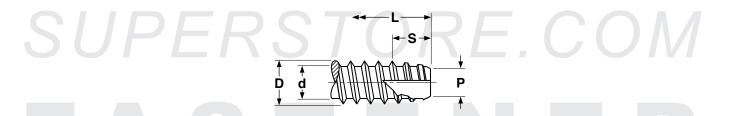
**Tolerance on Length** 

## **Thread Forming**

## Self- Tapping Screws

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



			D		d		Р	S		L		Minimum Torsional Strength, Ib in.
Nominal Size or Basic Screw Diameter		Threads Per Inch	Major Diameter		Minor Diameter		Point Diameter	Point Taper Length		Minimum Practical Screw Length		
			Max	Min	Max	Min	Ref	Max	Min	90° Heads	Csk Heads	(STEEL SCREWS ONLY)
2	.0860	32	.088	.082	.064	.060	.058	.062	.047	5/32	3/16	4
4	.1120	24	.114	.108	.086	.082	.079	.083	.063	3/16	1/4	13
5	.1250	20	.130	.123	.094	.090	.087	.100	.075	7/32	9/32	18
6	.1380	20	.139	.132	.104	.099	.095	.100	.075	1/4	9/32	24
7	.1510	19	.154	.147	.115	.109	.105	.105	.079	1/4	5/16	30
8	.1640	18	.166	.159	.122	.116	.112	.111	.083	9/32	11/32	39
10	.1900	16	.189	.182	.141	.135	.130	.125	.094	5/16	3/8	56
12	.2160	14	.215	.208	.164	.157	.152	.143	.107	11/32	7/16	88
1/4	.2500	14	.246	.237	.192	.185	.179	.143	.107	3/8	1/2	142
5/16	.3125	12	.315	.306	.244	.236	.230	.167	.125	15/32	19/32	290
3/8	.3750	12	.380	.371	.309	.299	.293	.167	.125	17/32	11/16	590

A thread cutting screw with spaced threads, a blunt point, tapered entering threads, a single wide cutting edge, and a Description chip cavity. Steel Stainless Stainless screws offer greater corrosion resistance than steel screws but have a more limited range of appli-Applications/ For molded or through holes in plastics and other soft cations due to being a softer metal. When using any Advantages materials. Provides excellent chip clearing capability. thread-cutting screw, the material in which the threads are cut should have a a lower hardness by 10-20 Rockwell hardness points. Material AISI 1016 - 1024 or equivalent steel. 18-8 stainless steel. Screws shall be guenched in liquid and then tempered by **Heat Treatment** 18-8 thread-cutting screws are not heat-treated. reheating to 650°F minimum. Surface Hardness Rockwell C45 minimum No. 4 thru 6 diameter: .002 - .007 **Case Depth** No. 8 thru 10 diameter: .004 - .009 1/4" diameter and larger: .005 - .011 **Core Hardness** Rockwell B90 - C20 Rockwell C28 - 38 (after tempering) Plating See Appendix-A for plating information.

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