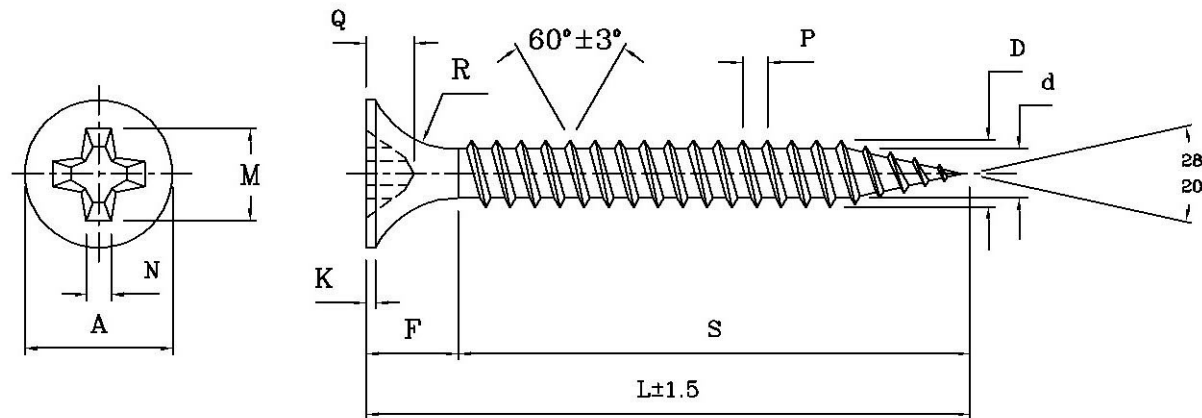


Tianjin Sinsun Imp & Exp Co., Ltd.

Fine Thread Drawing



DETAILS SIZE	HEAD DIA. A	F	MAJOR DIA. D	MINOR DIA. d	K	PITCH P	RECESS DEPTH Q	R	RECESS WIDTH M	N	TORQ Kg-cm	WIRE Ø
#6 (3.5mm)	7.90 8.50	4.50 7.00	3.30 3.60	2.00 2.30	0.50 0.80	1.40 1.70	2.35 2.93	4.50 5.00	4.50 5.10	0.81	28 min.	2.65 -0.02
#7 (3.9mm)	7.90 8.50	4.50 7.00	3.70 4.00	2.25 2.55	0.50 0.80	1.40 1.70	2.35 2.93	4.50 5.00	4.50 5.10	0.81	35 min.	2.95 -0.02
#8 (4.2mm)	7.90 8.50	4.50 7.00	4.00 4.30	2.50 2.80	0.50 0.80	1.40 1.70	2.35 2.93	4.50 5.00	4.50 5.10	0.81	45 min.	3.15 -0.02
#10 (4.8mm)	8.80 9.40	4.50 7.00	4.70 5.00	3.05 3.35	0.50 1.00	2.10 2.30	2.50 3.18	4.50 5.00	4.50 5.10	0.81	65 min.	3.80 -0.02

DESCRIPTION

PHIL BUGLE HEAD DRYWALL SCREW

TWINFAST THREAD TYPE-A

THREAD LENGTH

$L < 55\text{mm}$, $S = L - F$.

$L > 56\text{mm} < 75\text{mm}$, $S = 50\text{mm}$.

$L > 76\text{mm}$, $S = 60\text{mm}$.

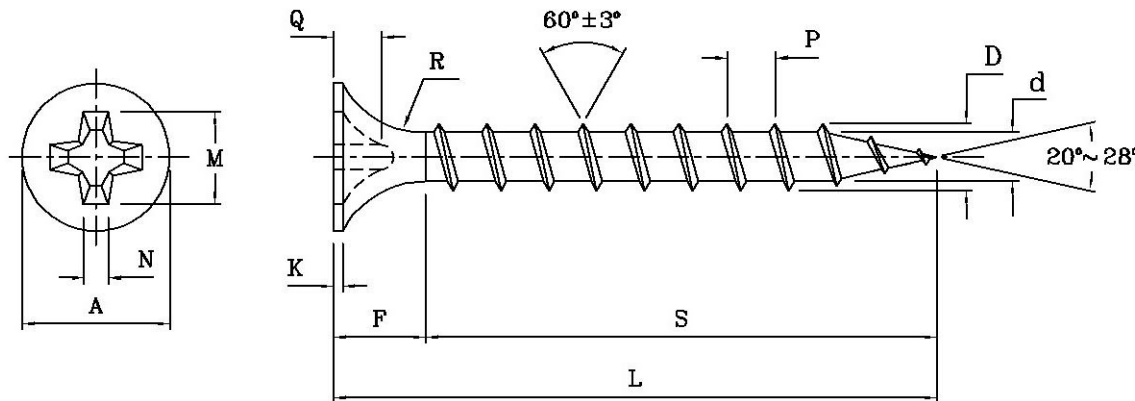
REMARKS

1. SURFACE HARDNESS MIN.550 HV
2. CORE HARDNESS 240 ~ 450 HV
3. MATERIAL C1022
4. DEPTH OF HARDNESS
M3.5~M3.9 : 0.05~0.18mm
M4.2~M5.5 : 0.10~0.23mm
5. DRIVE TEST TIME
 $L \leq 2-1/2$: 2.0S: $\geq 90\%$, 2.5S: $\leq 10\%$
 $L > 2-1/2$: 2.5S: $\geq 90\%$, 3S: $\leq 10\%$
6. MAXIMUM OUT-OF-STRAIGHTNESS LIMIT
A. $L \leq 100\text{mm}$ Out-of-Straightness Limit
 $= L \times 0.152 + 25.4$
EX. $L = 80\text{mm} = 80 \times 0.152 + 25.4 = 0.48\text{mm}$
Out-of-Straightness Limit = $0.48\text{mm} \pm 0.24\text{mm}$
B. $L > 100\text{mm}$ Out-of-Straightness Limit
 $= L \times 0.01$
EX. $L = 160\text{mm} = 160 \times 0.01 = 1.60\text{mm}$
Out-of-Straightness Limit = $1.60\text{mm} \pm 0.80\text{mm}$

NO	DATE	CHANGE	BY
1.	0205 1997	WIRE. CHANGE	
2.	0429 1998	REMARKS ADD	

Tianjin Sinsun Imp & Exp Co., Ltd.

Coarse Thread Drawing



DESCRIPTION

PHIL. BUGLE HEAD DRYWALL SCREWS
(COARSE THREAD)

LENGTH TOLERANCE

L : ± 1.50

THREAD LENGTH

L : 13mm ~ 100mm

REMARKS

1. SURFACE HARDNESS MIN. 500 HV
2. CORE HARDNESS 240 ~ 450 HV
3. MATERIAL C1018 ~ C1022
4. DEPTH OF HARDNESS
M3.5 : 0.05 ~ 0.18mm
M3.9~M4.8 : 0.10 ~ 0.23mm
- 5.
- 6.
- 7.
- 8.
- 9.

DETAILS SIZE	HEAD DIA. A	F	MAJOR DIA. D	MINOR DIA. d	K	PITCH P	RECESS DEPTH Q	R	RECESS WIDTH M	N	TORQ. Kg-cm	WIRE ϕ
#6 (3.5mm)	7.90 8.50	4.50 7.00	3.50 3.90	2.05 2.35	0.50 0.80	2.70 2.80	2.35 2.93	4.50 5.00	4.50 5.10	0.81	28 min.	2.65 -0.02
#7 (3.9mm)	7.90 8.50	4.50 7.00	3.80 4.20	2.20 2.50	0.50 0.80	2.70 2.80	2.35 2.93	4.50 5.00	4.50 5.10	0.81	28 min.	2.80 -0.02
#8 (4.2mm)	7.90 8.50	4.50 7.00	4.20 4.60	2.55 2.85	0.50 0.80	2.80 2.90	2.35 2.93	4.50 5.00	4.50 5.10	0.81	45 min.	3.15 -0.02
#9 (4.5mm)	7.90 8.50	4.50 7.00	4.40 4.80	2.80 3.10	0.50 0.80	2.80 2.90	2.35 3.18	4.50 5.00	4.50 5.10	0.81	55 min.	3.45 -0.02
#10 (4.8mm)	8.80 9.40	4.50 7.00	4.90 5.35	3.05 3.35	0.50 1.00	3.10 3.20	2.50 3.18	4.50 5.00	4.50 5.10	0.81	65 min.	3.80 -0.02
#7 L>2"~ (M3.9>50mm)	7.90 8.50	4.50 7.00	4.00 4.40	2.35 2.65	0.50 0.80	2.70 2.80	2.35 2.93	4.50 5.00	4.50 5.10	0.81	35 min.	2.95 -0.02



THREAD LENGTH

L<55mm,S=FULLY

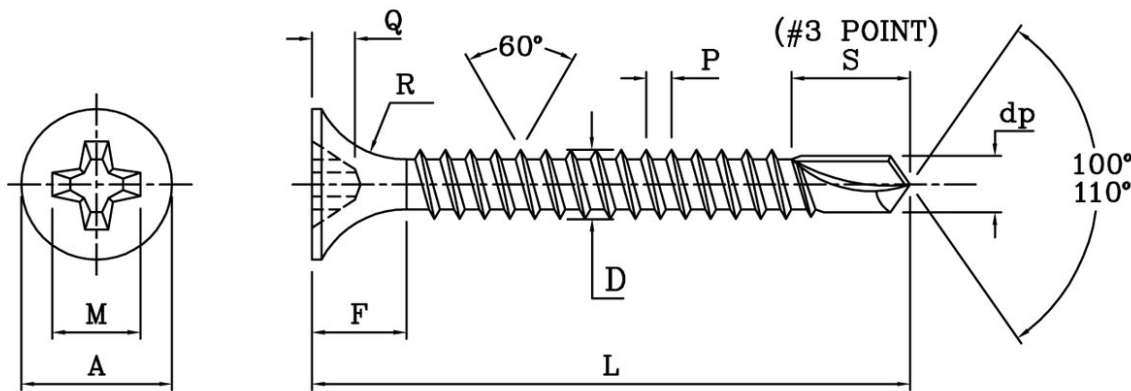
L>56mm<75mm,S=50mm.

L>76mm,S=60mm.

NO	DATE	CHANGE	BY
1.		ORIGINAL	
2.	JUN.28 1999	CHANGE HARDNESS	
3.	NOV.08 2000	#7 L>2"~ CHANGE	
4.			

Tianjin Sinsun Imp & Exp Co., Ltd.

Self Drilling Screw Drawing



DETAILS	HEAD DIA. A	F	RECESS WIDTH M	RECESS DEPTH Q	DRIVE SIZE	R (REF.)	MAJOR DIA. D	PITCH P (REF.)	S	dp	TORQUE Kg-cm	WIRE ϕ
SIZE												
#6 (3.5mm)	7.90 8.50	4.50 7.00	4.50 5.10	2.35 2.93	2	5.00	3.35 3.53	1.30	4.50 5.00	2.70 2.90	28 min	2.80 -0.02
#7 (3.9mm)	7.90 8.50	4.50 7.00	4.50 5.10	2.35 2.93	2	5.50	3.73 3.91	1.35	4.50 5.00	3.10 3.20	35 min	3.05 -0.02
#8 (4.2mm)	7.90 8.50	4.50 7.00	4.50 5.10	2.35 2.93	2	5.50	4.04 4.22	1.40	5.50 6.00	3.30 3.50	45 min	3.30 -0.02

DESCRIPTION

PHIL. BUGLE HEAD SELF DRILLING
SCREWS (WITH #3 POINT)

LENGTH TOLERANCE

L : ± 1.50

REMARKS

1. SURFACE HARDNESS MIN.550 HV
2. CORE HARDNESS 240 ~ 450 HV
3. MATERIAL C1018 ~ C1022
4. DEPTH OF HARDNESS
#6 : 0.05~0.18mm
#7 : 0.10~0.23mm
#8 : 0.10~0.23mm
5. A,F,M,Q,R,D,d,P,TORQ. ACCORDING TO JIS B1125(1990)
- 6.
- 7.

NO	DATE	CHANGE	BY
1.	APR.28 1998	DRAWING,REMARKS CHANGE	
2.	JAN.20 1999	ADD. #7(M3.9mm) CHANGE REMARKS	
3.	AUG.07 1999	CHANGE A,F,M,Q	
4.	OCT.07 1999	CHANGE S	