



TAPPING SCREW PERFORMANCE SPECIFICATIONS

F.I.P. - 1000.1 THROUGH F.I.P. - 1000.7

SPECIFICATION F.I.P. - 1000.1

TYPE A
— INCH ONLY —



SIZE	DUCTILITY minimum degrees	MINIMUM TORSIONAL STRENGTH lb.-in.	TEST PLATES (FIP 70-85)		HYDROGEN EMBRITTLEMENT TORQUE lb.-in.
			Thickness ±.002	Hole Size ±.001	
2-32	10	4	.048	.076	SEE HYDROGEN EMBRITTLEMENT TEST
2-28	10	5	.048	.081	
3-24	10	12	.048	.086	
4-20	10	18	.048	.104	
5-16	10	25	.075	.118	
7-16	10	30	.075	.125	
8-16	10	36	.075	.136	
9-14	10	43	.075	.140	
10-12	10	48	.075	.150	
10-11	10	83	.125	.1875	
10-10	10	125	.125	.2100	
10-9	10	152	.125	.238	
10-8	10	190	.125	.261	
10-7	10	250	.125	.290	
10-6	10	482	.125	.3430	
Minimum Sample Size	8 pc	4 pc			13 pc

SPECIFICATION F.I.P. - 1000.2

TYPE AB, B, BT(25)
— INCH AND METRIC —



SIZE	DUCTILITY minimum degrees	MINIMUM TORSIONAL STRENGTH lb.-in.	TEST PLATES (FIP 70-85)		HYDROGEN EMBRITTLEMENT TORQUE lb.-in.
			Thickness ±.002 in"	Hole Size ±.001 in"	
2-32	10	4	.048	.076	SEE HYDROGEN EMBRITTLEMENT TEST
2-28	10	5	.048	.081	
3-24	10	12	.048	.086	
4-20	10	18	.048	.104	
5-16	10	25	.075	.118	
7-16	10	30	.075	.125	
8-16	10	36	.075	.136	
9-14	10	43	.075	.140	
10-12	10	48	.075	.150	
10-11	10	83	.125	.1875	
10-10	10	125	.125	.2100	
10-9	10	152	.125	.238	
10-8	10	190	.125	.261	
10-7	10	250	.125	.290	
10-6	10	482	.125	.3430	
Minimum Sample Size	8 pc	4 pc			13 pc

SPECIFICATION F.I.P. - 1000.3

TYPE F, AND T(23)
— INCH —



SIZE	DUCTILITY minimum degrees	MINIMUM TORSIONAL STRENGTH lb.-in.	TEST PLATES (FIP 70-85)		HYDROGEN EMBRITTLEMENT TORQUE lb.-in.	
			Thickness ±.002	Hole Size ±.001		
2-56	10	5	.079	.079	SEE HYDROGEN EMBRITTLEMENT TEST	
2-48	10	5	.094	.081		
3-40	10	13	.103	.086		
4-40	10	18	.109	.101		
5-32	10	25	.140	.125		
6-32	10	42	.140	.142		
10-24	10	36	.3975	.373		
10-32	10	74	.3975	.377		
10-24	10	328	.3975	.368		
10-20	10	140	.250	.238		
10-18	10	179	.250	.234		
10-16	10	306	.3125	.290		
10-14	10	375	.3125	.286		
Minimum Sample Size	8 pc	4 pc				13 pc

SPECIFICATION F.I.P. - 1000.4

TYPE F, AND T(23)
— METRIC —



SIZE	DUCTILITY minimum degrees	MINIMUM TORSIONAL STRENGTH lb.-in.	TEST PLATES (FIP 70-85)		HYDROGEN EMBRITTLEMENT TORQUE lb.-in.	
			Thickness ±.002 in"	Hole Size ±.001 in"		
M2 x .04	10	4	.079	.087	SEE HYDROGEN EMBRITTLEMENT TEST	
M3.5 x 0.45	10	10	.094	.083		
M5 x 0.5	10	18	.106	.102		
M3.5 x 0.6	10	27	.140	.132		
M4 x 0.7	10	41	.140	.136		
M5 x 0.8	10	63	.142	.137		
M6 x 1.0	10	142	.250	.210		
M8 x 1.25	10	354	.312	.291		
Minimum Sample Size	8 pc	4 pc				13 pc

SPECIFICATION F.I.P. - 1000.5

THREAD ROLLING SCREWS
— INCH —



SIZE	DUCTILITY min. degrees	MINIMUM TORSIONAL STRENGTH lb.-in.	TEST PLATES (FIP 70-85)		DRIVE TORQUE		HYDROGEN EMBRITTLEMENT TORQUE lb.-in.	
			Thickness ±.002	Hole Size ±.001	Phos & Oil Cad	Zinc		
2-32	10	6	.125	.075	4.3	6	SEE HYDROGEN EMBRITTLEMENT TEST	
3-48	10	10	.125	.087	7.3	9.3		
4-40	10	14	.125	.098	9	13		
5-40	10	22	.125	.110	12	16		
6-32	10	34	.125	.120	14	20		
8-32	10	48	.1675	.147	25	32		
10-24	10	66	.1675	.156	36	52		
10-32	10	74	.1675	.172	39	52		
10-20	10	190	.250	.219	90	120		
10-18	10	230	.277	.240	240	240		
10-16	10	300	.275	.240	240	300		
Minimum Sample Size	8 pc	4 pc			4 pc	4 pc		13 pc

SPECIFICATION F.I.P. - 1000.6

THREAD ROLLING SCREWS
— METRIC —



SIZE	DUCTILITY min. degrees	MINIMUM TORSIONAL STRENGTH lb.-in.	TEST PLATES (FIP 70-85)		DRIVE TORQUE		HYDROGEN EMBRITTLEMENT TORQUE lb.-in.	
			Thickness ±.002 in"	Hole Size ±.001 in"	Phos & Oil Cad	Zinc		
M2 x 0.4	10	6	.125	.070	4	6	SEE HYDROGEN EMBRITTLEMENT TEST	
M3 x 0.45	10	11	.125	.086	7	9		
M3.5 x 0.5	10	19	.125	.106	11	15		
M5 x 0.6	10	31	.125	.134	17	21		
M4 x 0.7	10	46	.2037	.142	22	22		
M5 x 0.8	10	83	.207	.179	42	53		
M6 x 1.0	10	157	.250	.2125	66	81		
M8 x 1.25	10	380	.25	.2875	142	177		
M10 x 1.5	10	770	.384	.362	242	310		
Minimum Sample Size	8 pc	4 pc			4 pc	4 pc		13 pc

SPECIFICATION F.I.P. - 1000.7

SELF DRILLING SCREWS



SIZE	DUCTILITY minimum degrees	TORSIONAL STRENGTH lb.-in.	HYDROGEN EMBRITTLEMENT			
			TEST PLATE (FIP 60-85) Thickness ±.002 in"	TORQUE minimum lb.-in.		
2-32	10	14	Style 2	Style 3	SEE HYDROGEN EMBRITTLEMENT TEST	
3-20	10	24	200	110		
4-16	10	42	200	142		
5-16	10	61	172	173		
10-14	10	92	142	200		
10-14	10	170	173	209		
Minimum Sample Size	8 pc	4 pc				13 pc

SIZE	TEST PLATE (FIP 60-85) Thickness ±.002 in"	DRILL SPEED RPM	AXIAL LOAD			DRILL/DRIVE TIME max. sec.
			A	B	C	
4-34	M2.8 x 1.38	.062	2000	25	30	4.0
6-30	M3.5 x 1.27	.062	2000	30	35	4.5
8-18	M4.2 x 1.41	.062	2000	35	45	5.0
10-16	M4.8 x 1.58	.062	2000	35	40	5.0
10-14	M5.5 x 1.81	.062	1800	45	50	6.0
10-14	M6.3 x 2.12	.062	1800	45	50	6.0
Minimum Recommended Sample Size						See Note 2

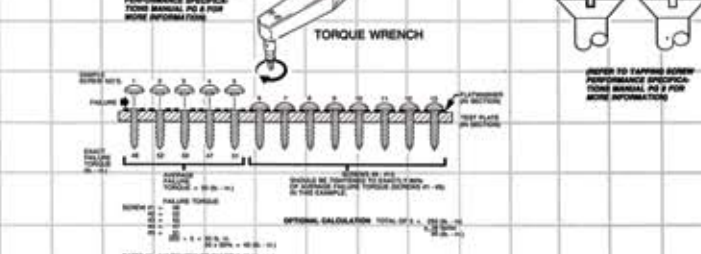
NOTES:
1. Flare Classifications:
A. Flaring thickness up to 2000 thickness.
B. Flaring thickness over 2000 thickness.
C. Chrome plated parts.

2. Sample Size:
A. Lat Size Sample Size Acceptable Deviation
0.010 6 0 0
0.015 12 0 0
0.020 24 0 0
0.030 and over 36 0 0

B. If any parts exceed drill time double sample size and drill time
Sample Size Slow Drill Excessive Drill
24 1 0
36 2 0
36 3 1
36 3 1

*"Slow Drill" is time in excess of the minimum of drill time but less than twice the minimum.
*"Excessive Drill" is time in excess of minimum drill time but more than twice the minimum.

REFER TO TAPPING SCREW PERFORMANCE SPECIFICATION MANUAL, PG 4 FOR MORE INFORMATION



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