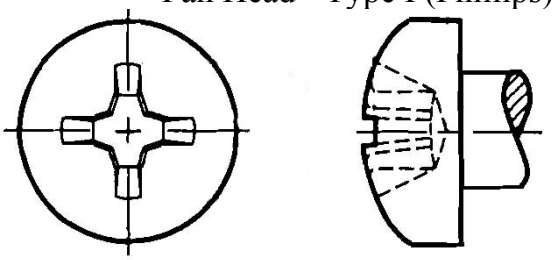
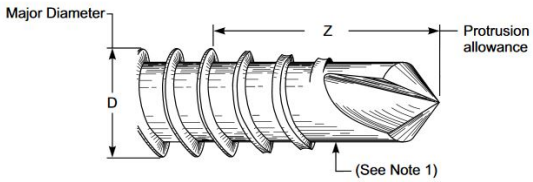
Pan Head - Type I (Phillips) - Self-drilling Screw - Type BSD, Style 3 Point





Typical Self-Drilling Tapping Screw Point

THREAD DATA		
Size: #10	**Threads per in.:** 16	**Thread Class or Type:** BSD
Major Diameter: 0.1890 - 0.1820	**Standard:** ASME B18.6.3-2013	
DIMENSIONAL DATA		
Type: Pan Head - Type I (Phillips) - Self-drilling Screw - Type BSD, Style 3 Point	**Standard:** IFI - 113	**Nominal Diameter:** 0.19
A - Head Diameter: 0.373 - 0.357	**H - Head Height:** 0.133 - 0.122	**Driver Size:** 2
Penetration Depth: 0.113 - 0.089	**Wobble:** 12º	**M – Ref. Recess Dim.:** 0.192
Z - Min. Point Protrusion: 0.300	**L - Minimum Practical Length:** 1/2	**L - Length:** 1-1/2
Length Tolerance: ± 0.05		
PHYSICAL REQUIREMENTS		
Nominal: 0.19	**Standard:** IFI - 113/SAE J78 / ASTM C1513	**Typical Materials:** carbon steel: 1018-1022
Test Plate Thickness in.: 0.060 - 0.064	**Torsional Strength, Min. (in.lbf):** 61	**Core Hardness:** HRC 32 - 40
Case Hardness: HRC 52 - 58	**Case Depth (in.):** .009-.004	**Ductility Test Angle:** 5˚
Axial Test Load +/- 5% (0.0003 in. max. finish): 35	**Axial Test Load +/- 5% (over 0.0003 in. finish):** 40	**Max. time to drill & form thread (seconds):** 3.5
Test Drill Speed (RPM): 1800 - 2500	**Straightness Factor:** N/A	
FINISH DATA		
Finish: Zinc & Clear, non-hexavalent/Cr(VI) free - .0001"/ 3µm	**K factor (ref. DIN 946):** 0.22	**Standard:** ASTM F1941/F1941M-2016, Fe/Zn 3AN

[1] These torque values are based on K factors determined using DIN 946, tightening tension of 75% of the yield strength, and the calculation formula T=KDP. These values are advisory only. The torque for assembling critical joints should be determined and/or verified through actual experimentation by the user. The IFI is not responsible for any losses or claims resulting from the use of these values.[2] Calculated Pretension is equal to 75% of the bolt's yield strength achieved when using the indicated Tightening Torque.

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