

# TYPE 25 THREAD CUTTING SCREWS



Nominal Size or Basic Screw Diameter		Threads Per Inch	D		d		P	S		L		Minimum Torsional Strength, lb.- in.
			Major Diameter		Minor Diameter		Point Diameter	Point Taper Length		Minimum Practical Screw Length		
			Max	Min	Max	Min	Ref	Max	Min	90. Heads	Csk Heads	
2	.0860	32	.088	.082	.064	.060	.058	.062	.047	5/32	3/16	
4	.1120	24	.114	.108	.086	.082	.079	.083	.063	3/16	1/4	13
5	.1250	20	.130	.123	.094	.090	.087	.100	.075	7/32	9/32	18
6	.1380	20	.139	.132	.104	.099	.095	.100	.075	1/4	9/32	24
8	.1640	18	.166	.159	.122	.116	.112	.111	.083	9/32	11/32	39
10	.1900	16	.189	.182	.141	.135	.130	.125	.094	5/16	3/8	56
12	.2160	14	.215	.208	.164	.157	.152	.143	.107	11/32	7/16	88
14	.2500	14	.246	.237	.192	.185	.179	.143	.107	3/8	1/2	142
5/16	.3125	12	.315	.306	.244	.236	.230	.167	.125	15/32	19/32	290
3/8	.3750	12	.380	.371	.309	.299	.293	.167	.125	17/32	11/16	590
<b>Tolerance on Length</b>		Up to 3/4 in., Incl.: -0.03						Over 3/4 to 1-1/2 in., Incl.: -0.05				

<b>Description</b>	A thread cutting screw with spaced threads, a blunt point, tapered entering threads, a single wide cutting edge, and a chip cavity.
<b>Applications/ Advantages</b>	For molded or through holes in plastics and other soft materials. Provides excellent chip clearing capability.
<b>Material</b>	AISI 1016 - 1024 or equivalent steel.
<b>Heat Treatment</b>	Screws shall be quenched in liquid and then tempered by reheating to 650°F minimum.
<b>Surface Hardness</b>	Rockwell C45 minimum
<b>Case Depth</b>	No. 4 thru 6 diameter: .002 - .007 No. 8 thru 10 diameter: .004 - .009 1/4" diameter and larger: .005 - .011
<b>Core Hardness (after tempering)</b>	Rockwell C28 - 38
<b>Plating</b>	See Appendix-A for plating information.