

Installing EJOT Self-Drilling fasteners.

EJOT Self-drilling fasteners should be installed using the correct EJOT power screwdriver. The screwdriver should be equipped with the correct driving attachments and adjustable nose piece.

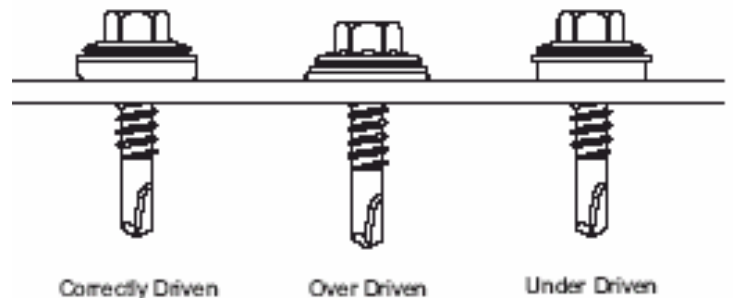


The screwdriver should be positioned perpendicular to the material being fixed. An applied force equal to the end load figures given in the table "Recommended drill speeds and end loads" should be maintained during the drilling and tapping operation. The screwdriver should be set

to automatically disengage its clutch when the depth sensing nose piece makes contact with the surface of the material being fixed.

We would recommend that initial trial drives are carried out on a spare piece of material before commencing work, the purpose of the trial drives is to ensure that the screwdriver's clutch disengages before damage is done to the fastener or materials whilst ensuring correct mechanical joint is achieved.

Fasteners with bonded washers should achieve 25% compression to ensure weather seal.



Note washers, which are under driven, may not provide the desired weather seal. EJOT recommend That all fasteners are vacuum tested after installation To ensure they have been correctly installed.

Recommended Drill Speeds and end loads

Product:
JT2 Carbon Steel Self Drilling Fasteners

Product Code	Ø mm	x	L mm	Drilling Speeds			End Load Kg
				1300 RPM	1500 RPM	1800 RPM	
SF	4.8	x	All				17
SF	6.3	x	All				25
SF	8.0	x	All				25
RLS	-	x	All	Install by hand only			
LS	5.5	x	All				25
LSHT	5.5/6.3	x	All				25
JT2 - 3 -	4.8	x	All				17
JT2 - 3 -	5.5	x	All				25
JT2 - 6 -	5.5	x	All				27
JT2 - 6 -	6.3	x	All				27
JT2 - D6 -	5.5/6.3	x	All				27
HS	5.5	x	All				35
HSHT	5.5/6.3	x	All				35
JT2 - 12 -	6.3	x	All				35

Product:
JT3 Stainless Steel Bi-Metal Self Drilling Fasteners

Product Code	Ø mm	x	L mm	Drilling Speeds			End Load Kg
				1300 RPM	1500 RPM	1800 RPM	
JT3 - 2 -	4.8	x	All				17
JT3 - 2 -	4.9	x	All				17
JT3 - 2 -	5.6	x	All				25
JT3 - 2 -	6.0	x	All				25
JT3 - X2 -	6.0	x	All				25
JT3 - 2 -	6.3	x	All				25
JT3 - 2 -	6.5	x	All				25
JT3 - 3 -	5.5	x	All				25
JT3 - 3 -	6.3	x	All				25
JT3 - D3 -	5.5/6.3	x	All				25
JT3 - 6 -	5.5	x	All				27
JT3 - 6 -	6.3	x	All				27
JT3 - D6 -	5.5/6.3	x	All				27
JT3 - 12 -	5.5	x	All				35
JT3 - 12 -	6.3	x	All				35
JT3 - D12 -	5.5/6.3	x	All				35