

1 | 2 | 3 | 4

A

B

C

D

E

F

DIN 7504, SQUARE SOCKET (BIT NO. 1), PAN HEAD WITH LOCKING SERRATIONS UNDER HEAD, NO.2 POINT (DRILLING CAPACITY UP TO 2MM STEEL), TYPE AB, ZINC PLATED 4-6 micrometer, including 1 pc./box SQ-Bit 50mm

DRILLING SCREW

diametre	3,5	ISO		3,5	ISO		
PITCH (P)	1.3	1478	MAJOR DIA. (D)	3.35-3.53	1478		
HEAD DIA. (A)	MAX 7	7049	MINOR DIA. (d)	2.51-2.64	1478		
HEAD HEIGHT (H)	2.6	7049	DRILL POINT DIA. (R)	2.7-3.0	10666		
SQUARE RECESS DEPTH (K)			FLUTE LENGTH (U)	3.50-4.80			
SQUARE ACROSS WIDTH (e)							
Zinc plated white/blue	4-6micro	4042					
steel no. material	C1022						

TOLERANCE ON LENGTH L=9.5mm±0.75mm Tolerances according to ISO 4759-1, all dimensions in mm, Acceptance inspection according to ISO 3269:2000

DRILLING STANDARD	PLATE THICKNESS	1+1=2mm	ROTATIONAL SPEED	2500RPM	MAX SEC.	4.0 SEC	ISO
	AXIAL FORCE	150 (N)	LOADING	7.56 KGS			10666

MECHANICAL PROPERTY	SIZE	3.5	CORE HARDNESS	MAX 425 HV	BREAKING TORQUE	Min 30 (kg-cm)	10666
	MATERIAL	1022	SURFACE HARDNESS	MIN 560 HV	CARBON PENETRATE REQUIREMENT	0.05-0.18	10666

customer Nr.: production Nr.: Tolerances according to ISO 4759-1, all dimensions in mm, Acceptance inspection according to ISO 3269

designed	checked	approved by - date	Name of file	date	scale
G. Kramme	M. Goebel		4181135955	2007-10-25	no scale

4181135955 DIN 7504

GOEBEL GMBH

DRAWING Nr.:	Version	paper
4	REV0	1/1