

# A Better Way to Fasten Sheet Metal.

## STAMPING SUPERIOR THREAD FORMS



### A Better Way to Fasten Sheet Metal

Thread forms provide a fast, cost-effective way to hold sheet metal finishing screws in place. Using a thread form tool, a helical spiral is created that accepts the thread pitch of a given sheet metal screw. The screw holds firmly due to the metal tension in the thread form. Unlike lock nuts and other threading methods, there are no extra parts or additional assembly time required.

Thread form tools from Wilson Tool offer a better fit and more features, resulting in a superior end product.

- Holding finishing screws firmly in place
- Custom built tools for a perfect fit
- Custom designs available for non-standard threads
- Test run for flawless stamping
- Coin and form in one hit \*
- Pierce and form in one hit \*\*
- Long lasting M2 steel standard on headed punches
- Extra tough M4 steel standard on ball lock punches

For more information on thread forms,  
call 800-944-4671



\*When sheet metal is too thick for the pitch of the screw thread, a coining operation may solve the problem by thinning the sheet. Wilson Tool's innovative tooling allows you to coin and form in just one step.

\*\* Wilson Tool Impax Tooling Solutions® tools can pierce the hole and create the thread form in a single hit, simplifying die design, reducing labor costs and shortening lead times. One-hit thread form tools are available in many thread types, but not for materials in which coining is required. (A special pre-punch is required when forming stainless steel.)

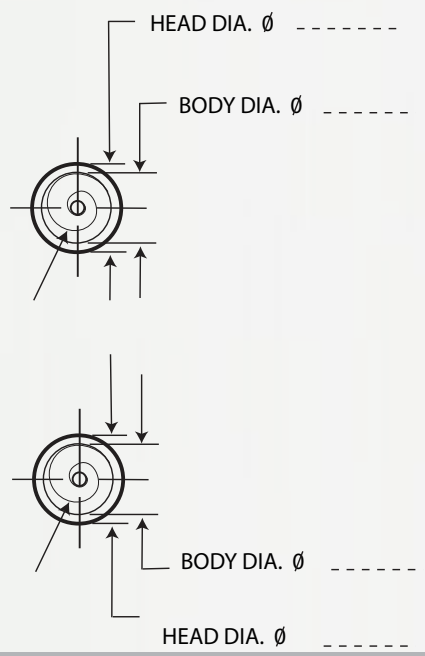
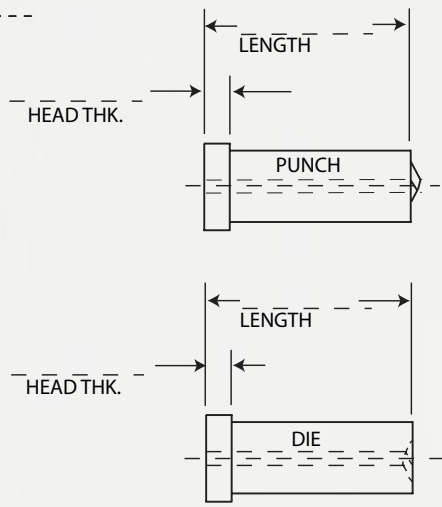
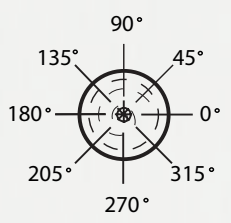


**Strength. Performance. Innovation.**



## Thread Forms dimension requirements

KEY TYPE = -----  
 KEY LOCATION = -----  
 M DIM. = -----



THREAD FORM DATA CHART

Thread Size	Metric Equivalent	Min. Punch Dia for given thread form
1/4 - 14	6.3 X 1.8 MM	0.6250
1/4 - 20		0.6250
3/16 - 24		0.4375
5/16 - 12	8 x 2.1MM	0.7500
5/16 - 18		0.7500
3/8 - 16	10 X 1.5MM	0.7500
4 - 40		0.3750
6 - 18		0.3750
6 - 20	3.5 X 1.3MM	0.3750
6 - 32		0.4375
7 - 16		0.4375
8 - 15		0.4375
8 - 18	3.9 X 1.4MM	0.4375
8 - 32		0.4375
10 - 12		0.5000
10 - 16	4.8 X 1.6MM	0.4375
10 - 24		0.4375
10 - 32	5.0 X 0.8MM	0.4375
12 - 11		0.6250
12 - 14	5.5 X 1.8MM	0.6250
12 - 24		0.6250
14 - 10		0.6250

### Be prepared to provide the following information when ordering:

- Material Type & Thickness
- Thread Size
- Punch and Die Requirements per above drawing

*Three years ago, we switched to Impax thread form tools for our heating products. Their custom design concept provides a tight fit that doesn't strip out under high torque levels. Impax thread forms not only make assembly faster, they also smooth product repairs, fitting perfectly for easier screwing and unscrewing. I've researched the market and Impax offers the best option available for thread forms today.*

*- Don Zimmer, Manager of Tool Engineering  
 Lennox International®*



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