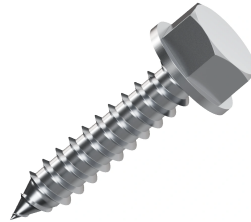


ISO 7053

Hexagon washer head tapping screws



Standard	ISO 7053		
Product Type	This document specifies the characteristics of hexagon washer head tapping screws, made of steel and stainless steel, with thread sizes ST2,2 to ST8, and with product grade A.		
Material	Stainless Steel, Carbon Steel		
Surface Finish	Passivated, Plain, Zinc Plated, Dacromet, Ruspert		
Size Range	ST2.2 - ST8	Length Range	4.5-50 mm
Thread	Tapping screw thread (ST) per ISO 1478		

BASIS OF SPECIFICATION

WHICH STANDARD GOVERNS WHAT

Dimensions to	ISO 7053:2019
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)	y (ref)	y (ref)	y (ref)
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	Point Length - C - mm	Point Length - F - mm	Point Length - R - mm
ST2.2	0.8	0.8	0.25	2.8	4.2	3.8	3.2	2	1.7	0.9	0.1	0.15	3	2.86	2	1.6	-
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	2.6	2.1	-
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	3.2	2.5	2.7
ST3.9	1.3	1.3	0.6	4.6	8.3	7.6	5.96	3.4	3	1.5	0.2	0.25	5.5	5.32	3.5	2.7	3
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	3.7	2.8	3.2
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	4.3	3.2	3.6
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	5	3.6	4.3
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	6	3.6	5
ST8	2.1	2.1	1.2	9.2	18	16.7	14.26	7	6.4	3.3	0.4	0.6	13	12.73	7.5	4.2	6.3

TECHNICAL SPECIFICATIONS

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

Steel — No marking clause

What	None. Neither the product standard nor ISO 2702 contains a marking clause
Sizes	
Clause	ISO 2702:2011, Clauses 1 to 6 (Scope, Normative references, Materials, Requirements, Acceptance, Test methods), none of which is a marking clause

Stainless steel — Not mandatory on the part; required on the package

What	Marking the part is not mandatory. Where the hardness class symbol is marked, the manufacturer identification mark shall be there as well, as far as technically possible; the mark shall carry the steel group and hardness class, for example A4-20H. On the package, marking is required without exception: manufacturer and/or distributor identification, the steel group and hardness class symbol, and the manufacturing lot number to ISO 16426
Where	On the part where marked, and on the package in every case
Sizes	All sizes
Clause	ISO 3506-4:2009, 3.2.1 to 3.2.4, with 3.3 on delivery condition

- ISO 7053:2019 has no marking clause of its own: its contents run Clauses 1 to 6, ending with Designation.
- Stainless parts are delivered clean and bright and passivated (Table 2, footnote a: passivation method in ISO 16048).
- 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.