



BUILDING FASTENERS

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TECHNICAL BULLETIN 400 SERIES STAINLESS FASTENERS

TYPE OF FASTENER

A, AB, B Number 14 Diameter.

TYPE OF MATERIAL

Fasteners are to be made from a good quality heading wire in the 400 Series. Screws to be heat treated after cold forming to produce a Rockwell Hardness of C-38 minimum.

TYPE OF PLATING

Screws are bright hardened and cleaned.
Other finishes available upon request.

TOOL SELECTION

An electric screwgun with a variable speed of 0 - 2000 RPM incorporating a clutch or depth setting feature is the suggested tool. Impact type guns are not recommended.

RECOMMENDED USAGE

Type B to be used for sheet to structure. Type AB to be used for sheet to light gauge purlins or laps. Type A lap

PERFORMANCE TESTS

Test Results	Strength of Fasteners	
	1/4" Type B	#14 Type A & AB
Minimum tensile strength	3,500 lbs.	3,150 lbs.
Minimum shear strength	2,580 lbs.	2,400 lbs.
Minimum torsion strength	150 inch lbs.	140 inch lbs.

(These are conservative values)

Test Results	Pull Out Tests					
	Thickness of Steel	Hardness of Steel Rockwell B	Drilled Hole Size	Average Pull Out Values in lbs.		
				1/4" Type B	#14 Type AB	#14 Type A
20 gauge	50	3/16"				505
18 gauge	60	3/16"		855	650	682
16 gauge	64	#8		1090	1150	990
14 gauge	64	#8		1325	1460	1505
12 gauge	64	#7		2480	1777	
1/4" gauge	60	#1		4490		
1/2" gauge	62	#1		4915		

Test Results	Pull Over Tests				
	Thickness of Steel	Hardness of Steel Rockwell B	Drilled Hole Size	Washer Diameter	Average Pull Over in lbs.
20 gauge	56	3/16"		15mm Stainless	1485
22 gauge	52	3/16"		15mm Stainless	1273
24 gauge	50	3/16"		15mm Stainless	906
26 gauge	49	1/8"		15mm Stainless	644

The test results shown are believed to be reliable. However, variances in testing and actual field conditions may alter the results. There is no expressed or implied warranty on the test data.