

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION R 1479

HEXAGON HEAD TAPPING SCREWS

METRIC SERIES

1st EDITION

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HEXAGON HEAD TAPPING SCREWS

METRIC SERIES

1. SCOPE

This ISO Recommendation specifies dimensions of hexagon head tapping screws, metric series, and provides a system of standard lengths, i.e. recommended combinations of thread size and nominal length.

2. DIMENSIONS

Principal dimensions are given in the Table opposite. For thread dimensions and thread ends see ISO Recommendation R 1478, *Tapping screw thread - Dimensions in millimetres and inches*.

Nominal sizes of series I should be preferred.

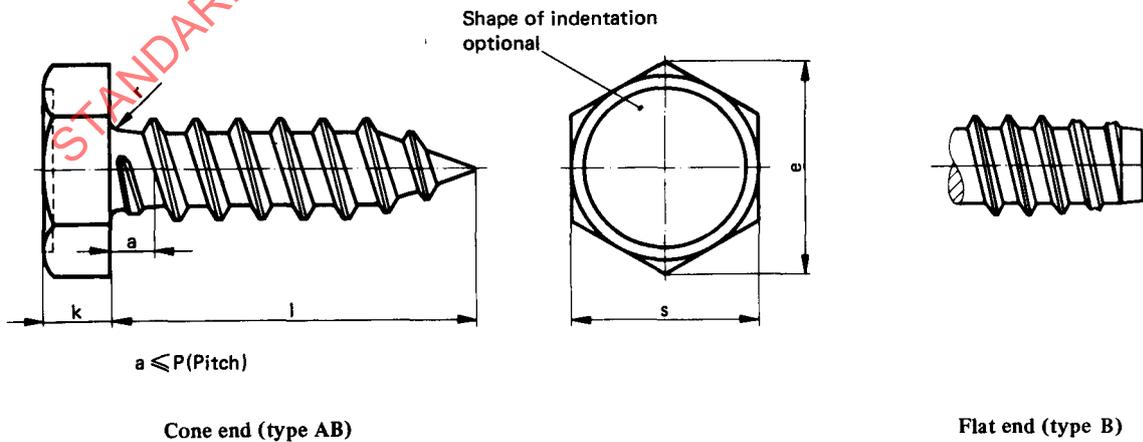


TABLE - Principal dimensions

		Dimensions in millimetres											
Nominal size	Series I		2		4		6		8	10		14($\frac{1}{4}$)	
	Series II	1		3		5		7		12		16($\frac{5}{8}$)	
<i>s</i>	h13	3.2	3.2	4	5	5	5.5	7	7	8	8	10	13
<i>e</i>	min.	3.41	3.41	4.32	5.45	5.45	6.01	7.66	7.66	8.87	8.87	11.05	14.38
<i>k</i>	j_s 14	1.3	1.3	1.4	1.5	1.8	2.3	2.3	2.8	3	4	4.8	5.8
<i>r</i>	max.	0.3	0.35	0.4	0.45	0.5	0.55	0.6	0.65	0.7	0.8	0.9	1.2
Nominal length <i>l</i>		Standard lengths											
3.2	— — — — — — — — — — — — — —												
4.5	— — — — — — — — — — — — — —												
6.5	— — — — — — — — — — — — — —												
9.5	— — — — — — — — — — — — — —												
13	— — — — — — — — — — — — — —												
16	— — — — — — — — — — — — — —												
19	— — — — — — — — — — — — — —												
22	— — — — — — — — — — — — — —												
25	— — — — — — — — — — — — — —												
32	— — — — — — — — — — — — — —												
38	— — — — — — — — — — — — — —												
45	— — — — — — — — — — — — — —												
50	— — — — — — — — — — — — — —												

The standard lengths are given between the stepped solid lines (———).

The upper stepped solid line (———) is the limit of the minimum practical length for both types.

Flat end tapping screws (type B) with lengths above the stepped broken line (---) are short screws and those below this stepped line are long screws, in accordance with ISO Recommendation R 1478.