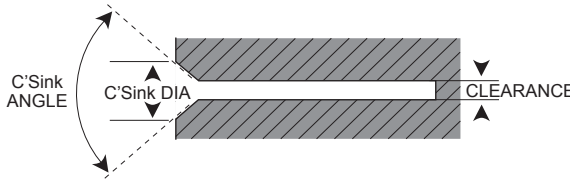
NOTE: All recommendations are considered as starting parameters only

SUN PRO CARBIDE

Countersinks

Material	SFM
Aluminum Alloys	300-500
Brass/Bronze	150-250
Cast Iron	125-225
Malleable Iron	90-150
Magnesium	250-400
Inconel/Monel	50-75
Plastic	250-400
Steel (Annealed)	50-80
Steel (Mild)	80-170
Steel (Rc 18-24)	40-60
Steel (Rc 25-37)	35-55
Stainless Steel (Free Machining)	80-125
Stainless Steel (Other)	50-75
Titanium	60-90



SCREW SIZE	SCREW HEAD DIAMETER	SCREW HEAD HEIGHT	C'SINK SIZE	CLEARANCE CLOSE	CLEARANCE FREE
#2 (0.086″)	0.168”	0.064”	3/16 (0.214″)	3/32 (0.094”)	# 36 (0.106”)
#4 (0.112″)	0.218”	0.083”	1/4 (0.272″)	1/8 (0.125”)	# 29 (0.136”)
#6 (0.138″)	0.263”	0.097”	5/16 (0.324″)	# 23 (0.154”)	# 18 (0.170”)
#8 (0.164″)	0.311”	0.112”	3/8 (0.376″)	#15 (0.180”)	# 9 (0.196”)
#10 (0.190″)	0.359”	0.127”	3/8 (0.428″)	# 5 (0.206”)	# 2 (0.221”)
1/4 (0.250″)	0.480”	0.161”	1/2 (0.548″)	17/64 (0.266”)	9/32 (0.281”)
5/16 (0.313″)	0.600”	0.198”	5/8 (0.673″)	21/64 (0.328”)	11/32 (0.344”)
3/8 (0.375″)	0.720”	0.234”	3/4 (0.798″)	25/64 (0.391”)	13/32 (0.406”)
7/16 (0.438″)	0.781”	0.234”	7/8 (0.861″)	29/64 (0.453”)	15/32 (0.469”)
1/2 (0.500″)	0.872”	0.251”	1 (1.000″)	33/64 (0.516”)	17/32 (0.531”)
5/8 (0.625″)	1.112”	0.324”	1-1/4 (1.250″)	41/64 (0.641”)	21/32 (0.656”)
3/4 (0.750″)	1.355”	0.396”	1-1/2 (1.500″)	49/64 (0.766”)	25/32 (0.781”)
7/8 (0.875″)	1.604”	0.468”	1-3/4 (1.750″)	57/64 (0.891”)	29/32 (0.906”)
1 (1.000″)	1.841”	0.540”	2 (2.000″)	1-1/64 (1.016”)	1-1/32 (1.031”)

- Countersink diameters are based on the theoretical maximum head diameter at a depth of .005 to .015 & an angle of 82°
- Actual depth may vary depending on actual head diameter and angle.
- Free should be used unless close is required