.1	25.4	64.3	7.9	17.5	26.5
M12 x 20.5	1045869	1000	.11	M12 x 1.75	20.5	49.5	30.2	77.7	9.7	23.1	32.8
M16 x 27	1045913	1800	.25	M16 x 2.0	27.0	60.5	35.1	96.0	12.7	28.7	38.9
M20 x 30	1045995	2500	.42	M20 x 2.5	30.0	70.0	38.1	108	16.0	35.1	43.4
M24 x 36	1046029	4000	1.05	M24 x 3.0	36.0	95.5	51.0	142	22.4	46.0	58.4
M27 x 69.8	1046038	5000	1.42	M27 x 3.0	69.8	107	57.1	183	24.6	52.3	59.7
M30 x 45	1046075	6000	1.77	M30 x 3.5	45.0	114	63.5	171	25.4	58.0	69.3
M36 x 54	1046109	8500	3.12	M36 x 4.0	54.0	140	76.0	207	31.8	70.0	83.3
M42 x 95.2	1046118	14000	4.58	M42 x 4.5	95.2	159	88.9	266	35.0	76.2	91.4
M48 x 102	1046127	17300	8.71	M48 x 5.0	102	194	101	313	46.0	85.9	114
M64 x 127	1046136	29500	14.74	M64 x 6.0	127	223	114	378	53.8	108	140

\*Ultimate Load is 5 times the Working Load Limit. Maximum Proof Load is 2 times the Working Load Limit. \*\* On Request: Special threading or as forged bolts for customer conversion.

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**FORGED EYE BOLT**

**WARNINGS & APPLICATION INSTRUCTIONS**



**⚠ WARNING**

- Load may slip or fall if proper eye bolt assembly and lifting procedures are not used.
- A falling load can seriously injure or kill.
- Read and understand these instructions, and follow all eye bolt safety information presented here.
- Read, understand, and follow information in diagrams and charts below before using eye bolt assemblies.

**Important Safety Information - Read & Follow**

**Inspection/Maintenance Safety:**

- Always inspect eye bolt before use.
- Never use eye bolt that shows signs of wear or damage.
- Never use eye bolt if eye or shank is bent or elongated.
- Always be sure threads on shank and receiving holes are clean.
- Never machine, grind, or cut eye bolt.
- Do not leave threaded end of machinery eye bolt in aluminum loads for long periods of time as it may cause corrosion.

**Assembly Safety:**

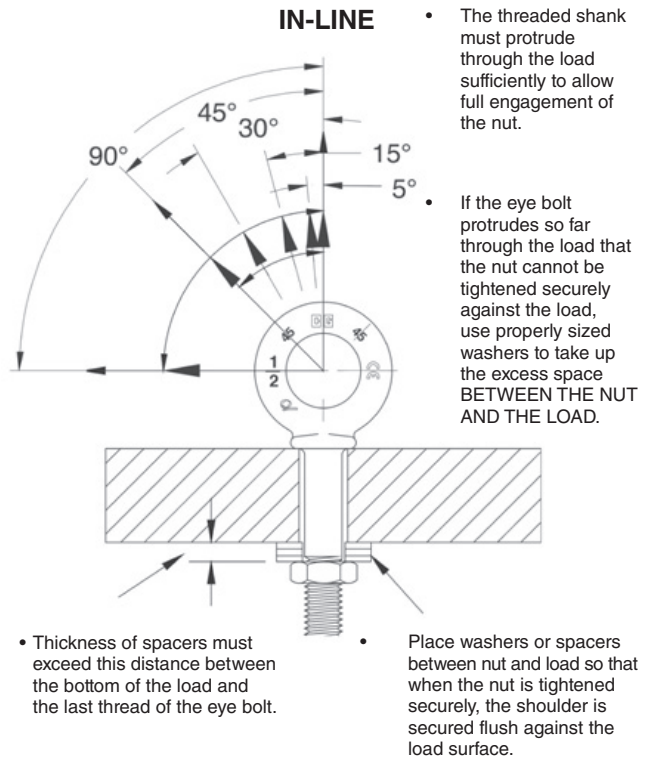
- Never exceed load limits specified in Table 1 & Table 2.
- Never use regular nut eye bolts for angular lifts.
- Always use shoulder nut eye bolts (or machinery eye bolts) for angular lifts.
- For angular lifts, adjust working load as follows:

ANGLE FROM "IN-LINE"	ADJUSTED WORKING LOAD LIMIT
5 degrees	100% of rated working load
15 degrees	80% of rated working load
30 degrees	65% of rated working load
45 degrees	30% of rated working load
90 degrees	25% of rated working load

- Never undercut eye bolt to seat shoulder against the load.
- Always countersink receiving hole or use washers with sufficient I.D. to seat shoulder.
- Always screw eye bolt down completely for proper seating.
- Always tighten nuts securely against the load.

Size (in.)	Working Load Limit (lbs.)
1/4	650
5/16	1,200
3/8	1,550
1/2	2,600
5/8	5,200
3/4	7,200
7/8	10,600
1	13,300
1-1/8	15,000
1-1/4	21,000
1-1/2	24,000
1-3/4	34,000
2	42,000
2-1/2	65,000

**Shoulder Nut Eye Bolt – Installation for Angular Loading**



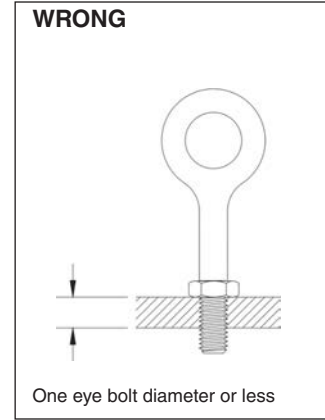
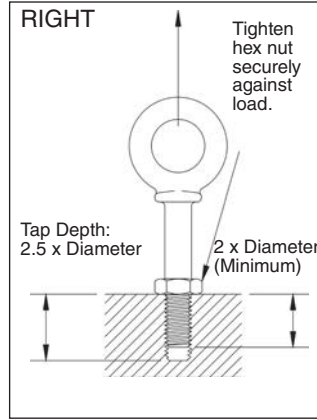
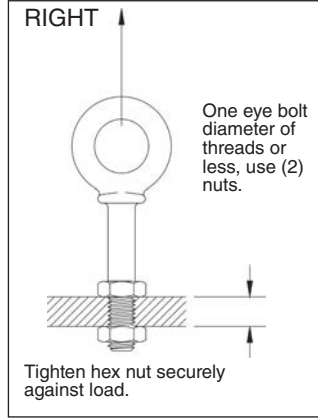
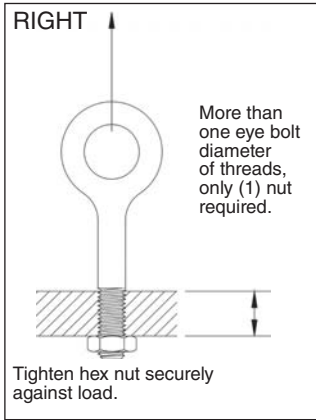
**Figure 1**

Metric Size	Working Load Limit - kg
m6	200
m8	400
m10	640
m12	1000
m16	1800
m20	2500
m24	4000
m27	5000
m30	6000
m36	8500
m42	14000
m48	17300
m64	29500



# Important – Read and understand these instructions before using eye bolts.

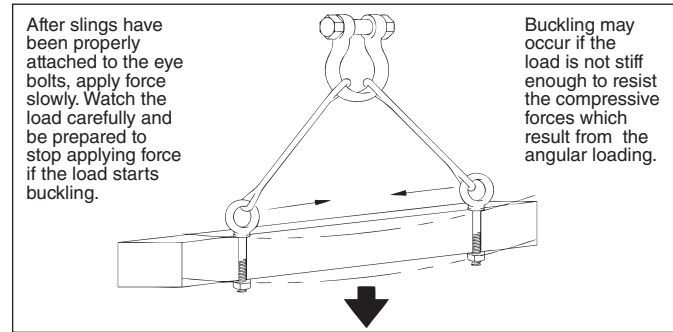
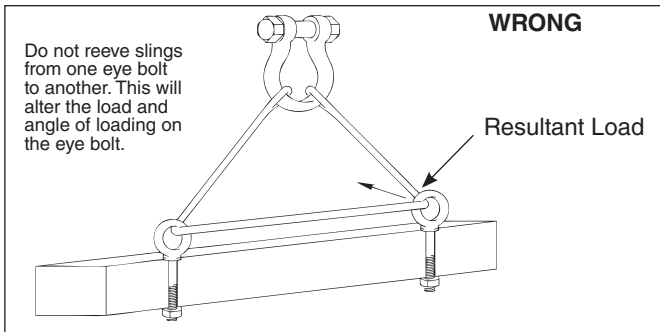
## Regular Nut & Shoulder Nut Eye Bolt – Installation for In-Line Loading



### Operating Safety

- Always stand clear of load.
- Always lift load with steady, even pull – do not jerk.
- Always apply load to eye bolt in the plane of the eye – not at an angle.

- Never exceed the capacity of the eye bolt—see Table 1 & 2.
- When using lifting slings of two or more legs, make sure the loads in the legs are calculated using the angle from the vertical sling angle to the leg and properly size the shoulder nut or machinery eye bolt for the angular load.



## Machinery Eye Bolt - Installation for In-Line & Angular Loading

These eye bolts are primarily intended to be installed into tapped holes.

1. After the loads on the eye bolts have been calculated, select the proper size eye bolt for the job.

For angular lifts, adjust working load as follows:

Direction of Pull (from In-Line)	Adjusted Working Load
45 degrees	30% of rated working load
90 degrees	25% of rated working load

2. Drill and tap the load to the correct sizes to a minimum depth of one-half the eye bolt size beyond the shank length of the machinery eye bolt.
3. Thread the eye bolt into the load until the shoulder is flush and securely tightened against the load.
4. If the plane of the machinery eye bolt is not aligned with the sling line, estimate the amount of unthreading rotation necessary to align the plane of the eye properly.
5. Remove the machinery eye bolt from the load and add shims (washers) of proper thickness to adjust the angle of the plane of the eye to match the sling line. Use Table 3 to estimate the required shim thickness for the amount of unthreading rotation required.

**Table 3**

Eye Bolt Size (in.)	Shim Thickness Required to Change Rotation 90° (in.)	Eye Bolt Size (mm)	Shim Thickness Required to change Rotation 90° (mm)
1/4	.0125	M6	.25
5/16	.0139	M8	.31
3/8	.0156	M10	.38
1/2	.0192	M12	.44
5/8	.0227	M16	.50
3/4	.0250	M20	.62
7/8	.0278	M24	.75
1	.0312	M27	.75
1-1/8	.0357	M30	.88
1-1/4	.0357	M36	1.00
1-1/2	.0417	M42	1.13
1-3/4	.0500	M48	1.25
2	.0556	M64	1.50
2-1/2	.0625	—	—

