

INTERNATIONAL
STANDARD

ISO
15482

First edition
1999-08-01

**Cross recessed countersunk head drilling
screws with tapping screw thread**

*Vis autoperceuses à tête fraisée à empreinte cruciforme, avec filetage de
vis à tôle*

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Reference number
ISO 15482:1999(E)

Foreword

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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 15482 was prepared by Technical Committee ISO/TC 2, *Fasteners*.

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Cross recessed countersunk head drilling screws with tapping screw thread

1 Scope

This International Standard specifies the characteristics of cross recessed countersunk 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 4757:1983, *Cross recesses for screws*.

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

ISO 7721:1983, *Countersunk head screws — Head configuration and gauging*.

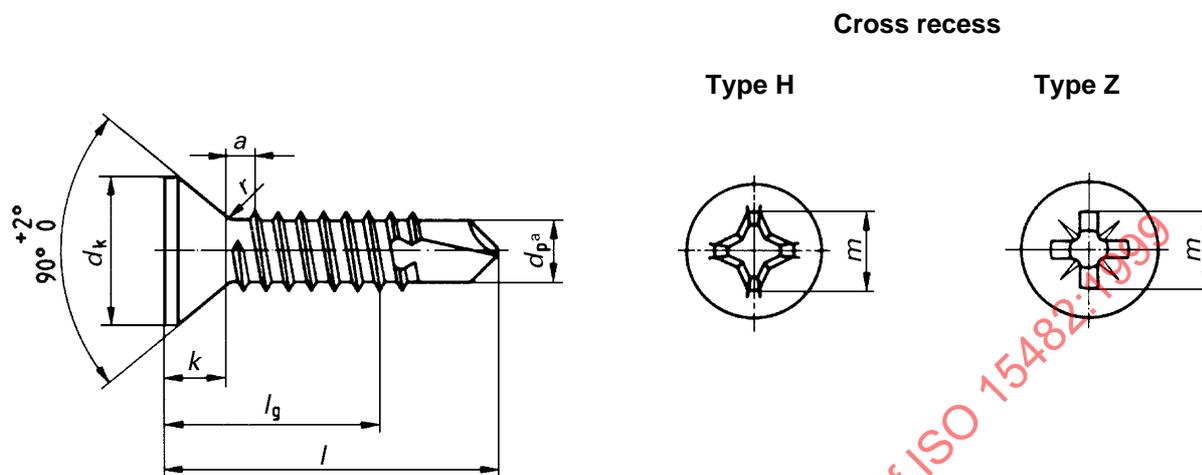
ISO 10666:1999, *Drilling screws with tapping screw thread — Mechanical and functional properties*.

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

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Table 1 — Dimensions

Dimensions in millimetres

| Thread size | | | 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_k | theoretical ^c | max. | 6,3 | 8,2 | 9,4 | 10,4 | 11,5 | 12,6 | |
| | | actual | | | | | | | |
| | | max. | 5,5 | 7,3 | 8,4 | 9,3 | 10,3 | 11,3 | |
| | | min. | 5,2 | 6,9 | 8,0 | 8,9 | 9,9 | 10,9 | |
| k | | max. | 1,7 | 2,35 | 2,6 | 2,8 | 3 | 3,15 | |
| r | | max. | 1,2 | 1,4 | 1,6 | 2 | 2,2 | 2,4 | |
| Cross recess | Recess No. | | 1 | 2 | | | 3 | | |
| | Type H | m ref. | 3,2 | 4,4 | 4,6 | 5,2 | 6,6 | 6,8 | |
| | | Penetration | max. | 2,1 | 2,4 | 2,6 | 3,2 | 3,3 | 3,5 |
| | | | min. | 1,7 | 1,9 | 2,1 | 2,7 | 2,8 | 3,0 |
| | Type Z | m ref. | 3,2 | 4,3 | 4,6 | 5,1 | 6,5 | 6,8 | |
| | | Penetration | max. | 2 | 2,2 | 2,5 | 3,05 | 3,2 | 3,45 |
| | | | min. | 1,6 | 1,75 | 2,05 | 2,6 | 2,75 | 3,00 |
| Drilling range (sheet or plate thickness) ^d | 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^e | | | | | | |
| nom. | min. | max. | min. | | | | | | |
| 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 See ISO 7721.

^d 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 thicknesses.

^e 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 |
| Cross recesses | International Standard | ISO 4757 |
| 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 cross recessed countersunk head drilling screw with thread ST3,5, nominal length $l = 16$ mm and recess type Z is designated as follows:

Drilling screw ISO 15482 - ST3,5 × 16 - Z