

INTERNATIONAL
STANDARD

ISO
15480

First edition
1999-09-01

**Hexagon washer head drilling screws
with tapping screw thread**

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

STANDARDSISO.COM : Click to view the full PDF of ISO 15480:1999



Reference number
ISO 15480:1999(E)

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

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

STANDARDSISO.COM : Click to view the full PDF of ISO 15480:1999

© ISO 1999

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from the publisher.

International Organization for Standardization
Case postale 56 • CH-1211 Genève 20 • Switzerland
Internet iso@iso.ch

Printed in Switzerland

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*.

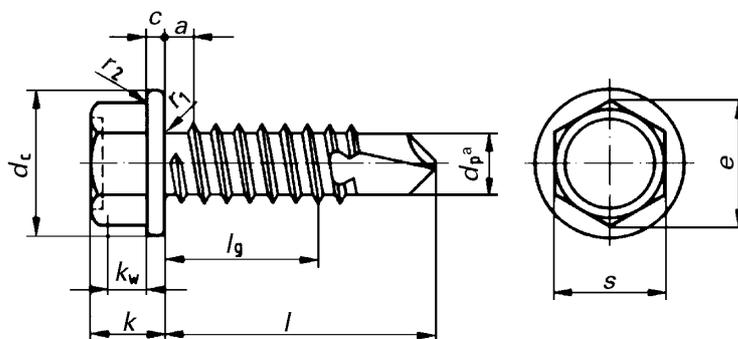
ISO 10666:1999, *Drilling screws with tapping screw thread — Mechanical and functional properties*.

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

STANDARDSISO.COM : Click to view the full PDF of ISO 15480:1999

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 | 7 |
| 22 | 21 | 23 | | 15,1 | 13,3 | 11,7 | 11 | 10 |
| 25 | 24 | 26 | | 18,1 | 16,3 | 14,7 | 14 | 13 |
| 32 | 30,75 | 33,25 | | | 23 | 21,5 | 21 | 20 |
| 38 | 36,75 | 39,25 | | | 29 | 27,5 | 27 | 26 |
| 45 | 43,75 | 46,25 | | | | 34,5 | 34 | 33 |
| 50 | 48,75 | 51,25 | | | | 39,5 | 39 | 38 |

^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