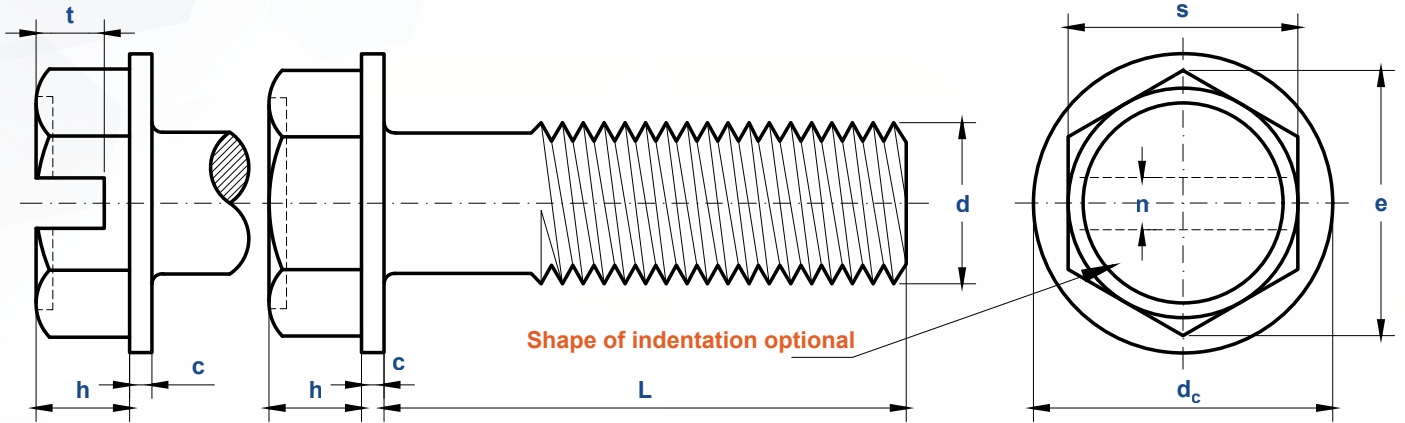




Thread Size d		2#	3#	4#	5#	6#	8#	10#	12#	1/4	5/16	3/8	7/16	1/2
d	Nominal Size	0.0860	0.0990	0.1120	0.1250	0.1380	0.1640	0.1900	0.2160	0.2500	0.3125	0.3750	0.4375	0.5000
PP		56	48	40	40	32	32	24	24	20	18	16	14	13
s	max	0.125	0.125	0.188	0.188	0.250	0.250	0.312	0.312	0.375	0.500	0.562	0.625	0.750
	min	0.120	0.120	0.181	0.181	0.244	0.244	0.305	0.305	0.367	0.489	0.551	0.610	0.735
e	min	0.134	0.134	0.202	0.202	0.272	0.272	0.340	0.340	0.409	0.545	0.614	0.682	0.820
h	max	0.050	0.055	0.060	0.070	0.093	0.110	0.120	0.155	0.190	0.230	0.295	0.348	0.400
	min	0.040	0.044	0.049	0.058	0.080	0.096	0.105	0.139	0.172	0.208	0.270	0.321	0.367
d_c	max	0.166	0.177	0.243	0.260	0.328	0.348	0.414	0.432	0.520	0.676	0.780	0.870	1.040
	min	0.154	0.163	0.225	0.240	0.302	0.322	0.384	0.398	0.480	0.624	0.720	0.790	0.960
c	max	0.016	0.016	0.019	0.025	0.025	0.031	0.031	0.039	0.050	0.055	0.063	0.073	0.085
	min	0.010	0.010	0.011	0.015	0.015	0.019	0.019	0.022	0.030	0.035	0.037	0.043	0.050
n	max	/	/	0.039	0.043	0.048	0.054	0.060	0.067	0.075	0.084	0.094	0.094	0.106
	min	/	/	0.031	0.035	0.039	0.045	0.050	0.056	0.064	0.072	0.081	0.081	0.091
t	max	/	/	0.042	0.049	0.053	0.074	0.080	0.103	0.111	0.134	0.168	0.175	0.195
	min	/	/	0.025	0.030	0.033	0.052	0.057	0.077	0.083	0.100	0.131	0.140	0.155

- ①. Machine Screw Length of Thread 1) Sizes No.5 and smaller. Screws of nominal lengths equal to three diameters and shorter shall have full-form threads extending to within one pitch (thread) of the bearing surface of the head, or closer, if practicable. Nominal lengths greater than three diameters, up to and including 1-1/8 in., shall have full-form threads extending to within two pitches (threads) of the bearing surface of the head, or closer, if practicable. Screws of longer nominal lengths shall, unless otherwise specified, have a minimum length of full-form thread of 1 in. 2) Sizes No.6 and smaller. Screws of nominal lengths equal to three diameters and shorter shall have full-form threads extending to within one pitch (thread) of the bearing surface of the head, or closer, if practicable. Nominal lengths greater than three diameters, up to and including 2 in., shall have full-form threads extending to within two pitches (threads) of the bearing surface of the head, or closer, if practicable. Screws of longer nominal lengths shall have a minimum length of full-form thread of 1.5 in. unless otherwise specified.
- ②. Unless otherwise specified by the purchaser, hex washer head screws are not slotted.
- ③. Fillet radius, R , at the edges and corners of the sides of the hex and the top of the washer shall not exceed 0.15 times the basic screw diameter.
- ④. Shape of indentation optional.
- ⑤. The diameter of the body on machine screws having other than trim heads shall not be less than the Class 2A thread minimum pitch diameter nor greater than the basic major diameter of the thread.
- ⑥. Slot depth beyond the bottom of the indentation shall not be less than one-third of the minimum slot depth specified.
- ⑦. A slight rounding of all edges and corners of the hex surfaces shall be permissible.
- ⑧. Dimensions across flats and across corners of the head shall be measured at the point of maximum metal. The taper of the sides of the hex (the angle between one side and the axis) shall not exceed 2 degrees or 0.004 in., whichever is greater, the specified width across flats being the large dimension.
- ⑨. The rounding due to lack of fill on all six corners of the head shall be reasonably uniform, and the width-across-corners of the head shall be such that when a sharp ring having an inside diameter equal to the specified minimum width-across-corners is placed on the top of the head, the hex portion of the head shall protrude by an amount equal to or greater than the F value tabulated. See Mandatory Appendix II for across corners gauging of hex heads.