
International Standard



1478

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Tapping screws thread

Filetage de vis à tôle

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[ISO 1478:1983](#)

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Descriptors : fasteners, screws, tapped screws, screw threads, dimensions.

Price based on 2 pages

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been authorized 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.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 1478 was developed by Technical Committee ISO/TC 2, *Fasteners*, and was circulated to the member bodies in December 1981.

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It has been approved by the member bodies of the following countries:

Australia	Germany, F. R.	ISO 1478:1983
Austria	Hungary	New Zealand
Brazil	India	Norway
Canada	Ireland	Poland
China	Italy	Romania
Czechoslovakia	Japan	South Africa, Rep. of
Denmark	Korea, Dem. P. Rep. of	Spain
Egypt, Arab Rep. of	Korea, Rep. of	Sri Lanka
Finland	Mexico	Sweden
France	Netherlands	Switzerland
		USA

The member bodies of the following countries expressed disapproval of the document on technical grounds:

Belgium
United Kingdom
USSR

This International Standard cancels and replaces ISO Recommendation R 1478-1970, of which it constitutes a technical revision.

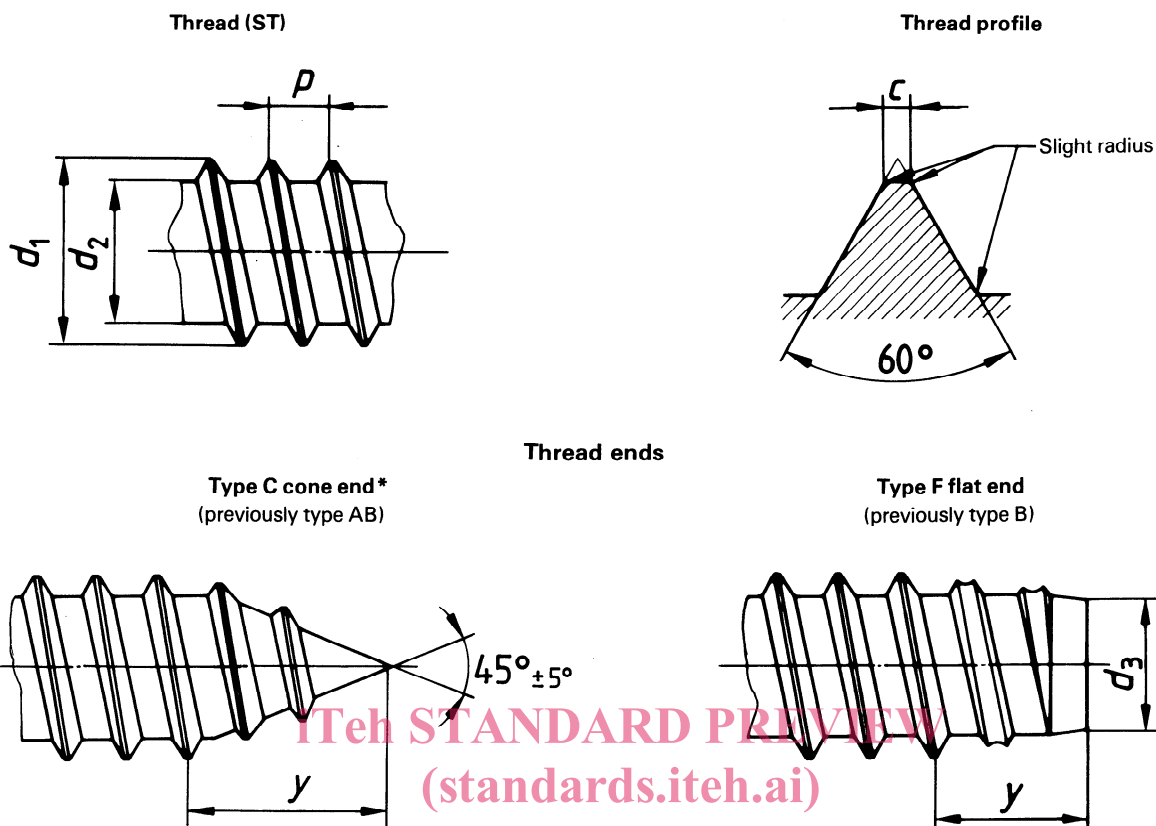
Tapping screws thread

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1 Scope and field of application

This International Standard specifies the thread and thread ends for tapping screws (sheet metal screws) with thread sizes from ST 1,5 to ST 9,5 inclusive. <https://standards.iteh.ai/catalog/standards/sist/2a73ebe2-480e-44a5-96ac-11eaaa0f810a/iso-1478-1983>

2 Dimensions



ISO 1478:1983
<https://standards.itech.ai/catalog/standards/sist/2a73ebe2-480e-44a5-96ac-11e0a0810a5a/iso-1478-1983>

Dimensions in millimetres

Thread size	ST 1,5	ST 1,9	ST 2,2	ST 2,6	ST 2,9	ST 3,3	ST 3,5	ST 3,9	ST 4,2	ST 4,8	ST 5,5	ST 6,3	ST 8	ST 9,5	
<i>P</i>	≈ 0,5	0,6	0,8	0,9	1,1	1,3	1,3	1,3	1,4	1,6	1,8	1,8	2,1	2,1	
<i>d</i> ₁	max.	1,52	1,90	2,24	2,57	2,9	3,3	3,53	3,91	4,22	4,8	5,46	6,25	8	9,65
	min.	1,38	1,76	2,1	2,43	2,76	3,12	3,35	3,73	4,04	4,62	5,28	6,03	7,78	9,43
<i>d</i> ₂	max.	0,91	1,24	1,63	1,90	2,18	2,39	2,64	2,92	3,10	3,58	4,17	4,88	6,20	7,85
	min.	0,84	1,17	1,52	1,80	2,08	2,29	2,51	2,77	2,95	3,43	3,99	4,70	5,99	7,59
<i>d</i> ₃	max.	0,79	1,12	1,47	1,73	2,01	2,21	2,41	2,67	2,84	3,30	3,86	4,55	5,84	7,44
	min.	0,69	1,02	1,37	1,60	1,88	2,08	2,26	2,51	2,69	3,12	3,68	4,34	5,64	7,24
<i>c</i>	max.	0,1	0,1	0,1	0,1	0,1	0,1	0,1	0,1	0,15	0,15	0,15	0,15	0,15	
<i>y</i> ref. 1)	Type C	1,4	1,6	2	2,3	2,6	3	3,2	3,5	3,7	4,3	5	6	7,5	8
	Type F	1,1	1,2	1,6	1,8	2,1	2,5	2,5	2,7	2,8	3,2	3,6	3,6	4,2	4,2
Number ²⁾	0	1	2	3	4	5	6	7	8	10	12	14	16	20	

1) Length of incomplete thread.

2) For information only.

3 Designation

Example for the designation of a tapping screw thread with thread size ST 3,5:

Tapping screw thread ISO 1478 - ST 3,5

* No extrusion of excess metal beyond the apex of the type C cone end resulting from thread rolling shall be permissible. A slight rounding or truncation of the point is desirable.