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TECHNICAL BULLETIN

PLATED STEEL

SELF-DRILLING MINI POINT

TYPE OF FASTENER

Self-drilling mini point # 14 diameter with # 1 drill point.

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 or very light gage steel.

PERFORMANCE TESTS

Test Results	Strength of Fastener
Minimum tensile strength	3,750 lbs.
Minimum shear strength	2,400 lbs.
Minimum torsional strength.....	150 inch lbs.
(These are conservative values)	

Test Results	Pull Out Tests	
To determine the tension required to remove properly drilled screws out of steel member.		
Thickness of Steel	Hardness of Steel Rockwell	Average Pull Out Values in Lbs. #14
24 gauge	50	329
22 gauge	60	497
20 gauge	64	586
18 gauge	64	691

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.