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XYZ XPANSION™ THREADED PINS

PART NUMBER	EXTERNAL THREAD	MAX TORQUE*	TAPERED SCREW	REPLACEMENT TAPERED SCREW P/N	MAX TORQUE	CONTACT FORCE	VERTICAL PULL OFF FORCE
31850	1/2/2013	25 Ft/Lbs	1/4-20 X 1 1/4"	31010	13.3 Ft/Lbs	1,900 Lbs	750 Lbs
38850	M12 X 1.75	33 Nm	M6-1.0 X 30mm	38010	17.00 Nm	8,455 N	3336 N
31860	5/8/2011	50 Ft/Lbs	5/16-18 X 1/4"	31020	27.6 Ft/Lbs	2,500 Lbs	900 Lbs
38860	M16 X 2.0	68 Nm	M8 X 1.25 X 30mm	38020	34 Nm	11,125 N	4003 N

* Threaded XYZ Xpansion Pin Installation Max Torque is limited by Taper Seat bearing area at end of thread.
If there is a concern of XYZ Pin loosening in the fixture, we suggest the use of a medium strength anaerobic thread locking compound such as Loctite® Blue Threadlocker #243® or equivalent.

XYZ XPANSION™ PRESS FIT PINS

17-4 PH (SST) P/N	12L14 (MS) P/N	REPLACEMENT TAPERED SCREW	REPLACEMENT TAPERED SCREW P/N	MAX TORQUE	CONTACT FORCE	PULL OFF FORCE
31730	31630	5-40 X 5/8"	31731S	1.6 Ft/Lbs	425 Lbs	250 Lbs
38730	38630	M3-0.5 X 16mm	38731S	2.80 Nm	1,900 N	1112 N
31740	31640	8-32 X 7/8"	31002S	3.6 Ft/Lbs	950 Lbs	450 Lbs
38740	38640	M4-0.7 X 22mm	38002S	5.00 Nm	4,228 N	2001 N
31750	31650	1/4-20 X 7/8"	31010S	13.3 Ft/Lbs	1,900 Lbs	750 Lbs
38750	38650	M6-1.0 X 22mm	38010S	17.00 Nm	8,455 N	3336 N
31760	31660	5/16-18 X 7/8"	31020S	27.6 Ft/Lbs	2,500 Lbs	900 Lbs.
38760	38660	M8-1.25 X 22mm	38020S	34.00 Nm	11,125 N	4003 N
N/A	31670	3/8-16 X 7	31032S	49.3 Ft/Lbs	4,500 Lbs	1,650 Lbs
N/A	38670	M10 X 22mm	38032S	60.00 Nm	20,025 N	7,500 N

Notes on Tapered Screws:

- Tapered Screws use an anti-friction coating, so less torque produces greater tension and force.
- Typically, Tapered Screws fail either by the Hex Head expanding and stripping, or by thread failure.
- Torque at failure for one time use is typically from over torquing the screw 60% to 100%. For example, a ¼-20 Taper Screw will typically fail at 22-25 Lbs/Ft.
- Pull Off Force Values are based on the typical surface finish of a drilled hole. The Pull Off Force Value for smooth, burnished holes is reduced approximately 50%.