

Technical Data

Countersunk hole processing

When the thickness of the countersunk part of the screw is thicker than the material, the screw head will protrude outwards. In this case, please advise on how to handle this on your drawings.

All dimensions are in mm

Thread size	Countersunk height	Minimum thickness
M2	1.2	1.2mm
M2.5	1.45	1.45mm
M2.6	1.5	1.5mm
M3	1.75	1.75mm
M3.5	2.0	2.0mm
M4	2.3	2.3mm
M4.5	2.55	2.55mm
M5	2.8	2.8mm
M6	3.4	3.4mm
M8	4.4	4.4mm

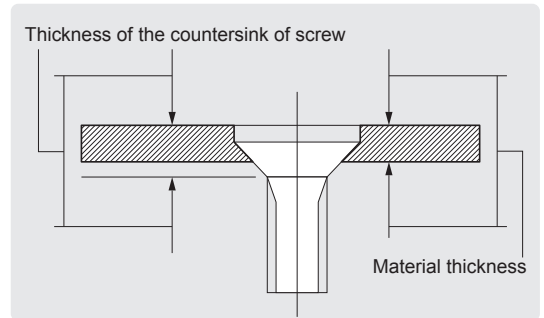


Fig.01

Should you encounter problems with protruding screw head/s, you could:

- Slightly deepen the head depth size to allow full insertion. (See Fig.01)
- Switch to having a standard circular hole.
- Consider switching to a smaller head screw.
- Change to using smaller screws.
- Or to let the protruding screw head remain protruded from the surface. (See Fig.02)

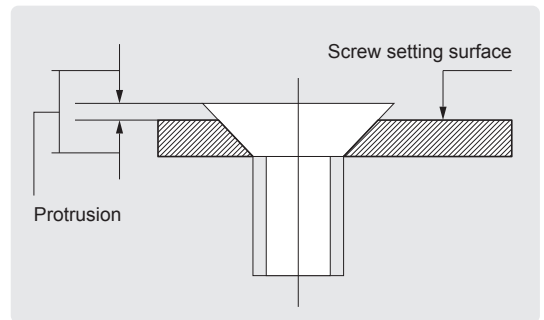


Fig.02

Threading

We can process thread holes from M1.7 to M32 and from PG7 to PG21 as per the chart below. Both plastic and metallic material types can be processed.

Metric Thread

Size	Pitch	Size	Pitch
M1.7	0.35	M11	0.75
M2	0.4	M12	1
M2.3	0.4		1.25
M2.5	0.45		1.5
M2.6	0.45	M13	1
M3	0.5	M16	1.5
M4	0.7	M18	1
M5	0.8	M20	1.5
M6	1	M25	1.5
M7	0.5	M32	1.5
M8	0.75		
	1.25		
M9	0.5		
	0.75		
M10	0.75		
	1		

PG Thread

Size	Pitch
PG7	1.27
PG9	1.41
PG11	
PG13.5	
PG16	1.588
PG21	



See Clinching-1, Self-clinching standoff / stud / nut

See Clinching-6, Inserts for plastic

