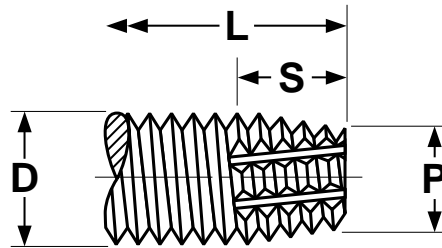


Self-Tapping Screws

Thread Cutting

Type-F



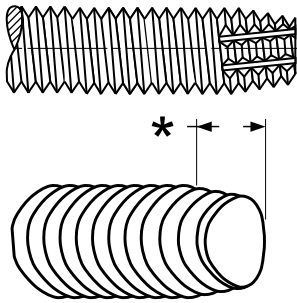
THREADS AND POINTS FOR TYPE-F THREAD CUTTING SCREWS															ANSI B18.6.4	
Nominal Size or Basic Screw Diameter	Threads Per Inch	D		P		S				L				Minimum Torsional Strength, lb.-in. (STEEL SCREWS ONLY)		
		Major Diameter		Point Diameter		Point Taper Length				Determinant Length for Point Taper		Minimum Practical Screw Lengths				
		Max	Min	Max	Min	Short Screws		Long Screws		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.

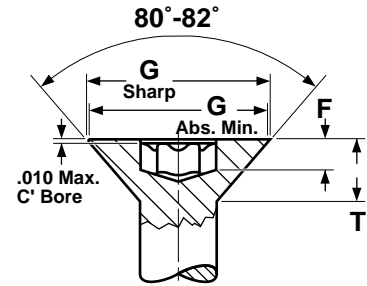
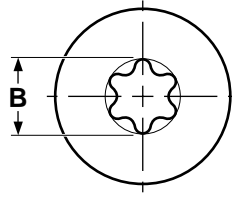
Type-F**

Floorboard Screws

Self-Tapping Screws



*2-3 Pitch Lead Length



TORX® DRIVE FLAT HEADS (FLOORBOARD)							
Nominal Size or Basic Screw Diameter		G		T	B	F	Drive Size
		Head Dimensions			Recess Dimensions		
		Max Sharp	Abs. Min	Ref	Ref	Gauge Penetration Min	
8	.164	.332	.292	.100	.132	.040	T15
10	.190	.385	.340	.116	.155	.050	T20
12	.216	.438	.389	.132	.178	.055	T25
1/4	.2500	.520	.452	.160	.221	.060	T30
5/16	.3125	.648	.568	.199	.266	.090	T40
3/8	.375	.762	.685	.230	.266	.115	T40
1/2**	.500	.875	.775	.223	.352	.119	T50

**1/2 inch diameter floorboard screws are supplied as trilobular thread rolling screws.

Description	A countersunk, torx® drive thread cutting screw with machine screw thread pitch, blunt point, tapered entering threads, and multiple cutting edges. Larger diameter sizes may also be supplied as a thread rolling screw rather than thread cutting. Floorboard screws are, by definition, available in much longer sizes than standard type-F screws.
Applications/ Advantages	Floorboard screws are specifically designed for installing wood floors into truck trailers.
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. 8 thru 12 diameter: .004 - .009 1/4" diameter & larger: .005 - .011
Core Hardness (after tempering)	Rockwell C28 - 38
Thread Dimensions	#8 thru 3/8" diameters: Same as those for Type-F thread cutting screws. 1/2" diameter: Same as those for a thread rolling screw.
Plating	See Appendix-A for information on the plating of floorboard screws.