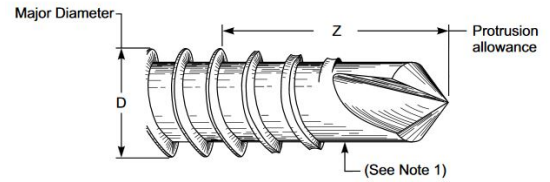
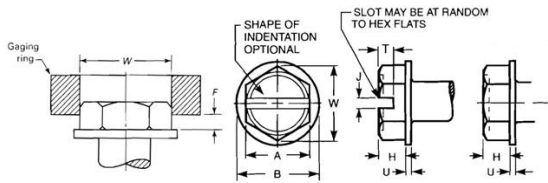


Hex Washer Head - Unslotted and Sltd - Self-drilling Screw - Type BSD, Style 3 Point



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: 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: 0.012	
FINISH DATA		
Finish: Zinc & Clear, non-hexavalent/Cr(VI) free - .0001" / 3 μ m	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.

