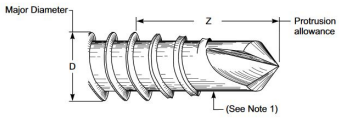
Bugle Head - Type I (Phillips) - Drywall Screws - Drill Point - Fine Thread





Typical Self-Drilling Tapping Screw Point

GRADE MARK

THREAD DATA		
Size: #6	**Threads per in.:** 20	**Series Designation:** Single Lead
Thread Class or Type: DWDS	**Major Diameter:** 0.1390 - 0.1350	**Standard:** ASME B18.6.3-2013
DIMENSIONAL DATA		
Type: Bugle Head - Type I (Phillips) - Drywall Screws - Drill Point - Fine Thread	**Standard:** IFI - 113 (DWS, Drill Point)	**Nominal Diameter:** 0.138
A - Head Diameter: .347 - .315	**R - Fillet Radius:** .256 - .160	**Point Type:** Drill Point
Driver Size: 2	**Penetration Depth:** 0.116 - 0.093	**Wobble:** 0º
K - Flange Thickness: 0.020 - 0.031	**Z - Ref. Point Protrusion:** 0.190	**L - Length:** 1-1/4
Length Tolerance: -0.05		
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: Black Phosphate on carbon steel	**K factor (ref. DIN 946):** 0.2	**Standard:** MIL-DTL-13924D (Classes 1, 2, &3)

[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.

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