

NORM FASTENERS

NORMEST® EASY SELF TAPPING FASTENERS

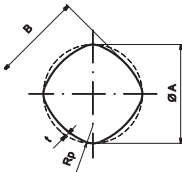
NORMEST® fasteners were developed to provide strong connection between assembly parts with high strip-to-drive ratio.



Originally developed thread geometry of **NORMEST®** allows excellent thread forming on the assembly hole.



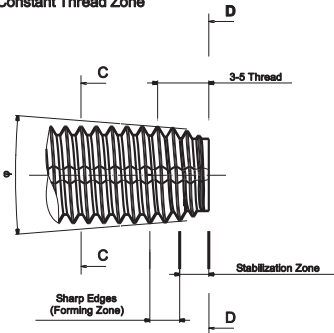
NORMEST® is a self-threading fastener providing customers to eliminate tapping operation of pilot hole and also provides vibration resistant connection.



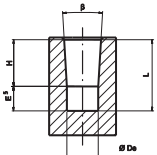
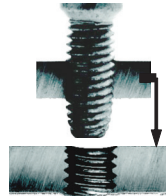
Section C - C
Constant Thread Zone



Section D - D
End - Point



Basic dimensional specifications(mm)



Superior four-cornered form provides low thread forming torque.



for more information:

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NORM EST®

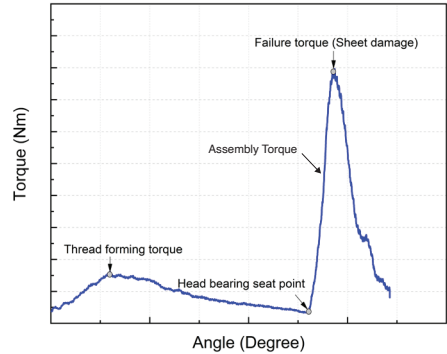
NORM EST Fasteners were developed to provide strong connection between assembly parts with high strip-to-drive ratio. NORM EST® is a self-threading fasteners providing customers to eliminate tapping operation of pilot hole and also provides vibration resistant connection. Originally developed thread geometry of NORM EST® allows excellent thread forming on the assembly hole. Superior four-cornered form provides low thread forming torque.

| M6 x 1 | | | | | | | |
|--------|---------------------|---------------------|----------------------|--------------------|----------------------------|---------------------|-------------------|
| Size | Major Diameter (mm) | Plate Hardness (HV) | Plate Thickness (mm) | Hole Diameter (mm) | Thread Forming Torque (Nm) | Failure Torque (Nm) | Strip/Drive Ratio |
| M6 x 1 | 5.64-5.94 | 90 | 3 | 5.46-5.49 | 1.12 | 7.12 | 6.43 |
| M6 x 1 | 5.64-5.94 | 150 | 3 | 5.46-5.49 | 2.41 | 8.37 | 3.6 |
| M6 x 1 | 5.64-5.94 | 200 | 3.25 | 5.48-5.50 | 1.46 | 9.55 | 6.54 |
| M6 x 1 | 5.64-5.94 | 200 | 4.25 | 5.51-5.53 | 1.59 | 12.45 | 7.83 |
| M6 x 1 | 5.64-5.94 | 200 | 5.25 | 5.55-5.57 | 1.73 | 16.15 | 9.33 |

| M8 x 1.25 | | | | | | | |
|-----------|---------------------|---------------------|----------------------|--------------------|----------------------------|---------------------|-------------------|
| Size | Major Diameter (mm) | Plate Hardness (HV) | Plate Thickness (mm) | Hole Diameter (mm) | Thread Forming Torque (Nm) | Failure Torque (Nm) | Strip/Drive Ratio |
| M8x1.25 | 7.76-7.94 | 190 | 2.5 | 7.26-7.28 | 4.65 | 8.9 | 1.9 |
| M8x1.25 | 7.76-7.94 | 150 | 3.25 | 7.24-7.26 | 5.82 | 19.15 | 3.3 |
| M8x1.25 | 7.76-7.94 | 200 | 3.25 | 7.30-7.32 | 4.01 | 18.57 | 4.66 |
| M8x1.25 | 7.76-7.94 | 200 | 4.25 | 7.35-7.37 | 5.67 | 22.12 | 3.89 |
| M8x1.25 | 7.76-7.94 | 200 | 5.25 | 7.38-7.40 | 7.26 | 24.93 | 3.49 |

Notes:

1. Bolt coating is Zinc Cr+3 + TT 8 with friction coefficient chancing between 0.07 and 0.10.
2. Tests were performed on cold-rolled sheets having different hardness values.
3. Deviations in the thickness, hardness and hole diameters from those given, the above values may vary.
4. All failure occurred in sheet metal plates at the end of the assembly.



for more information:

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