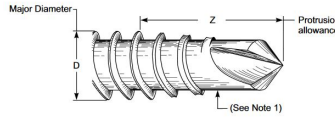
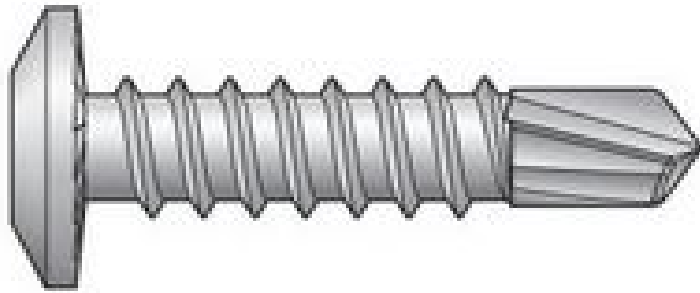


# Truss Head - Type I (Phillips) - Lath Screw - Drill Point



Typical Self-Drilling Tapping Screw Point

## GRADE MARK

THREAD DATA		
<b>Size: #8</b>	<b>Threads per in.: 18</b>	<b>Series Designation: Single Lead</b>
<b>Thread Class or Type: DWDS</b>	<b>Major Diameter: 0.1660 - 0.1610</b>	<b>Standard: ASME B18.6.3-2013</b>
DIMENSIONAL DATA		
<b>Type: Truss Head - Type I (Phillips) - Lath Screw - Drill Point</b>	<b>Standard: IFI - 113 (DWS, Drill Point)</b>	<b>Nominal Diameter: 0.164</b>
<b>A - Head Diameter: 0.275 ref.</b>	<b>R - Fillet Radius: 0.06 min.</b>	<b>H - Head Height: 0.433 - 0.414</b>
<b>Point Type: Drill Point</b>	<b>Driver Size: 2</b>	<b>Penetration Depth: 0.075 - 0.095</b>
<b>Wobble: 0°</b>	<b>U - Washer Thickness: 0.047 ref.</b>	<b>L - Length: 3/4</b>
<b>Length Tolerance: -0.03</b>		
PHYSICAL REQUIREMENTS		
<b>Nominal: 0.164</b>	<b>Standard: IFI - 113/SAE J78 / ASTM C1513</b>	<b>Typical Materials: carbon steel: 1018-1022</b>
<b>Test Plate Thickness in.: 0.060 - 0.064</b>	<b>Torsional Strength, Min. (in.lbf): 42</b>	<b>Core Hardness: HRC 32 - 40</b>
<b>Case Hardness: HRC 52 - 58</b>	<b>Case Depth (in.): .009-.004</b>	<b>Ductility Test Angle: 5°</b>
<b>Axial Test Load +/- 5% (0.0003 in. max. finish): 30</b>	<b>Axial Test Load +/- 5% (over 0.0003 in. finish): 35</b>	<b>Max. time to drill &amp; form thread (seconds): 3</b>
<b>Test Drill Speed (RPM): 1800 - 2500</b>	<b>Straightness Factor: N/A</b>	
FINISH DATA		
<b>Finish: Zinc &amp; Clear, non-hexavalent/Cr(VI) free - .0001"/ 3µm</b>	<b>K factor (ref. DIN 946): 0.22</b>	<b>Standard: ASTM F1941/F1941M-2016, Fe/Zn 3AN</b>

<sup>1</sup> 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. <sup>2</sup> Calculated Pretension is equal to 75% of the bolt's yield strength achieved when using the indicated Tightening Torque.

