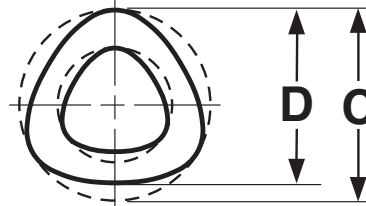
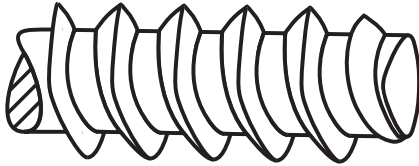


Self-Tapping Screws

Thread Rolling

Trilobular 48-2



TRILOBULAR 48-2 THREAD ROLLING SCREWS

Nominal Screw Size and Threads Per Inch	C		D		Minimum Out-Of-Round	Recommended Pilot Hole Sizes	
	Diameter of Circumscribing Circle		Measurements Across Center			Soft Ductile Materials	Brittle Materials
	Max	Min	Max	Min			
0 - 42	.0665	.0635	.0635	.0605	-	.048	.056
2 - 28	.092	.086	.089	.083	.002	.076	.080
3 - 24	.110	.104	.106	.100	.002	.088	.094
4 - 20	.127	.121	.123	.117	.002	.100	.106
5 - 20	.136	.132	.133	.129	.002	-	-
6 - 19	.147	.141	.143	.137	.003	.122	.128
7 - 18	.166	.160	.160	.154	.004	.134	.142
8 - 16	.185	.179	.179	.173	.004	.149	.158
10 - 14	.212	.206	.208	.202	.004	.175	.185
12 - 11	.232	.226	.226	.220	.005	.195	.205
1/4 - 10	.276	.270	.268	.262	.006	.224	.240
5/16 - 9	.345	.335	.335	.325	.006	.286	.303
Tolerance on Length	0 thru 1/4" diameters		Thru 3/4": ±.030"		Over 3/4": ±.050"		
	Over 1/4" diameter		± .050" (all lengths)				

Description	Trilobular thread-rolling screw with extra wide spacing between 48° profile threads; twin lead threads with a 1-2 thread point taper.	
Applications/ Advantages	Thermoplastics, engineering resins and certain thermosets. Sharper thread profile increases holding strength while reducing material displacement. Drive and strip torques are higher, reducing the need for inserts or reinforcing clips.	
Material	<i>Steel</i> AISI 1022 steel	<i>Stainless</i> 18-8: 18-8 stainless steel 410: 410 austenitic stainless steel
Heat Treatment	Screws shall be quenched in liquid and then tempered by reheating to 650°F minimum.	410: Screws shall be annealed by heating to 1850°-1950°F, held at least 1/2 hr & rapid air- or oil-quenched; then reheated to 525°F min. for at least 1 hr & air cooled to provide the required mechanical properties.
Case Hardness	Rockwell C45 minimum	-
Case Depth	No. 2 thru 6 diameters: .002 - .007 No. 8 thru 10 diameters: .004 - .009 1/4" & 5/16" diameters: .005 - .011	-
Core Hardness (after tempering)	Rockwell C28-38	18-8: Rockwell B90 - C20 410: Rockwell C34 - 42
Plating	Various finishes with wax coating (see Appendix-A)	Stainless thread rolling screws are supplied passivated & waxed.