

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION R 1480

HEXAGON HEAD TAPPING SCREWS

INCH SERIES

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HEXAGON HEAD TAPPING SCREWS

INCH SERIES

1. SCOPE

This ISO Recommendation specifies dimensions of hexagon head tapping screws, inch 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.

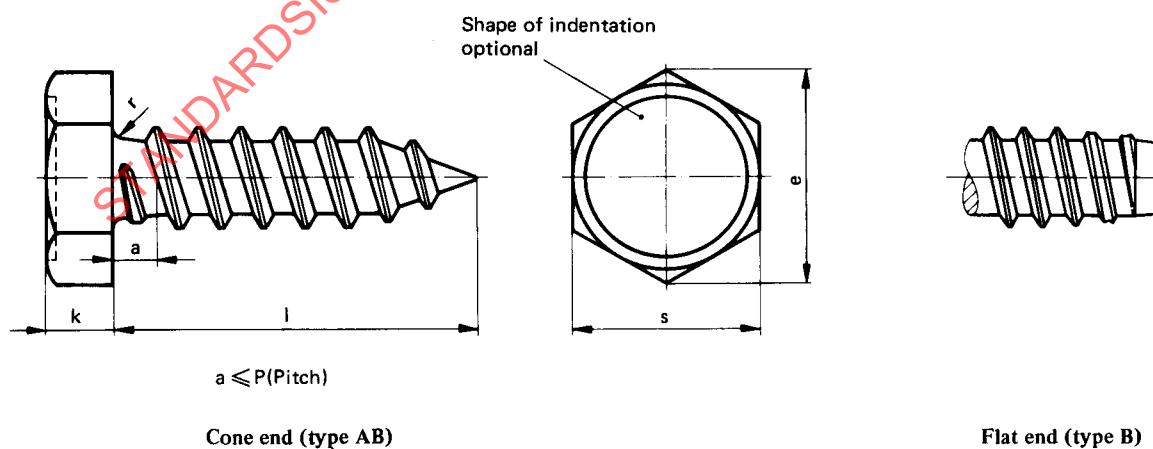


TABLE - Principal dimensions

Dimensions in inches

Nominal size	Series I		2		4		6		8	10		14($\frac{1}{4}$)	
	Series II	1		3		5		7			12		16($\frac{5}{16}$)
<i>s</i>	max.	0.125	0.125	0.187	0.187	0.187	0.250	0.250	0.250	0.312	0.312	0.375	0.500
	min.	0.120	0.120	0.181	0.181	0.181	0.244	0.244	0.244	0.305	0.305	0.367	0.489
<i>e</i>	min.	0.136	0.136	0.205	0.205	0.205	0.276	0.276	0.276	0.345	0.345	0.415	0.553
<i>k</i>	max.	0.050	0.050	0.055	0.060	0.070	0.093	0.093	0.110	0.120	0.155	0.190	0.230
	min.	0.040	0.040	0.044	0.049	0.058	0.080	0.080	0.096	0.105	0.139	0.172	0.208
<i>r</i>	max.	0.011	0.013	0.015	0.017	0.019	0.021	0.023	0.025	0.028	0.032	0.037	0.047
Nominal length <i>l</i>		Standard lengths											
$\frac{1}{8}$			—	—	—	—	—	—	—	—	—	—	—
$\frac{3}{16}$				—	—	—	—	—	—	—	—	—	—
$\frac{1}{4}$										—	—	—	—
$\frac{3}{8}$											—	—	—
$\frac{1}{2}$												—	—
$\frac{5}{8}$													—
$\frac{3}{4}$													
$\frac{7}{8}$													
1													
$1\frac{1}{4}$													
$1\frac{1}{2}$													
$1\frac{3}{4}$													
2													

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.