Hex Washer Head - Unslotted and Sltd - Self-drilling Screw - Type BSD, Style 2 Point
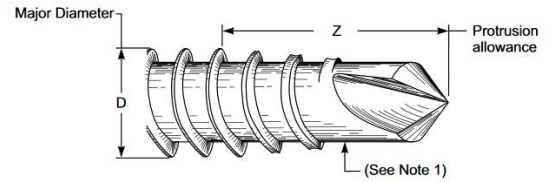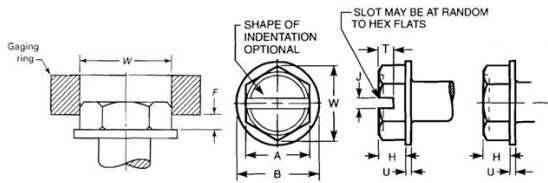

Typical Self-Drilling Tapping Screw Point

THREAD DATA		
Size: #6	**Threads per in.:** 20	**Thread Class or Type:** BSD
Major Diameter: 0.1390 - 0.1320	**Standard:** ASME B18.6.3-2013	

DIMENSIONAL DATA		
Type: Hex Washer Head - Unslotted and Sltd - Self-drilling Screw - Type BSD, Style 2 Point	**Standard:** IFI - 113	**Nominal Diameter:** 0.138
H - Head Height: 0.093 - 0.080	**J - Slot Width:** 0.048 - 0.039	**T - Slot Depth:** 0.053 - 0.033
F - Protrusion Height: 0.048 Min	**G - Gage Diameter:** 0.272	**A - Hex AF:** 0.250 - 0.244
W - Hex AC: 0.272 Min	**B - Washer Diameter:** 0.328 - 0.302	**U - Washer Thickness:** 0.025 - 0.015
Z - Min. Point Protrusion: 0.190	**L - Minimum Practical Length:** 5/16	**L - Length:** 3/4
Length Tolerance: ± 0.03		

PHYSICAL REQUIREMENTS		
Nominal: 0.138	**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):** 24	**Core Hardness:** HRC 32 - 40
Case Hardness: HRC 52 - 58	**Case Depth (in.):** .007-.002	**Ductility Test Angle:** 5˚
Axial Test Load +/- 5% (0.0003 in. max. finish): 30	**Axial Test Load +/- 5% (over 0.0003 in. finish):** 35	**Max. time to drill & form thread (seconds):** 2.5
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.