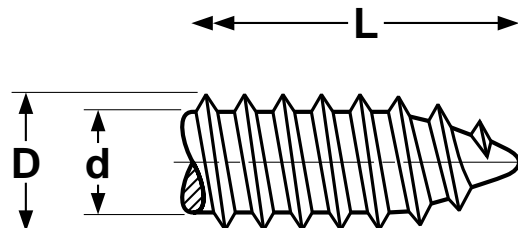


Type-AB

Thread Forming

Self-Tapping Screws



THREADS FOR SELF-TAPPING SCREWS TYPE AB										ANSI B18.6.4
Nominal Size or Basic Screw Diameter		Threads Per Inch	D		d		L		Minimum Torsional Strength, lb.- in.	
			Major Diameter		Minor Diameter		Minimum Practical Screw Length			
			Max	Min	Max	Min	90° Heads	Csk Heads		
2	.0860	32	.088	.082	.064	.060	3/16	7/32	4	
4	.1120	24	.114	.108	.086	.082	7/32	9/32	13	
5	.1250	20	.130	.123	.094	.090	1/4	5/16	18	
6	.1380	20	.139	.132	.104	.099	9/32	11/32	24	
7	.1510	19	.154	.147	.115	.109	5/16	3/8	30	
8	.1640	18	.166	.159	.122	.116	5/16	3/8	39	
10	.1900	16	.189	.182	.141	.135	3/8	7/16	56	
12	.2160	14	.215	.208	.164	.157	7/16	21/32	88	
1/4	.2500	14	.246	.237	.192	.185	1/2	19/32	142	
5/16	.3125	12	.315	.306	.244	.236	5/8	3/4	290	
3/8	.3750	12	.380	.371	.309	.299	3/4	29/32	590	
Tolerance on Length			Up to 1" Incl.: ±0.03				Over 1": ±0.05			

Description	A thread forming tapping screw with spaced threads and a gimlet point
Applications/ Advantages	For self starting in thin metal or resin-filled plywood. Recommended over a Type-A, particularly in brittle materials.
Material	AISI 1016 - 1024 or equivalent steel.
Heat Treatment	Screws shall be quenched in liquid and then tempered by reheating to 650°F minimum.
Surface Hardness	Rockwell C45 minimum
Case Depth	No. 4 thru 6 diameter: .002 - .007 No. 8 thru 12 diameter: .004 - .009 1/4" and larger: .005 - .011
Core Hardness (after tempering)	Rockwell C28 - 38
Plating	See Appendix-A for plating information.