

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION R 1482

SLOTTED COUNTERSUNK (FLAT) HEAD TAPPING SCREWS

DIMENSIONS IN MILLIMETRES AND INCHES

1st EDITION

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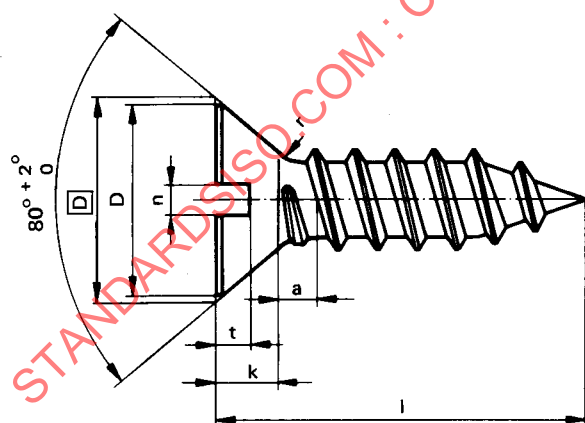
1. SCOPE

This ISO Recommendation specifies dimensions, in millimetres and inches, of slotted countersunk (flat) head tapping screws and provides a system of standard lengths, i.e. recommended combinations of thread size and nominal length.

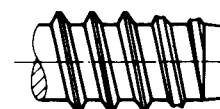
2. DIMENSIONS

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.



Cone end (type AB)



Flat end (type B)

$a \leq P$ (pitch)

TABLE - Principal dimensions

Dimensions in millimetres and inches

Nominal size	Series I			2		4		6		8	10		14($\frac{1}{4}$)		
	Series II	0	1		3		5		7			12		16($\frac{5}{16}$)	
D	theor.	mm	3.02	3.71	4.37	5.05	5.72	6.40	7.09	7.75	8.43	9.78	11.13	12.88	16.13
		in	0.119	0.146	0.172	0.199	0.225	0.252	0.279	0.305	0.332	0.385	0.438	0.507	0.635
	min.	mm	2.51	3.12	3.73	4.34	4.95	5.59	6.20	6.81	7.42	8.64	9.88	11.48	14.43
		in	0.099	0.123	0.147	0.171	0.195	0.220	0.244	0.268	0.292	0.340	0.389	0.452	0.568
k	$\approx$	mm	0.89	1.09	1.30	1.50	1.70	1.90	2.11	2.31	2.54	2.95	3.35	3.89	4.85
		in	0.035	0.043	0.051	0.059	0.067	0.075	0.083	0.091	0.100	0.116	0.132	0.153	0.191
n	min.	mm	0.41	0.48	0.58	0.69	0.79	0.89	0.99	0.99	1.14	1.27	1.42	1.63	1.83
		in	0.016	0.019	0.023	0.027	0.031	0.035	0.039	0.039	0.045	0.050	0.056	0.064	0.072
	max.	mm	0.58	0.66	0.79	0.89	0.99	1.09	1.22	1.22	1.37	1.52	1.70	1.90	2.13
		in	0.023	0.026	0.031	0.035	0.039	0.043	0.048	0.048	0.054	0.060	0.067	0.075	0.084
t	min.	mm	0.25	0.30	0.38	0.43	0.51	0.56	0.61	0.69	0.74	0.86	0.99	1.17	1.47
		in	0.010	0.012	0.015	0.017	0.020	0.022	0.024	0.027	0.029	0.034	0.039	0.046	0.058
	max.	mm	0.38	0.48	0.58	0.69	0.76	0.86	0.97	1.04	1.14	1.35	1.52	1.78	2.24
		in	0.015	0.019	0.023	0.027	0.030	0.034	0.038	0.041	0.045	0.053	0.060	0.070	0.088
r	max.	mm	0.61	0.76	0.89	1.02	1.17	1.32	1.42	1.57	1.68	1.90	2.18	2.46	3.20
		in	0.024	0.030	0.035	0.040	0.046	0.052	0.056	0.062	0.066	0.075	0.086	0.097	0.126
Nominal length															
l		Standard lengths													
mm	in														
3.2	$\frac{1}{8}$		—	—	—	—	—	—	—	—	—	—	—	—	—
4.5	$\frac{3}{16}$					—	—	—	—	—	—	—	—	—	—
6.5	$\frac{1}{4}$						—	—	—	—	—	—	—	—	—
9.5	$\frac{3}{8}$							—	—	—	—	—	—	—	—
13	$\frac{1}{2}$								—	—	—	—	—	—	—
16	$\frac{5}{8}$									—	—	—	—	—	—
19	$\frac{3}{4}$										—	—	—	—	—
22	$\frac{7}{8}$											—	—	—	—
25	1												—	—	—
32	$1\frac{1}{4}$													—	—
38	$1\frac{1}{2}$														—
45	$1\frac{3}{4}$														
50	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.