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TECHNICAL BULLETIN

PLATED STEEL

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 1022 designation. Screws to be heat treated after cold forming to produce a Rockwell Hardness of C-38 minimum.

TYPE OF PLATING

Mechanical plating .0005 zinc minimum and clear chromate finish.
 Alternate: electro zinc .0004 and clear chromate finish.

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	1710 lbs.	2150 lbs.	2925 lbs.	4050 lbs.
Minimum shear strength	930 lbs.	1420 lbs.	2125 lbs.	2825 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
20 gauge	50		285	300	390	450
18 gauge	60		430	440	583	665
16 gauge	64		590	550	746	890
14 gauge	64		760	780	1001	1200
12 gauge	64			1090	1286	1610
3/16" gauge	60				2678	3466

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.