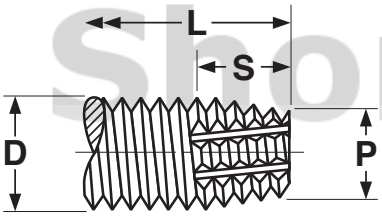
THREAD CUTTING

Type F



Threads and Points for Type-F Thread Cutting Screws

ASME B18.6.3-2013

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	Ref	Max	Min	Max	Min	90° Heads	Csk Heads	90° Heads	Csk Heads	
2	.0860	56	.0860	.0813	.068	.062	.045	.080	.062	5/32	3/16	5/32	3/16	5
4	.1120	40	.1120	.1061	.087	.088	.062	.112	.088	7/32	1/4	3/16	1/4	13
5	.1250	40	.1250	.1191	.100	.088	.062	.112	.088	7/32	9/32	3/16	1/4	18
6	.1380	32	.1380	.1312	.107	.109	.078	.141	.109	1/4	5/16	1/4	5/16	23
8	.1640	32	.1640	.1571	.132	.109	.078	.141	.109	1/4	11/32	1/4	5/16	42
10	.1900	24	.1900	.1818	.148	.146	.104	.188	.146	11/32	7/16	5/16	13/32	56
10	.1900	32	.1900	.1831	.158	.109	.078	.141	.109	1/4	11/32	1/4	5/16	74
12	.2160	24	.2160	.2078	.174	.146	.104	.188	.146	11/32	7/16	5/16	13/32	93
1/4	.2500	20	.2500	.2408	.200	.175	.125	.225	.175	13/32	17/32	3/8	1/2	140
5/16	.3125	18	.3125	.3026	.257	.194	.139	.250	.194	15/32	19/32	7/16	9/16	306
3/8	.3750	16	.3750	.3643	.312	.219	.156	.281	.219	1/2	11/16	15/32	5/8	560
1/2	.5000	13	.5000	.4876	.423	.269	.192	.346	.269	5/8	25/32	19/32	3/4	1075

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	Steel thread-cutters are used in heavy gauge sheet metal, aluminum, zinc and lead die castings, cast iron, brass and plastic. Stainless screws offer additional resistance to corrosion, 18-8 moreso than 410. When using any thread-cutting screw, the material in which the threads are cut should have a lower hardness by at least 10 to 20 Rockwell hardness points.
Material	**Steel**: AISI 1016 - 1024 or equivalent steel. **Stainless**: 410 martensitic stainless steel or 18-8 stainless steel.
Heat Treatment	***Steel***: 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.
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
Hardness	**Steel (after tempering)**: Core: Rockwell C28 - 38 **410**: Rockwell C38 - 46 (approx.); **18-8** Stainless: Rockwell B90 - C20 (approx.)
Plating	See Appendix-A for information on plating of steel thread cutting screws.