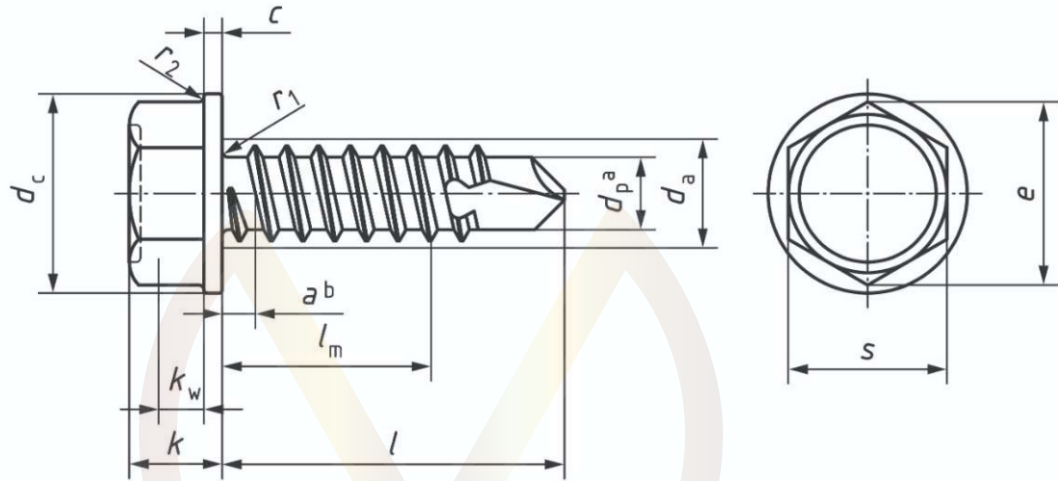


SELF DRILLING HEX FLANGE HD SCREW

ISO 15480:2019(E)



- a The function of the drilling point (diameter d_p) is specified in ISO 10666.
- b Dimension a shall be measured at the core diameter of the first full thread.

Fastening Everything

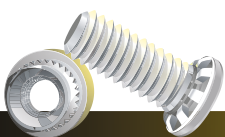


Table 1 — Dimensions

Dimensions in millimetres

Thread			ST2,9	ST3,5	ST4,2	ST4,8	ST5,5	ST6,3	
p_a			1,1	1,3	1,4	1,6	1,8	1,8	
a	max.		1,1	1,3	1,4	1,6	1,8	1,8	
c	min.		0,4	0,6	0,8	0,9	1,0	1,0	
d_a	max.		3,5	4,1	4,9	5,6	6,3	7,3	
d_c	max.		6,3	8,3	8,8	10,5	11,0	13,5	
	min.		5,8	7,6	8,1	9,8	10,0	12,2	
e	min.		4,28	5,96	7,59	8,71	8,71	10,95	
k	nom. = max		2,8	3,4	4,1	4,3	5,4	5,9	
	min.		2,5	3,0	3,6	3,8	4,8	5,3	
k_w^b	min.		1,3	1,5	1,8	2,2	2,7	3,1	
r_1	min.		0,1	0,1	0,2	0,2	0,25	0,25	
r_2	max.		0,2	0,25	0,3	0,3	0,4	0,5	
s	nom. = max		4,00 ^c	5,50	7,00	8,00	8,00	10,00	
	min.		3,82	5,32	6,78	7,78	7,78	9,78	
Drilling range (sheet or plate thickness) ^d	from		0,7	0,7	1,75	1,75	1,75	2,0	
	to		1,9	2,25	3,0	4,4	5,25	6,0	
l			l_m^e						
nom.	min.	max.	min.						
9,5	8,75	10,25	3,25	2,85	Screws with too short lengths				
13	12,1	13,9	6,6	6,2				4,3	3,7
16	15,1	16,9	9,6	9,2	7,3	5,8	5,0		
19	18,0	20,0	12,5	12,1	10,3	8,7	8,0	7,0	
22	21,0	23,0	Lengths to be agreed between the purchaser and the manufacturer		15,1	13,3	11,7	11,0	10,0
25	24,0	26,0			18,1	16,3	14,7	14,0	13,0
32	30,75	33,25			23,0	21,5	21,0	20,0	
38	36,75	39,25			29,0	27,5	27,0	26,0	
45	43,75	46,25			34,5	34,0	33,0		
50	48,75	51,25			39,5	39,0	38,0		

^a P is the pitch of the thread.

^b k_w is the wrenching height.

^c Divergence from the width across flats for hexagon tapping screws in accordance with ISO 1479 (5 mm). In the case of hexagon washer head tapping screws (see ISO 7053), the width across flats of 4 mm has been introduced worldwide and also applies in this case.

^d In order to determine the nominal length l needed for the application, it can be necessary to add an air gap (if present) to the individual sheet or plate thickness(es).

^e l_m is the distance from the bearing face to the last major diameter of the thread.

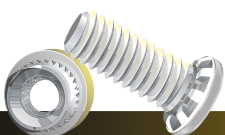


Table 2 — Requirements and reference International Standards

Material		Steel
	International Standard	ISO 10666
General requirements	International Standard	ISO 8992
Thread	International Standard	ISO 1478
Mechanical and functional properties	International Standard	ISO 10666
Tolerances	Product grade	A
	International Standard	ISO 4759-1
Finish — Coating		As processed (no coating) Electroplated coatings as specified in ISO 4042 Additional requirements or other finishes or coatings shall be agreed between the supplier and the purchaser.
Acceptability		Acceptance inspection as specified in ISO 3269

Fastening Everything

SPECIFICATIONS & DETAILS			
MVD PART CODE	MV7504NXXX	MVD DESCRIPTION	SELF DRILLING SCREWS TYPE K WITH EPDM WASHER NOXXX
DRAWN BY	ABHISHEK	APPROVED BY	MAGESH
DRAWING REV. NO	00	MATERIAL	STEEL
DATE		FINISH	ELECTRO PLATED
ALL DIMENSIONS ARE IN MM, UNLESS SPECIFIED			

