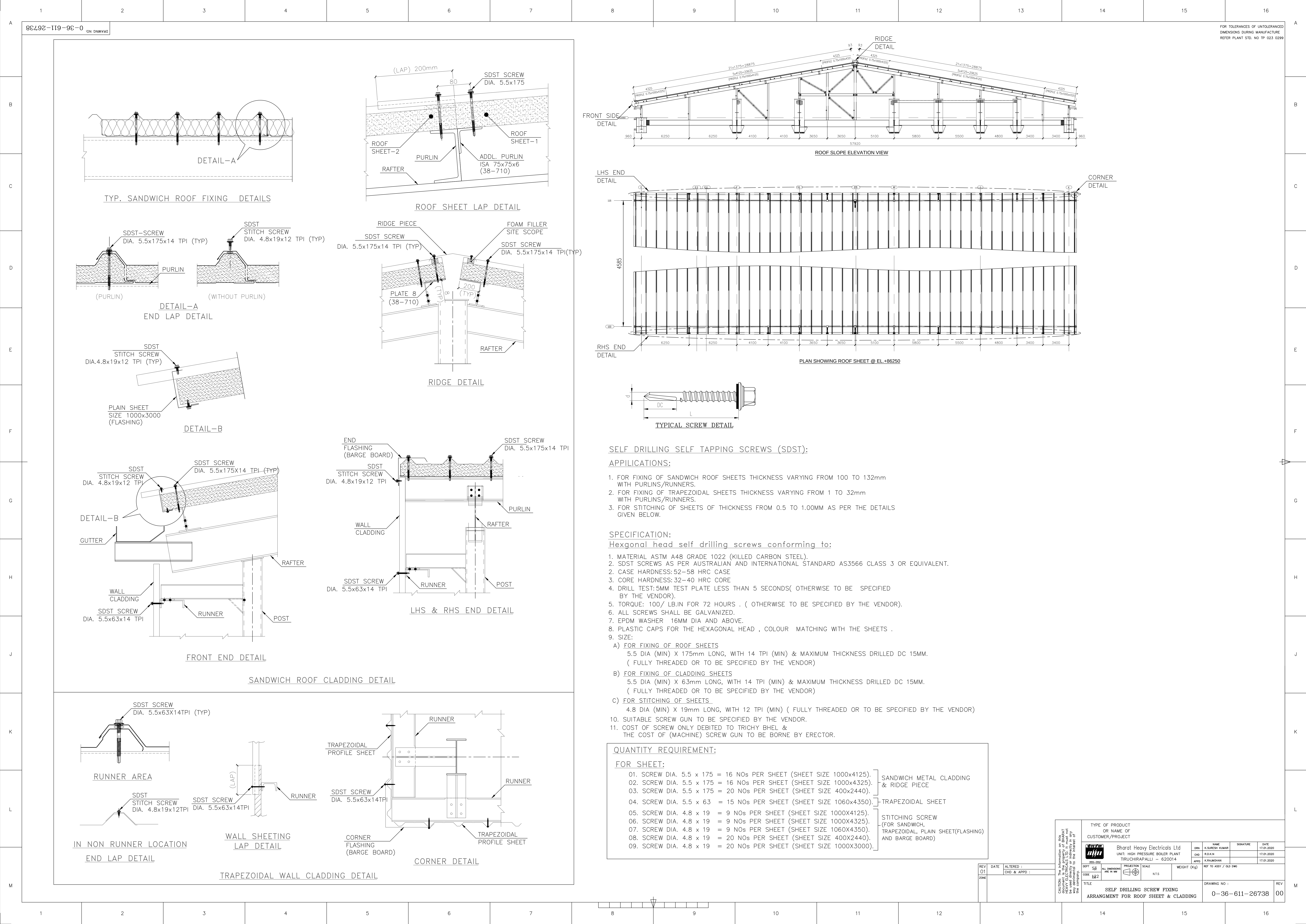




SELF DRILLING SELF TAPPING SCREWS (SDST):

APPLICATIONS:

1. FOR FIXING OF SANDWICH ROOF SHEETS THICKNESS VARYING FROM 100 TO 132mm WITH PURLINS/RUNNERS.
2. FOR FIXING OF TRAPEZOIDAL SHEETS THICKNESS VARYING FROM 1 TO 32mm WITH PURLINS/RUNNERS.
3. FOR STITCHING OF SHEETS OF THICKNESS FROM 0.5 TO 1.00MM AS PER THE DETAILS GIVEN BELOW.

SPECIFICATION:

Hexagonal head self drilling screws conforming to:

1. MATERIAL ASTM A48 GRADE 1022 (KILLED CARBON STEEL).
2. SDST SCREWS AS PER AUSTRALIAN AND INTERNATIONAL STANDARD AS3566 CLASS 3 OR EQUIVALENT.
2. CASE HARDNESS: 52-58 HRC CASE
3. CORE HARDNESS: 32-40 HRC CORE
4. DRILL TEST: 5MM TEST PLATE LESS THAN 5 SECONDS(OTHERWISE TO BE SPECIFIED BY THE VENDOR).
5. TORQUE: 100/ LB.IN FOR 72 HOURS . (OTHERWISE TO BE SPECIFIED BY THE VENDOR).
6. ALL SCREWS SHALL BE GALVANIZED.
7. EPDM WASHER 16MM DIA AND ABOVE.
8. PLASTIC CAPS FOR THE HEXAGONAL HEAD , COLOUR MATCHING WITH THE SHEETS .
9. SIZE:
 - A) FOR FIXING OF ROOF SHEETS
5.5 DIA (MIN) X 175mm LONG, WITH 14 TPI (MIN) & MAXIMUM THICKNESS DRILLED DC 15MM.
(FULLY THREADED OR TO BE SPECIFIED BY THE VENDOR)
 - B) FOR FIXING OF CLADDING SHEETS
5.5 DIA (MIN) X 63mm LONG, WITH 14 TPI (MIN) & MAXIMUM THICKNESS DRILLED DC 15MM.
(FULLY THREADED OR TO BE SPECIFIED BY THE VENDOR)
 - C) FOR STITCHING OF SHEETS
4.8 DIA (MIN) X 19mm LONG, WITH 12 TPI (MIN) (FULLY THREADED OR TO BE SPECIFIED BY THE VENDOR)
10. SUITABLE SCREW GUN TO BE SPECIFIED BY THE VENDOR.
11. COST OF SCREW ONLY DEBITED TO TRICHY BHEL & THE COST OF (MACHINE) SCREW GUN TO BE BORNE BY ERECTOR.

QUANTITY REQUIREMENT:

FOR SHEET:

- | | |
|---|---|
| 01. SCREW DIA. 5.5 x 175 = 16 NOS PER SHEET (SHEET SIZE 1000x4125). | SANDWICH METAL CLADDING & RIDGE PIECE |
| 02. SCREW DIA. 5.5 x 175 = 16 NOS PER SHEET (SHEET SIZE 1000x4325). | |
| 03. SCREW DIA. 5.5 x 175 = 20 NOS PER SHEET (SHEET SIZE 400x2440). | |
| 04. SCREW DIA. 5.5 x 63 = 15 NOS PER SHEET (SHEET SIZE 1060x4350). | TRAPEZOIDAL SHEET |
| 05. SCREW DIA. 4.8 x 19 = 9 NOS PER SHEET (SHEET SIZE 1000x4125). | STITCHING SCREW
(FOR SANDWICH, TRAPEZOIDAL, PLAIN SHEET(FLASHING) AND BARGE BOARD) |
| 06. SCREW DIA. 4.8 x 19 = 9 NOS PER SHEET (SHEET SIZE 1000x4325). | |
| 07. SCREW DIA. 4.8 x 19 = 9 NOS PER SHEET (SHEET SIZE 1060x4350). | |
| 08. SCREW DIA. 4.8 x 19 = 20 NOS PER SHEET (SHEET SIZE 400X2440). | |
| 09. SCREW DIA. 4.8 x 19 = 20 NOS PER SHEET (SHEET SIZE 1000X3000). | |

CAUTION: The information on this drawing is the property of Bharat Heavy Electricals Ltd. It must not be used for any purpose other than that for which it was prepared without the written consent of the company.		TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT			
		Bharat Heavy Electricals Ltd UNIT: HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI - 620014			
		DEPT	NAME	SIGNATURE	DATE
		CODE	DESIGN	DATE	DATE
REV 01		DATE	ALTERED :		
ZONE		CHD & APPD :			
		PROJECTION	SCALE	WEIGHT (kg)	REF TO ASSY / OLD DWG
		1:1	NTS		
		TITLE			DRAWING NO :
		SELF DRILLING SCREW FIXING ARRANGMENT FOR ROOF SHEET & CLADDING			REV 00