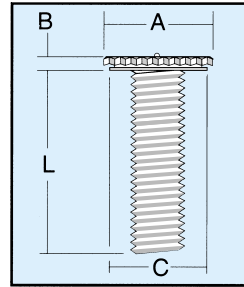


**Material:** Mild steel, heat treated  
**Finish:** Zinc plated and yellow passivated



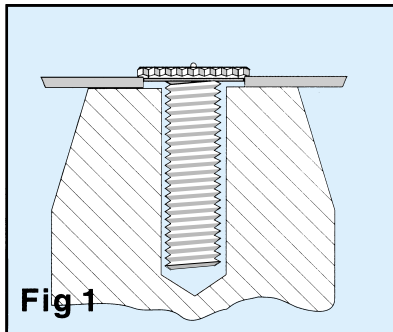
## PRESS SCREW

Inserted by hand or power presses, the installation procedure causes the parent material to flow into the undercut between the flange and the knurl holding the stud firmly in place. The parent material must be suitably malleable to allow material flow during penetration of the case hardened knurl, e.g. mild steel, aluminium etc.

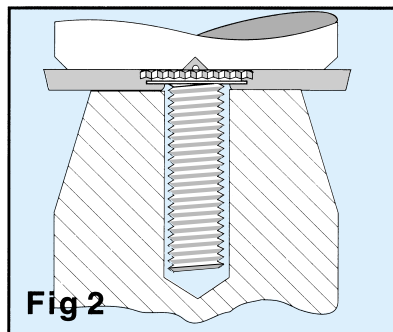


### PLUS POINTS

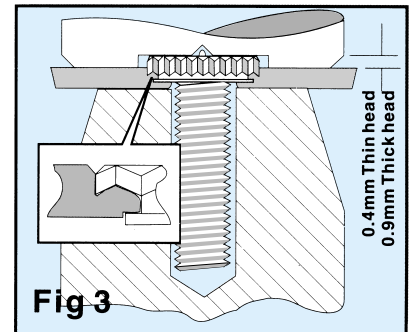
- Will not rotate
- No need for welding
- Available with flush and non-flush heads
- No maximum material thickness



Pass screw through material ensuring location of diameter "C" in hole so that knurl points are resting on parent material. Support die must fit close to threaded diameter.



Drive the Press Screw in parent material until flush (Fig 2) or in the case of the minimum thickness sheet, to dimensions (Fig 3) using a recessed top tool.  
**NOTE:** Punching tool should have a small clearance dimple drilled on its face to accommodate the possibility of a part-off pip which can occur on the screw head.



Thread size	Length (L) ±0.4	A ±0.2	B ±0.1		C Max.	Hole size ±0.1 -0.0	Min. sheet thickness		Min. sheet thickness flush fit		Part No	
			Thin head	Thick head			Thin head	Thick head	Thin head	Thick head	Thin head	Thick head
M2.5	A selection of lengths available from stock. Call our Sales Department to check your required length.	5.71	1.38	-	4.34	4.4	1	-	1.4	-	P1504	-
M3		7.3	1.38	-	5.75	5.8	1	-	1.4	-	P1505	-
M4		7.3	1.38	-	5.74	5.8	1	-	1.4	-	P1507	-
M5		8.89	1.571	2.25	7.09	7.14	1.2	1.4	1.6	2.3	P1508	P1535
M6		10.84	1.57	2.43	8.69	8.7	1.2	1.6	1.6	2.5	P1509	P1536
M8		12.86	1.57	2.43	11.05	11.1	1.2	1.6	1.6	2.5	P1510	P1537

All dimensions are in millimetres