

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



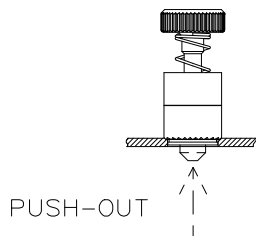
THIRD ANGLE PROJECTION

A4
PAPER
SIZE

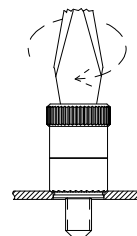
SOUTHCO PERFORMANCE GUIDELINES

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.

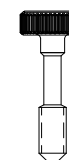
*X" = 7: KNURLED, TORX/SLOT
 8: SMOOTH, TORX/SLOT
 9: KNURLED, PHILLIPS/SLOT
 A: SMOOTH, PHILLIPS/SLOT



PRESS-IN STYLE SHOWN



TIGHTENING
TORQUE



TENSILE

ASSEMBLY PART NUMBER	SCREW SIZE	AVERAGE INSTALLATION FORCE N (lbf)	AVERAGE PUSH-OUT ^③ FORCE N (lbf)	RECOMMENDED TIGHTENING TORQUE ^④ N _{cm} (lbf _{in})	ULTIMATE TIGHTENING TORQUE N _{cm} (lbf _{in})	AVERAGE ULTIMATE TENSILE 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)			

- PRESS-IN ASSEMBLIES WERE INSTALLED AND TESTED IN 0.9mm (.036in) THICK COLD ROLLED STEEL PANELS (MAXIMUM Rb55).
- 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).
- FAILURE OCCURED IN THE SCREW PUSHING OUT OF THE ASSEMBLY OR THE FERRULE PUSHING OUT OF THE PANEL.
- REFERENCE - ASSEMBLY ENGINEERING MASTERS CATALOG; VOL. 10, 1971(C) HITCHCOCK PUBLISHING CO.
- 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.