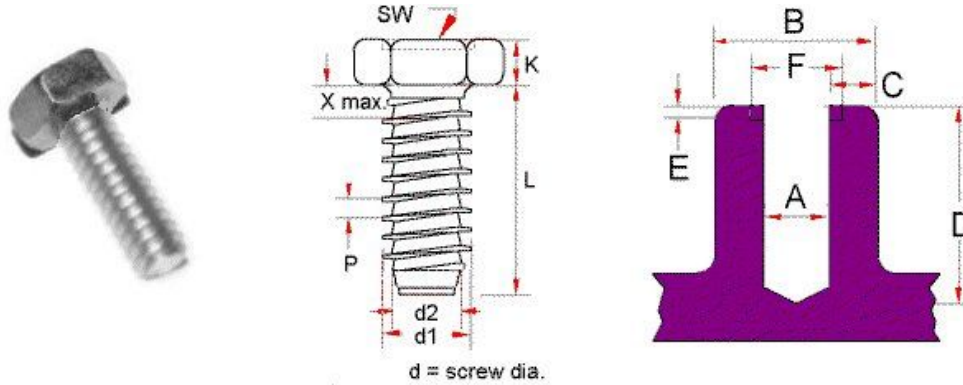




Series: 20216 Type: 1546



Hard materials = 85 to 100 VPN
 Soft materials = 40 to 50 VPN
 Medium Soft materials = 65 to 75 VPN
 Screws can be used successfully in sheet alloy.

MATERIALS	A hole	B min. boss dia.	C min. edge distance	D min. thread penetration	D max. thread penetration	E counterbore depth	F counterbore dia.
Hard	0.92 x d	2.5 x d	0.5 x d	1.5 x d	2.5 x d	0.5 x d	+ 0.2mm
Med. soft	0.89 x d	2.5 x d	0.5 x d	1.5 x d	2.5 x d	0.5 x d	on
Soft	0.87 x d	2.5 x d	0.5 x d	1.5 x d	2.5 x d	0.5 x d	screw dia.

Genuine Durocast 30* Thread forming screw for Light Alloys

Part No.	Diam. d1	Diam. d2	Pitch p	X max	Across Flats SW	Head height K
1546K50xL	5.0	3.68	1.23	3.7	8.0	3.5
1546K40xL	4.0	2.93	1.04	3.2	7.0	2.8
1546K35xL	3.5	2.56	0.95	2.9	6.0	2.4
1546K30xL	3.0	2.18	0.86	2.6	5.5	2.0
1546K25xL	2.5	1.81	0.77	2.3	5.0	1.7
1546K22xL	2.2	1.59	0.71	2.2	4.0	1.4
1546K60xL	6.0	4.42	1.42	4.3	10.0	4.0

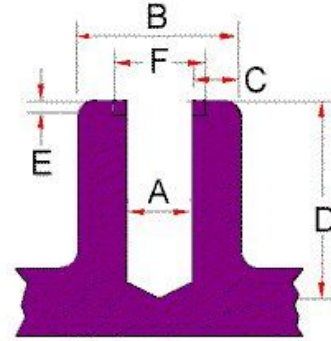
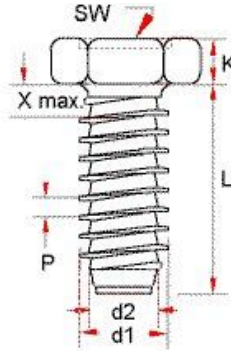
Substitute the drive code for the ? and the length for the L in the part no. to specify the exact part required. The 30 deg. Flank angle and recessed core diameter of these thread forming screws for light alloys and highly filled plastics provides optimum performance. The large difference between the drive in torque and ultimate stripping torque is achieved due to the narrow 30 degree flank angle of the thread. The screw does not require high drive in torque as it displaces only half the material of a conventional screw form. The greater penetration achieved by the low profile flank form ensures a greater surface area contact with the material therefore increasing frictional retention which directly results in high stripping and break-loose torque values. The additional space provided by the recessed core eliminates galling during thread forming. Elimination of thread cutting means a chipless assembly, there is no need for cleaning the threads. A high repeatability is guaranteed as the conical blunt point provides optimum start location for thread forming and preliminary location prior to thread engagement

All information is given for guidance only and designers should satisfy themselves as to the suitability of the specification by requesting samples



Continued from previous page...

Series: 20216 Type: 1546



d = screw dia.

Hard materials = 85 to 100 VPN
 Soft materials = 40 to 50 VPN

Medium Soft materials = 65 to 75 VPN
 Screws can be used successfully in sheet alloy.

MATERIALS	A hole	B	C	D	D	E	F
		min. boss dia.	min. edge distance	min. thread penetration	max. thread penetration	counterbore depth	counterbore dia.
Hard	0.92 x d	2.5 x d	0.5 x d	1.5 x d	2.5 x d	0.5 x d	+ 0.2mm on screw dia.
Med. soft	0.89 x d	2.5 x d	0.5 x d	1.5 x d	2.5 x d	0.5 x d	
Soft	0.87 x d	2.5 x d	0.5 x d	1.5 x d	2.5 x d	0.5 x d	

on restarts, therefore eliminating cross threading.

All information is given for guidance only and designers should satisfy themselves as to the suitability of the specification by requesting samples