

INTERNATIONAL STANDARD

ISO 15480

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Hexagon washer head drilling screws with tapping screw thread

*Vis autoperceuses à tête hexagonale à embase plate, avec filetage de vis
à tôle*

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Reference number
ISO 15480:1999(E)

ISO 15480:1999(E)**Foreword**

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International Standard ISO 15480 was prepared by Technical Committee ISO/TC 2, *Fasteners*.

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Hexagon washer head drilling screws with tapping screw thread

1 Scope

This International Standard specifies the characteristics of hexagon washer head drilling screws with tapping screw threads from ST2,9 up to and including ST6,3.

2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this International Standard. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

ISO 1478:1999, *Tapping screw thread*.

ISO 3269:—¹⁾, *Fasteners — Acceptance inspection*.

ISO 4042:1999, *Fasteners — Electroplated coatings*.

ISO 4759-1:—²⁾, *Tolerances for fasteners — Part 1: Bolts, screws, studs and nuts — Product grades A, B and C*.

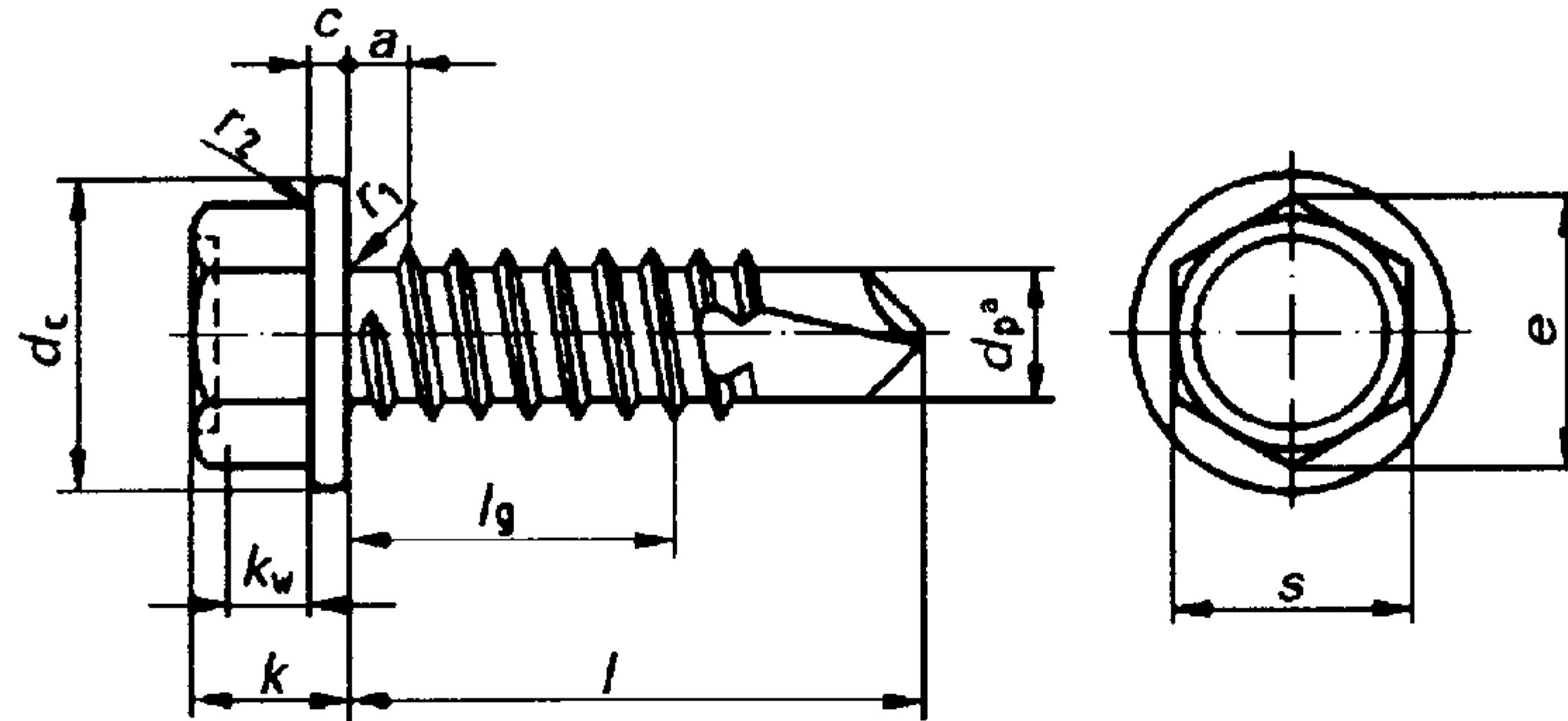
ISO 10666:1999, *Drilling screws with tapping screw thread — Mechanical and functional properties*.

¹⁾ To be published. (Revision of ISO 3269:1988)

²⁾ To be published. (Revision of ISO 4759-1:1978)

3 Dimensions

See Figure 1 and Table 1.



^a The function of the drilling point (diameter d_p) is specified in ISO 10666.

Figure 1

Table 1 — Dimensions

Dimensions in millimetres

Thread		ST2,9	ST3,5	ST4,2	ST4,8	ST5,5	ST6,3	
p^a		1,1	1,3	1,4	1,6	1,8	1,8	
a^b	max.	1,1	1,3	1,4	1,6	1,8	1,8	
d^c	max.	6,3	8,3	8,8	10,5	11	13,5	
	min.	5,8	7,6	8,1	9,8	10	12,2	
c	min.	0,4	0,6	0,8	0,9	1	1	
s	nom. = max.	4,00 ^c	5,50	7,00	8,00	8,00	10,00	
	min.	3,82	5,32	6,78	7,78	7,78	9,78	
e	min.	4,28	5,96	7,59	8,71	8,71	10,95	
k	nom. = max.	2,8	3,4	4,1	4,3	5,4	5,9	
	min.	2,5	3,0	3,6	3,8	4,8	5,3	
k_w^d	min.	1,3	1,5	1,8	2,2	2,7	3,1	
r_1	max.	0,4	0,5	0,6	0,7	0,8	0,9	
r_2	max.	0,2	0,25	0,3	0,3	0,4	0,5	
Drilling range (sheet or plate thickness) ^e	from	0,7	0,7	1,75	1,75	1,75	2	
	to	1,9	2,25	3	4,4	5,25	6	
l		l_g^f						
nom.	min.	max.	min.					
9,5	8,75	10,25	3,25	2,85				
13	12,1	13,9	6,6	6,2	4,3	3,7		
16	15,1	16,9	9,6	9,2	7,3	5,8	5	
19	18	20	12,5	12,1	10,3	8,7	8	
22	21	23		15,1	13,3	11,7	11	
25	24	26		18,1	16,3	14,7	14	
32	30,75	33,25			23	21,5	21	
38	36,75	39,25			29	27,5	27	
45	43,75	46,25				34,5	34	
50	48,75	51,25				39,5	39	

a P is the pitch of the thread.

b a is the distance from the underside of the head to the first major diameter of the thread.

c Divergence from the width across flats for hexagon tapping screws in accordance with ISO 1479 (5 mm). In the case of hexagon washer head tapping screws (see ISO 7053) the width across flats of 4 mm has been introduced worldwide and also applies in this case.

d k_w is the wrenching height.

e In order to determine the nominal length l it may be necessary to add an air gap (if present) to the individual sheet or plate thickness.

f l_g is the distance from the underside of the head to the last major diameter of the thread.

4 Specifications and reference International Standards

See Table 2.

Table 2 — Specifications and reference International Standards

Material		Steel
	International Standard	ISO 10666
Thread	International Standard	ISO 1478
Mechanical and functional properties	International Standard	ISO 10666
Tolerances	Product grade	A
	International Standard	ISO 4759-1
Finish		Plain Requirements for electroplating are covered in ISO 4042.
Acceptability		Acceptance procedure is covered in ISO 3269.

5 Designation

EXAMPLE A hexagon washer head drilling screw with thread ST3,5 and nominal length $l = 16$ mm is designated as follows:

Drilling screw ISO 15480 - ST3,5 × 16

Bibliography

- [1] ISO 1479:1983, *Hexagon head tapping screws.*
- [2] ISO 7053:1992, *Hexagon washer head tapping screws.*

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