FASTENERS &

.3750

.3643

.312

Up to 3/4 in., Incl.: -0.03

.219

.156

.281

.219

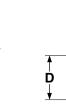
Over 3/4 to 1-1/2 in., Incl.: -0.05

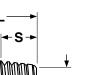
11/16

15/32

560

Over 1-1/2 in.: -0.06







THREADS AND POINTS FOR TYPE 23 THREAD CUTTING SCREWS ASME B18.6.3-2010														
Nominal Size or Ba- sic Screw Diameter		Threads Per Inch	D Major Diameter		P Point Diameter	S Point Taper Length								
										Determinant		Minimum Practical		Minimum Torsional
						Short Screws		Long Screws		Length for Point Taper		Nominal Screw Lengths		Strength, lbin. (STEEL
			Max	Min	Ref	Max	Min	Max	Min	90° Heads	Csk Heads	90° Heads	Csk Heads	parts only)
2	.0860	56	.0860	.0813	.068	.062	.045	.080	.062	5/32	3/16	5/32	3/16	5
3	.0990	48	.0990	.0938	.078	.073	.052	.094	.073	3/16	7/32	5/32	7/32	9
4	.1120	40	.1120	.1061	.087	.088	.062	.112	.088	7/32	1/4	3/16	1/4	13
5	.1250	40	.1250	.1191	.100	.088	.062	.112	.088	7/32	9/32	3/16	1/4	18
6	.1380	32	.1380	.1312	.107	.109	.078	.141	.109	1/4	5/16	1/4	5/16	23
8	.1640	32	.1640	.1571	<i>₹</i> .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	7 5140
5/16	3125	18	.3125	3026	.257	194	139	250	194	15/32	19/32	7/16	9/16	306

Description	A thread cutting screw with machine screw thread pitch, a blunt point, tapered entering threads, a single wide cutting edge, and a chip cavity.									
Applications/ Advantages	Steel type-23's are well-suited for cast iron and zinc, aluminum die castings, and plastics. The type-23 design provides excellent chip clearing with minimum tightening torques. 18-8 stainless screws offer additional resistance to corrosion. When using any thread-cutting screw, the material in which the threads are cut should have a lower hardness by at least 10 to 20 Rockwell hardness points.									
Material	Steel: AISI 1016 - 1024 or equivalent steel; Stainless:18-8 stainless steel.									
Heat Treatment	Steel: Screws shall be quenched in liquid and then tempered by reheating to 650°F minimum.									
Surface Hardness	Steel: Rockwell C45° minimum									
Case Depth (steel)	No. 2 thru 6 diameter: .002007 No. 8 thru 12 diameter: .004009 1/4" diameter and larger: .005011									
Core Hardness	Steel (after tempering): Rockwell C28 - 38 Stainless: Rockwell B90 - C20									
Plating	See Appendix-A for plating of steel thread-cutting screws.									

.3750

Tolerance on Length