

Dril-Flex® Structural Self-Drilling Fasteners

Offers virtual immunity to hydrogen-assisted stress corrosion cracking for maximum performance in the field

Dril-Flex fasteners are specially designed and processed to help prevent hydrogen-induced brittle failures. Each fastener undergoes the unique Flex Technology® dual-hardening process to ensure the optimal combination of ductility and hardness required for maximum performance in the field.

Testing of this product, in accordance with ASTM standards, has proven that Dril-Flex fasteners provide the same resistance to hydrogen-assisted cracking (HAC) as a Grade 5 fastener.

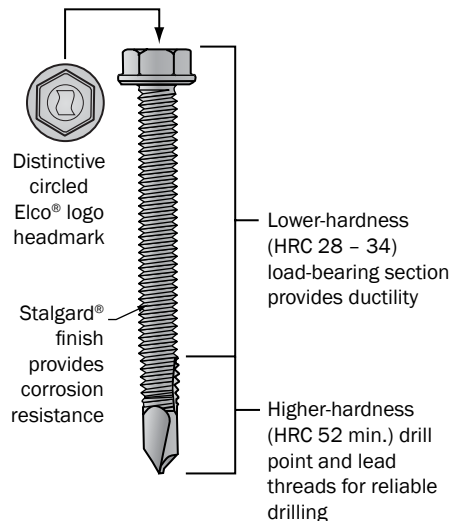
Unique Hardening and Finishing Processes Provide High Performance

Hydrogen-Assisted Stress Corrosion Cracking (HASCC) refers to a time-delayed failure that is aggravated or accelerated by hydrogen generated in the application. This is most often encountered and associated with dissimilar metal applications through the galvanic corrosion process. Most self-drilling fasteners, including 410 fasteners, are case or similarly hardened, which provides the necessary hardness for drilling and tapping, but leaves the screws vulnerable to HASCC due to their high surface or core hardness.

Dril-Flex fasteners offer the unique Flex Technology dual-hardening process. The self-drilling point and lead tapping threads are selectively hardened to a minimum of HRC 52. The load-bearing portion of the screw is held at or below the critical HRC 34 level. This reduced hardness level also meets SAE J429 Grade 5 and ASTM A449 strength and ductility standards.

Dril-Flex fasteners are then coated with silver Stalgard finish to provide superior corrosion resistance and enhanced galvanic compatibility. Fasteners coated with Stalgard finish typically show no red rust or other base metal corrosion on significant surfaces even after 1000 hours of 5% neutral salt spray exposure (ASTM B117).

The combination of this unique dual-hardening process and Stalgard finish results in a strong, reliable fastener that can be used where other self-drillers would fail. Dril-Flex self-drilling fasteners are the ideal fastening solution for demanding construction applications.



Features

- Self-drilling point
- Higher hardness (HRC 52 min.) point and lead threads
- Lower-hardness (HRC 28 - 34) load-bearing threads
- Silver Stalgard multi-layered corrosion resistant finish

Benefits

- Virtually immune to delayed HASCC brittle failures found with other hardened fasteners
- Provides the same high resistance to hydrogen-assisted failure as a Grade 5 fastener
- Precision self-drilling point ensures consistent, reliable drilling and tapping
- Eliminates separate drilling and tapping operations
- Corrosion resistance superior to zinc- or cadmium-based finishes
- Provides enhanced galvanic compatibility in dissimilar metal applications
- Approvals: ICC ES ER-4780 Legacy Report; COLA (City of Los Angeles) Research Report #25095

Product Information

Dril-Flex® Structural Self-Drilling Fasteners



Selection Guide

	Catalog No.	Description	Point	L Load-Bearing Area	Finish	Carton Qty.	Carton Weight
#10-16 With 5/16" Hex Washer Head							
	HFAF430	10-16 x 3/4"	#3	.500"	Stalgard	6,000	48
	HFAF460	10-16 x 1-1/2"	#3	1.00"	Stalgard	2,500	30
	HFAF470	10-16 x 2"	#3	1.50"	Stalgard	2,000	28
	HFAF480	10-16 x 2-1/2"	#3	1.83"	Stalgard	1,500	25
#10-16 With #2 Phillips Pan Head							
	HFDX445	10-16 x 3/4"	#2	.500"	Stalgard	6,000	36
#10-24 With #2 Phillips Wafer Head							
	HFBL530	10-24 x 1-1/4"	#3	.750"	Stalgard	5,000	44
#12-14 With 5/16" Hex Washer Head							
	HFAF621*	12-14 x 7/8"	#3	.470"	Stalgard	5,000	54
	HFAF641	12-14 x 1"	#3	.500"	Stalgard	4,000	44
	HFAF681	12-14 x 1-1/2"	#3	1.00"	Stalgard	2,500	38
	HFAF755	12-24 x 1-3/4"	#5	.800"	Stalgard	2,500	48
	HFAF690	12-14 x 2"	#3	1.50"	Stalgard	2,000	37
	HFAF715	12-14 x 3"	#3	2.50"	Stalgard	1,000	27
#12-14 With #3 Phillips Undercut Flat Head							
	HFBL215	12-14 x 1"	#3	.500"	Stalgard	4,000	36
	HFBL223	12-14 x 1-1/2"	#3	1.00"	Stalgard	2,500	26
1/4-14 With 3/8" Hex Washer Head							
	HFAF816	1/4-14 x 1"	#3	.450"	Stalgard	3,000	54
	HFAF841	1/4-14 x 1-1/2"	#3	.950"	Stalgard	2,000	45
	HFAF846	1/4-14 x 2"	#3	1.45"	Stalgard	1,500	41
1/4-20 With 3/8" Hex Washer Head							
	HFAF876	1/4-20 x 1-1/2"	#4	.830"	Stalgard	2,000	48
	HFAF886	1/4-20 x 2"	#4	1.33"	Stalgard	1,500	45
	HFAF865	1/4-20 x 1-1/8"	#4	.500"	Stalgard	2,500	51
	HFAF888	1/4-20 x 1-3/4"	#5	.800"	Stalgard	1,000	27
	HFAF890	1/4-20 x 2-1/2"	#4	1.830"	Stalgard	1,000	45
	HFAF900	1/4-20 x 3-3/8"	#4	2.70"	Stalgard	500	22
	HFAF910	1/4-20 x 4"	#4	3.50"	Stalgard	500	23
1/4-20 With #3 Phillips Undercut Flat Head							
	HFBL330	1/4-20 x 3"	#4	2.50"	Stalgard	500	20
	HFBL340	1/4-20 x 4"	#4	3.50"	Stalgard	500	23
5/16-18 With 3/8" Hex Washer Head							
	HFAF940	5/16-18 x 1-1/2"	#3	.850"	Stalgard	1,000	37
5/16-24 With 3/8" Hex Washer Head							
	HFAF960	5/16-24 x 1-1/2"	#4	.850"	Stalgard	1,000	40
	HFAF970	5/16-24 x 2"	#4	1.35"	Stalgard	1,000	49

* EAF621 is for aluminum applications ONLY.

Fasteners shown are in-stock. Other head styles, threads, lengths and drilling capabilities can be produced to meet specific application needs.

IMPORTANT: to ensure proper performance, only the load-bearing area should be engaged in the material being fastened.

COMPARISON TO STAINLESS STEEL FASTENERS

300 series stainless steel fasteners will not rust, and, because of their low hardness, they also provide high resistance to hydrogen embrittlement failures. However, because plain-finished stainless steel is galvanically incompatible with certain building materials – including steel and aluminum – it can cause other problems (see chart) when combined with these materials. Stainless steel fasteners trigger a sacrificial action in the aluminum or steel panel, which can lead to degradation of the panel and loosening of the fastener.

The dual-hardening process allows Dril-Flex® fasteners to provide high strength and resistance to hydrogen embrittlement failures. Their unique Stalgard® finish provides corrosion resistance several times greater than other commonly-used finishes. Fasteners coated with Stalgard finish typically show no red rust or other base metal corrosion on significant surfaces even after 1000 hours of 5% neutral salt spray exposure (ASTM B117).

If the environment is corrosive enough to significantly affect the Stalgard finish, the potential for significant degradation of the aluminum/stainless steel assembly would also exist.

Galvanic Series

Anodic End	
Metal/Alloy	EMF (v)
Magnesium.....	-1.60
Zinc.....	-1.10
Alum (5000, 6000, 7000).....	-.75
Iron, Low Alloy Steels.....	-.70
Alum (2000).....	-.60
Lead.....	-.55
18% Chromium Steel.....	-.35
Naval Brass.....	-.30
Brass, Bronze.....	-.25
Austenitic Stainless (300 Series)....	-.20
Nickel.....	-.15
Silver.....	0
Gold.....	+15
Cathodic End	

In the presence of moisture, materials higher on the list will be sacrificial to materials lower on the list. The greater the EMF differential, the greater the sacrificial action of the anode to the cathode in a galvanic cell.

EMBRITTLMENT TESTING

Embrittlement testing of Dril-Flex fasteners was performed in accordance to ASTM F1624-06, "Standard Test Method for Measurement of Hydrogen Embrittlement in Steel by the Incremental Loading Method". Fastener lots were tested to determine their Threshold Stress Limits for both Internal Hydrogen Embrittlement and Environmental Hydrogen Embrittlement. Threshold Stress Limit is the stress level below which no time-dependent cracking will occur. Above this level, subcritical cracking that leads to time-delayed fracture or embrittlement may occur if the fastener is exposed to a hydrogen environment.

Embrittlement Test Results

- Dril-Flex fasteners have a hardness range of HRC 28 – 34, which is roughly equivalent to a SAE Grade 5 fastener (HRC 25 – 34).
- Dril-Flex fasteners showed resistance to the effect of hydrogen-assisted cracking when loaded to 75% of their tensile strength. This is within accepted industry guidelines for in-service loading conditions.
- Dril-Flex fasteners showed no degradation or failures in tensile strength below their Ultimate Tensile Strength.

SHEAR AND PULL-OUT VALUES

Pull-out Tests – Steel

Pull-out values shown are in lbs.

Screw Size	Point Type	Drill Cap.	Steel							
			18	16	14	12	1/8	3/16	1/4	5/16
10-16	3	.150	396	501	634	1595	1693			
12-14	3	.187	396	527	710	1678	2061	2898		
1/4-14	3	.187	398	530	686	1950	2264	3919		
1/4-20	4	.312		516	649	1912	2296	2928	3561	4488
5/16-24	4	.312				2148	2573	4226	5424	6622

Shear Tests – Steel

Shear values shown are in lbs.

Screw Size	Point Type	Drill Cap.	Steel						
			18-18 gage	18-14 gage	16-16 gage	14-14 gage	1/8"-3/16"	3/16"-1/4"	1/4"-12 gage
10-16	3	.150	1362	1733	1462				
12-14	3	.187	1315	2118	1655	1816			
1/4-14	3	.187	1395	2313	1681	2417	2600		
1/4-20	4	.312	1350	2086	1582	2450	2814	2810	2706
5/16-24	4	.312					5486	5283	4761

Pull-out Tests – Aluminum

Pull-out values shown are in lbs.

Screw Size	Point Type	Drill Cap.	Aluminum 6063-T5		
			1/8"	1/4"	3/8"
10-16	3	.150			
12-14	3	.187	939	2286	
1/4-14	3	.187	1003	2424	
1/4-20	4	.312	897	2075	3683
5/16-24	4	.312	1043	2566	

Shear Tests – Aluminum

Shear values shown are in lbs.

Screw Size	Point Type	Drill Cap.	Aluminum 6063-T5	
			1/8" - 1/8"	1/8" - 1/4"
10-16	3	.150	1466	
12-14	3	.187	1797	2483
1/4-14	3	.187	1996	2883
1/4-20	4	.312	2006	2926
5/16-24	4	.312	1849	2926

NOTE: All test setups and dimensions were as limited and outlined in AISI Test Method for Mechanically Fastened Cold-Formed Steel Connections (CF92-1) document. Performance values listed are ultimate values obtained under laboratory conditions. Appropriate safety factors should be applied for design purposes.

SPECIFICATIONS

Applications:

Metal (including aluminum) to steel structurals like those found in curtainwall and solar panel systems

Short Form Specification:

Dual-hardened fastener with self-drilling point and self-tapping thread that meets SAE J429 Grade 5 and ASTM A449 strength and ductility requirements, which provides a maximum load-bearing area of _____.

Approvals/Listings:

- ICC ES ER-4780 Legacy Report
- COLA (City of Los Angeles) Research Report #25095

Diameters:

#10, #12, 1/4", 5/16"

Head Styles:

Hex washer, undercut flat, pan and wafer; custom heads styles available

Thread Form:

Self-tapping

Point Type:

Self-drilling

Material:

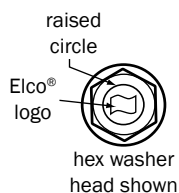
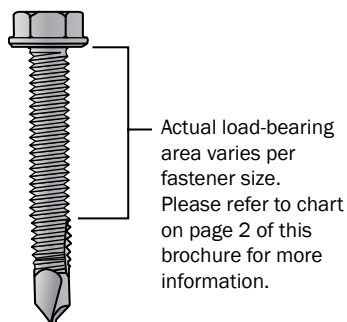
Special alloy steel

Finish:

Silver-colored Stalgard® corrosion-resistant finish withstands a minimum of 1000 hours salt spray per ASTM B117 standards

Inspection

In-place inspection can be made by identifying the special Dril-Flex headmarking. This is a combination of two markings: an Elco® logo surrounded by a raised circle.



DESIGNING WITH DRIL-FLEX® FASTENERS

Download CAD files from our web site at www.elcoconstruction.com or contact Elco Construction Products for a free disk containing CAD drawings and specifications.

QUALITY CONTROL

Dril-Flex fasteners are produced under lot control conditions. Each production run is sampled and checked for two key conditions. First, that the lower hardness zone extends down the shank to the length specified, and second, that the hardness in that zone is per the specifications. Documentation is retained for a period of five years. Lot numbers are marked on every box of product.



QUALITY FLEX TECHNOLOGY® PRODUCTS

- Bi-Flex™ bi-metal self-drilling fasteners with Stalgard GB coating for metal applications, including aluminum, in demanding environments
- Aggre-gator® bi-metal anchors with Stalgard GB coating for concrete applications, including exposed/wet areas
- ConFlex® large diameter masonry fasteners with Stalgard coating in 3/8" and 1/2" diameters
- AllFlex™ stainless steel thread-forming and thread-cutting screws with Stalgard GB coating
- Alumi-Flex™ 302 stainless steel drill screws with Stalgard GB coating

Visit www.elcoconstruction.com for more information on these and other quality fastening systems from Elco Construction Products.

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Hurripanel™ Fasteners

2128 Springwood • Carrollton, TX 75006

1.972.417.8882 • toll-free 1. 877.424.7616

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