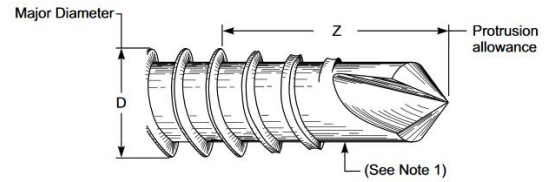
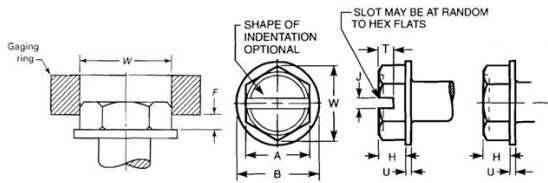


Hex Washer Head - Unslotted and Sltd - Self-drilling Screw - Type BSD, Style 3 Point



Typical Self-Drilling Tapping Screw Point

| THREAD DATA | | |
|---|--|--|
| Size: 1/4 | Threads per in.: 14 | Thread Class or Type: BSD |
| Major Diameter: 0.2460 - 0.2370 | Standard: ASME B18.6.3-2013 | |
| DIMENSIONAL DATA | | |
| Type: Hex Washer Head - Unslotted and Sltd - Self-drilling Screw - Type BSD, Style 3 Point | Standard: IFI - 113 | Nominal Diameter: 0.25 |
| H - Head Height: 0.190 - 0.172 | J - Slot Width: 0.075 - 0.064 | T - Slot Depth: 0.111 - 0.083 |
| F - Protrusion Height: 0.103 Min | G - Gage Diameter: 0.409 | A - Hex AF: 0.375 - 0.367 |
| W - Hex AC: 0.409 Min | B - Washer Diameter: 0.520 - 0.480 | U - Washer Thickness: 0.050 - 0.030 |
| Z - Min. Point Protrusion: 0.393 | L - Minimum Practical Length: 1/2 | L - Length: 1-1/2 |
| Length Tolerance: ± 0.05 | | |
| PHYSICAL REQUIREMENTS | | |
| Nominal: 0.25 | 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): 150 | Core Hardness: HRC 32 - 40 |
| Case Hardness: HRC 52 - 58 | Case Depth (in.): .011-.005 | Ductility Test Angle: 5° |
| Axial Test Load +/- 5% (0.0003 in. max. finish): 45 | Axial Test Load +/- 5% (over 0.0003 in. finish): 50 | Max. time to drill & form thread (seconds): 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.

