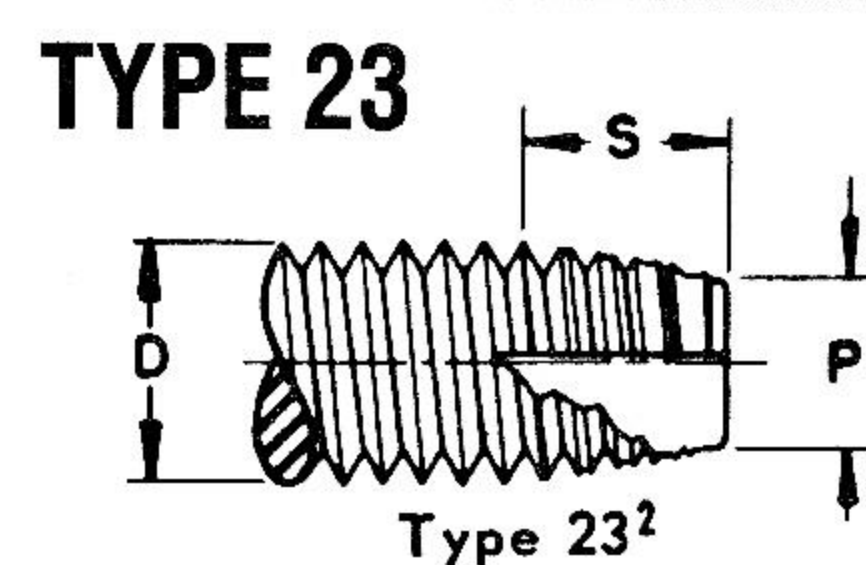
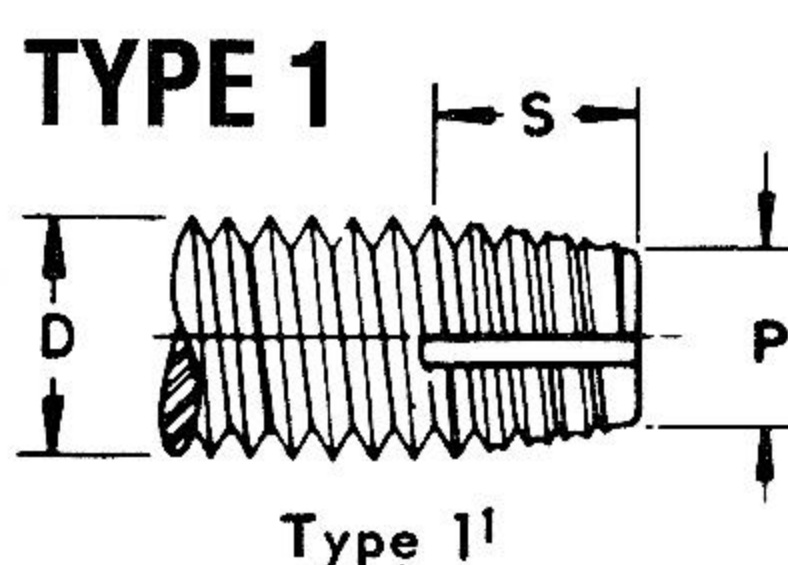
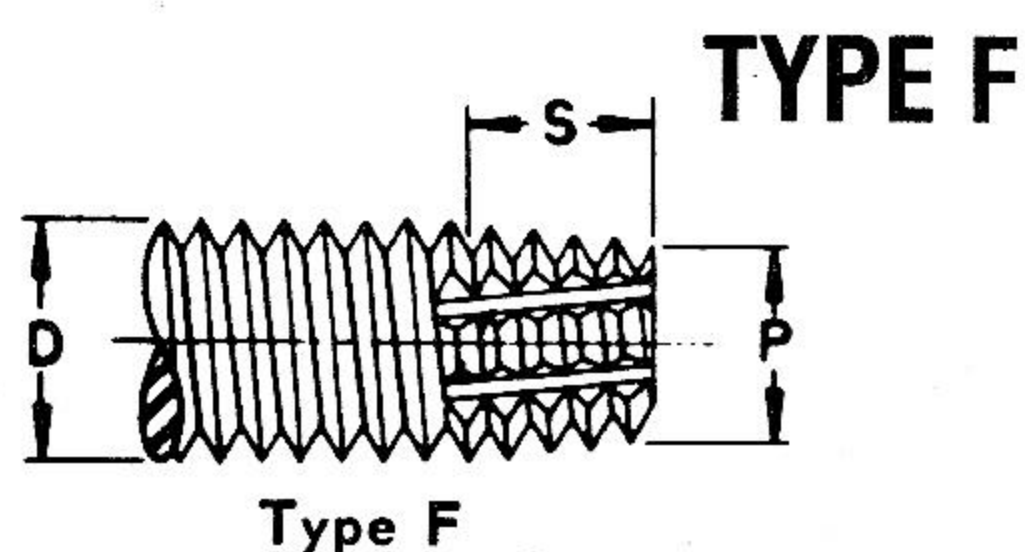


# THREAD CUTTING SPECIFICATIONS



## COARSE THREADS

## FINE THREADS

SIZE	THRDS. PER INCH	D			P	
		MAJOR DIA.			POINT DIA.	
		BASIC	MAX.	MIN.	MAX.	MIN.
2	56	.0860	.0860	.0820	.067	.061
3	48	.0990	.0990	.0946	.077	.070
4	40	.1120	.1120	.1072	.086	.077
5	40	.1250	.1250	.1202	.099	.090
6	32	.1380	.1380	.1326	.106	.095
8	32	.1640	.1640	.1586	.132	.121
10	24	.1900	.1900	.1834	.147	.133
12	24	.2160	.2160	.2094	.173	.159
1/4	20	.2500	.2500	.2428	.198	.181
5/16	18	.3125	.3125	.3043	.255	.236
3/8	16	.3750	.3750	.3660	.310	.289

SIZE	THRDS. PER INCH	D			P	
		MAJOR DIA.			POINT DIA.	
		BASIC	MAX.	MIN.	MAX.	MIN.
2	64	.0860	.0860	.0822	.070	.064
3	56	.0990	.0990	.0950	.080	.074
4	48	.1120	.1120	.1076	.090	.083
5	44	.1250	.1250	.1204	.101	.093
6	40	.1380	.1380	.1332	.112	.103
8	36	.1640	.1640	.1590	.135	.125
10	32	.1900	.1900	.1846	.158	.147
12	28	.2160	.2160	.2098	.179	.167
1/4	28	.2500	.2500	.2438	.213	.201
5/16	24	.3125	.3125	.3059	.269	.255
3/8	24	.3750	.3750	.3684	.332	.318

Taper and Flutes: screws shall be tapered and fluted as illustrated in cut. Details of taper and flute design shall be optional with manufacturer, provided they meet the performance requirements and the flutes extend through the first full thread.

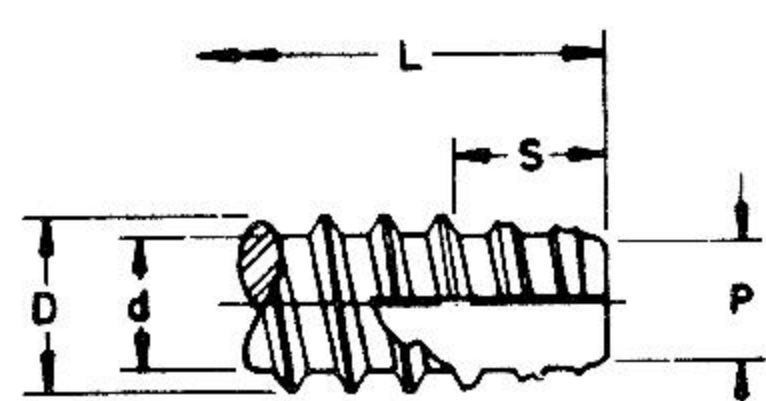
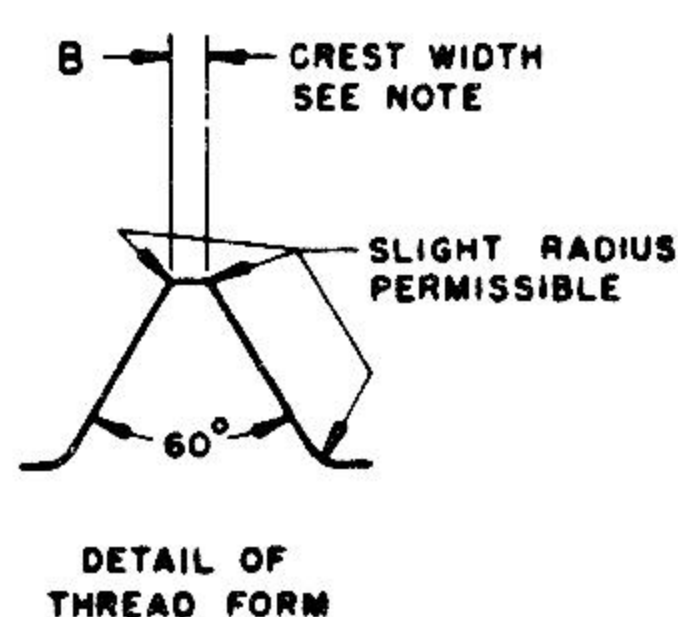
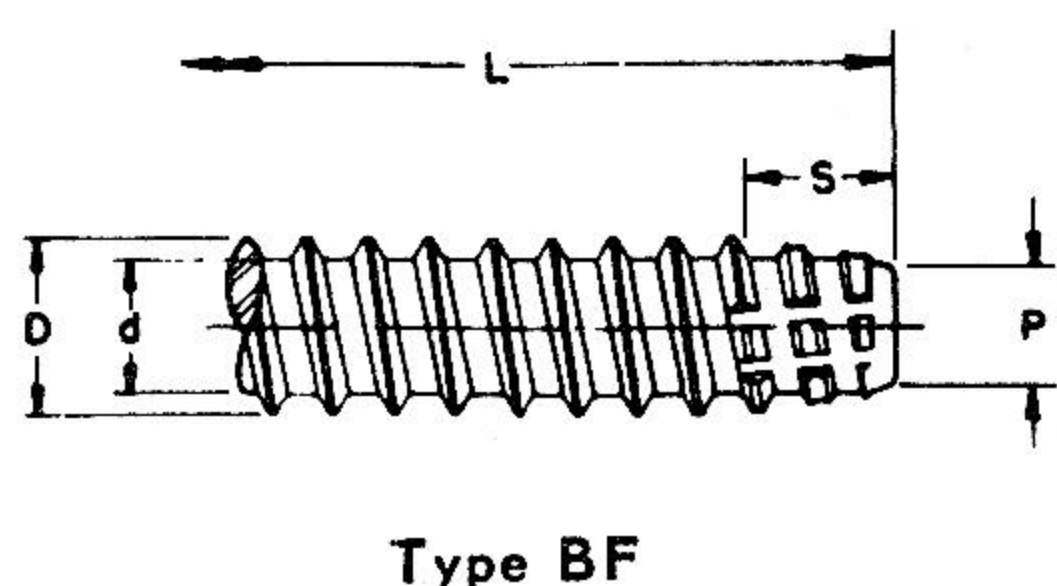
Screws having a thread length a of 8 pitches or less will have a taper length (s) of 2-1/2 to 3-1/2 times the pitch distance. Longer lengths will have a taper length (s) of 3-1/2 to 4-1/2 times the pitch distance.

Sizes and pitches listed in the above table are not necessarily stock sizes.

<sup>1</sup>Otherwise designated as type "D"

<sup>2</sup>Otherwise designated as type "T"

## TYPE BF TYPE 25



Type 25<sup>1</sup>

SIZE	THRDS. PER INCH	D			d		P**		Special Taper Length S for these lengths and under shall be 1-1/2 to 2 times the pitch of the thread	
		MAJOR DIA.			MINOR DIA.		POINT DIA.		90°	*C' sk
		BASIC	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.		
0	48	.060	.060	.057	.036	.033	.031	.027	5/64	1/8
1	42	.073	.075	.072	.049	.046	.044	.040	5/64	5/32
2	32	.086	.088	.084	.064	.060	.058	.054	7/64	3/16
3	28	.099	.101	.097	.075	.071	.068	.063	9/64	7/32
4	24	.112	.114	.110	.086	.082	.079	.074	3/16	1/4
5	20	.125	.130	.126	.094	.090	.087	.082	3/16	1/4
6	20	.138	.139	.135	.104	.099	.095	.089	1/4	5/16
7	19	.151	.154	.149	.115	.109	.105	.099	5/16	3/8
8	18	.164	.166	.161	.122	.116	.112	.106	5/16	7/16
10	16	.190	.189	.183	.141	.135	.130	.123	3/8	1/2
12	14	.216	.215	.209	.164	.157	.152	.145	7/16	9/16
1/4	14	.250	.246	.240	.192	.185	.179	.171	1/2	5/8
5/16	12	.3125	.315	.308	.244	.236	.230	.222	1/2	5/8

Maximum crest of thread (B) up to and including size 8 equals 0.004 inch; maximum crest of thread over size 8 equals 0.006 inch.

Tapered threads have unfinished crests.

Taper and Flutes: Screws shall be tapered and fluted as illustrated in cut. Details of taper and flute design shall be optional with manufacturer, provided they meet the performance requirements and the flutes extend through the first full thread.

Taper length (S) is 1-1/2 to 2 times the pitch of the thread.

Sizes and pitches listed in the table above right are not necessarily stock sizes.

\*Countersunk Heads these lengths and shorter shall be furnished with undercut heads.

\*\*These values are before roll threading.

<sup>1</sup>Otherwise designated as Type "BT".