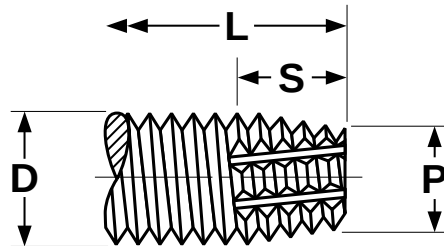


Self-Tapping Screws

Thread Cutting

Type-F



THREADS AND POINTS FOR TYPE-F THREAD CUTTING SCREWS														ANSI B18.6.4	
Nominal Size or Basic Screw Diameter		Threads Per Inch	D		P		S				L				Minimum Torsional Strength, lb.-in. (STEEL SCREWS ONLY)
			Major Diameter		Point Diameter		Point Taper Length				Determinant Length for Point Taper		Minimum Practical Screw Lengths		
							Short Screws		Long Screws						
			Max	Min	Max	Min	Max	Min	Max	Min	90° Heads	Csk Heads	90° Heads	Csk Heads	
2	.0860	56	.0860	.0813	.068	.061	.062	.045	.080	.062	5/32	3/16	5/32	3/16	5
4	.1120	40	.1120	.1061	.087	.078	.088	.062	.112	.088	7/32	1/4	3/16	1/4	13
6	.1380	32	.1380	.1312	.107	.096	.109	.078	.141	.109	1/4	5/16	1/4	5/16	23
8	.1640	32	.1640	.1571	.132	.122	.109	.078	.141	.109	1/4	11/32	1/4	5/16	42
10	.1900	24	.1900	.1818	.148	.135	.146	.104	.188	.146	11/32	7/16	5/16	13/32	56
10	.1900	32	.1900	.1831	.158	.148	.109	.078	.141	.109	1/4	11/32	1/4	5/16	74
12	.2160	24	.2160	.2078	.174	.161	.146	.104	.188	.146	11/32	7/16	5/16	13/32	93
1/4	.2500	20	.2500	.2408	.200	.184	.175	.125	.225	.175	13/32	17/32	3/8	1/2	140
5/16	.3125	18	.3125	.3026	.257	.239	.194	.139	.250	.194	15/32	19/32	7/16	9/16	306
3/8	.3750	16	.3750	.3643	.312	.293	.219	.156	.281	.219	1/2	11/16	15/32	5/8	560
Tolerance on Length			Up to 3/4 in., incl.: -0.03					Over 3/4 to 1-1/2 in., incl.: -0.05				Over 1-1/2 in.: -0.06			

Description	A thread cutting screw with machine screw thread pitch, blunt point, tapered entering threads and multiple cutting edges.
Applications/ Advantages	For use in heavy gauge sheet metal, aluminum, zinc and lead die castings, cast iron, brass and plastic.
Material	Steel: AISI 1016 - 1024 or equivalent steel. Stainless: 410 martensitic stainless steel.
Heat Treatment	Steel: Screws shall be quenched in liquid and then tempered by reheating to 650°F minimum. Stainless: Screws shall be annealed by heating to 1850-1950°F, held at least for 1/2 hour and rapid air- or oil-quenched then reheating to 525°F minimum for at least 1 hour and air cooled to provide the required tensile, yield and hardness properties.
Surface Hardness	Steel: Rockwell C45 minimum
Case Depth (steel)	No. 4 thru 6 diameter: .002 - .007 No. 8 thru 12 diameter: .004 - .009 1/4" diameter & larger: .005 - .011
Core Hardness (after tempering)	Steel: Rockwell C28 - 38 Stainless: Rockwell C38 - 42
Plating	See Appendix-A for information on plating of steel thread cutting screws.