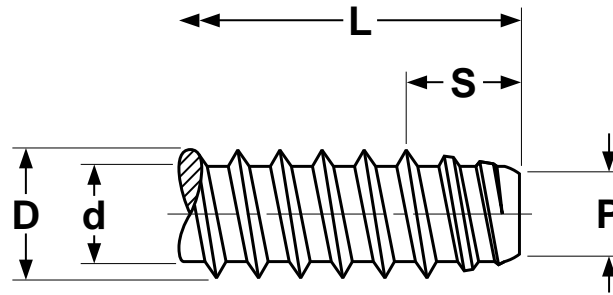


Self-Tapping Screws

Thread Forming

Type-B



THREADS FOR SELF-TAPPING SCREWS TYPE-B

ANSI B18.6.4

| Nominal Size or Basic Screw Diameter | Threads Per Inch | D | | d | | P | | S | | L | | Minimum Torsional Strength, lb.- in. (STEEL SCREWS ONLY) | |
|--|---------------------|-----------------------------|------|-------------------------------------|------|-----------------------|------|-----------------------|------|--------------------------------------|--------------|--|-----|
| | | 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 |
| 3 | .0990 | 28 | .101 | .095 | .075 | .071 | .068 | .064 | .071 | .054 | 3/16 | 7/32 | 9 |
| 4 | .1120 | 24 | .114 | .108 | .086 | .082 | .079 | .074 | .083 | .063 | 3/16 | 1/4 | 13 |
| 5 | .1250 | 20 | .130 | .123 | .094 | .090 | .087 | .082 | .100 | .075 | 7/32 | 9/32 | 18 |
| 6 | .1380 | 20 | .139 | .132 | .104 | .099 | .095 | .089 | .100 | .075 | 1/4 | 9/32 | 24 |
| 7 | .1510 | 19 | .154 | .147 | .115 | .109 | .105 | .099 | .105 | .079 | 1/4 | 5/16 | 30 |
| 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 |
| 12 | .2160 | 14 | .215 | .208 | .164 | .157 | .152 | .145 | .143 | .107 | 11/32 | 7/16 | 88 |
| 1/4 | .2500 | 14 | .246 | .237 | .192 | .185 | .179 | .171 | .143 | .107 | 3/8 | 1/2 | 142 |
| 5/16 | .3125 | 12 | .315 | .306 | .244 | .236 | .230 | .222 | .167 | .125 | 15/32 | 19/32 | 290 |
| 3/8 | .3750 | 12 | .380 | .371 | .309 | .299 | .293 | .285 | .167 | .125 | 17/32 | 11/16 | 590 |
| 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 | | | | | | | |

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| Description | A thread forming tapping screw with spaced threads and a blunt point with incomplete entering threads. |
| Applications/ Advantages | For molded or through holes in thin metal, non-ferrous castings, plastics or resin-filled plywood. |
| Material | Steel: AISI 1016 - 1024 or equivalent steel. Stainless: 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. 4 thru 6 diameter: .002 - .007 No. 8 thru 12 diameter: .004 - .009 1/4" and larger: .005 - .011 |
| Core Hardness (after tempering) | Steel: Rockwell C28 - 38 |
| Plating | See Appendix-A for plating information. |