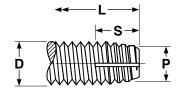
## **Thread Cutting**

## Self- Tapping Screws

FASTENERS & COMPONENTS





		THRE	EADS A	ND PC	DINTS FO	R TY	pe <b>1</b>	THR	EAD (		ig <b>S</b> cr	REWS	0	ASME B18.6.4-1998	
		Threads Per Inch	D Major Diameter		P Point Diameter		S	;							
Nominal Size or Basic Screw Diameter						Point Tape Short Screws		er Length Long Screws		Determinant Length for Point Taper		Minimum Practical Nominal Screw Lengths		Minimum Torsional Strength, Ibin.	
			Max	Min	Ref	Max	Min	Мах	Min	90° Heads	Csk Heads	90° Heads	Csk Heads	10111.	
2	.0860	56	.0860	.0813	.068	.062	.045	.080	.062	5/32	3/16	5/32	3/16	5	
4	.1120	40	.1120	.1061	.087	.088	.062	.112	.088	7/32	1/4	3/16	1/4	13	
6	.1380	32	.1380	.1312	.107	.109	.078	.141	.109	1/4	5/16	1/4	5/16	23	
8	.1640	32	.1640	.1571	.132	.109	.078	.141	.109	1/4	11/32	1/4	5/16	42	
10	.1900	24	.1900	.1818	.148	.146	.104	.188	.146	11/32	7/16	5/16	13/32	56	
10	.1900	32	.1900	.1831	.158	.109	.078	.141	.109	1/4	11/32	1/4	5/16	74	
12	.2160	24	.2160	.2078	.174	.146	.104	.188	.146	11/32	7/16	5/16	13/32	93	
1/4	.2500	20	.2500	.2408	.200	.175	.125	.225	.175	13/32	17/32	3/8	1/2	140	
5/16	.3125	18	.3125	.3026	.257	.194	.139	.250	.194	15/32	19/32	7/16	9/16	306	
3/8	.3750	16	.3750	.3643	.312	.219	.156	.281	.219	1/2	11/16	15/32	5/8	560	
1/2	.5000	13	.5000	.4876	.423	.269	.192	.346	.269	5/8	25/32	19/32	3/4	1075	
Tolerance on Length			Up to 3/4 in., Incl.: -0.03				Over 3/4 to 1-1/2 i				in., Incl.: -0.05		Over 1-1/2 in.: -0.0		
				0											
C	Descript	ion	FD	A thread	cutting screw	with mach	nine screw	thread p	oitch, blun	it point, tape	ered enterin	g threads and a	a single cutting e	dge.	
			EN	TS!	Steel							Stainless			
Applications/ Advantages			May be used in steel sheets, structural shapes, special alloy steels, cast iron, brass or plastics.					lir	Stainless screws offer greater corrosion resistance than steel screws but have a mo limited range of applications due to being a softer metal. When using any thread- cutting screw, the material in which the threads are cut should have a lower hardness by 10-20 Rockwell hardness points.						
Material			AISI 1016 - 1024 or equivalent steel.						18-8 stainless steel.						
Heat Treatment			Screws shall be quenched in liquid and then tempered by reheating to 650°F minimum.					у	18-8 thread-cutting screws are not heat-treated.						
Surface Hardness			Rockwell C45 minimum						<u> </u>						
Case Depth			No. 4 thru 6 diameter: .002007 No. 8 thru 12 diameter: .004009 1/4" diameter and larger: .005011						-						
Core Hardness (after tempering)			Rockwell C28 - 38						Rockwell B90 - C20						
	Plating						Soo /	nnond	iv A for	plating inf	ormation				

COMPONENTS