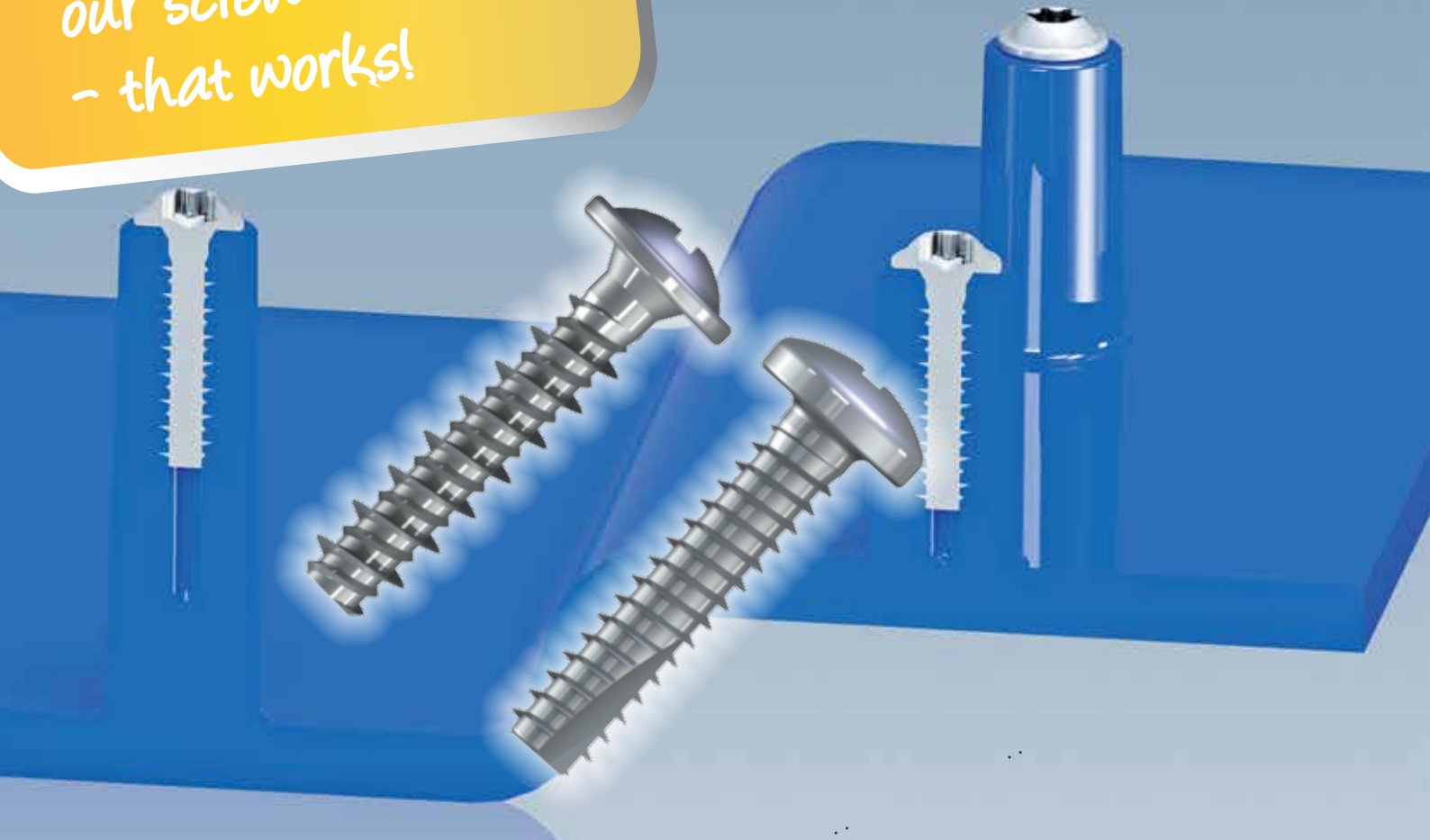


Your application,
our screw
- that works!



REISSER REKU THERMO DURO

Thread forming for Thermoplastics/ Duroplastics

- High extraction torque
- High overturning torque
- Low screw-in torque due to asymmetrical thread
- High process safety during the assembly thanks to guide thread

REISSER-Schraubentechnik GmbH
Fritz-Müller-Str. 10 • D-74653 Ingelfingen-Criesbach
Fon: +49 7940/127-152 • Fax: +49 940/127-123
produktion@reisser-screws.com • www.reisser-screws.com



REKU - REISSER plastic screw

Length tolerances

nominal length	ø3	ø3,5	ø4	ø5	ø6
8 ± 0,45					
10 ± 0,45					
12 ± 0,55					
14 ± 0,55					
16 ± 0,55					
18 ± 0,55					
20 ± 0,65					
25 ± 0,65					
30 ± 0,65					
35 ± 0,80					
40 ± 0,80					
45 ± 0,80					
50 ± 0,80					
60 ± 0,95					
70 ± 0,95					
80 ± 0,95					
90 ± 1,10					
100 ± 1,10					

Different dimensions on request.

REKU THERMO - REISSER plastic screw for THERMOplastics

Specially developed for direct screw coupling in Thermoplastics

Because of its asymmetrical thread, optimally directed flank angles and the guide thread between the thread flanks REKU THERMO is the perfect fastening element for THERMOplastics.

With this screw it is possible to screw directly in the core hole. Thread cutting is not necessary because REKU THERMO forms thread itself. High thread pitch for quick and easy assembly with less screw-in torque. Repeat assemblies can be carried out without difficulty. The guide thread between the thread flanks prevents tipping during the assembly and guarantees high process safety.

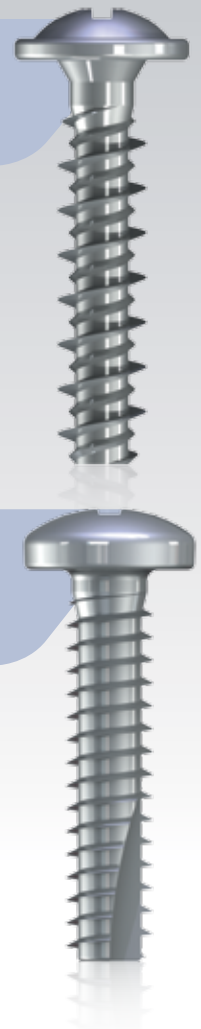
REKU DURO - REISSER plastic screw for DUROplastics

Specially developed for direct screw coupling in Duroplastics

Duroplastics place high demands on the fastening element. Due to their hardness and brittleness Duroplastics permit only low material expansion.

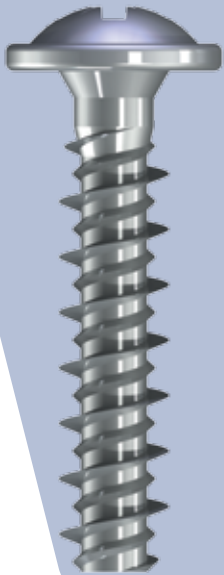
Because of its perfect elaborated thread and scraper groove the REKU DURO is the perfect fastening element for Duroplastics.

REKU DURO forms thread itself, therefore it is possible to screw directly in the core hole. The removed material will carry down in the scraper groove and prevent damage in the component part. Repeat assemblies can be carried out without difficulty.



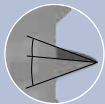
REKU THERMO -

REISSER plastic screw for THERMOplastics



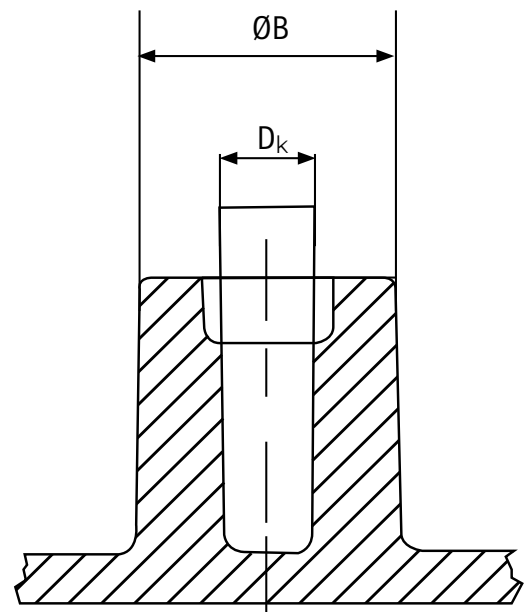
Advantages:

- High extraction torque
- High overturning torque
- Low screw-in torque
 - ↳ due to asymmetrical thread 25°/5° flank angles
- High process safety during the assembly
 - ↳ due to guide thread between the thread flanks



Construction recommendations for the dome:

material	core hole- $\varnothing D_k$	external - $\varnothing B$	screw-in depth T
ABS	$0,80 \times d_1$	$2,00 \times d_1$	$2,00 \times d_1$
ABS/PC Blend	$0,80 \times d_1$	$2,00 \times d_1$	$2,00 \times d_1$
ASA	$0,78 \times d_1$	$2,00 \times d_1$	$2,00 \times d_1$
PA 4.6	$0,73 \times d_1$	$1,85 \times d_1$	$1,80 \times d_1$
PA 4.6 - GF 30	$0,78 \times d_1$	$1,85 \times d_1$	$1,80 \times d_1$
PA 6	$0,75 \times d_1$	$1,85 \times d_1$	$1,70 \times d_1$
PA 6 - GF 30	$0,80 \times d_1$	$2,00 \times d_1$	$1,90 \times d_1$
PA 6.6	$0,75 \times d_1$	$1,85 \times d_1$	$1,70 \times d_1$
PA 6.6 - GF 30	$0,82 \times d_1$	$2,00 \times d_1$	$1,80 \times d_1$
PBT	$0,75 \times d_1$	$1,85 \times d_1$	$1,70 \times d_1$
PBT - GF 30	$0,80 \times d_1$	$1,80 \times d_1$	$1,70 \times d_1$
PC	$0,85 \times d_1$	$2,50 \times d_1$	$2,20 \times d_1$
PC - GF 30	$0,85 \times d_1$	$2,20 \times d_1$	$2,00 \times d_1$
PE (weich)	$0,70 \times d_1$	$2,00 \times d_1$	$2,00 \times d_1$
PE (hart)	$0,75 \times d_1$	$1,80 \times d_1$	$1,80 \times d_1$
PET	$0,75 \times d_1$	$1,85 \times d_1$	$1,70 \times d_1$
PET - GF 30	$0,80 \times d_1$	$1,80 \times d_1$	$1,70 \times d_1$
PMMA	$0,85 \times d_1$	$2,00 \times d_1$	$2,00 \times d_1$
POM	$0,75 \times d_1$	$1,95 \times d_1$	$2,00 \times d_1$
PP	$0,70 \times d_1$	$2,00 \times d_1$	$2,00 \times d_1$
PP - TV 20	$0,72 \times d_1$	$2,00 \times d_1$	$2,00 \times d_1$
PPO	$0,85 \times d_1$	$2,50 \times d_1$	$2,20 \times d_1$
PS	$0,80 \times d_1$	$2,00 \times d_1$	$2,00 \times d_1$
PVC (hart)	$0,80 \times d_1$	$2,00 \times d_1$	$2,00 \times d_1$



d_1 = nominal diameter of screw
 core hole diameter D_k according to table

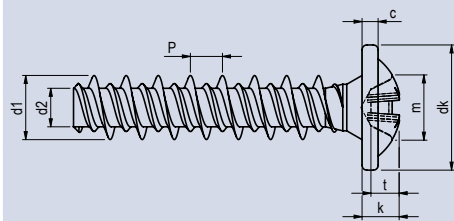
The stated values are reference values.

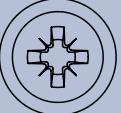

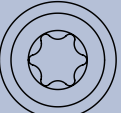
REKU THERMO -

REISSER plastic screw for THERMOplastics

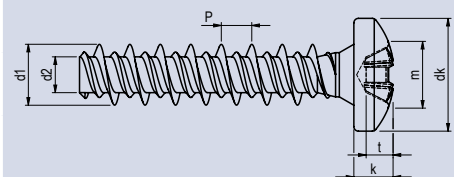
nominal - \emptyset	d_1	3,00	3,50	4,00	5,00	6,00
thread core - \emptyset	d_2	1,80	1,95	2,30	2,95	3,50
thread pitch	P	1,50	1,75	2,00	2,40	2,85

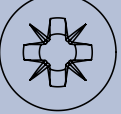
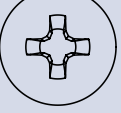
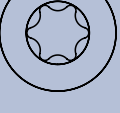
head diameter	max. d_k	6,00	7,00	8,00	10,00	12,00
height of head	k	2,10	2,40	2,50	3,20	4,00
thickness of washer	c	0,75	0,85	0,95	1,20	1,40



RN 0037 	PZD dimension / width	m	1 / 2,8	2 / 3,8	2 / 4,2	2 / 4,7	3 / 6,3	
	penetration depth	t min	1,26	1,08	1,40	2,01	2,27	
		t max	1,51	1,54	1,86	2,47	2,73	
	RN 0038 	PH dimension / width	m	1 / 2,9	2 / 3,0	2 / 4,1	2 / 4,6	3 / 6,4
		penetration depth	t min	1,15	1,25	1,50	2,11	2,34
			t max	1,60	1,70	1,96	2,62	2,90
RN 0039 	TX	dimension	10	10	20	25	25	
	penetration depth	t min	1,01	1,52	1,42	1,52	2,28	
		t max	1,27	1,78	1,8	1,91	2,6	

head diameter	d_k	5,60	6,50	7,50	8,80	10,80
height of head	k	2,20	2,55	2,75	3,40	4,10



RN 0044 	PZD dimension / width	m	1 / 3,0	2 / 4,0	2 / 4,4	2 / 4,9	3 / 6,4
	penetration depth	t min	1,40	1,40	1,90	2,15	2,50
		t max	1,80	1,90	2,40	2,75	3,10
RN 0046 	PH dimension / width	m	1 / 3,0	2 / 3,9	2 / 4,4	2 / 4,9	3 / 6,4
	penetration depth	t min	1,40	1,40	1,90	2,15	2,50
		t max	1,80	1,90	2,40	2,75	3,10
RN 0048 	TX	dimension	10	10	20	25	25
	penetration depth	t min	1,01	1,14	1,27	1,39	1,9
		t max	1,27	1,4	1,66	1,78	2,29

REKU THERMO -

REISSER plastic screw for THERMOplastics

nominal - \emptyset	d_1	3,00	3,50	4,00	5,00	6,00
thread core - \emptyset	d_2	1,80	1,95	2,30	2,95	3,50
thread pitch	P	1,50	1,75	2,00	2,40	2,85

	RN 0052 	head diameter	max. d_k	5,50	7,30	8,40	9,30	11,30
		PZD dimension / width	m	1 / 2,8	2 / 4,0	2 / 4,2	2 / 4,4	3 / 6,6
	penetration depth	t min	1,48	1,60	1,85	2,05	2,99	
		t max	1,73	2,06	2,31	2,51	3,45	
	RN 0053 	PH dimension / width	m	1 / 3,0	2 / 4,2	2 / 4,4	2 / 4,6	3 / 6,2
		penetration depth	t min	1,40	1,62	1,90	2,11	2,31
	t max		1,70	2,12	2,40	2,62	2,81	
	RN 0054 	TX	dimension	10	10	20	25	25
		penetration depth	t min	0,84	1,14	1,27	1,52	2,28
	t max		1,10	1,40	1,66	1,91	2,60	

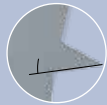
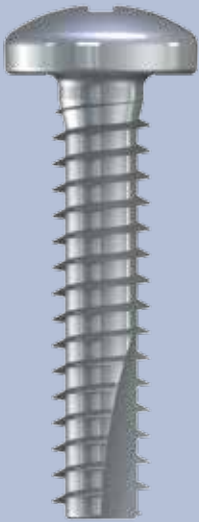
	RN 0059 	head diameter	max. d_k	5,50	7,30	8,40	9,30	11,30
		PZD dimension / width	m	1 / 3,0	2 / 4,2	2 / 4,4	2 / 4,6	3 / 6,4
	penetration depth	t min	1,40	1,60	1,90	2,15	2,50	
		t max	1,80	2,10	2,40	2,75	3,10	
	RN 0060 	PH dimension / width	m	1 / 3,0	2 / 4,2	2 / 4,4	2 / 4,6	3 / 6,4
		penetration depth	t min	1,40	1,60	1,90	2,15	2,50
	t max		1,80	2,10	2,40	2,75	3,10	
	RN 0061 	TX	dimension	10	10	20	25	25
		penetration depth	t min	1,01	1,52	1,52	1,9	2,28
	t max		1,27	1,78	1,91	2,29	2,67	

	RN 0070 	width across flat	AF	5,00	5,50	7,00	8,00	10,00
		height of head	k	1,60	2,40	2,40	3,10	3,60
		width across corners	e	5,4	5,96	7,59	8,71	10,95

Different dimensions and performances on request.

REKU DURO -

REISSER plastic screw for DUROplastics



- High extraction torque
- High overturning torque
- Low screw-in torque
↳ due to asymmetrical thread



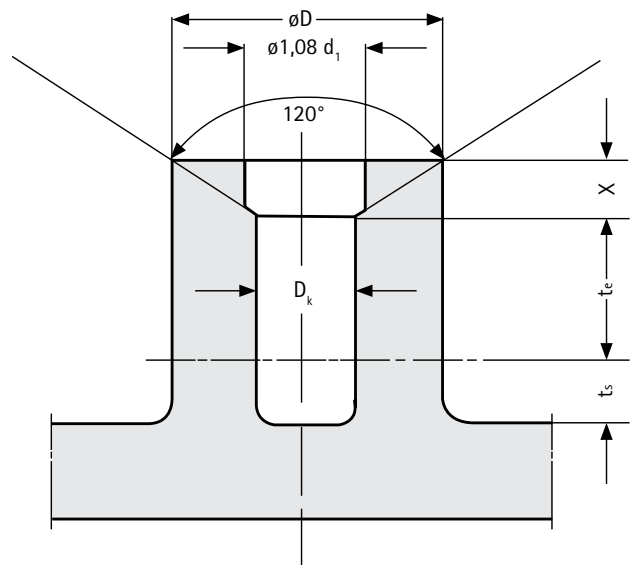
- No damage in the component part
↳ scraper groove offers space for removed material

Material reference values and core hole appointment

type	resin type	type of filling material	density [g/cm ³]
31	phenol	wood flour	1,4
181	melamine-phenol	cellulose	1,6
802	polyester	fiberglass	2,0
B1040	phenol	asbestos	1,75

material	core hole- $\varnothing D_k$ [mm]	diameter D[mm]
type 31	$0,85 \times d_1$	$8,567 \times d_1 - 6,667 \times D_k$
type 181	$0,88 \times d_1$	
type 802	$0,85 \times d_1$	
B1040	$0,88 \times d_1$	

material	screw-in depth t_e [mm]	chip space volume t_s [mm]	depth of countersink x [mm]
type 31	$\geq 2 \times d_1$ $\leq 3 \times d_1$	$0,8 \times d_1 \div 1,2 \times d_1$	$\frac{\tan 30^\circ}{2} (d_1 - D_k)$
type 181			
type 802			
B1040			

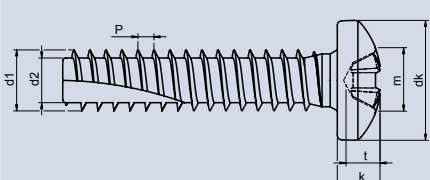

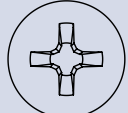
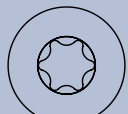


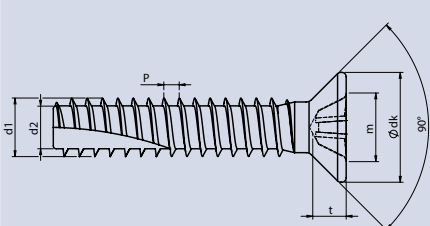



d_1 = nominal diameter of screw
 D_k = core hole diameter

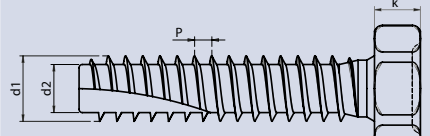

REKU DURO -

REISSER plastic screw for DUROplastics

nominal - \emptyset	d_1	2,50	3,00	3,50	4,00	5,00	6,00	8,00
thread core - \emptyset	d_2	1,81	2,18	2,56	2,93	3,68	4,42	5,91
thread pitch	P	0,77	0,86	0,95	1,05	1,23	1,42	1,79

		head diameter	d_k	5,00	6,00	7,00	8,00	10,00	12,00	16,00	
		height of head	k	2,00	2,40	2,70	3,10	3,80	4,60	6,00	
	RN DUR1	PZD dimension / width	m	1 / 2,60	1 / 3,00	2 / 4,00	2 / 4,30	2 / 5,00	3 / 6,70	4 / 8,80	
		penetration depth	t min	1,27	1,68	1,65	1,90	2,64	3,02	4,06	
			t max	1,52	1,93	2,11	2,36	3,10	3,48	4,52	
		RN DUR2	PH dimension / width	m	1 / 2,70	1 / 3,10	2 / 4,20	2 / 4,60	2 / 5,30	3 / 6,80	4 / 9,00
		penetration depth	t min	1,30	1,70	1,74	2,04	2,77	3,03	4,18	
			t max	1,60	2,00	2,24	2,54	3,27	3,53	4,68	
		RN DUR3	TX	dimension	8	10	15	20	25	30	40
	penetration depth	t min	0,9	1	1,2	1,4	1,6	2	2,7		
		t max	1,15	1,3	1,5	1,8	2	2,4	3,2		

		head diameter	d_k	4,70	5,60	6,50	7,50	9,20	11,00	14,50	
	RN DUR4	PZD dimension / width	m	1 / 2,50	1 / 2,80	2 / 3,70	2 / 4,00	2 / 4,40	3 / 6,10	4 / 8,50	
		penetration depth	t min	1,22	1,48	1,34	1,60	2,05	2,46	3,86	
			t max	1,47	1,73	1,80	2,06	2,51	2,92	4,32	
		RN DUR5	PH dimension / width	m	1 / 2,70	1 / 2,90	2 / 3,90	2 / 4,40	2 / 4,60	3 / 6,60	4 / 8,70
		penetration depth	t min	1,25	1,50	1,40	1,90	2,10	2,80	3,90	
			t max	1,55	1,80	1,90	2,40	2,60	3,30	4,40	
		RN DUR6	TX	dimension	8	10	15	20	25	30	40
	penetration depth	t min	0,70	0,70	1,20	1,20	1,30	1,70	2,40		
		t max	0,95	1,05	1,55	1,70	1,80	2,15	2,90		

		width across flat	AF	5,00	5,50	6,00	7,00	8,00	10,00	13,00
	RN DUR7	height of head	k	1,70	2,00	2,40	2,80	3,50	4,00	5,30
										

Different dimensions and performances on request.

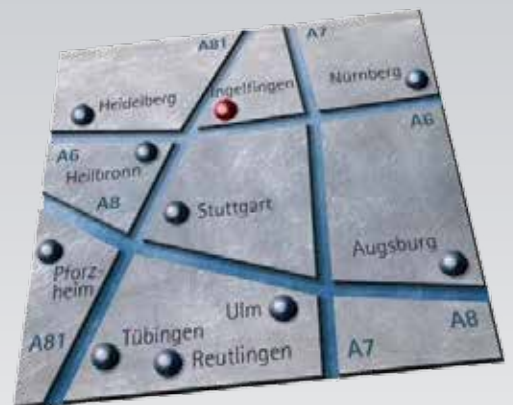


REISSER-Schraubentechnik GmbH is your partner in the field of fastening technology with a history of more than 90 years. For customers all over the world.

We develop and produce screws for industrial lightweight applications, for the roof + wall + solar segment as well as for plastic joining, wood applications and the different types of industries.

REISSER-Schraubentechnik is one of the leading stainless steel screw manufacturers in Europe. The REISSER profile is complemented by its own electroplating plant with first-class surface design.

We look forward to your visit.



REISSER-Schraubentechnik GmbH
Fritz-Müller-Str. 10 • D-74653 Ingelfingen-Criesbach
Fon: +49 7940/127-152 • Fax: +49 7940/127-123
produktion@reisser-screws.com • www.reisser-screws.com

