

Termotöödeldud terasest plekikruvid. Mehaanilised omadused (ISO 2702:2011)

Heat-treated steel tapping screws - Mechanical properties (ISO 2702:2011)

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN ISO 2702:2011 sisaldab Euroopa standardi EN ISO 2702:2011 ingliskeelset teksti.

Standard on kinnitatud Eesti Standardikeskuse 31.05.2011 käskkirjaga ja jõustub sellekohase teate avaldamisel EVS Teatajas.

Euroopa standardimisorganisatsioonide poolt rahvuslikele liikmetele Euroopa standardi teksti kättesaadavaks tegemise kuupäev on 01.05.2011.

Standard on kättesaadav Eesti standardiorganisatsioonist.

This Estonian standard EVS-EN ISO 2702:2011 consists of the English text of the European standard EN ISO 2702:2011.

This standard is ratified with the order of Estonian Centre for Standardisation dated 31.05.2011 and is endorsed with the notification published in the official bulletin of the Estonian national standardisation organisation.

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English Version

Heat-treated steel tapping screws - Mechanical properties (ISO 2702:2011)

Vis à tête en acier traité thermiquement - Caractéristiques mécaniques (ISO 2702:2011)

Wärmebehandelte Blechschrauben aus Stahl - Mechanische Eigenschaften (ISO 2702:2011)

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Foreword

This document (EN ISO 2702:2011) has been prepared by Technical Committee ISO/TC 2 "Fasteners" in collaboration with Technical Committee CEN/TC 185 "Fasteners" the secretariat of which is held by DIN.

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of an identical text or by endorsement, at the latest by November 2011, and conflicting national standards shall be withdrawn at the latest by November 2011.

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Endorsement notice

The text of ISO 2702:2011 has been approved by CEN as a EN ISO 2702:2011 without any modification.

Introduction

The primary objective of this International Standard is to ensure that tapping screws form mating threads in materials into which they are normally driven without deforming their own thread and without breaking during assembly or service.

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Heat-treated steel tapping screws — Mechanical properties

1 Scope

This International Standard specifies the characteristics of heat-treated steel tapping screws, with tapping screw thread from ST2,2 to ST9,5 inclusive according to ISO 1478, together with the corresponding test methods.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 898-7:1992, *Mechanical properties of fasteners — Part 7: Torsional test and minimum torques for bolts and screws with nominal diameters 1 mm to 10 mm*

ISO 6507-1, *Metallic materials — Vickers hardness test — Part 1: Test method*

3 Materials

Tapping screws shall be made from cold heading, case hardening quality steel.

4 Requirements

4.1 Metallurgical requirements

4.1.1 Surface hardness

The minimum surface hardness after heat treatment shall be 450 HV 0,3 (see ISO 6507-1).

4.1.2 Case depth

The case depth shall conform to the values given in Table 1.

Table 1 — Case depth

Dimensions in millimetres

Thread	Case depth	
	min.	max.
ST2,2, ST2,6	0,04	0,10
ST2,9, ST3,3, ST3,5	0,05	0,18
ST3,9, ST4,2, ST4,8, ST5,5	0,10	0,23
ST6,3, ST8, ST9,5	0,15	0,28