



SLOVENSKI STANDARD
SIST EN ISO 1478:2002
01-julij-2002

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SIST EN ISO 1478:1996

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Tapping screws thread (ISO 1478:1999)

Blechsraubengewinde (ISO 1478:1999)

Filetage de vis a tôle (ISO 1478:1999)

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Ta slovenski standard je istoveten z: EN ISO 1478:1999

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ICS:

21.040.30 Posebni navoji Special screw threads

SIST EN ISO 1478:2002 **en**

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN ISO 1478

August 1999

ICS 21.040.00

Supersedes EN ISO 1478:1994

English version

Tapping screw thread (ISO 1478:1999)

Filetage de vis à tôle (ISO 1478:1999)

Blechsraubengewinde (ISO 1478:1999)

This European Standard was approved by CEN on 16 July 1999.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

Foreword

The text of the International Standard ISO 1478:1999 has been prepared by Technical Committee ISO/TC 2 "Fasteners" in collaboration with Technical Committee CEN/TC 185 "Threaded and non-threaded mechanical fasteners and accessories", the secretariat of which is held by DIN.

This European Standard supersedes EN ISO 1478:1994.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by February 2000, and conflicting national standards shall be withdrawn at the latest by February 2000.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

NOTE FROM CEN/CS: The foreword is susceptible to be amended on reception of the German language version. The confirmed or amended foreword, and when appropriate, the normative annex ZA for the references to international publications with their relevant European publications will be circulated with the German version.

Endorsement notice

The text of the International Standard ISO 1478:1999 was approved by CEN as a European Standard without any modification.

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INTERNATIONAL STANDARD

**ISO
1478**

Second edition
1999-08-01

Tapping screws thread

Filetage de vis à tôle

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Reference number
ISO 1478:1999(E)

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established 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. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 1478 was prepared by Technical Committee ISO/TC 2, *Fasteners*.

This second edition cancels and replaces the first edition (ISO 1478:1983) which has been technically revised.

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Printed in Switzerland

Tapping screws thread

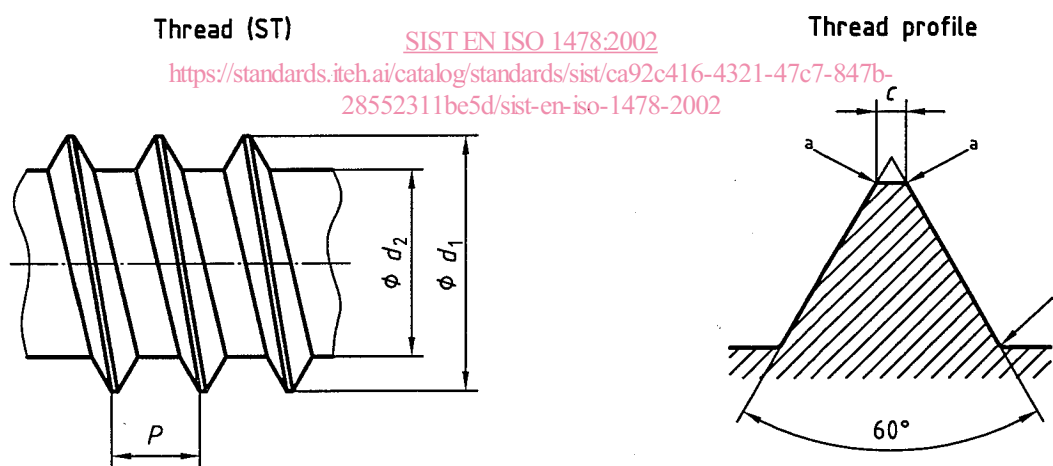
1 Scope

This International Standard specifies the thread and thread ends for tapping screws (sheet metal screws) with thread sizes from ST1,5 to ST9,5 inclusive.

2 Dimensions

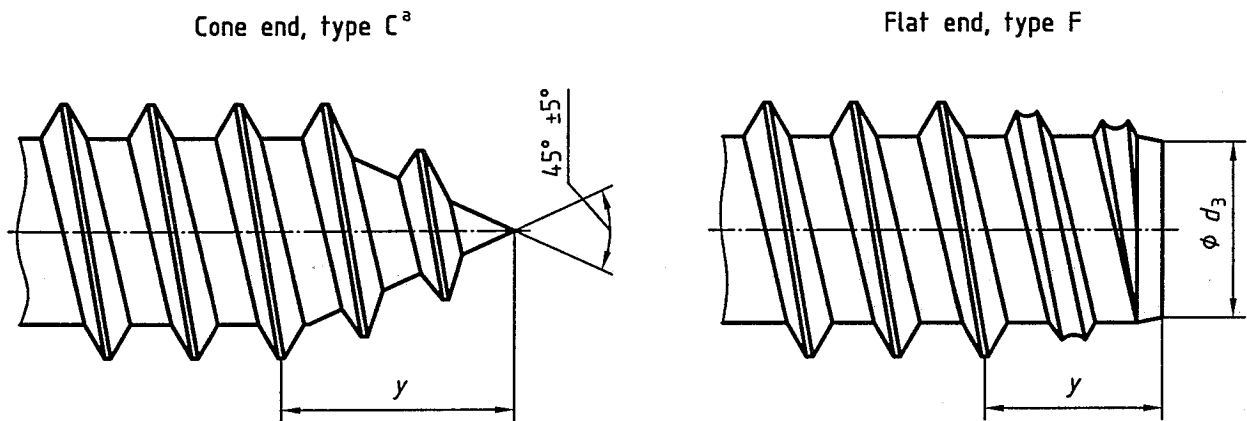
See Figures 1 and 2 and Table 1

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a Slight radius

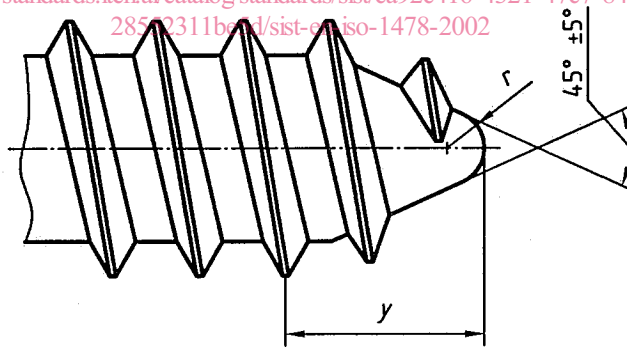
Figure 1 — Thread dimensions



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Rounded end, type R

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- ^a 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.

Figure 2 — Thread ends

Table 1 — Dimensions

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
P	≈	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
d_1	max.	1,52	1,90	2,24	2,57	2,90	3,30	3,53	3,91	4,22	4,80	5,46	6,25	8,00	9,65
	min.	1,38	1,76	2,10	2,43	2,76	3,12	3,35	3,73	4,04	4,62	5,28	6,03	7,78	9,43
d_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
d_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
c	max.	0,1	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
r^a	≈	—	—	—	—	—	—	0,5	0,6	0,6	0,7	0,8	0,9	1,1	1,4
y ref. ^b	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
	Type R	—	—	—	—	—	—	2,7	3	3,2	3,6	4,3	5	6,3	—
Number ^c		0	1	2	3	4	5	6	7	8	10	12	14	16	20

^a Dimension r is a reference and has been provided for guidance only. The end may not be perfectly spherical but shall not be sharp to the touch.

^b Length of incomplete thread.

^c Former thread designation, for information only.

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3 Designation

EXAMPLE A tapping screw thread with thread size ST3,5 is designated as follows:

Tapping screw thread ISO 1478 - ST3,5

NOTE The type of thread end should be specified within the product designation, see product standards.