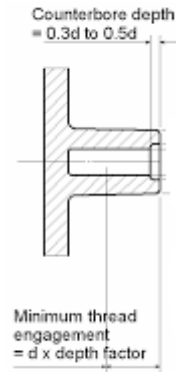
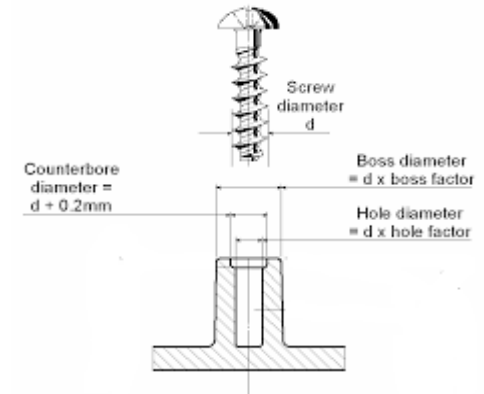


Thread Rolling Screw Pilot Hole Recommendations



Design Recommendation			
Material	Hole Diameter	Boss Diameter	Min Screw Depth
ABS	0.8 x d	2 x d	2 x d
ABS/PC Blend	0.8 x d	2 x d	2 x d
ASA	0.78 x d	2 x d	2 x d
PA 4.6	0.73 x d	1.85 x d	1.8 x d
PA 4.6 - GF 30	0.78 x d	1.85 x d	1.8 x d
PA 6	0.75 x d	1.85 x d	1.7 x d
PA 6 - GF 30	0.8 x d	2 x d	1.9 x d
PA 6.6	0.75 x d	1.85 x d	1.7 x d
PA 6.6 - GF 30	0.82 x d	2 x d	1.8 x d
PBT	0.75 x d	1.85 x d	1.7 x d
PBT - GF30	0.8 x d	1.80 x	1.7 x d
PC	0.85 x d	2.5 x d	2.2 x d
PC - GF 30	0.85 x d	2.2 x d	2 x d
PE LD	0.7 x d	2 x d	2 x d
PE HD	0.75 x d	1.8 x d	1.8 x d
PET	0.75 x d	1.85 x d	1.7 x d
PET - GF 30	0.8 x d	1.8 x d	1.7 x d
PMMA	0.85 x d	2 x d	2 x d
POM	0.75 x d	1.95 x	2 x d
POM - GF 30	0.8 x d	1.95 x	2 x d
PP	0.7 x d	2 x d	2 x d
PP - GF 30	0.8 x d	2 x d	2 x d
PP TV 20	0.72 x d	2 x d	2 x d
PPO	0.85 x d	2.5 x d	2 x d
PS	0.80 x d	2 x d	2 x d
PVC (hard)	0.80 x d	2 x d	2 x d
PEEK	0.85 x d	2 x d	2 x d
SAN	0.77x d	2 x d	1.9 x d



Above Technical Information May Be Subject To Change If International Standards
Are Amended

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