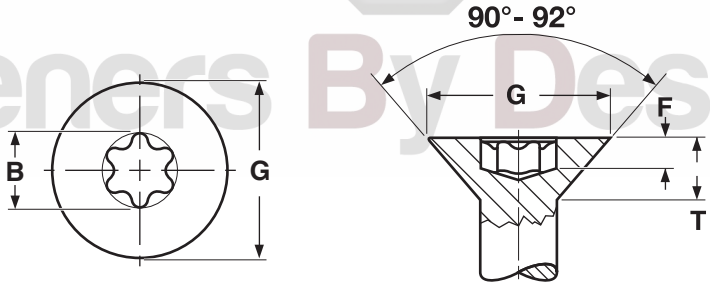
THREAD FORMING SCREWS

DIN 7500 / Six-Lobe Flat Head to ISO 14581

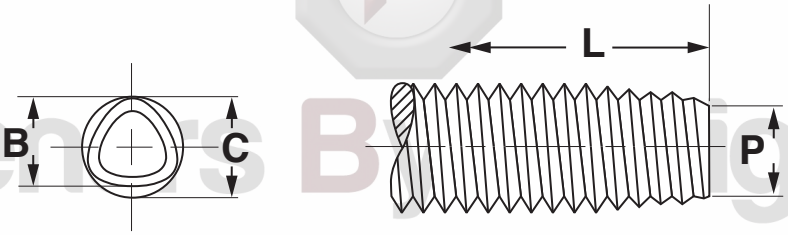


METRIC - ISO 14581 90° Flat Six-Lobe

ISO 14581

Nominal Size	Thread Pitch	G		T	B	F		Recess Size
		Head Diameter		Height of Head	Recess Diameter	Recess Penetration		
		Max	Min	Max	Ref	Max	Min	
M2.5	0.45	5.5	4.4	1.5	2.4	0.79	0.66	T8
M3	0.5	6.3	5.2	1.65	2.80	0.83	0.70	T10
M4	0.7	9.4	8.04	2.70	3.95	1.53	1.14	T20
M5	0.8	10.4	8.94	2.70	4.50	1.51	1.12	T25

Tolerance on Length			
	3mm: ±0.20	4-6mm: ±0.24	7-10mm: ±0.29
	11-16mm: ±0.35	20-30mm: ±0.42	35-50mm: ±0.50



METRIC - Trilobular Thread Rolling Screws

DIN 7500-1

Nominal Size & Thread Pitch	C		B	
	Diameter of Circumscribing Circle		Major Thread Diameter	
	Max	Min	Max	Min
M2.5-0.45	2.57	2.48	2.48	2.39
M3-0.5	3.07	2.98	2.97	2.88
M4-0.7	4.08	3.98	3.94	3.84
M5-0.8	5.09	4.98	4.93	4.82

Tolerance on Length			
	3-6mm: ±0.375	over 6-10mm: ±0.45	over 10-18mm: ±0.55
	over 18-30mm: ±0.65	over 30 - 50mm: ±0.80	over 50-80: ±0.95

Description	A trilobular thread forming screw with a machine screw's thread pitch. As each lobe of the screw moves through the pilot hole in the nut material, it forms and work hardens the nut thread metal, producing an uninterrupted grain flow.
Applications/ Advantages	For use in drilled, punched or cored holes in aluminum or zinc die cast applications. Eliminates chips that result from using thread cutting screws. Requires low drive torque and provides resistance to vibrational loosening. Since A2 stainless thread rolling screws are not hardened, it is recommended they only be used in materials that have a hardness gradient of at least 15-20 Rockwell points lower than the hardness of the screw.
Material	A2 Stainless Steel
Plating	Stainless thread rolling screws shall have a wax coating to maximize performance.