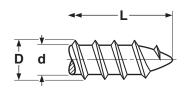
Thread Forming







THREADS FOR SELF-TAPPING SCREWS TYPE A ASME B18.6.4									
Nominal Size or Basic Screw Diameter				D d			L		Minimum Torsional Strength, Ibin. (STEEL
		Threads Per Inch	Major Diameter		Minor Diameter		These Lengths or Shorter Have AB Threads		
			Max	Min	Max	Min	90° Heads	Csk Heads	SCREWS ONLY)
6	0.1380	18	.141	.136	.102	.096	1/4	5/16	24
7	0.1510	16	.158	.152	.114	.108	5/16	3/8	30
8	0.1640	15	.168	.162	.123	.116	3/8	7/16	39
9*	0.1770	14	.181	.170	.130	.120	3/8	7/16	47
10	0.1900	12	.194	.188	.133	.126	3/8	1/2	48
12	0.2160	11	.221	.215	.162	.155	7/16	9/16	83
14	0.2420	10	.254	.248	.185	.178	1/2	5/8	125
20	0.3200	9	.333	.327	.234	.226	11/16	13/16	250
24	0.3720	9	.390	.383	.291	.282	3/4	1	492
Tolerance on Length				Up to 1" Incl.: ±0.03			Over 1": ±0.05		
* Dimension	s for #9 diamet	er are indep	endent of ASN	ME B18.6.4					

Description	A thread forming tapping screw with wider spaced threads than a Type-AB and a gimlet point.					
Applications/ Advantages	For self starting in thin (.015050 thick) metal or resin-filled plywood. 18-8 Stainless steel tapping screws may be used in applications which require general atmospheric corrosion resistance. Fastening stainless steel parts to aluminum or steel can cause a type of corrosion known as a galvanic couple in some environments.					
Material	Steel: AISI 1016 - 1024 or equivalent steel. Stainless: Austenitic 18-8 stainless steel					
Heat Treatment (Steel only)	Screws shall be quenched in liquid and then tempered by reheating to 650°F minimum.					
Surface Hardness	Steel: Rockwell C45 minimum					
Case Depth (Steel only)	No. 6 diameter: .002007 No. 8 thru 12 diameter: .004009 1/4" and larger: .005011					
Core Hardness (after tempering)	Steel: Rockwell C28 - 38					
Plating	See Appendix-A for information on plating of steel screws.					