

Testing of Screw Withdrawal :

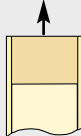
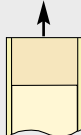
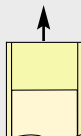
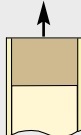
- measurements of screws and bores in mm
- screw withdrawal given in kN
- results given are the average of at least 10 tests

Preparation of the tests :

- skin : 3 mm particle board
- 4mm of frame material trimmed off
- boring according to the table

Screws:

- all measurements with particle board screws SPAX
- thread reach according to the table

	Spax-Screws Size Bore Thread reach	4,5 x 25 2,5 x 15 15	4,5 x 40 2,5 x 30 30
Extruded Solid board with additional glue HVA 650 kg/m ³ HVB 700 kg/m ³		0,81 kN 1,12 kN	2,18 kN 2,73 kN
Extruded Solid board VV 600 kg/m ³ VA 650 kg/m ³ VB 700 kg/m ³		0,56 kN 0,65 kN 0,84 kN	1,73 kN 2,15 kN 2,36 kN
Mat-produced Particle board 650 kg/m ³		0,61 kN	1,46 kN
Spruce 400 kg/m ³ 430 kg/m ³		0,68 kN 0,81 kN	2,15 kN 2,55 kN