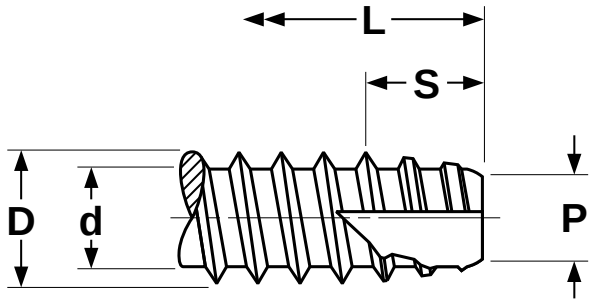
Type-25 *Thread Cutting* Self-Tapping Screws



THREADS FOR THREAD CUTTING SCREWS TYPE 25

ANSI B18.6.4

Nominal Size or Basic Screw Diameter		Threads Per Inch	D		d		P		S		L		Minimum Torsional Strength, lb.- in.
			Major Diameter		Minor Diameter		Point Diameter		Point Taper Length		Minimum Practical Screw Length		
			Max	Min	Max	Min	Max	Min	Max	Min	90° Heads	Csk Heads	
2	.0860	32	.088	.082	.064	.060	.058	.054	.062	.047	5/32	3/16	4
4	.1120	24	.114	.108	.086	.082	.079	.074	.083	.063	3/16	1/4	13
6	.1380	20	.139	.132	.104	.099	.095	.089	.100	.075	1/4	9/32	24
8	.1640	18	.166	.159	.122	.116	.112	.106	.111	.083	9/32	11/32	39
10	.1900	16	.189	.182	.141	.135	.130	.123	.125	.094	5/16	3/8	56
14	.2500	14	.246	.237	.192	.185	.179	.171	.143	.107	3/8	1/2	142
Tolerance on Length			Up to 3/4 in., Incl.: -0.03						Over 3/4 to 1-1/2 in., Incl.: -0.05				

Description	A thread cutting screw with spaced threads, a blunt point, tapered entering threads, a single wide cutting edge, and a chip cavity.
Applications/ Advantages	For molded or through holes in plastics and other soft materials. Provides excellent chip clearing capability.
Material	AISI 1016 - 1024 or equivalent steel.
Heat Treatment	Screws shall be quenched in liquid and then tempered by reheating to 650°F minimum.
Surface Hardness	Rockwell C45 minimum
Case Depth	No. 4 thru 6 diameter: .002 - .007 No. 8 thru 10 diameter: .004 - .009 1/4" diameter: .005 - .011
Core Hardness (after tempering)	Rockwell C28 - 38
Plating	See Appendix-A for plating information.