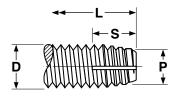
Self- Tapping Screws



THREADS AND POINTS FOR TYPE 1 THREAD CUTTING SCREWS ASME B18.6.4-1998															
Nominal Size or Basic Screw Diameter		Threads Per Inch	D		Р		5	6		L					
			Major Diameter		Point Diameter	Po	oint Tap	er Len	gth	Determinant		Minimum Practical		Minimum	
						Short Screws		Long	Screws	Length for Point Taper		Nominal Screw Lengths		Torsional Strength, Ibin.	
			Max	Min	Ref	Max	Min	Max	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 Ov					er 3/4 1	r 3/4 to 1-1/2 in., Incl.: -0.05 Over 1-1/2 in.					-0.06	
Description								thread	read pitch, blunt point, tapered entering threads and a single cutting edge.						
			Steel					010	Stainless						
Applications/ Advantages			May be used in steel sheets, structural shapes, special alloy steels, cast iron, brass or plastics.					l li	Stainless screws offer greater corrosion resistance than steel screws but have a more 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					у	18-8 thread-cutting screws are not heat-treated.						
			reheating to 650°F minimum.						~ 						
Surface Hardness			Rockwell C45 minimum No. 4 thru 6 diameter: .002007												
с	ase Dep	oth	No. 4 thru 5 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			See Appendix-A for plating information.												