METRIC FASTENERS

THREAD FORMING SCREWS

B.

DIN 7500M / STAINLESS <u>Six-Lobe Flat Head</u>



METRIC - DIN 7500M 90° FLAT SIX-LOBE—STAINLESS									
Nominal Size	Thread Pitch	G Head Diameter		Т	B Recess Diameter	F Recess Penetration		Recess Size	
				Height of Head					
		Max	Min	Max	Nom	Max	Min		
M2.5	0.45	4.7	4.4	1.5	2.4	0.79	0.66	Т8	
M3	0.5	5.5	5.2	1.65	2.8	0.83	0.70	T10	
M4	0.7	8.4	8.04	2.7	3.95	1.53	1.14	T20	
< M5 <	0.8	9.3	8.94	2.7 🕥	4.5	1.51	1.12	T25	
M6	1.0	11.3	10.87	3.3	5.6	1.78	1.39	T30	
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								
	(D	В					
Nominal Size & Thread Pitch	Diame Circumscri	Major Thread Diameter						
	Мах	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				
M6-1.0	6.10	5.97	5.90	5.77				
Toloropoo on Longth	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 stainless steel 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.