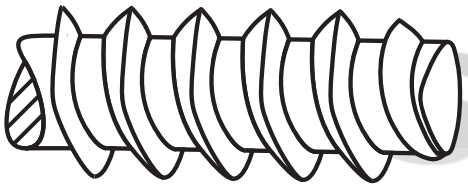
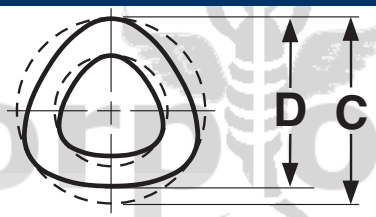
THREAD ROLLING

Plastite® 48-2





PLASTITE® 48-2 THREAD ROLLING SCREWS

REMINC•

Nominal Screw Size and Threads Per Inch	C		D		Minimum Out-Of-Round	Recommended Pilot Hole Sizes	
	Diameter of Circumscribing Circle		Measurements Across Center				
	Max	Min	Max	Min		Soft Ductile Materials	Brittle Materials
• 0 - 40	.0665	.0635	.0635	.0605	.002	.0498	.0490
2 - 28	.092	.086	.089	.083	.002	.076	.080
3 - 24	.110	.104	.106	.100	.002	.088	.094
4 - 20	.127	.121	.123	.117	.002	.100	.106
• 5 - 20	.136	.132	.133	.129	.002	-	-
6 - 19	.147	.141	.143	.137	.003	.122	.128
7 - 18	.166	.160	.160	.154	.004	.134	.142
8 - 16	.185	.179	.179	.173	.004	.149	.158
9 - 15	.199	.193	.193	.187	.004	.162	.172
10 - 14	.212	.206	.208	.202	.004	.175	.185
12 - 11	.232	.226	.226	.220	.005	.195	.205
1/4 - 10	.276	.270	.268	.262	.006	.224	.240
5/16 - 9	.345	.335	.335	.325	.006	.286	.303

Tolerance on Length	Thru 3/4": ±.030"	Over 3/4": ±.050"	Over 1/4" Diameter, All Lengths: ±.050"

• Specifications for the 0-40 & 5-20 diameters are independent from the REMINC standard and are listed here for reference purposes only.

Description	Trilobular thread-rolling screw with extra wide spacing between 48° profile threads; twin lead threads with a 1-2 thread point taper.	
Applications/ Advantages	Thermoplastics, engineering resins and certain thermosets. Sharper thread profile increases holding strength while reducing material displacement. Drive and strip torques are higher, reducing the need for inserts or reinforcing clips.	
Material	***Steel***	***Stainless***
	AISI 1022 steel	***18-8:*** 18-8 stainless steel ***410:*** 410 austenitic stainless steel
Heat Treatment	Screws shall be quenched in liquid and then tempered by reheating to 650°F minimum.	***410 SS:*** An ideal method of hardening 410 stainless screws is a bright hardening process, which typically involves a vacuum furnace. Another key factor affecting hardness is the chemistry of the fastener--most elements have maximum values but not minimums. This fact can contribute to hardness variance. 18-8 is only hardenable by cold-working.
Case Hardness	Rockwell C45 minimum	-
Case Depth	***No. 2 thru 6 diameters:*** .002 - .007 ***No. 8 thru 10 diameters:*** .004 - .009 ***1/4" diameter:*** .005 - .011	-
Core Hardness	Core: Rockwell C28-38 (after tempering)	***18-8:*** Rockwell B90 - C20 (approx.) ***410:*** Rockwell C38 - 46 (approx.)
Plating	Various finishes with wax coating (see Appendix-A)	Stainless thread rolling screws are supplied passivated & waxed.

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