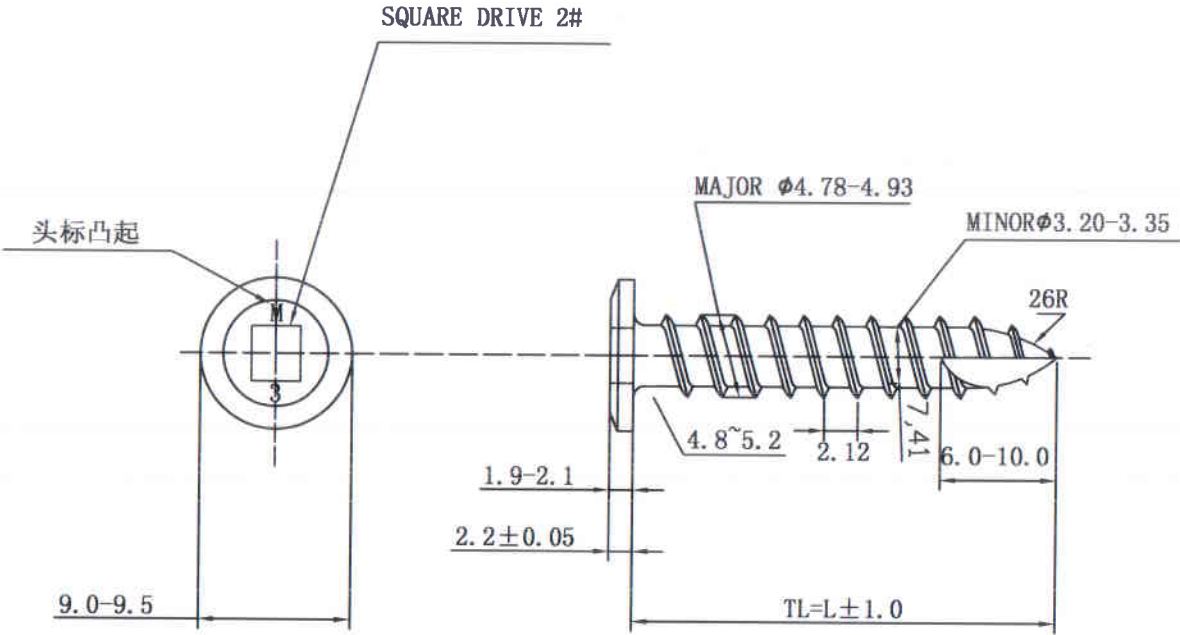


HANGZHOU HUAXING INDUSTRY CO., LTD

Size: T17 10-12×45&65WAFER HEAD
CL3 SQUARE DRIVE

DRAWING NO: M3-15



HEAT TREATMENT: CARBONITRIDE
(GAS CARBURISE)

MATERIAL	SAE1022
CORE HARDNESS	HV 270-425
CASE HARDNESS	HV 450Min
CASE DEPTH	0.10-0.30mm
TORSIONAL STRENGTH	5.4Nm
HEAD BEND ANGLE	12DegreeS Min
Approve	
Approve	
Approve	

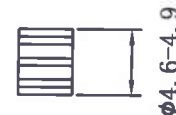
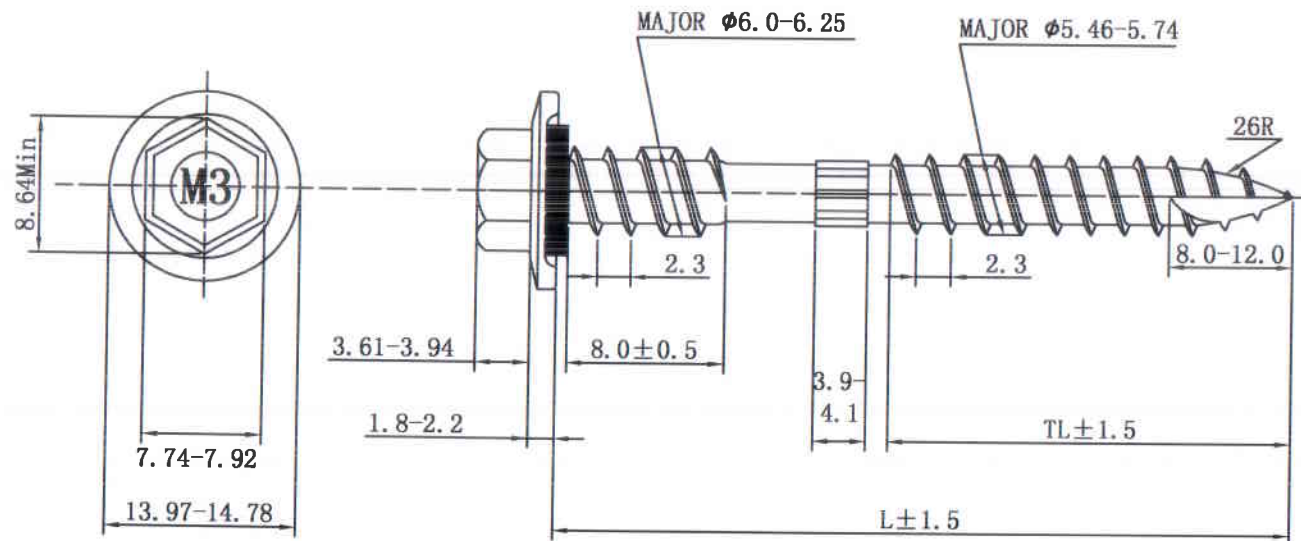
ISSUE	MODIFICATION	DATE	APPD	REF

L	TL
65	50
45	FULL

DRILL TEST REQUIREMENTS							
RPM	LOAD	Test Plate THICKNESS & Material	Test Plate No.	No. Of Tests	Average DrillTime (Max)	Maximum Individual Drill Time	Tests allowed above max. Individual
2200	18KG	0.55mm G300	N0.2	25Pcs	1.5sec	3.0sec	2.0Pcs

HANGZHOU HUAXING INDUSTR CO., LTD

Size: TG T17 12-11×50&65&75&90&115&125 M3 DRAWING NO:M3-09
HEX CL3+SL



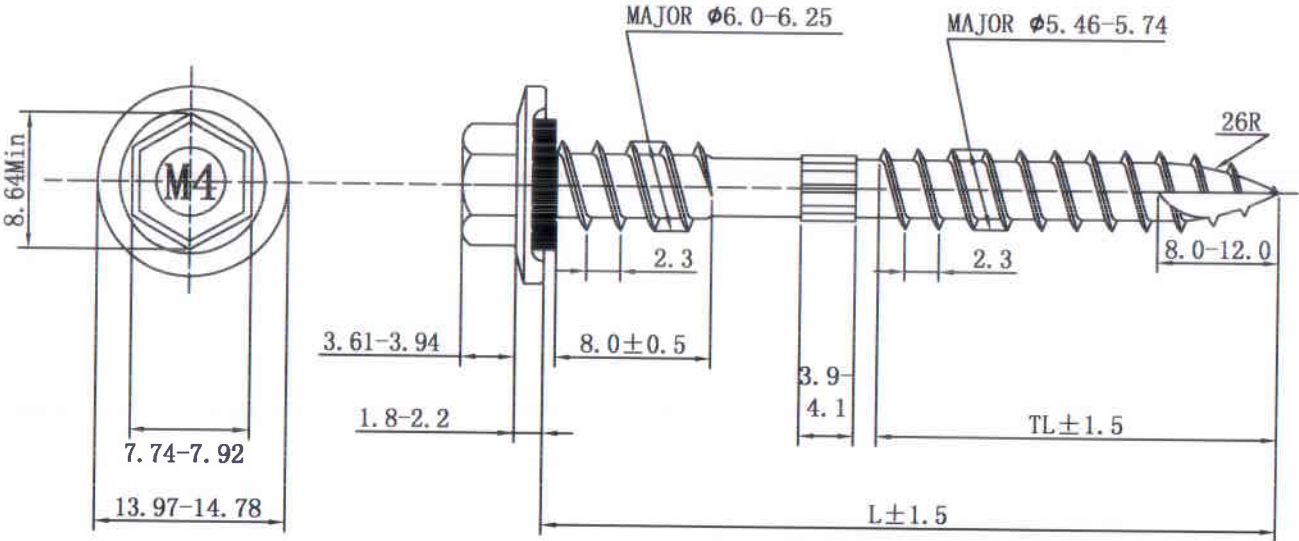
ISSUE	MODIFICATION	DATE	APPD	REF	L	TL
					125	50
					115	50
					90	50
					75	31
					65	31
					50	31

DRILL TEST REOUIREMNTS							
RPM	LOAD	Test Plate THICKNESS & Material	Test Plate No.	No. Of Tests	Average DrillTime (Max)	Maximum Individual Drill Time	Tests allowed above max. Individual
2200	18KG	0.55mm G300	NO. 2	25Pcs	1.5sec	2.0sec	2.0Pcs

HEAT TREATMENT: CARBONITRIDE (GAS CARBURISE)	
MATERIAL	SAE1022
CORE HARDNESS	HV 270-425
CASE HARDNESS	HV 450min
CASE DEPTH	0.10-0.30mm
TORSIONAL STRENGTH	9.4Nm
HEAD BEND ANGLE	12DegreeS Min
Approve	
Approve	
Approve	

HANGZHOU HUAXING INDUSTR CO., LTD

Size: TG T17 12-11×65&75&90&115&125 M4 DRAWING NO:M4-03
HEX CL4+SL



ISSUE	MODIFICATION	DATE	APPD	REF

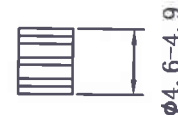
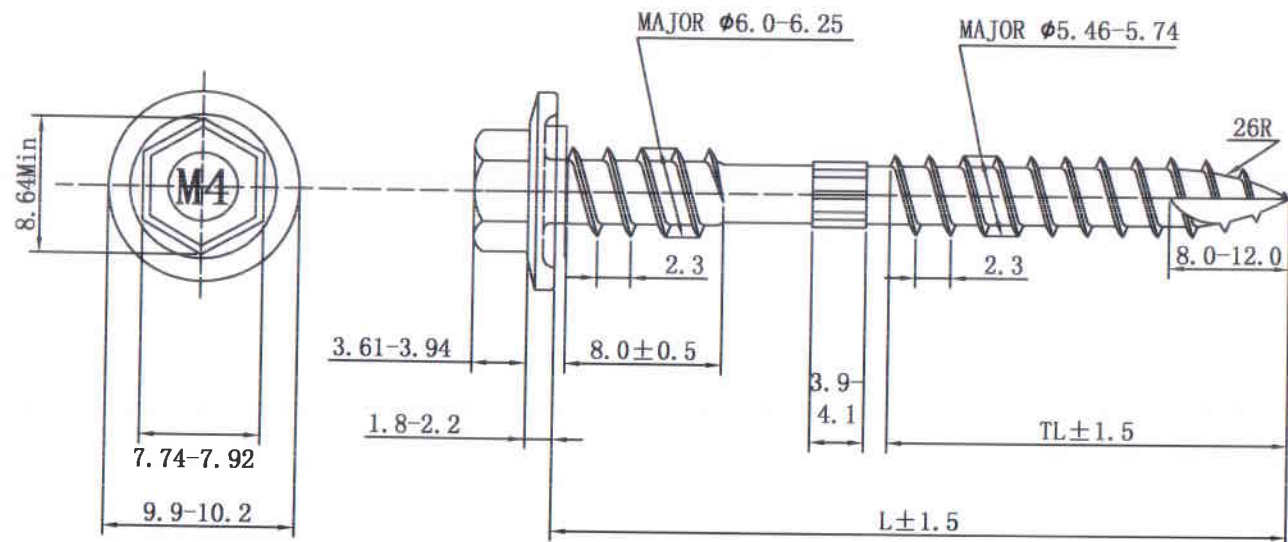
L	TL
125	50
115	50
90	50
75	31
65	31

DRILL TEST REQUIREMNTS							
RPM	LOAD	Test Plate THICKNESS & Material	Test Plate No.	No. Of Tests	Average DrillTime (Max)	Maximum Individual Drill Time	Tests allowed above max. Individual
2200	18KG	0.55mm G300	NO. 2	25Pcs	1.5sec	2.0sec	2.0Pcs

HEAT TREATMENT:CARBONITRIDE (GAS CARBURISE)	
MATERIAL	SAE1022
CORE HARDNESS	HV 270-425
CASE HARDNESS	HV 450min
CASE DEPTH	0.10-0.30mm
TORSIONAL STRENGTH	9.4Nm
HEAD BEND ANGLE	12DegreeS Min
Approve	
Approve	
Approve	

HANGZHOU HUAXING INDUSTR CO., LTD

Size: TG T17 12-11×50&65&90 M4 DRAWING NO:M4-35
HEX CL4



ISSUE	MODIFICATION	DATE	APPD	REF

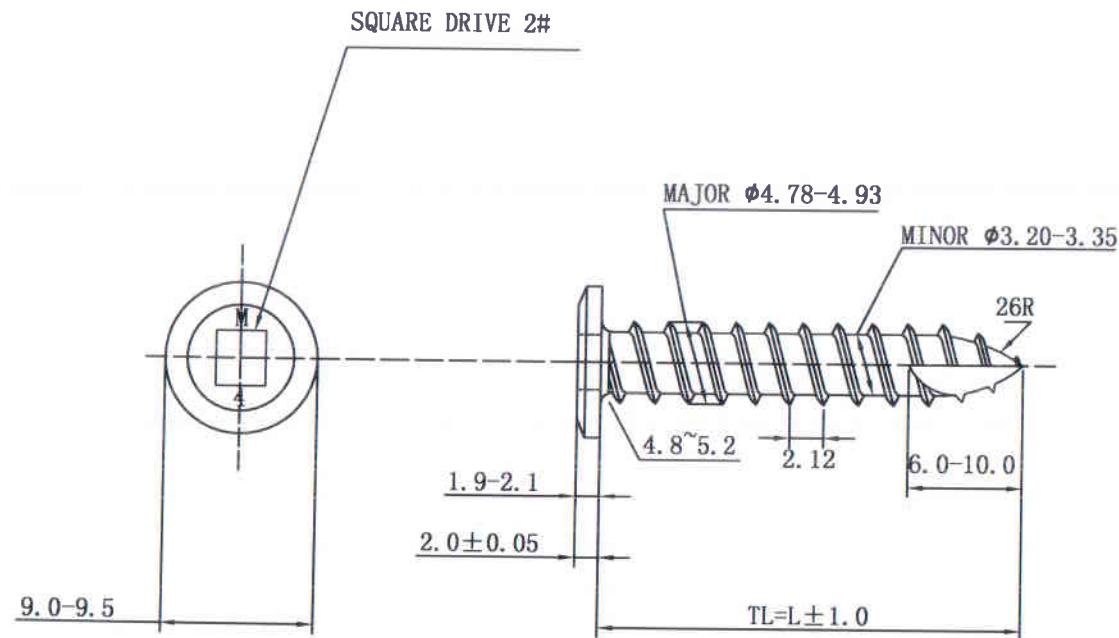
L	TL
90	50
65	31
50	31

DRILL TEST REQUIREMENTS							
RPM	LOAD	Test Plate THICKNESS & Material	Test Plate No.	No. Of Tests	Average DrillTime (Max)	Maximum Individual Drill Time	Tests allowed above max. Individual
2200	18KG	0.55mm G300	NO. 2	25Pcs	1.5sec	2.0sec	2.0Pcs

HEAT TREATMENT: CARBONITRIDE (GAS CARBURISE)	
MATERIAL	SAE1022
CORE HARDNESS	HV 270-425
CASE HARDNESS	HV 450min
CASE DEPTH	0.10-0.30mm
TORSIONAL STRENGTH	9.4Nm
HEAD BEND ANGLE	12DegreeS Min
Approve	
Approve	
Approve	

HANGZHOU HUAXING INDUSTRY CO., LTD

Size: T17 10-12×45WAFER HEAD DRAWING NO: M4-19
CL4 SQUARE DRIVE



ISSUE	MODIFICATION	DATE	APPD	REF

L	TL
45	FULL

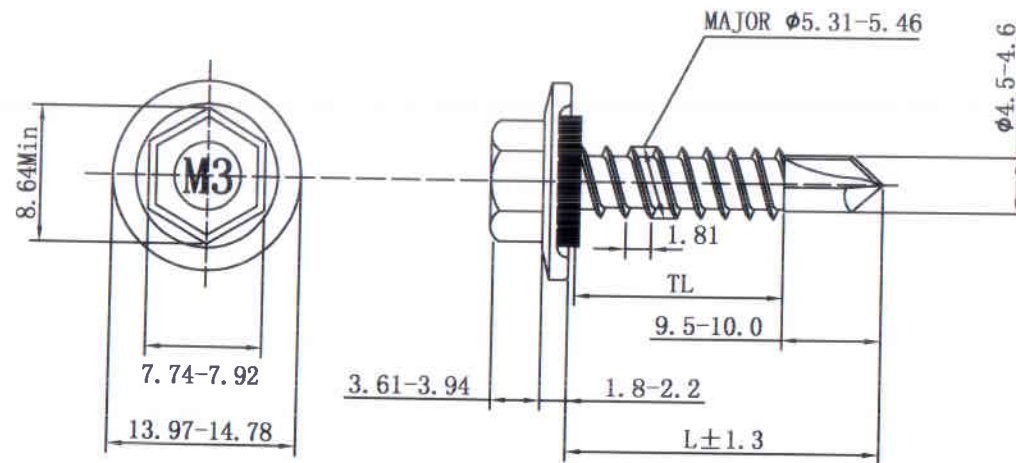
DRILL TEST REQUIREMENTS							
RPM	LOAD	Test Plate THICKNESS & Material	Test Plate No.	No. Of Tests	Average DrillTime (Max)	Maximum Individual Drill Time	Tests allowed above max. Individual
2200	18KG	0.55mm G300	NO. 2	25Pcs	1.5sec	3.0sec	2.0Pcs

HEAT TREATMENT: CARBONITRIDE (GAS CARBURISE)	
MATERIAL	SAE1022
CORE HARDNESS	HV 270-425
CASE HARDNESS	HV 450Min
CASE DEPTH	0.10-0.30mm
TORSIONAL STRENGTH	5.4Nm
HEAD BEND ANGLE	12DegreeS Min
Approve	
Approve	
Approve	

HANGZHOU HUAXING INDUSTRY CO., LTD

Size: SDS 12-14×25 M3
HEX CL3+SL

DRAWING NO: M3-24



ISSUE	MODIFICATION	DATE	APPD	REF

L	TL
25	FULL

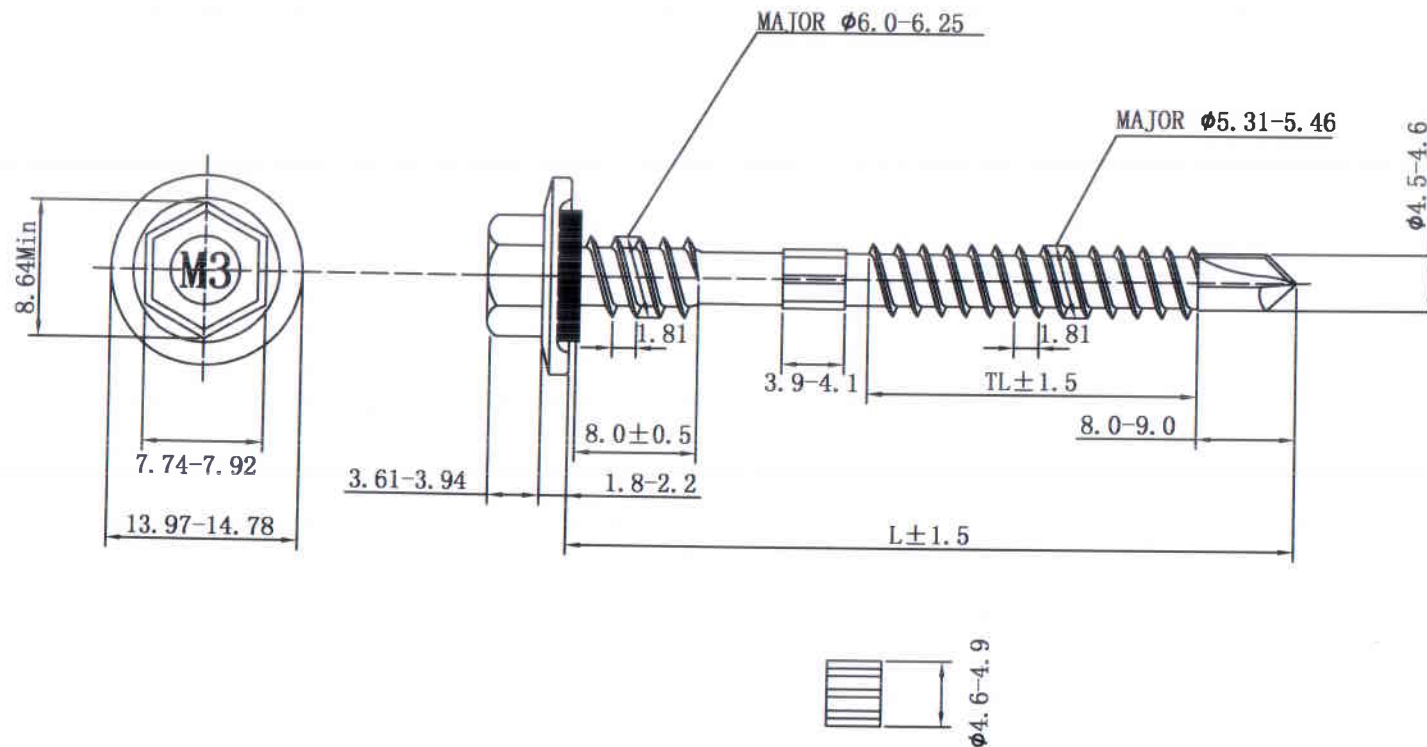
DRILL TEST REOUIREMNTS							
RPM	LOAD	Test Plate THICKNESS & Material	Test Plate No.	No. Of Tests	Average DrillTime (Max)	Maximum Individual Drill Time	Tests allowed above max. Individual
2200	24KG	2.4mm G450	NO. 1	25Pcs	3.0sec	4.0sec	2.0Pcs

HEAT TREATMENT: CARBONITRIDE (GAS CARBURISE)	
MATERIAL	SAE1022
CORE HARDNESS	HV 270-425
CASE HARDNESS	HV ≥560
CASE DEPTH	0.10-0.30mm
TORSIONAL STRENGTH	10.9Nm
HEAD BEND ANGLE	12DegreeS Min
Approve	
Approve	
Approve	

HANGZHOU HUAXING INDUSTRY CO., LTD

Size: SDS TG 12-14×50&65&90&115&125 M3
HEX CL3+SL

DRAWING NO: M3-11



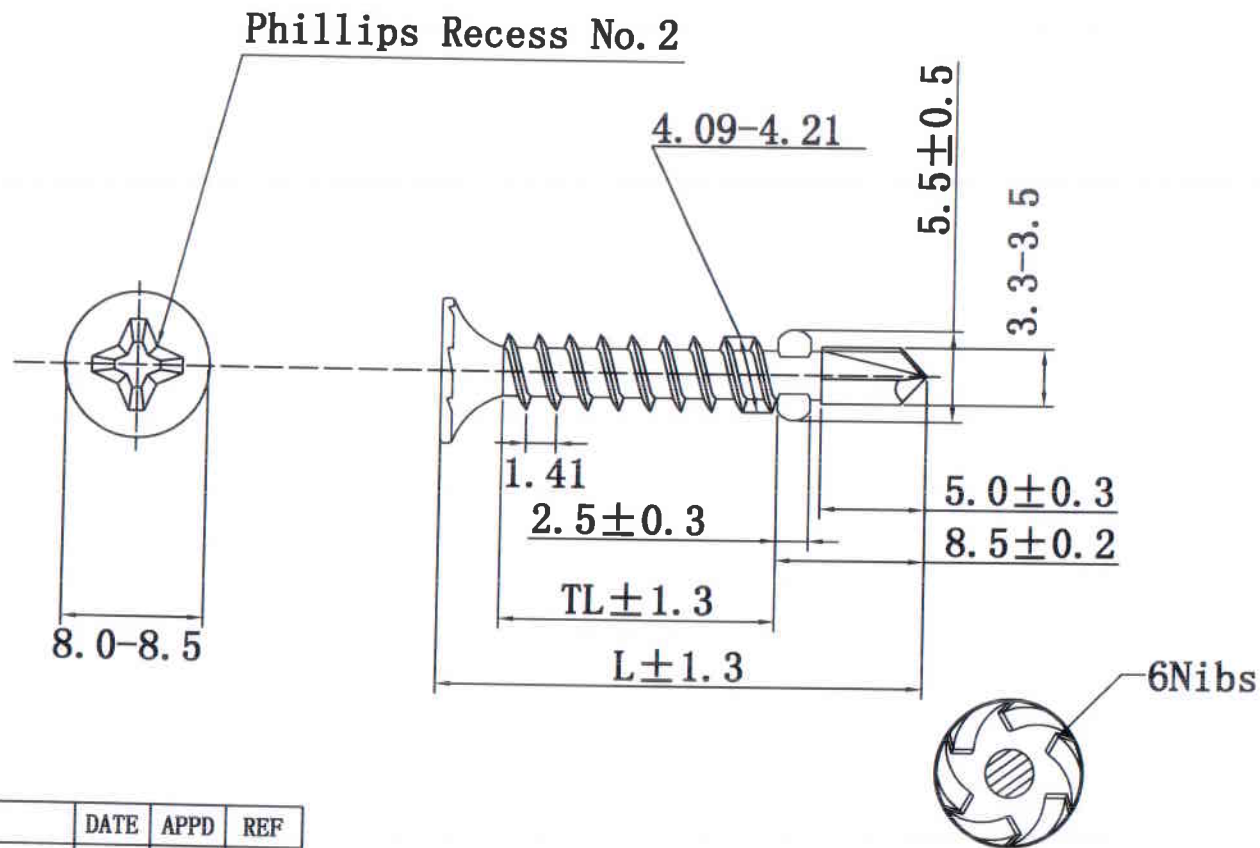
ISSUE	MODIFICATION	DATE	APPD	REF	L	TL
					100	50
					75	33
					65	27
					50	23

DRILL TEST REQUIREMENTS							
RPM	LOAD	Test Plate THICKNESS & Material	Test Plate No.	No. Of Tests	Average DrillTime (Max)	Maximum Individual Drill Time	Tests allowed above max.
2200	24KG	2.4mm G450	NO. 1	25Pcs	3.0sec	4.0sec	2.0Pcs

HEAT TREATMENT: CARBONITRIDE (GAS CARBURISE)	
MATERIAL	SAE1022
CORE HARDNESS	HV 270-425
CASE HARDNESS	HV ≥560
CASE DEPTH	0.10-0.30mm
TORSIONAL STRENGTH	10.9Nm
HEAD BEND ANGLE	12DegreeS Min
Approve	
Approve	
Approve	

HANGZHOU HUAXING INDUSTRY CO., LTD

Size: SDS 8-18×32&45 wing PH #2 DRAWING NO: M3-32
bugle head with nibs under head CL3



ISSUE	MODIFICATION	DATE	APPD	REF

L	TL
45	FULL
32	FULL

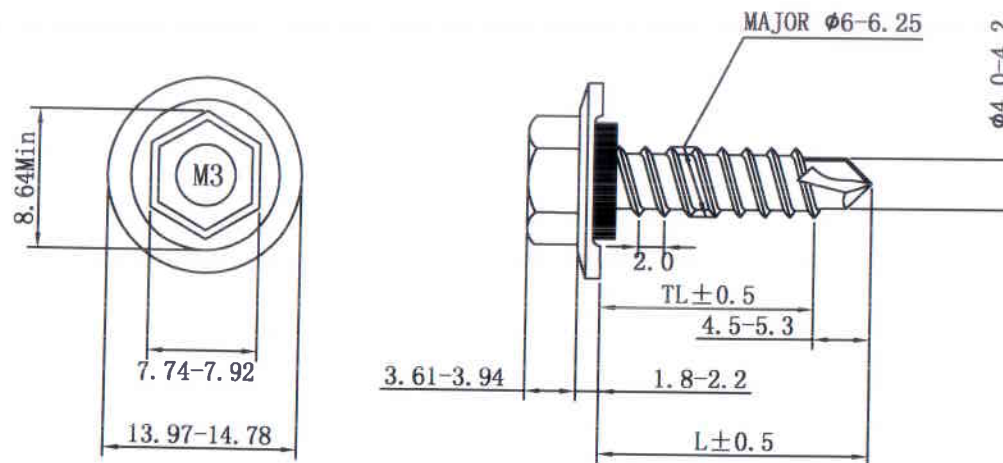
DRILL TEST REQUIREMENTS							
RPM	LOAD	Test Plate THICKNESS & Material	Test Plate No.	No. Of Tests	Average Drill Time (Max)	Maximum Individual Drill Time	Tests allowed above max. Individual
2200	18KG	1.5mm G450	NO. 1	25Pcs	3.0sec	4.5sec	2.0Pcs

HEAT TREATMENT: CARBONITRIDE (GAS CARBURISE)	
MATERIAL	SAE1022
CORE HARDNESS	HV 270-425
CASE HARDNESS	HV ≥ 560
CASE DEPTH	0.10-0.30mm
TORSIONAL STRENGTH	4.4Nm
HEAD BEND ANGLE	12DegreeS Min
Approve	
Approve	
Approve	

HANGZHOU HUAXING INDUSTRY CO., LTD

Size: SDS 14×22
Stitching Screw CL3+SL

DRAWING NO: M3-35



ISSUE	MODIFICATION	DATE	APPD	REF

L	TL
22	FULL

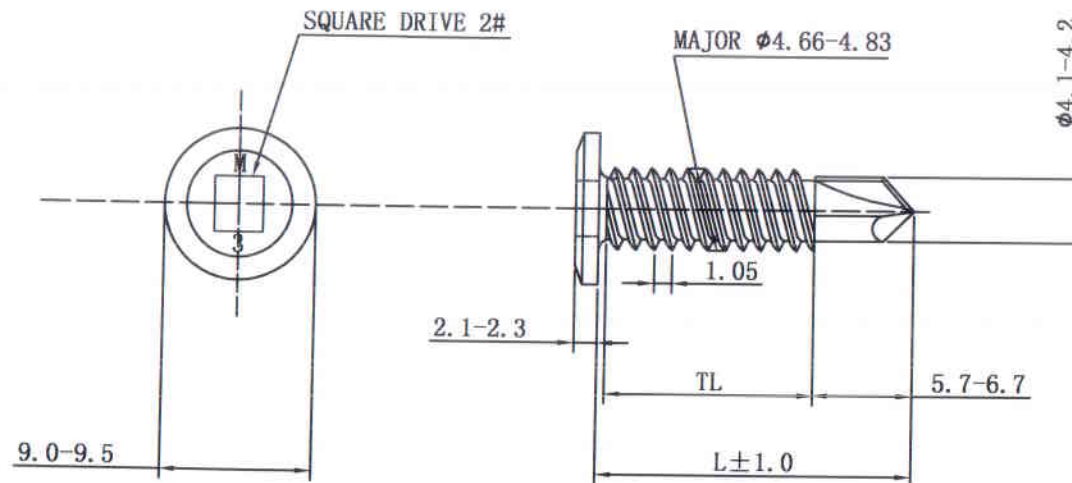
DRILL TEST REQUIREMENTS							
RPM	LOAD	Test Plate THICKNESS & Material	Test Plate No.	No. Of Tests	Average Drill Time (Max)	Maximum Individual Drill Time	Tests allowed above max. Individual
2200	24KG	2.4mm G450	NO. 1	25Pcs	3.0sec	4.0sec	2.0Pcs

HEAT TREATMENT: CARBONITRIDE (GAS CARBURISE)	
MATERIAL	SAE1022
CORE HARDNESS	HV 270-425
CASE HARDNESS	HV ≥ 560
CASE DEPTH	0.10-0.30mm
TORSIONAL STRENGTH	14.0Nm
HEAD BEND ANGLE	12DegreeS Min
Approve	
Approve	
Approve	

HANGZHOU HUAXING INDUSTRY CO., LTD

Size: SDS 10-24×16&22
WAFER SQUARE DRIVE CL3

DRAWING NO: M3-20



ISSUE	MODIFICATION	DATE	APPD	REF

L	TL
22	FULL
16	FULL

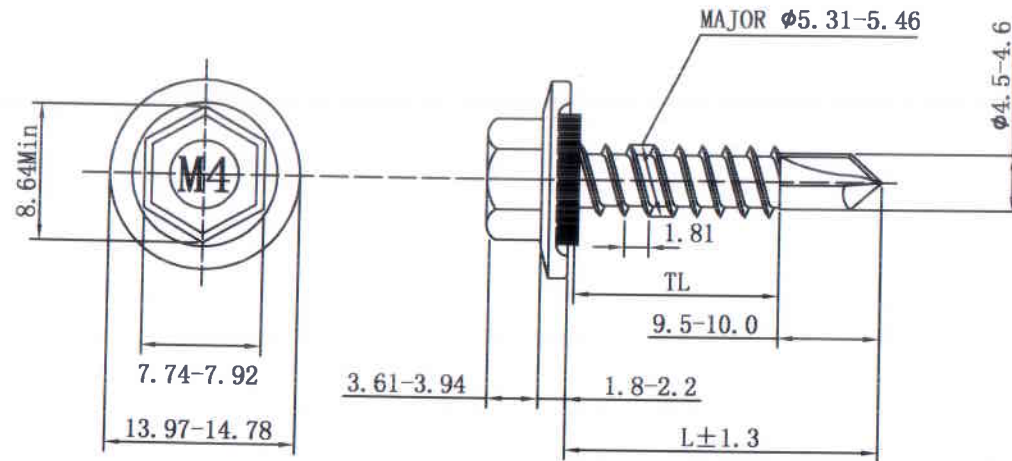
DRILL TEST REQUIREMENTS							
RPM	LOAD	Test Plate THICKNESS & Material	Test Plate No.	No. Of Tests	Average DrillTime (Max)	Maximum Individual Drill Time	Tests allowed above max. Individual
2200	24KG	2.4mm G450	NO. 1	25Pcs	3.5sec	4.5sec	2.0Pcs

HEAT TREATMENT: CARBONITRIDE (GAS CARBURISE)	
MATERIAL	SAE1022
CORE HARDNESS	HV 270-425
CASE HARDNESS	HV ≥ 560
CASE DEPTH	0.10-0.30mm
TORSIONAL STRENGTH	6.9Nm
HEAD BEND ANGLE	12DegreeS Min
Approve	
Approve	
Approve	

HANGZHOU HUAXING INDUSTRY CO., LTD

Size: SDS 12-14×25 M4
HEX CL4+SL

DRAWING NO: M4-05



ISSUE	MODIFICATION	DATE	APPD	REF

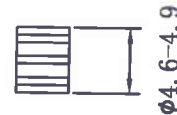
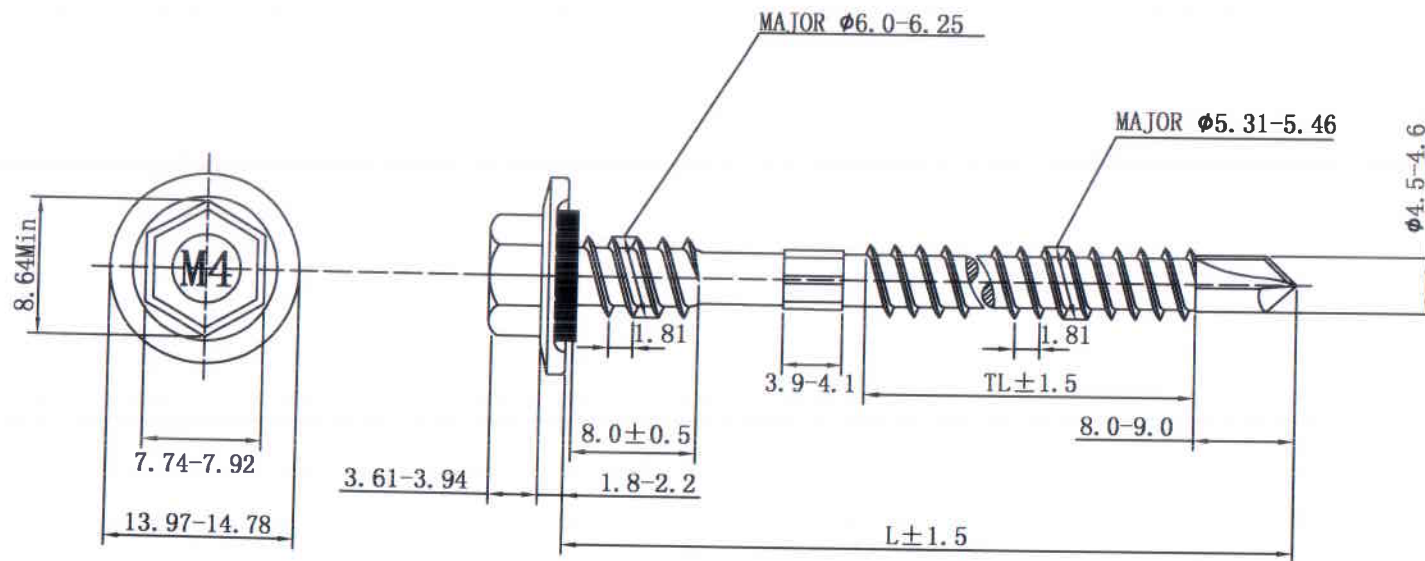
L	TL
25	FULL

DRILL TEST REOUIREMNTS							
RPM	LOAD	Test Plate THICKNESS & Material	Test Plate No.	No. Of Tests	Average DrillTime (Max)	Maximum Individual Drill Time	Tests allowed above max. Individual
2200	24KG	2.4mm G450	NO. 1	25Pcs	3.0sec	4.0sec	2.0Pcs

HEAT TREATMENT: CARBONITRIDE (GAS CARBURISE)	
MATERIAL	SAE1022
CORE HARDNESS	HV 270-425
CASE HARDNESS	HV ≥560
CASE DEPTH	0.10-0.30mm
TORSIONAL STRENGTH	10.9Nm
HEAD BEND ANGLE	12DegreeS Min
Approve	
Approve	
Approve	

HANGZHOU HUAXING INDUSTRY CO., LTD

Size: SDS TG 12-14×50&65&90&115&125 M4 DRAWING NO: M4-06
HEX CL4+SL



ISSUE	MODIFICATION	DATE	APPD	REF

L	TL
125	50
115	50
90	50
65	27
50	24

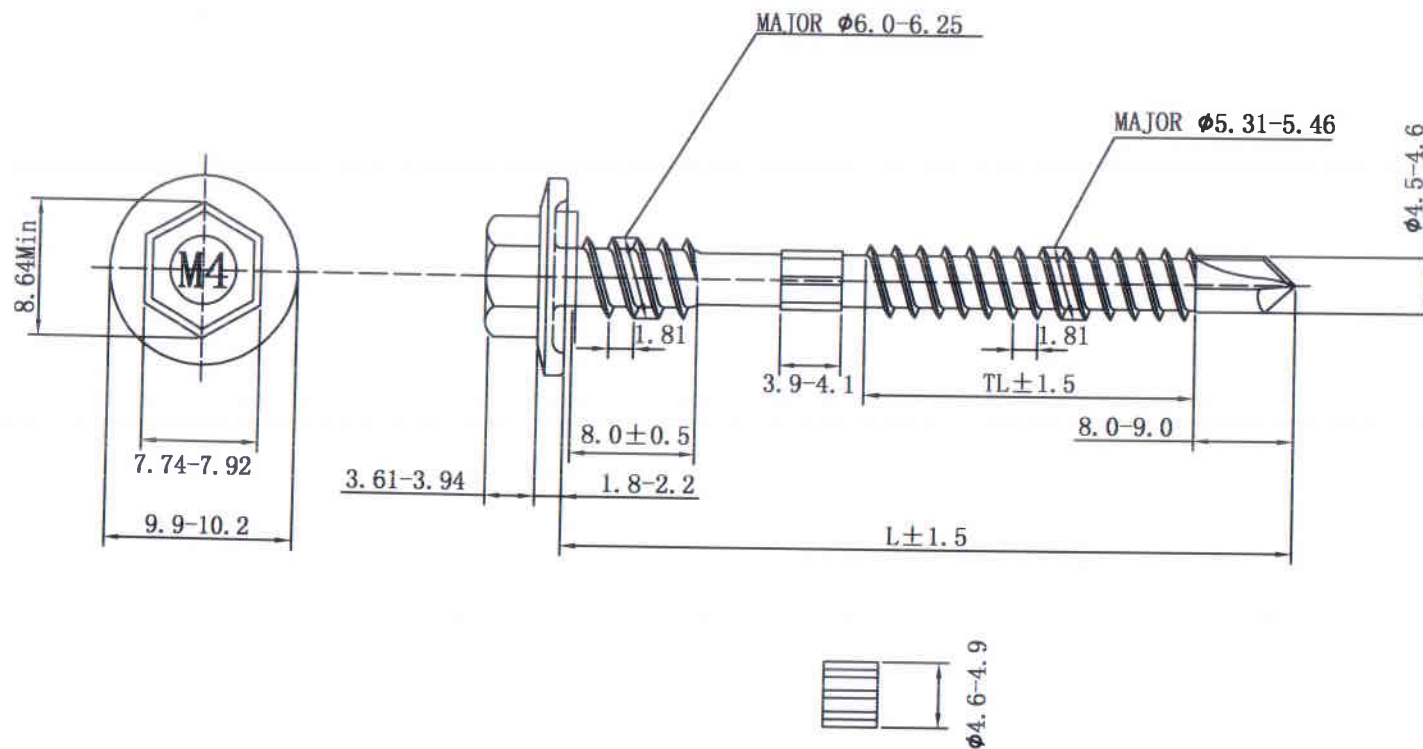
DRILL TEST REOUIREMNTS							
RPM	LOAD	Test Plate THICKNESS & Material	Test Plate No.	No. Of Tests	Average DrillTime (Max)	Maximum Individual Drill Time	Tests allowed above max. Individual
2200	24KG	2.4mm G450	NO. 1	25Pcs	3.0sec	4.0sec	2.0Pcs

HEAT TREATMENT: CARBONITRIDE (GAS CARBURISE)	
MATERIAL	SAE1022
CORE HARDNESS	HV 270-425
CASE HARDNESS	HV ≥560
CASE DEPTH	0.10-0.30mm
TORSIONAL STRENGTH	10.9Nm
HEAD BEND ANGLE	12DegreeS Min
Approve	
Approve	
Approve	

HANGZHOU HUAXING INDUSTRY CO., LTD

Size: SDS TG 12-14×65&90 M4
HEX CL4

DRAWING NO: M4-34



ISSUE	MODIFICATION	DATE	APPD	REF

L	TL
90	50
65	27

DRILL TEST REQUIREMENTS							
RPM	LOAD	Test Plate THICKNESS & Material	Test Plate No.	No. Of Tests	Average DrillTime (Max)	Maximum Individual Drill Time	Tests allowed above max. Individual
2200	24KG	2.4mm G450	NO. 1	25Pcs	3.0sec	4.0sec	2.0Pcs

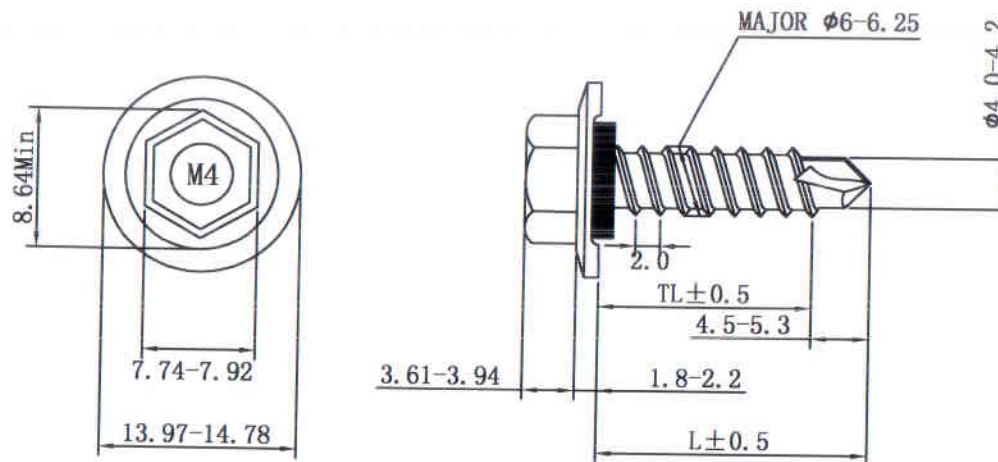
HEAT TREATMENT: CARBONITRIDE (GAS CARBURISE)	
MATERIAL	SAE1022
CORE HARDNESS	HV 270-425
CASE HARDNESS	HV ≥ 560
CASE DEPTH	0.10-0.30mm
TORSIONAL STRENGTH	10.9Nm
HEAD BEND ANGLE	12DegreeS Min
Approve	
Approve	
Approve	

HANGZHOU HUAXING INDUSTRY CO., LTD

Size: SDS 14×22

DRAWING NO: M4-31

Stitching Screw CL4+SL



ISSUE	MODIFICATION	DATE	APPD	REF

L	TL
22	FULL

DRILL TEST REOUIREMNTS							
RPM	LOAD	Test Plate THICKNESS & Material	Test Plate No.	No.Of Tests	Average DrillTime (Max)	Maximum Individual Drill Time	Tests allowed above max. Individual
2200	24KG	2.4mm G450	NO.1	25Pcs	3.0sec	4.0sec	2.0Pcs

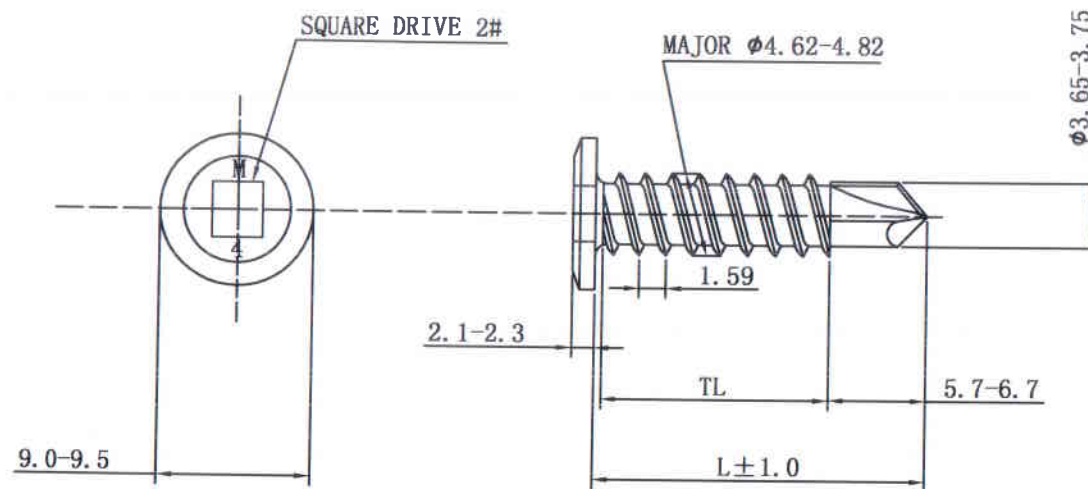
HEAT TREATMENT:CARBONITRIDE (GAS CARBURISE)	
MATERIAL	SAE1022
CORE HARDNESS	HV 270-425
CASE HARDNESS	HV ≥ 560
CASE DEPTH	0.10-0.30mm
TORSIONAL STRENGTH	14.0Nm
HEAD BEND ANGLE	12DegreeS Min
Approve	
Approve	
Approve	

HANGZHOU HUAXING INDUSTRY CO., LTD

Size: SDS 10-16×22

DRAWING NO: M4-20

WAFER SQUARE DRIVE CL4



HEAT TREATMENT: CARBONITRIDE
(GAS CARBURISE)

MATERIAL	SAE1022
CORE HARDNESS	HV 270-425
CASE HARDNESS	HV ≥560
CASE DEPTH	0.10-0.30mm
TORSIONAL STRENGTH	6.9Nm
HEAD BEND ANGLE	12DegreeS Min
Approve	
Approve	
Approve	

ISSUE	MODIFICATION	DATE	APPD	REF

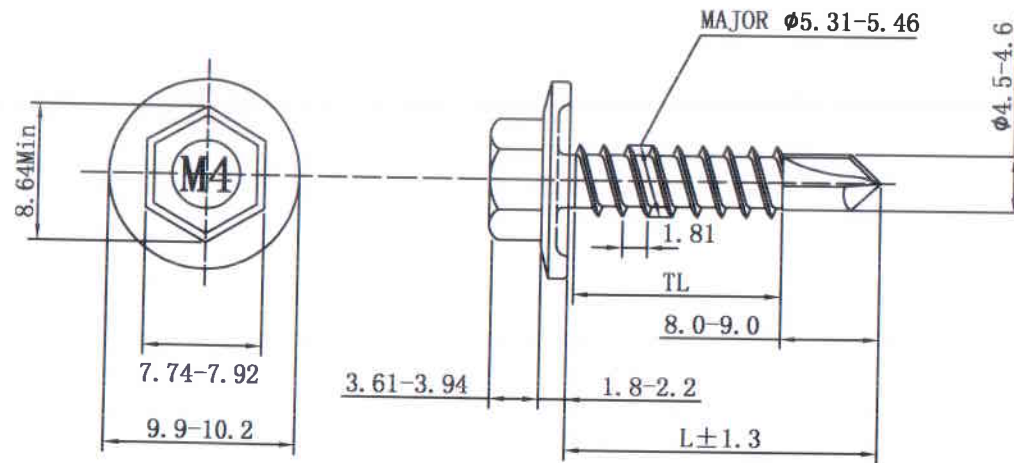
L	TL
22	FULL

DRILL TEST REOUIREMNTS

RPM	LOAD	Test Plate THICKNESS & Material	Test Plate No.	No. Of Tests	Average DrillTime (Max)	Maximum Individual Drill Time	Tests allowed above max. Individual
2200	24KG	2.4mm G450	NO.1	25Pcs	3.5sec	4.5sec	2.0Pcs

HANGZHOU HUAXING INDUSTRY CO., LTD

Size: SDS 12-14×20&25&50 M4 DRAWING NO: M4-27
HEX CL4



ISSUE	MODIFICATION	DATE	APPD	REF

L	TL
50	FULL
25	FULL
20	FULL

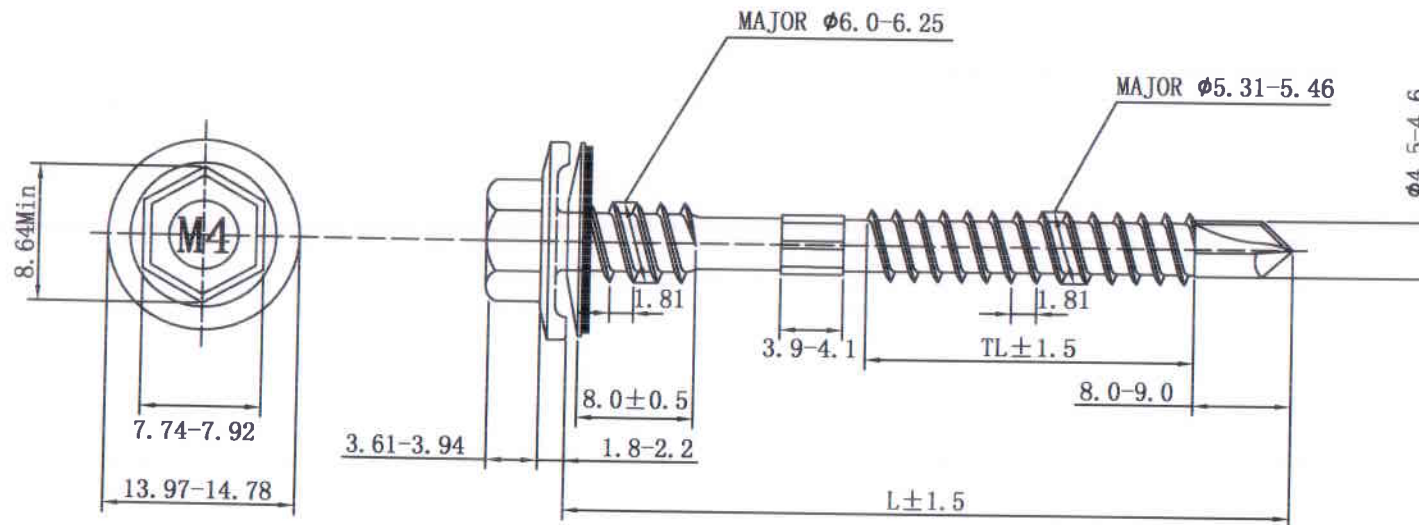
DRILL TEST REQUIREMENTS								
RPM	LOAD	Test Plate THICKNESS & Material	Test Plate No.	No. Of Tests	Average DrillTime (Max)	Maximum Individual Drill Time	Tests allowed above max. Individual	
2200	24KG	2.4mm G450	NO. 1	25Pcs	3.0sec	4.0sec	2.0Pcs	

HEAT TREATMENT: CARBONITRIDE (GAS CARBURISE)	
MATERIAL	SAE1022
CORE HARDNESS	HV 270-425
CASE HARDNESS	HV ≥ 560
CASE DEPTH	0.10-0.30mm
TORSIONAL STRENGTH	10.9Nm
HEAD BEND ANGLE	12DegreeS Min
Approve	
Approve	
Approve	

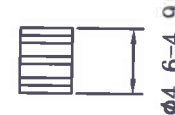
HANGZHOU HUAXING INDUSTRY CO., LTD

Size: SDS TG 12-14×65&90M4 HEX CL4
ASSEMBLED WITH 12mm ALUM BOND WASH

DRAWING NO: M4-43



Alum thickness: 0.8 ± 0.1
Alum OD: 12.0 ± 0.2
Alum ID: 6.5 ± 0.2
Rubber thickness: 2.0 ± 0.2
Rubber ID: $4.9 \pm$



ISSUE	MODIFICATION	DATE	APPD	REF

L	TL
90	50
65	27

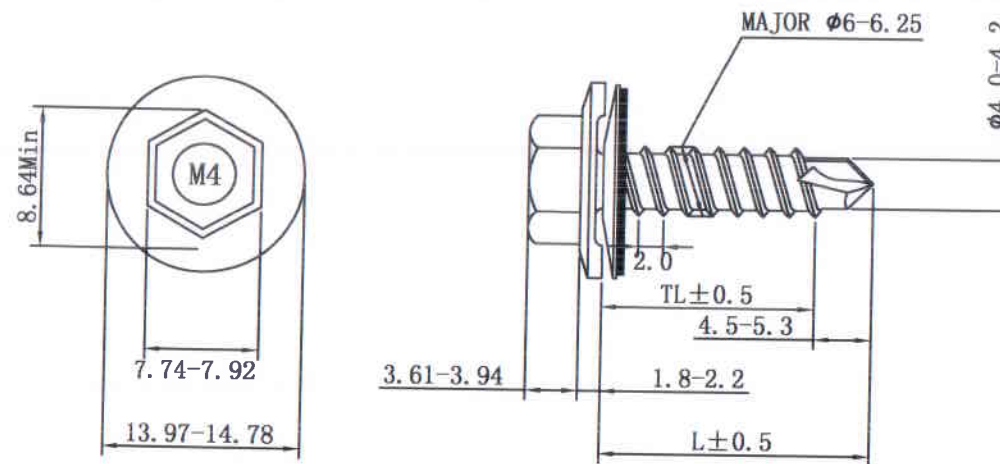
DRILL TEST REQUIREMENTS							
RPM	LOAD	Test Plate THICKNESS & Material	Test Plate No.	No. Of Tests	Average Drill Time (Max)	Maximum Individual Drill Time	Tests allowed above max. Individual
2200	24KG	2.4mm G450	NO. 1	25Pcs	3.0sec	4.0sec	2.0Pcs

HEAT TREATMENT: CARBONITRIDE (GAS CARBURISE)	
MATERIAL	SAE1022
CORE HARDNESS	HV 270-425
CASE HARDNESS	HV ≥560
CASE DEPTH	0.10-0.30mm
TORSIONAL STRENGTH	10.9Nm
HEAD BEND ANGLE	12DegreeS Min
Approve	
Approve	
Approve	

HANGZHOU HUAXING INDUSTRY CO., LTD

Size: SDS 14×22 Stitching Screw CL4
ASSEMBLED WITH 12mm ALUM BOND WASH

DRAWING NO: M4-42



Alum thickness: 0.8 ± 0.1

Alum OD: 12.0 ± 0.2

Alum ID: 6.5 ± 0.2

Rubber thickness: 2.0 ± 0.2

Rubber ID: $4.9 \pm$



ISSUE	MODIFICATION	DATE	APPD	REF

L	TL
22	FULL

DRILL TEST REQUIREMENTS							
RPM	LOAD	Test Plate THICKNESS & Material	Test Plate No.	No. Of Tests	Average DrillTime (Max)	Maximum Individual Drill Time	Tests allowed above max. Individual
2200	24KG	1.5mm G450	NO.1	25Pcs	3.0sec	4.0sec	2.0Pcs

HEAT TREATMENT: CARBONITRIDE (GAS CARBURISE)	
MATERIAL	SAE1022
CORE HARDNESS	HV 270-425
CASE HARDNESS	HV ≥ 560
CASE DEPTH	0.10-0.30mm
TORSIONAL STRENGTH	14.0Nm
HEAD BEND ANGLE	12DegreeS Min
Approve	
Approve	
Approve	