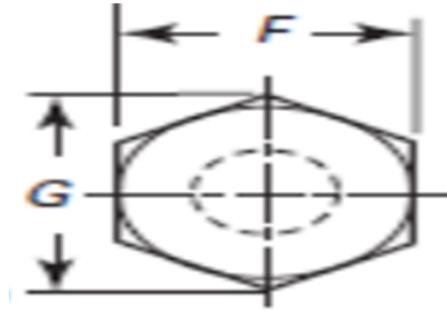
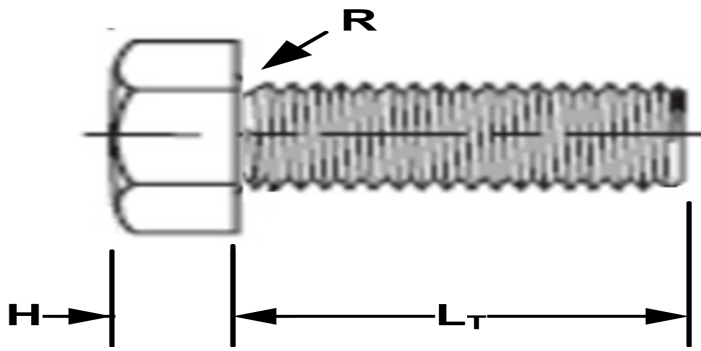


# Hex Tap Bolts



**F 468K**

GRADE MARK

THREAD DATA		
Size: 1/4	Threads per in.: 20	Series Designation: UNC
Thread Class or Type: 2A	Major Diameter: 0.2489 - 0.2408	Pitch and Functional Dia.: 0.2164 - 0.2127
Tensile Stress Area: 0.0318	Standard: ASME B1.1 - 2003 (R2008)	
DIMENSIONAL DATA		
Type: Hex Tap Bolts	Standard: IFI - 199	Nominal Diameter: 0.25
F - Width Across Flats: 0.438 - 0.425	G - Width Across Corners: 0.505 - 0.484	R - Fillet Radius: 0.030 - 0.010
H - Head Height: 0.188 - 0.150	L <sub>T</sub> - Thread Length for Screw Length 6 in. or less: Fully Threaded	Point Type: Non-pointed
L - Length: 1	Length Tolerance: +0.02/-0.03	
PHYSICAL REQUIREMENTS		
Nominal: 0.25	Standard: ASTM F468-2013, Silicon Bronze	Typical Materials: Cu 651
Hardness: HRB 95 - 75	Tensile Load, Min. (lbf): 2226	Yield PSI, 2% Offset, Machined Specimen: 55,000
Tensile Strength, Min. (psi): 70,000	Tensile Strength, Max. (psi): 100,000	Calculated Shear Load-BODY (ref.)(lbf): 1,336
Calculated Shear Load-THREADS (ref.)(lbf): 1,113	Straightness Factor: N/A	Calculated Pretension <sup>2</sup> (lbf) : 1,312
Tightening Torque <sup>1</sup> : 5 ft.lbf, 66 in.lbf, 7.4 Nm		
FINISH DATA		
Finish: As received steel	K factor (ref. DIN 946): 0.2	

<sup>1</sup> 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.<sup>2</sup> Calculated Pretension is equal to 75% of the bolt's yield strength achieved when using the indicated Tightening Torque.

