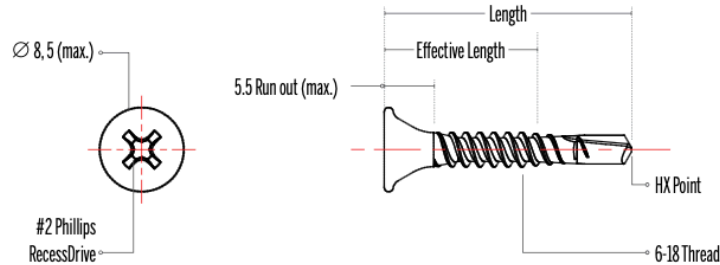


Product Technical Data sheet

SPECIFICATION: M3.5X50MM, SELF DRILLING SCREWS, BUGLE HEAD , BLACK PHOSPHATE, HARDENED



PHYSICAL SPECIFICATIONS

Part No.	Gauge	TPI	Length
DWGY62025 - DWGY82025	6 and 8	20	25 mm
DWGY62035 - DWGY82035	6 and 8	20	35 mm
DWGY62040 - DWGY82040	6 and 8	20	40 mm
DWGY62045 - DWGY82045	6 and 8	20	45 mm

OTHER SPECIFICATIONS

Finish 1: Zinc Coating in White; 24 and 48 hours under ASTM B117
 Finish 2: Black Phosphate Coating in Black; 1000 hours Salt Spray
 tested as per AS2331.3.1 under AS3556.2 - 2002 Class 3
 Screw Point: Also available in sharp point

INSTALLATION GUIDELINES

Use Phillips Cross Recess Driver Bit #2
 Utilise a mains-powered / cordless screw driver with 3000 RPM speed
 Fit the Phillips Driver Bit #2 into the screw and position it at the place of fastening
 Place firm pressure (end load) to the screw driver until the screw is drilled and fixed



TEST RESULTS

Product : Self Drilling Screws, Bugle Head , Black Phosphate, Hardened, #2 Phillips ,
Size : 3.5mm x 50mm – Collated.

Characteristics	Instrument	Dimensions Specification		Samples	AC	RE	Inspection Results		Judgment	Footnote
		Min.	Max.				Min.	Max.		
Type of Screw	Visual	Type - SS		25	25	0	OK		OK	
Head Diameter	Vernier Caliper	7.80	8.20	10	10	0	7.90	8.05	OK	
Head Height	Vernier Caliper	0.80	1.00	10	10	0	0.84	0.86	OK	
Recess Penetration Depth	Depth Gauge	2.59	3.10	25	25	0	2.71	2.73	OK	
Type of Recess	Visual	#2 Phillips		10	10	0	OK		OK	
Major Diameter	Micrometer	3.40	3.60	25	25	0	3.45	3.52	OK	
Threads per Inch $\pm 10\%$	Visual	20		10	10	0	OK		OK	
Radius	Radius Gauge	Ref. 4.5 ± 0.5		10	10	0	4.60	4.70	OK	
Thread Length	Vernier Caliper	FULLY		10	10	0	OK		OK	
Length	Vernier Caliper	49.80	51.80	25	25	0	49.92	50.35	OK	
SDP Dia	Micrometer	2.80min.		10	10	0	2.83	2.84	OK	
Point Length	Vernier Caliper	4.00	4.50	10	10	0	4.40	4.50	OK	
Finish Treatment	Visual	Black Phos		25	25	0	OK		OK	
Torque (Kgf-cm)	Torque Wrench	Min. 28		10	10	0	36	38	OK	
Thread Degree	Profile Projector	Ref. $60^\circ \pm 3^\circ$		10	10	0	57°	59°	OK	
Point Degree	Profile Projector	105°	115°	10	10	0	105°	107°	OK	
Drill Drive Test : Max. 4.0 Sec.	Drilling Testing	Thickness : 2.00 mm Load : 15 kg RPM 2500		25	25	0	0.98	1.35	OK	
Surface Hardened (HV)	Vickers Hardness	600-700 HV		3	3	0	639	646	OK	
Salt Spray life (Hour)	Salt Spray Testing	48 Hrs		5	5	0	No Rust		OK	

