



















9. Product Specification

Product Group: 005 - Self Drilling Screws

DIN 7504 N				
DIN 7504 P				
DIN 7504 Q				
DIN 7504 K				
DIN 7504 L				
~ DIN 7504 Wafer Flange				
~ DIN 7504 P with ribs and wings				

Description:	Requirement:	
Product Standard:	DIN 7504 N DIN 7504 P DIN 7504 Q DIN 7504 K DIN 7504 L	February 1992
	~ DIN 7504 Flange ~ DIN 7504 P with ribs and wings	According to drawing
Surface:	a) Cr3 zinc plated A2-F b) Cr3 black zinc plated A2-S	ISO 4042 (latest Edition)
Packaging:	Fastbolt Cartons	
Labels:	Fastbolt Label	

<p>Baking Process:</p>	<p>min. 4 hours* at 200°C – 240°C</p> <p>* measured when all parts have reached the min. temperature of 200°C</p>	<p>ISO 4042 (latest Edition)</p>
<ul style="list-style-type: none"> • The manufacturer has to ensure that <u>100%</u> of the goods will be baked. He has to develop an internal process to ensure this. • The temperature sensor of the baking oven has to be regularly calibrated. • The baking process has to be started immediately (<u>latest</u> 4 hours) after zinc plating process. The period between zinc plating and baking process has to be recorded. 		
<p>Required Test Certificate:</p>	<p>Suppliers Inspection Report</p> <ol style="list-style-type: none"> 1. Preloading Test for the detection of Hydrogen Embrittlement 2. Temper Chart* <p>*The temper chart has to show (at least) the following information:</p> <ol style="list-style-type: none"> a. Date and Time b. Description of the item c. Lot-Number d. P/O-Number e. Quantity f. Duration of baking process <ol style="list-style-type: none"> 1. Temperature Sequence 	
<p>ISO 15330 (latest Edition)</p>		

Specifics:

A) T-Multidrive penetration depth:

DIN 7504 N-T

d	3,5	3,9	4,2	4,8
t - min.	1,1	1,30	1,40	1,60
t - max.	1,4	1,60	1,60	2,00
T No.	15	20	20	25

DIN 7504 P-T

D	3,5	3,9	4,2	4,8	5,5	6,3
t - min.	1,30	1,30	1,40	1,40	1,60	2,02
t - max.	1,60	1,60	1,80	1,80	2,00	2,42
T No.	15	20	20	25	25	30

~ DIN 7504 P-T with wings and ribs

d	6,3
t - min.	2,02
t - max.	2,42
T No.	30

B) Thread length information:

- Thread length (up to 80 mm: fully threaded / > 80mm partial thread with 76mm)

C) Length of Drill-Point information:

7504K

3,5x9,5 - 4,8x13	2PT
4,8x16 - 4,8x100	3PT
5,5x16	2PT
5,5x19 - 5,5x80	3PT
6,3x16	2PT
6,3x19 - 6,3x160	3PT

DIN 7504 N-H

2,9x9,5 - 4,8x13	2PT
4,8x16 - 5,5x70	3PT
6,3x16	2PT
6,3x19 - 6,3x100	3PT

DIN 7504 N-T

3,9x9,5	1PT
3,5x13 - 4,8x13	2PT
4,8x16 - 4,8x50	3PT

DIN 7504 P-I

4,2x22	2PT
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7504L

4,2x13 - 4,8x13	2PT
4,8x16 - 4,8x22	3PT

DIN 7504 N-I

4,2x13 - 4,2x38	2PT
4,8x16 - 4,8x25	3PT

DIN 7504 P-H

2,9x9,5 - 2,9x25	2PT
3,5x9,5	1PT
3,5x13 - 3,5x45	2PT
3,9x9,5	1PT
3,9x13 - 3,9x50	2PT
4,2x13	1PT
4,2x16 - 4,2x80	2PT
4,8x13	1PT
4,8x16	2PT
4,8x19 - 5,5x80	3PT
6,3x19	2PT
6,3x22 - 6,3x120	3PT

~DIN 7504 wafer flange head

4,2x13 - 4,2x25	2PT
4,8x16 - 4,8x25	3PT

DIN 7504 N-I (underhead serrations)

4,2x13 - 4,2x19	2PT
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~7504 P-T wings&ribs

6,3x50 - 6,3x80	3PT
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~7504 P-H wings&ribs

4,2x25 - 4,2x50	2PT
4,8x25 - 6,3x90	3PT

Window Screw

3,9x13 - 3,9x38	2PT
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7504 Q-H

2,9x13 - 4,8x16	2PT
4,8x19 - 4,8x50	3PT

DIN 7504 P-T

3,5x13 - 4,8x16	2PT
4,8x19 - 4,8x50	3PT

D) Head Type information:

Head Type N	DIN 7981
Head Type P	DIN 7982
Head Type K	DIN 6928
Head Type L	DIN 6928 + slot according to DIN 962
Head Type Q	DIN 7983
Wafer Flange Head	according to drawing
Head Type N or P with inner square drive / serrations	according to drawing
DIN7504 with wings and ribs	according to drawing