
INTERNATIONAL STANDARD



2770

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

Tapping screws according to ISO/R 1478 to 1483 — Minimum and maximum lengths

Vis à tôle conformes à ISO/R 1478 à 1483 — Longueurs minimale et maximale

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FOREWORD

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (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 set up 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 2770 was drawn up by Technical Committee ISO/TC 2, *Bolts, nuts and accessories*, and circulated to the Member Bodies in February 1972.

It has been approved by the Member Bodies of the following countries :

| | | |
|---------------------|-------------|-----------------------|
| Canada | Italy | South Africa, Rep. of |
| Denmark | Japan | Spain |
| Egypt, Arab Rep. of | Netherlands | Sweden |
| Finland | New Zealand | Switzerland |
| Hungary | Norway | Turkey |
| India | Portugal | United Kingdom |
| Ireland | Romania | U.S.S.R. |

The Member Bodies of the following countries expressed disapproval of the document on technical grounds :

Austria
Belgium
France
U.S.A.

Tapping screws according to ISO/R 1478 to 1483 – Minimum and maximum lengths

1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies minimum and maximum lengths of tapping screws, types AB and B, according to ISO/R 1478 to 1483, in order to obtain a single series for both metric and inch units. These values are based on the nominal length in inches.

2 LENGTHS

TABLE

| nominal | | Length / | | | | | |
|---------|---------------|----------------|-------|---------|-------|--------|--------|
| | | minimum | | maximum | | | |
| | | types AB and B | | type AB | | type B | |
| mm | in | mm | in | mm | in | mm | in |
| 3,2 | 1/8 (0,125) | 2,575 | 0,101 | 3,775 | 0,149 | 3,175 | 0,125 |
| 4,5 | 3/16 (0,1875) | 4,163 | 0,164 | 5,363 | 0,211 | 4,763 | 0,1875 |
| 6,5 | 1/4 (0,250) | 5,600 | 0,220 | 7,100 | 0,280 | 6,350 | 0,250 |
| 9,5 | 3/8 (0,375) | 8,775 | 0,345 | 10,275 | 0,405 | 9,525 | 0,375 |
| 13 | 1/2 (0,500) | 11,800 | 0,465 | 13,600 | 0,535 | 12,700 | 0,500 |
| 16 | 5/8 (0,625) | 14,975 | 0,590 | 16,775 | 0,660 | 15,875 | 0,625 |
| 19 | 3/4 (0,750) | 18,000 | 0,709 | 20,100 | 0,791 | 19,050 | 0,750 |
| 22 | 7/8 (0,875) | 21,175 | 0,834 | 23,275 | 0,916 | 22,225 | 0,875 |
| 25 | 1 (1,000) | 24,350 | 0,959 | 26,450 | 1,041 | 25,400 | 1,000 |
| 32 | 1 1/4 (1,250) | 30,500 | 1,201 | 33,000 | 1,299 | 31,750 | 1,250 |
| 38 | 1 1/2 (1,500) | 36,850 | 1,451 | 39,350 | 1,549 | 38,100 | 1,500 |
| 45 | 1 3/4 (1,750) | 43,200 | 1,701 | 45,700 | 1,799 | 44,450 | 1,750 |
| 50 | 2 (2,000) | 49,300 | 1,941 | 52,300 | 2,059 | 50,800 | 2,000 |