52 CAPTIVE SCREW

DATE	DRAWN	CHKD	SCALE	DRAWING NUMBER
19APR2002	GDM	MAC	NTS	TD-52-3-J

REV	DATE	DRAWN/CHKD	DESCRIPTION
A	31JAN03	GDM	ADDED M4 SIZE

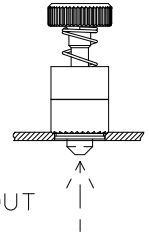
THIRD ANGLE PROJECTION

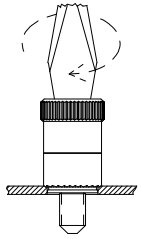
A4 PAPER SIZE

SOUTHCO PERFORMANCE GUIDELINES

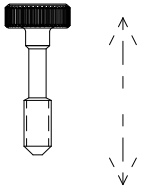
THE PERFORMANCE GUIDELINES SHOWN ON THIS PAGE ARE SUPPLIED AS A GENERAL GUIDE ONLY, AS CONDITIONS VARY WITH EACH APPLICATION AND METHOD OF INSTALLATION. STRENGTH DATA GIVEN IS FOR FAILURE OF THE PRODUCT OR FOR SUFFICIENT DEFORMATION TO MAKE THE PRODUCT INOPERABLE. NO SAFETY FACTOR HAS BEEN APPLIED. IT IS RECOMMENDED THAT THE USER REQUEST A PRODUCT SAMPLE FOR TESTING TO DETERMINE THE SUITABILITY OF THE PRODUCT FOR THE PURPOSE INTENDED AND USER'S PARTICULAR APPLICATION.

"X"=7:KNURLED, TORX/SLOT
8:SMOOTH, TORX/SLOT
9:KNURLED, PHILLIPS/SLOT
A:SMOOTH, PHILLIPS/SLOT





TIGHTENING TORQUE



ASSEMBLY PART NUMBER	SCREW SIZE	AVERAGE INSTALLATION FORCE N (lbf)	AVERAGE PUSH-OUT FORCE N (lbf) ③	RECOMMENDED TIGHTENING TORQUE N_cm (lbf_in) ④	ULTIMATE TIGHTENING TORQUE N_cm (lbf_in)	AVERAGE ULTIMATE TENSILE FORCE FORCE N (lbf) ⑤
52-1X-11-4 FLARE-IN	4-40	3000 (674)	600 (135)	60(5.2)	171 (15)	3500 (787)
52-1X-5 1/3-4 PRESS-IN		10000 (2248)	1000 (225)			
52-2X-21-4 FLARE-IN	6-32	3000 (674)	1160 (261)	110 (9.6)	281 (25)	5160 (1160)
52-2X-5 1/3-4 PRESS-IN		10000 (2248)	1190 (268)			
52-3X-11-4 FLARE-IN	M3	3000 (674)	600 (135)	60(5.2)	163 (14)	3500 (787)
52-3X-5 1/3-4 PRESS-IN		10000 (2248)	1000 (225)			
52-4X-21-4 FLARE-IN	M4	3000 (674)	1000 (225)	224 (19.8)	800 (70)	9900 (2226)
52-4X-51-4 PRESS-IN		10000 (2248)	1680 (378)			

1. PRESS-IN ASSEMBLIES WERE INSTALLED AND TESTED IN 0.9mm (.036in)THICK COLD ROLLED STEEL PANELS (MAXIMUM Rb55).
2. FLARE-IN M3/4-40 ASSEMBLIES WERE INSTALLED AND TESTED IN 0.8mm (.031in)THICK COLD ROLLED STEEL PANELS (MAXIMUM Rb55).
   FLARE-IN M4/6-32 ASSEMBLIES WERE INSTALLED AND TESTED IN 1.5mm (.060in)THICK COLD ROLLED STEEL PANELS (MAXIMUM Rb55).
3. FAILURE OCCURED IN THE SCREW PUSHING OUT OF THE ASSEMBLY OR THE FERRULE PUSHING OUT OF THE PANEL.
4. REFERENCE - ASSEMBLY ENGINEERING MASTERS CATALOG;VOL. 10, 1971(C)HITCHCOCK PUBLISHING CO.
5. FAILURE OCCURED IN THE BREAKING OF THE SCREW SHANK.

SAMPLES TESTED TO ASTM B117 SALT FOG TEST PROCEDURE LASTED A MINIMUM OF 144 HOURS BEFORE OCCURANCE OF RED RUST.

REF:52-89, 52-107