

Manufacturer: LR ETANCO (FRANCE)

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Product name

ZACROVIS 12 TH12 / 2C Ø 6 x L

Application:

Fastening sheets to metal purlins.

Description:

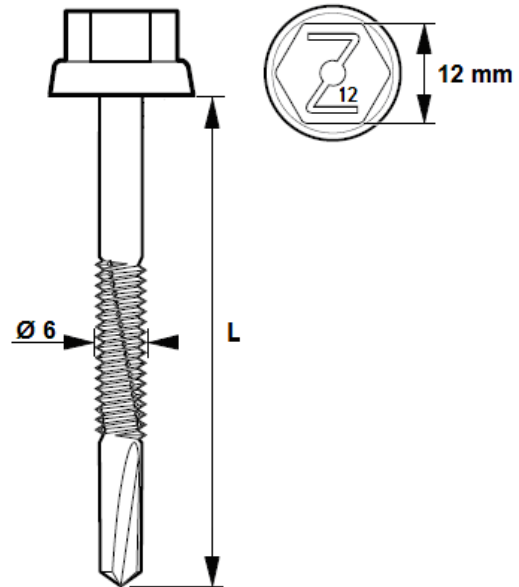
Self-drilling screw Ø 6 mm.
 ZAMAC hexagonal head of 12 mm with collar, natural finish or EPOXY powder painted, stove hardened.
 Pitch = 1.2 mm. Drill point.

Drilling capacity (CP):

4 to 12 mm into steel sheet.

Material:

Screw body: Cemented steel 20MB5 - SAE 1020 - JIS SWRCH22A.
 Surface hardness HV 0.5 _ 550 < HV < 750.
 Screw head: ZAMAC (Zinc, Alu).
 (20 years warranty against corrosion)



- **2C: SUPRACOAT 2C** treated cemented steel (12 to 20 µm)

Anti-corrosion level determined by Kesternich test (sulphur dioxide corrosion with general dampness condensation) according to NF EN 3231 (2ℓ):

Resisted to 15 cycles before the appearance of red rust.

Salt spray test according to NF ISO 9227 (March 2007):

Screw body: No trace of red rust after 500 hours.

Screw head: No trace of red rust after 1000 hours.

Painting of heads and washers:

Powder painted without TGIC – without Gloss polyester Epoxy

The following tests were carried out on 1 mm zinc plated steel test panels and a nominal coating thickness of 60 µm.

Test	ISO / ASTM Specification
Cross hatch adhesion	ISO 2409 - class 0
Impact resistance	ASTM D 2794 - pass 20 inch/lbs
Flexibility	ISO 1519 - pass 4 mm
Cupping test	ISO 1520 - pass 6 mm
Scratch resistance	N / A
Hot salt spray resistance	ISO 9227 - pass 1,000 hours
Humidity resistance	ISO 6270 - pass 1,000 hours
Kesternich resistance	ISO 3231 - pass 25 cycles
Chemical resistance	Resistance to most acids, alkalis and oils at normal temperatures. May be affected by chlorinated solvents.

Drilling Performance:

Conditions: a) Test material: S355 JR
 b) Test screwdriver: Drilling test with SCS Fein 6.3-19X power 400 W mini with torque limiter (depth control)

Drilling test	Unit	Ø 4.8	Ø 5.5	Ø 6.3 & 6.5
Drilling time	s/mm	< 2	< 2	< 2
Speed rotate	rpm	2000 *	2000 *	2000 *
Axial load	daN	16	20	27

* Under load: 1800 rotations/min

Drilling performance, diameter, length in mm and packaging

Drilling capacity	Ø x Length	CS Build up min	CS Build up max	Hex head TH	Packaging
4 to 12	6 x 75	42	54	12	100
4 to 12	6 x 85	22	64	12	100
4 to 12	6 x 105	42	84	12	100
4 to 12	6 x 120	57	99	12	100
4 to 12	6 x 145	82	124	12	100
4 to 12	6 x 180*	117	159	12	100
4 to 12	6 x 200*	137	179	12	100

* Crimped head

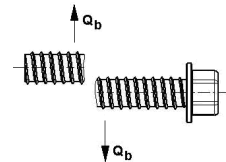
Tensile test value in daN:

$\bar{x} = 1294 \text{ daN}$



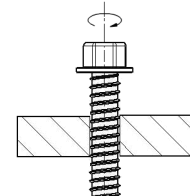
Shear test value – 0.6 x Rm (value in daN):

$\bar{x} = 776 \text{ daN}$



Torsion test value in Nm:

$\bar{x} = 16 \text{ Nm}$



Pull out test values (Pk in daN) – According to NF P 30-310

Steel sheet (Steel S235)				
4 mm	6 mm	8 mm	10 mm	12 mm
819	1062	1780**	1780**	1780**
Important: these values do not include safety coefficients and are provided for information purposes only				



**** Breaking point**

Conformity:

DTU 40.35

Recommended setting tools:

Screwdriver: FEIN SCS 6.3 -19X power 400 W mini with torque limiter (depth control)
Screw bit: 12 mm countersunk hexagonal head

Marking - Labelling:

ZACROVIS 12 TH12 / 2C – Ø 6 x L + CODE

Quality control:

ISO 9001 : 2015