

ORIGINAL DRAWING	EDITION	5TH EDITION
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DESCRIPTION

POZI. CSK HEAD CHIPBOARD SCREWS

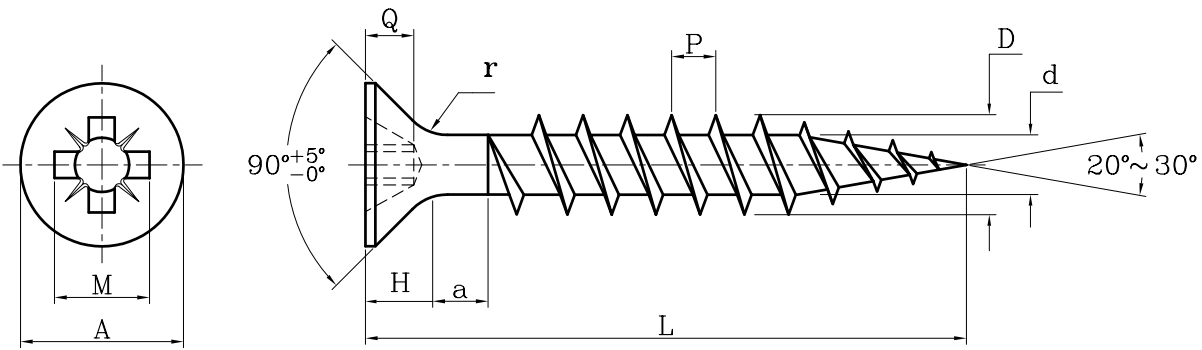
LENGTH TOLERANCE

12~18	±0.90	31~50	±1.25	81~120	±1.75
19~30	±1.05	51~80	±1.50	121~200	±2.00

REMARKS

- SURFACE HARDNESS min. 450 HV
- CORE HARDNESS 240 - 450 HV
- MATERIAL C1018 ~ C1022
- DEPTH OF HARDNESS
M2.5 :0.04 ~ 0.10mm
M3~M3.5:0.05 ~ 0.18mm
M4~M5 :0.10 ~ 0.23mm
M6 :0.10 ~ 0.28mm
- DRAWING REFERED TO DIN 7505
- MAXIMUM OUT-OF-STRAIGHTNESS LIMIT
A. M6.0≤140mm Out-of-Straightness Limit
M5.0≤100mm =L×0.152±25.4
EX. M6.0×80mm=80×0.152±25.4=0.48mm
Out-of-Straightness Limit=0.48mm=±0.24mm
B. M6>140mm Out-of-Straightness Limit
M5>100mm =L×0.01
EX. M6.0×160mm=160×0.01=1.60mm
Out-of-Straightness Limit=1.60mm=±0.80mm

NO	DATE	CHANGE	BY
2.	FEB.08 1999	REMARK ADD	戴樹德
3.	DEC.13 1999	CHANGE d	陳金純
4.	JUN.27 2000	M3.2 ADD	蘇秀菊
5.	NOV.08.05 2005	M5.5 ADD	蘇秀菊



DETAILS SIZE	HEAD DIA. A	H REF.	a max.	MAJOR DIA. D	MINOR DIA. d	PITCH P REF.	RECESS DEPTH Q	RECESS WIDTH M REF.	DRIVE SIZE	RADIUS r max.	TORQUE Kg-cm	WIRE DIA. Ø
M2.5	4.70 5.05	1.40	2.10	2.25 2.55	1.25 1.65	1.10	1.22 1.57	2.51	1	1.50	10 min.	1.85 -0.02
M3.0	5.70 6.05	1.80	2.35	2.75 3.05	1.50 1.90	1.35	1.60 2.11	3.00	1	1.50	15 min.	2.15 -0.02
M3.2	6.04 6.40	1.90	2.50	2.90 3.20	1.65 2.05	1.60	1.35 1.80	3.50	2	1.70	19 min.	2.30 -0.02
M3.5	6.64 7.05	2.00	2.60	3.20 3.55	1.80 2.20	1.60	1.76 2.16	4.00	2	1.80	20 min.	2.45 -0.02
M4.0	7.64 8.05	2.35	2.80	3.70 4.05	2.15 2.55	1.80	2.05 2.51	4.40	2	2.00	30 min.	2.80 -0.02
M4.5	8.64 9.05	2.55	3.00	4.20 4.55	2.35 2.75	2.00	2.46 3.02	4.80	2	2.20	44 min.	3.15 -0.02
M5.0	9.64 10.05	2.85	3.20	4.70 5.05	2.70 3.10	2.20	2.99 3.55	5.30	2	2.50	61 min.	3.47 -0.02
M5.5	10.57 11.05	3.10	3.40	5.20 5.55	3.00 3.40	2.40	2.72 3.18	6.30	3	2.50	78 min.	3.85 -0.02
M6.0	11.57 12.05	3.35	3.60	5.70 6.05	3.30 3.70	2.60	2.99 3.55	6.60	3	2.50	110 min.	4.20 -0.02

編號 ITEM No.	日期 DATE	APR.2998	繪圖 DWN.	李雨蓉	審核 CHECK	核准 APPROVE	單位 UNIT	mm	比例 SCALE	投影 PROJECTION	
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