

ZN

$\frac{D}{L}$	$\frac{\varnothing 4,8}{19}$
19	Ø

BI-METAL
A2

$\frac{D}{L}$	$\frac{\varnothing 4,8}{19}$	$\frac{\varnothing 6,0}{25}$
19	Ø	
25		Ø

PRODUCT DESCRIPTION AND CHARACTERISTICS

- Bi-metal screws made of stainless steel A2, with hardened carbon steel drilling point.
- Intended for use in environment up to C5 category acc. to EN ISO 12944-2.
- Screws available with assembled stainless steel washer with EPDM sealing ring E (mm) - Ø14, Ø16 or without sealing washer.
- The design of the screws enables fast and tight joining of metal elements with a thickness of 2 x 0.5 to 2 x 1.0 mm, without the formation of metal chips during assembly, which can cause corrosion.
- Innovative conical geometry of the screw reduces installation time and the sharp tip of the thread reduces the screw slippage on the sheet surface.
- The designed thread geometry ensures tight pressure of the fixed elements and high load-bearing capacity of the connection.
- The product meets the requirements of class A1 reaction to fire, according to EC 96/603/EC.



DRILLER®

BI-METAL
A2

Class A1 reaction to fire
EC 96/603/ EC

APPLICATION

- Fast, chipless and tight stitching of thin metal sheets
- Steel sheets overlapping
- Assembly of photovoltaic installation elements

INSTALLATION INSTRUCTIONS

- Set the screw perpendicular to the surface of the fastened elements.
- Set the proper rotational speed of the screwdriver acc. to Tab. A2.
- Installation with a minimum pressure force of 15-20 KG depending on the hardness of the base material.
- Use a screwdriver with adjustable torque for assembly. Installation torque $M_{t, nom}$ according to Table A2.
- Press the washer correctly to ensure tightness and prevent corrosion in the fixing point.

Table A1: MATERIAL PARAMETERS OF FASTENER

Elements	Material
1 Screw	Bi-metal: stainless steel – SAE 304 with hardened carbon steel drilling point
2 Washer	Stainless steel washer with EPDM sealing ring S280GD, S320GD or S350GD - EN 10346,
3 Fixed element	aluminium
4 Base material	S280GD, S320GD or S350GD - EN 10346, aluminium

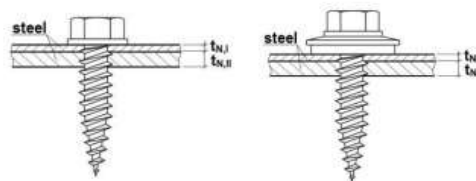


Table A2: FIXING PARAMETERS

Type	Screw diameter D [mm]	Screw length L [mm]	Head size AF [mm]	Drilling capacity Σt_i [mm] $t_{N, I} + t_{N, II}$	Max. thickness of fixed elements G+ Σt_i [mm] without washer steel/EPDM	Max. thickness of fixed elements G+ Σt_i [mm] with washer steel/EPDM $\geq \varnothing 14$	Installation torque $M_{t, nom}$ [Nm]	Drill speed [rpm]
WKFT (HS2)	4,8	19	8	2 x 0,5 – 2 x 1,0	11	8	3	max. 2500