

M18 Bolt Size Chart: Hex Head Dimensions s, e and k

M18	Both standards (GB/T 5783 / 5782) × both grades (A / B)	Nominal (= max) values	Row-level standards
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M18 hex bolt: socket size s = 27 mm; head diagonal e min = 30.14 mm (grade A) / 29.56 mm (grade B); head height k = 11.5 mm nominal, 11.85 mm max in grade B; pitch P = 2.5 mm; fine pitch options (2) / (1.5). Head values are the standard's nominal (= max) or minimum figures, not measured guarantees.

M18 in both standards and both product grades

One row per thread form and product grade. The head columns repeat because GB/T 5783 and GB/T 5782 share the same head; b is tabulated in GB/T 5782 only, and a dash means the standard does not tabulate that value for the combination.

Thread form	Product grade	Coarse pitch P (mm)	Width across flats s (mm, nominal = max)	s min (mm)	Width across corners e min (mm)	Head height k (mm, nominal)	k max (mm)	b at l ≤ 125 mm	b at 125 < l ≤ 200 mm	b at l > 200 mm
Partially threaded (GB/T 5782)	A	2.5	27	26.67	30.14	11.5	11.715	42	48	—
Partially threaded (GB/T 5782)	B	2.5	27	26.16	29.56	11.5	11.85	—	48	—
Fully threaded (GB/T 5783)	A	2.5	27	26.67	30.14	11.5	11.715	—	—	—
Fully threaded (GB/T 5783)	B	2.5	27	26.16	29.56	11.5	11.85	—	—	—

Thread length b on partially threaded bolts (GB/T 5782)

b = 2d + 6 at l ≤ 125 mm, b ≈ 2d + 12 at 125 < l ≤ 200 mm, b ≈ 2d + 25 at l > 200 mm; the tabulated figure is that value rounded to a whole millimetre. Grade A tables carry the shorter bands only; grade B carries the band that applies to each size.

Thread length b by length band, grade B (mm)

Size	b at l ≤ 125 mm	b at 125 < l ≤ 200 mm	b at l > 200 mm
M18	—	48	—

Thread length b by length band, grade A (mm)

Size	b at l ≤ 125 mm	b at 125 < l ≤ 200 mm	b at l > 200 mm
M18	42	48	—

Quote the diameter and the length together: b follows l, so only "M12×100" pins the thread length down.

Fine pitch hex bolts (GB/T 5785): fine thread against coarse thread

One diameter, one head: every fine pitch of the same d shares the same s, e, k and r, so the socket size does not change with the pitch.

Nominal diameter d (mm)	Fine pitch P (mm)	Coarse pitch P (mm)
M18	(2) / (1.5)	2.5

A pitch in brackets is the non-preferred fine pitch of that diameter in GB/T 5785-2025; diameters not listed have no fine thread series in that standard.

M18 beside the next sizes

The sizes either side of M18. Measure the thread diameter d with a caliper and compare the head against the rows below before ordering; the nominal diameter steps by 0.5 mm or 1 mm in this range.

Size	Coarse pitch P (mm)	Width across flats s (mm, nominal = max)	Width across corners e min (mm)	Head height k (mm, nominal)
M16 (d = 16)	2	24	26.17	10
M18 (d = 18)	2.5	27	29.56	11.5
M20 (d = 20)	2.5	30	32.95	12.5

Which number do you need: s, e or k?

"Bolt size" means three different numbers depending on the job, and order codes use a fourth. Buying a tool uses s, checking a head that will not go into a socket uses e, and a counterbore or a flush-head check uses k.

- s — width across flats (nominal = max) — M18 is s = 27 mm. This is the socket, spanner or ring size, and the number stamped on the tool. It is the same in grade A and grade B and the same in GB/T 5783 and GB/T 5782, because the two standards share the hex head.

- **e — width across corners (min)** — M18 is e min = 30.14 mm in grade A and 29.56 mm in grade B. This is the diagonal between two opposite corners of the head, the dimension that decides whether a 12-point socket or a ring spanner passes over the head. Most published bolt size charts leave this column out; it is also what you can still measure with a caliper once the flats have been rounded off.
- **k — head height (nominal, with a max)** — M18 is k = 11.5 mm nominal and 11.85 mm max in grade B. It sets how deep a counterbore or recess has to be and how far the head stands above the part. When the head must not protrude, k is the number to check, not s.
- **d — nominal thread diameter** — The number in the callout: M18 is a 18 mm thread, not a 18 mm head. The head is always wider, 27 mm across the flats here, which is where ordering by "size" alone goes wrong.
- **r — fillet radius under the head (min)** — r min = 0.6 mm at M18. The washer face has to clear this radius, so it matters when the bolt sits in a corner, against a shoulder or in a slotted hole rather than on a flat face.

References

- GB/T 5783-2025 Hexagon head bolts, fully threaded - width across flats s, s min, width across corners e min, head height k and fillet radius r min, product grades A and B; thread length rule b = l – a — https://openstd.samr.gov.cn/bzgk/gb/std?std_no=GB%2FT%205783-2025
- GB/T 5782-2025 Hexagon head bolts, partially threaded - the same head dimensions, plus the thread length b in three nominal-length bands (l ≤ 125 mm, 125 < l ≤ 200 mm, l > 200 mm) — https://openstd.samr.gov.cn/bzgk/gb/std?std_no=GB%2FT%205782-2025
- GB/T 5785-2025 Hexagon head bolts with fine pitch thread - fine pitch options per nominal diameter and the same hex head (s, e, k unchanged) — https://openstd.samr.gov.cn/bzgk/gb/std?std_no=GB%2FT%205785-2025
- Table values are the nominal (= max) or minimum figures of the standard editions above, checked row by row against the official text. No table values are reproduced from third-party dimension tables, and every row is labelled with the standard it comes from.

Disclaimer: this table is a selection and quotation reference built from the standard editions named on this page, not a design basis or an acceptance standard.

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