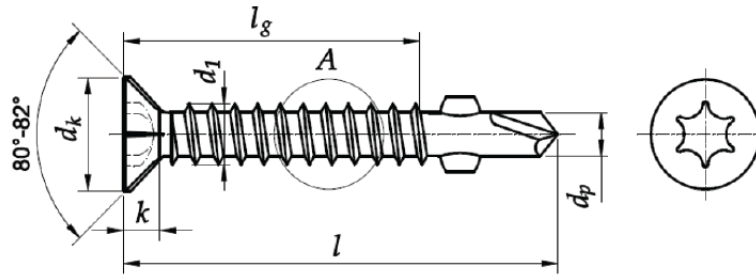




Drilling and milling screws with countersunk head



STANDARD	MATERIAL	CLASS	COATING
~DIN 7504 P			

Dimensions for screws with ST thread

d _t	ST4,8	ST5,5	ST6,3	ST8,0
P	1,6	1,8	1,8	2,1
d _t	9,5	10,80	12,40	15,05
k	3,0	3,4	3,8	4,2
d _p ≈	4	4,95	5,65	6,8
T	25	25	30	40

P – podziałka gwintu

T – gniazdo sześciokątne Tx (Torx)

Dimensions for screws with fine thread

d _t	5,5	6,3
P	1,1	1,25
d _t	10,8	12,4
k	3,0	3,4
d _p ≈	4,95	5,65
T	25	30

P – podziałka gwintu

T – gniazdo sześciokątne Tx (Torx)

For ST tapping thread

d _t	P	l _g	s	g _{max}
ST4,8x32	1,6	17,5	1,75-4,4	11
ST4,8x38		24		17
ST4,8x45		32		25
ST4,8x50		37		30
ST5,5x38	1,8	20	1,75-5,25	12
ST5,5x45		28		20
ST5,5x50		32		24
ST6,3x45	1,8	25	2,0-6,0	16
ST6,3x50		31		22
ST6,3x60		41		32
ST6,3x65		46		37
ST6,3x70		51		42
ST8x60	2,1	47	5,0-10,5	30
ST8x65		42		28
ST8x70		47		33
ST8x80		57		43

For fine tapping thread

d _t	l _g	s	g _{max}
5,5x38	20	4,0-5,2	13,5
5,5x45	28	4,0-5,2	21,5
5,5x50	32	4,0-5,2	25,5
6,3x38	17	4,0-6,0	8
6,3x45	25	4,0-6,0	16,5
6,3x50	31	4,0-6,0	22,5
6,3x60	41	4,0-6,0	32,5
6,3x65	46	4,0-6,0	38,5
6,3x70	51	4,0-6,0	42,5
6,3x80	61	4,0-6,0	52,5

*- in order to screw selection and assembly parameters practice test recommended