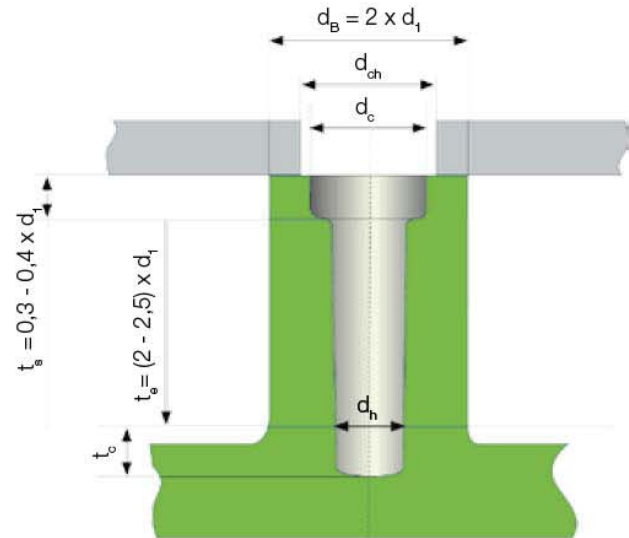


Advantages of DELTA PT® DS compared to screws with machine milled cutting edge:

- smaller hole depth possible because less chipping space is required compared to screws with a traditional cutting edge
- cost saving potential though standardisation - only one screw for thermosets and thermoplastics
- safe assembly with lead in
- wider production range regarding screw diameter and length
- larger thread engagement area for the same insertion depth

Hole geometry recommendations for DELTA PT® DS



production matrix of the DELTA PT® DS screw

Δ	22	25	30	35	40	45	50	60	70	80	90	100
nominal- \emptyset	2,2	2,5	3,0	3,5	4,0	4,5	5,0	6,0	7,0	8,0	9,0	10,0
tolerance js 16	nominal length l [mm]											
$\pm 0,375$												
	8											
$\pm 0,45$	7/5	7										
	8/5	8/6	8									
$\pm 0,55$	9	9/6	9/7	9								
	10/8	10	10/7	10/8	10							
	11/8	11/9	11/7	11/8	11/9	11						
	12/8	12/9	12	12/8	12/9	12/10	12					
	13/8	13/9	13/11	13/8	13/9	13/10	13/11					
	14/8	14/9	14/11	14	14/9	14/10	14/11					
	15/8	15/9	15/11	15/13	15/9	15/10	15/11	15				
	16/8	16/9	16/11	16/13	16	16/10	16/11	16/13				
	17/8	17/9	17/11	17/13	17/15	17/10	17/11	17/13	17			
	18/8	18/9	18/11	18/13	18/15	18	18/11	18/13	18/15			
$\pm 0,65$	20/8	20/9	20/11	20/13	20/15	20/17	20	20/13	20/15	20		
	21/8	21/9	21/11	21/13	21/15	21/17	21/19	21/13	21/15	21/18		
	22/8	22/9	22/11	22/13	22/15	22/17	22/19	22/13	22/15	22/18		
		23/9	23/11	23/13	23/15	23/17	23/19	23/13	23/15	23/18	23	
		24/9	24/11	24/13	24/15	24/17	24/19	24	24/15	24/18	24/20	
		25/9	25/11	25/13	25/15	25/17	25/19	25/22	25/15	25/18	25/20	25
			28/11	28/13	28/15	28/17	28/19	28/22	28	28/18	28/20	28/22
			30/11	30/13	30/15	30/17	30/19	30/22	30/26	30/18	30/20	30/22
$\pm 0,8$				32/13	32/15	32/17	32/19	32/22	32/26	32	32/20	32/22
				35/13	35/15	35/17	35/19	35/22	35/26	35/30	35/20	35/22
					36/15	36/17	36/19	36/22	36/26	36/30	36	36/22
					40/15	40/17	40/19	40/22	40/26	40/30	40/33	40
						45/17	45/19	45/22	45/26	45/30	45/33	45/37
$\pm 0,95$							50/19	50/22	50/26	50/30	50/33	50/37
								60/22	60/26	60/30	60/33	60/37
$\pm 1,1$									70/26	70/30	70/33	70/37
										80/30	80/33	80/37
										90/33	90/37	
												100/37

$d_h = \text{Hole- } \emptyset = 0,83 - 0,90 \times d_1$
 $d_1 = \text{Nominal } \emptyset \text{ of the screw}$
 $d_c = \text{counterbore diameter} = d_1 + 0,2 \text{ mm}$
 $t_c = \text{chip space} = 0,8 \text{ bis } 1,2 \times d_1$

X / X manufacturing only with partial thread (screw length / thread)
X manufacturing with complete thread