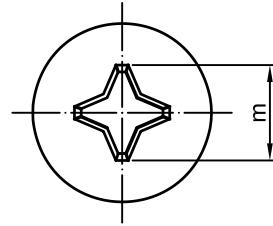
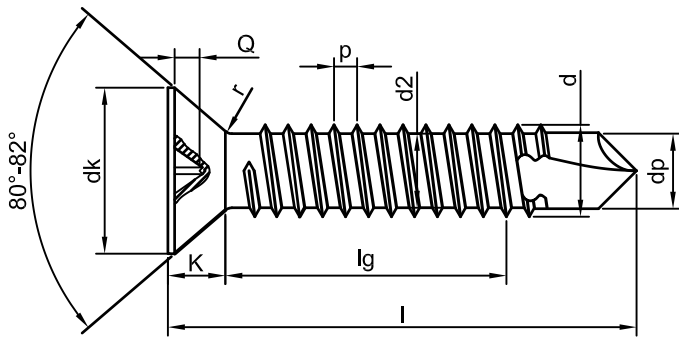
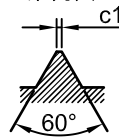
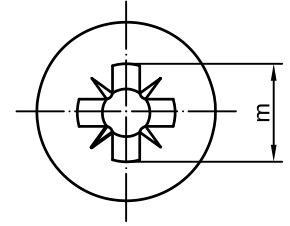


SCALE 比例: N/A

螺纹截面



Type H-十字槽



Type Z-米字槽

Size d	ST2.9	ST3.5	(ST3.9)	ST4.2	ST4.8	ST5.5	ST6.3	
p	1.1	1.3	1.4	1.4	1.6	1.8	1.8	
d	2.90-2.76	3.53-3.35	3.91-3.73	4.22-4.04	4.80-4.62	5.46-5.28	6.25-6.03	
dp (ref)	2.30	2.80	3.15	3.40	3.90	4.65	5.50	
d2	2.18-2.08	2.64-2.51	2.92-2.77	3.1-2.95	3.58-3.43	4.17-3.99	4.88-4.7	
Cross recess No.	1		2			3		
Type H	m		m		m		m	
	3.00	4.20	4.60	4.70	5.10	6.80	7.10	
	Penetration(Q)		Penetration(Q)		Penetration(Q)		Penetration(Q)	
	1.40-1.70	1.62-2.12	2.03-2.53	2.11-2.62	2.50-3.10	2.95-3.53	3.33-3.91	
Type Z	m		m		m		m	
	2.80	4.00	4.20	4.40	5.00	6.30	7.00	
	Penetration(Q)		Penetration(Q)		Penetration(Q)		Penetration(Q)	
	1.48-1.73	1.60-2.06	1.85-2.31	2.05-2.51	2.64-3.10	2.72-3.18	3.38-3.84	
dk	5.20-5.50	6.80-6.44	7.50-7.14	8.10-7.74	9.50-9.14	10.80-10.37	12.40-11.97	
k	1.70	2.10	2.30	2.50	3.00	3.40	3.80	
r (max)	1.10	1.40	1.50	1.60	1.90	2.10	2.40	
c1 (max)	0.10	0.10	0.10	0.10	0.15	0.15	0.15	
Range of Drill	1.40	2.00	2.00	3.00	4.00	5.00	5.00	
l nominal	l min-lmax		lg (min)					
9.5	8.75-10.25		3.25	2.85				
13	12.10-13.90		6.60	6.20	5.80	4.30	4.70	
16	15.10-16.90		9.60	9.20	8.80	7.30	5.80	
19	18.00-20.00		12.50	12.10	11.70	10.30	8.70	
22	21.00-23.00			15.10	14.70	13.30	11.70	
25	24.00-26.00			18.10	17.70	16.30	14.70	
32	30.75-33.25				24.50	23.00	21.50	
38	36.75-39.25				30.50	29.00	27.50	
45	43.75-46.25						34.50	
50	48.75-51.25						39.50	
Breaking Torque	N.m (min)		1.50	2.80	3.40	4.50	6.50	10.00
Item	Test data for the drilling and screwing -in-test							
Thickness of test plat	mm		1.4	2	2	3	4	5
Axial force	N		150	150	150	250	250	350
Rotational speed of screw under load	min <sup>-1</sup>		1800-2500	1800-2500	1800-2500	1800-2500	1800-2500	1000-1800
Case Depth	mm		0.05-0.18		0.10-0.23			0.15-0.28

Note:

- Material : C1022
- Surface coating finish: As Required in order.
- Thread type: DIN 7970 :1984
- Mechanical proprieties: DIN 7504:1982 Drilling Screws with self-tapping
- screws thread in accordance with DIN 7970  
Case Hardness :HV 560 min, Core Hardness:240-425
- Inspection: ISO 3269:2000 Fasteners - Acceptance Inspection

修订次序	修订日期	修订内容
1	2007-7-31	新制定
2	2009-8-5	增订渗碳层厚度
3	2009-8-10	根据HY建议, 修订 dp, dk, Range of drill.
4		

DIN 7504 P Drilling Screws with self-tapping screws thread in accordance with DIN 7970

SIZE 尺寸:

Various

DWG NO. 图纸号: QE-FM-0043	CUSTOMER DWG NO. 客户图纸号: N/A	CONTRACT No. 合同号/ORDER No. 订单号: PFPL-FD090207	FINISH 表面处理: As Required in order.	MATERIAL 材料: C1022
DRAWN BY 制图: Simon		APPROVE BY 审核:		UNITS 图纸单位: mm
DATE 日期: 2009-8-5				Sheet 页数: 1/1