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TECHNICAL BULLETIN

410 STAINLESS

SELF-DRILLING FASTENERS

TYPE OF FASTENER

Self-drilling #8, #10, #12 & #14 diameters with #2, #3 and #5 points.

TYPE OF MATERIAL

Fasteners are to be made from a good quality cold heading wire of 410 Stainless designation. 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

Fastener to be used for sheet to sheet to structural applications.

PERFORMANCE TESTS

Test Results	Strength of Fastener			
	#8	#10	#12	#14
Minimum tensile strength	1650 lbs.	2050 lbs.	2900 lbs.	4050 lbs.
lbs. Minimum shear strength	880 lbs.	1400 lbs.	2125 lbs.	2580 lbs.
Minimum torsional strength	48 inch lbs	75 inch lbs.	120 inch lbs.	155 inch lbs.

(These are conservative values)

Test Results	Pull Out Tests				
	Thickness of Steel	Hardness of Steel Rockwell	Average Pull Out Values in lbs.		
#8			#10	#12	#14
To determine the tension required to remove properly drilled screws out of steel member.					
20 gauge	50	280	300	390	460
18 gauge	60	440	440	583	685
16 gauge	64	590	560	748	890
14 gauge	64	780	780	1001	1220
12 gauge	64	1090	1295	1610	
3/16" gauge	60		2610	3335	

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.