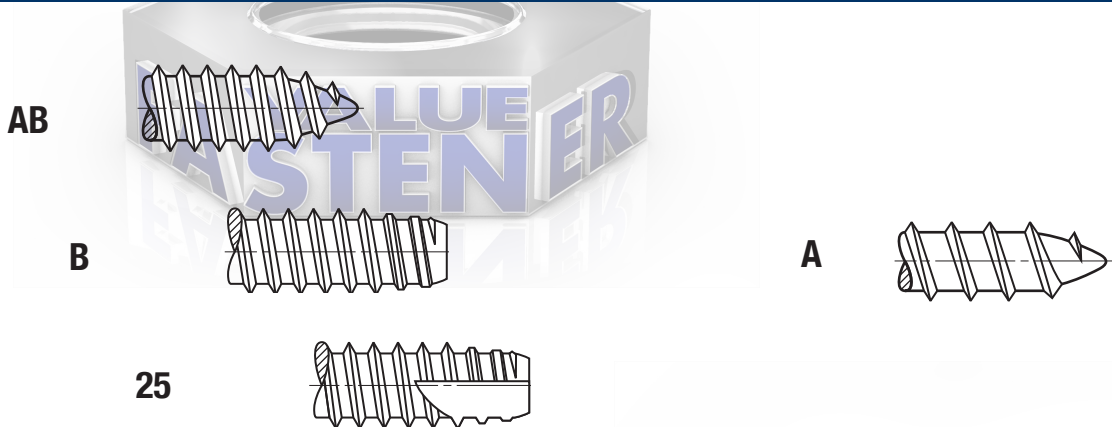


SELF-TAPPING SCREWS

HOLE SIZE DATA Types A, AB, B, 25



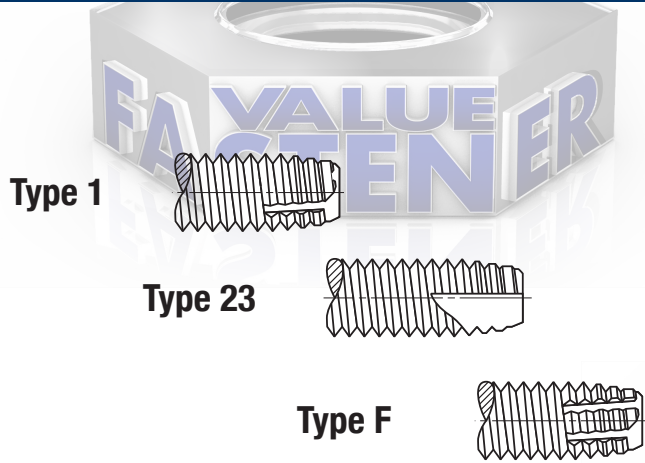
| SUGGESTED TEST PLATE THICKNESSES & HOLE SIZES FOR TYPES AB - B - 25 | | | | | |
|---|-----------|-------|-------|------------|------------|
| Nominal Screw Size & No. of Threads per Inch | Thickness | | | Hole Size | |
| | Gage | Max | Min | Drill Size | Hole Diam. |
| 2-32 | 18 | .0500 | .0460 | 48 | .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 |

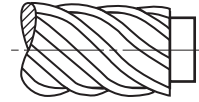
Notes Regarding Hole Preparation:

- Preformed 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.

Types 1, 23, F, U & High-Low **HOLE SIZE DATA**



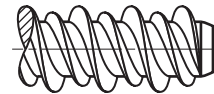
**Type U
Drive Screw**



| 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 |

| SUGGESTED TEST PLATE THICKNESSES & HOLE SIZES FOR TYPES 1, 23 & F THREAD CUTTING SCREWS | | | | | |
|---|-----------|-------|-------|------------|------------|
| Nominal Screw Size & Thread 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 |

**High-
Low**



| SUGGESTED HOLE SIZES -- HIGH-LOW SCREWS | | |
|---|--|---------------------------|
| Nominal Screw Size & Number of Threads per Inch | Pilot Hole Diameter Flexural Modulus of Plastic | |
| | Up to 200,000 P.S.I. | 200,000-400,000 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 |