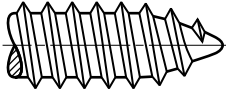


# Self-Tapping Screws

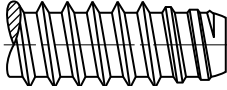
# Hole Size Data

Types A,  
AB, B, 25

AB



B



A



25



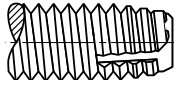
| SUGGESTED TEST PLATE THICKNESSES & HOLE SIZES FOR TYPES AB - B - 25 |           |       |       |            |            |
|---|-----------|-------|-------|------------|------------|
| Nominal Screw Size & No. of Threads per Inch                        | Thickness |       |       | Hole Size  |            |
|   | Gage      | Max   | Min   | Drill Size | Hole Diam. |
| 2-32  | 18        | .0500 | .0460 | 48         | .0760      |
| 3-28  | 18        | .0500 | .0460 | 46         | .0810      |
| 4-24  | 18        | .0500 | .0460 | 44         | .0860      |
| 5-20  | 18        | .0500 | .0460 | 36         | .1065      |
| 6-20  | 14        | .0770 | .0730 | 32         | .1160      |
| 7-19  | 14        | .0770 | .0730 | 30         | .1285      |
| 8-18  | 14        | .1270 | .1230 | 29         | .1360      |
| 10-16   | 1/8       | .1270 | .1230 | 21         | .1590      |
| 12-14   | 1/8       | .1270 | .1230 | 3/16       | .1875      |
| 1/4-14  | 3/16      | .1905 | .1845 | 5.5 mm     | .2165      |
| 5/16-12   | 3/16      | .1905 | .1845 | 1          | .2720      |
| 3/8-12  | 3/16      | .1905 | .1845 | 21/64      | .3281      |

| SUGGESTED HOLE SIZES FOR TYPE A |            |            |
|---------------------------------|------------|------------|
| Nominal Screw Size              | Hole Size  |            |
|                                 | Drill Size | Hole Diam. |
| 6-18                            | #32        | 0.1160     |
| 7-16                            | #30        | 0.1285     |
| 8-15                            | #29        | 0.1360     |
| 10-12                           | #21        | 0.1590     |
| 12-11                           | 3/16       | 0.1875     |
| 14-10                           | 5.5mm      | 0.2165     |
| 20-9                            | L          | 0.2900     |
| 24-9                            | 11/32      | 0.3438     |

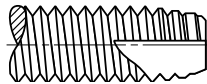
### Notes Regarding Hole Preparation:

- Performed holes can be drilled, cored, punched, pierced or extruded. If edge burrs can cause assembly difficulty, they should be removed. Wall ovality and/or taper can affect load carrying ability.
- “Minimum torsional strength” is the torque that free standing screws must accept without evidence of damage or failure.

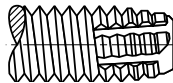
Type 1



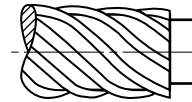
Type 23



Type F



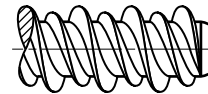
Type U  
Drive Screw



| SUGGESTED TEST PLATE THICKNESSES & HOLE SIZES FOR<br>TYPES 1, 23 & F<br>THREAD CUTTING SCREWS |           |       |       |            |            |
|---|-----------|-------|-------|------------|------------|
| Nominal<br>Screw Size<br>& Thread<br>Pitch  | Thickness |       |       | Hole Size  |            |
|   | Gage      | Max   | Min   | Drill Size | Hole Diam. |
| 2-56  | 18        | .0800 | .0760 | 49         | 0.0730     |
| 3-48  | 18        | .0960 | .0920 | 46         | 0.0810     |
| 4-40  | 18        | .1110 | .1070 | 41         | 0.0960     |
| 5-40  | 18        | .1110 | .1070 | 37         | 0.1010     |
| 6-32  | 14        | .1425 | .1385 | 31         | 0.1200     |
| 8-32  | 14        | .1905 | .1845 | 26         | 0.1470     |
| 10-24   | 1/8       | .1905 | .1845 | 17         | 0.1730     |
| 10-32   | 1/8       | .1905 | .1845 | 16         | 0.1770     |
| 12-24   | 1/8       | .1905 | .1845 | 8          | 0.1990     |
| 1/4-20  | 3/16      | .2530 | .2470 | 1          | 0.2280     |
| 5/16-18   | 3/16      | .3155 | .3095 | L          | 0.2900     |
| 3/8-16  | 3/16      | .3780 | .3720 | T          | 0.3580     |
| 1/2-13  | 3/16      | .471  | .443  | 29/64      | 0.4531     |

| RECOMMENDED HOLE SIZES -- TYPE-U DRIVE SCREWS |                |               |
|---|----------------|---------------|
| Screw Size                                    | Drill Size No. | Hole Diameter |
| 00  | 55             | .052          |
| 0   | 51             | .067          |
| 2   | 44             | .086          |
| 4   | 37             | .104          |
| 6   | 31             | .120          |
| 7   | 29             | .136          |
| 8   | 27             | .144          |
| 10  | 20             | .161          |
| 12  | 11             | .191          |
| 14  | 2              | .221          |

High-  
Low



| SUGGESTED HOLE SIZES -- HIGH-LOW SCREWS               |  |                           |
|---|--|---------------------------|
| Nominal Screw Size<br>& Number of<br>Threads per Inch | Pilot Hole Diameter<br>Flexural Modulus of Plastic |                           |
|   | Up to 200,000<br>P.S.I.                            | 200,000-400,000<br>P.S.I. |
| 2-32  | .0670  | .0700                     |
| 3-28  | .0730  | .0781                     |
| 4-24  | .0810  | .0860                     |
| 5-20  | .0935  | .0995                     |
| 6-19  | .1015  | .1100                     |
| 7-19  | .1200  | .1250                     |
| 8-18  | .1200  | .1285                     |
| 10-16   | .1360  | .1440                     |
| 12-16   | .1570  | .1660                     |
| 1/4-15  | .1890  | .2010                     |
| 5/16-14   | .2380  | .2500                     |

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**Taptite® - See p 34-37**

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