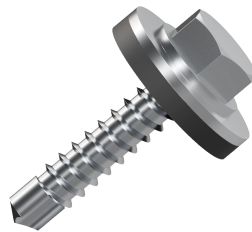


ISO 15480

Hexagon washer head drilling screws with tapping screw thread



Standard	ISO 15480		
Product Type	This document specifies the characteristics of hexagon washer head drilling screws with tapping screw threads, made of steel, with thread sizes ST2,9 to ST6,3, and with product grade A.		
Material	Stainless Steel, Carbon Steel		
Surface Finish	Passivated, Plain, Zinc Plated, Dacromet, Ruspert, Phosphate		
Size Range	ST2.9 - ST6.3	Length Range	9.5-50 mm
Thread	Tapping screw thread (ST) per ISO 1478		

BASIS OF SPECIFICATION

WHICH STANDARD GOVERNS WHAT

Dimensions to	ISO 15480:2019
Carbon steel / Alloy steel mechanical properties to	ISO 2702:2022
Stainless steel mechanical properties to	ISO 3506-4:2025
Product grade	A

DIMENSIONAL DATA - SIZES WE SUPPLY

ALL DIMENSIONS PER THE STANDARD

d	P	a (max)	c (min)	da (max)	dc	dc (min)	e (min)	k	k (min)	kw (min)	r1 (min)	r2 (max)	s (max)	s (min)	(min)	(max)
Diameter - mm	Thread Pitch - mm	Thread Runout - mm	Washer Height - mm	Underhead Diameter - mm	Flange Diameter - mm	Bearing Diameter - mm	Width Across Corners - mm	Nominal Head Height - mm	Head Height - mm	Wrenching Height - mm	Radius r1 - mm	Radius r2 - mm	Width Across Flats - mm	Width Across Flats - mm	Drilling Capacity - mm	Drilling Capacity - mm
ST3.5	1.3	1.3	0.6	4.1	8.3	7.6	5.96	3.4	3	1.5	0.1	0.25	5.5	5.32	0.7	2.25
ST4.2	1.4	1.4	0.8	4.9	8.8	8.1	7.59	4.1	3.6	1.8	0.2	0.3	7	6.78	1.75	3
ST4.8	1.6	1.6	0.9	5.6	10.5	9.8	8.71	4.3	3.8	2.2	0.2	0.3	8	7.78	1.75	4.4
ST5.5	1.8	1.8	1	6.3	11	10	8.71	5.4	4.8	2.7	0.25	0.4	8	7.78	1.75	5.25
ST6.3	1.8	1.8	1	7.3	13.5	12.2	10.95	5.9	5.3	3.1	0.25	0.5	10	9.78	2	6

FURTHER SIZES IN THIS STANDARD

ALL DIMENSIONS PER THE STANDARD

Not held in stock. Available to order; minimum order quantity applies.

d	P	a (max)	c (min)	da (max)	dc	dc (min)	e (min)	k	k (min)	kw (min)	r1 (min)	r2 (max)	s (max)	s (min)	(min)	(max)
Diameter - mm	Thread Pitch - mm	Thread Runout - mm	Washer Height - mm	Underhead Diameter - mm	Flange Diameter - mm	Bearing Diameter - mm	Width Across Corners - mm	Nominal Head Height - mm	Head Height - mm	Wrenching Height - mm	Radius r1 - mm	Radius r2 - mm	Width Across Flats - mm	Width Across Flats - mm	Drilling Capacity - mm	Drilling Capacity - mm
ST2.9	1.1	1.1	0.4	3.5	6.3	5.8	4.28	2.8	2.5	1.3	0.1	0.2	4	3.82	0.7	1.9

TECHNICAL SPECIFICATIONS

Surface Finish	Passivated, Plain, Zinc Plated, Dacromet, Ruspert, Phosphate
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MARKING

Carbon steel / Alloy steel	Head marking to ISO 2702:2022
Stainless steel	Head marking to ISO 3506-4:2025

Marking requirements are set by the material standard named above, not by the product standard. Confirm the ordered property class before production.

INSPECTION DOCUMENTS WE CAN ISSUE

EN 10204 3.1 material certificate	Can be included when agreed in the order.
Dimensional inspection report	Can be provided for the agreed inspection scope.
Certificate of conformity	Can be issued against the confirmed order requirements.
Mechanical test report	Available when the required tests are agreed before production.
Chemical analysis report	Available when the material verification scope is agreed.
Coating inspection report	Can record the coating checks agreed for the order.

REFERENCES & NOTES

Note: Dimensional values follow the selected execution standard. Material properties and batch test results are included only when declared or supported by the applicable certificate or test report.