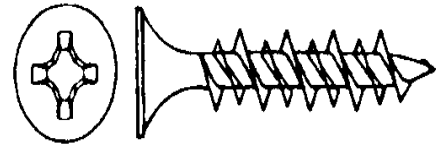


# HIGH-LOW TAPPING SCREW



Screw Size	D	B	P Strength	Pilot Hole Diameter Flexural Modulus of Plastic		Minimum Torsional lb. in. (STEEL SCREWS ONLY)
	High Thread Diameter	Low Thread Diameter	Point Diameter	Up to 200,000 P.S.I.	200,000-400,000 P.S.I.	
2-32	.084-.090	.069	.050-.058	.0670	.0000	
4-24	.105-.115	.086	.061-.070	.0810	.0860	4
5-20	.119-.125	.100	.073-.082	.0935	.0995	9
6-19	.135-.145	.108	.080-.090	.1015	.1100	13
8-18	.160-.170	.130	.095-.105	.1200	.1285	18
10-16	.185-.195	.145	.099-.110	.1360	.1440	30
12-16	.210-.220	.167	.125-.137	.1570	.1660	39
1/4-15	.250-.260	.200	.161-.175	.1890	.2010	56
<b>Tolerance on Length</b>			Up to 1 in., Incl. +0, -3/64		Over 1 in.: +0, -1/16	

<b>Description</b>	A thread forming screw with a double-lead, consisting of a high and low thread. The lower thread varies in height from 1/3 to 1/2 that of the higher thread, which is sharper and flatter than a standard thread.
<b>Applications/ Advantages</b>	For use in plastic, nylon, wood or other low-density materials. Thread design reduces driving torques, enhances resistance to thread stripping, improves pullout strength and lessens risk of cracking the work piece.
<b>Material</b>	Steel: 1019-1022 or equivalent steel. Stainless: 410 martensitic stainless steel
	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 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.
<b>Hardness</b>	Steel: Rockwell C45 - 50
<b>Case Depth (Steel)</b>	No. 2 thru 6 diameter: .002 - .007 No. 8 thru 12 diameter: .004 - .009 1/4" diameter: .005 - .011
<b>Core Hardin:1<sup>st</sup> (after tempering)</b>	Steel: Rockwell C28 - 36 Stainless: Rockwell C38 - 42
<b>Plant.</b>	See Appendix-A