

# Test Report

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Test Object: Initial Type Testing (ITT) of self-tapping screws for use in timber structures according to EN 14592:2008  
  
here: Testing of wood screws type "Tecfi TM", diameter d = 5 mm

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**Initial Type Testing (ITT) of self-tapping screws for use in timber structures according to EN 14592:2008**

**here: Testing of wood screws type “Tecfi TM”, diameter  $d = 5,0$  mm**

## **1 Preface**

With letter dated 15. October 2010, the company Tecfi S.p.A., 81050 Pastorano/Italy, commissioned MPA University of Stuttgart to conduct the Initial Type Testing (ITT) according to EN 14592:2008 of screws with the type designation “Tecfi TM”.

In this context, the company Tecfi S.p.A. submitted self-tapping screws with the type designation “Tecfi TM” to MPA University of Stuttgart for the purpose of testing. The test material arrived at MPA University of Stuttgart on 23. December 2010.

The present report covers the load bearing tests carried out with self-tapping wood screws with the type designation “Tecfi TM”, dimension  $d \times L = 5,0 \times 90$  mm, and their results.

## **2 Test material**

### **2.1 Wood screws**

The following wood screws were submitted by the customer for the purpose of testing:

- **Self-tapping wood screws type “Tecfi TM”, diameter  $d = 5,0$  mm, with Pan Head and partial thread made of carbon steel (cf. Figure 1, Annex 1):**

Date of receipt of samples: 23. December 2010

Sample size: Approx. 100 wood screws; dimension  $d \times L = 5,0 \times 90$  mm  
(= maximum screw length produced for this type of screw)

The exact product specifications of the screws submitted for testing purposes as well as the name and address of the manufacturing facility, as stated by the customer, are given in Table 8, Annex 12.

### **2.2 Solid wood and glued-laminated timber**

For the tests conducted in order to determine the withdrawal parameter and the head pull-through parameter of the screws under consideration, solid soft wood was used (wood species: spruce). The density of the soft wood met the requirements according to EN 28970, Method 2.

For the tests conducted in order to determine the torsional resistance („insertion moment“), glued-laminated timber of strength class GL 24 (wood species of lamellas: spruce) according to EN 14080 was used. According to the specifications given in EN 14592, Annex B, the density of the glued-laminated timber was in the range of 400 kg/m<sup>3</sup> to 500 kg/m<sup>3</sup>.

### **3 Test procedure**

#### **3.1 Dimensions of the screws**

The relevant dimensions governing the load bearing behaviour, in particular length, thread length, inner and outer thread diameter, etc., were measured according to specifications given in EN 14592, Section 5 and Table 4. The dimensions of the five screws type “Tecfi TM”, dimension  $d \times L = 5,0 \times 90$  mm, were measured by using a shape projector with twentyfold magnification.

#### **3.2 Tensile capacity**

The determination of the tensile capacity  $f_{\text{tens}}$  was carried out on following EN 1383, Image 4. Ten screws were tested, whereby each screw was loaded up to rupture. During the tensile test, the screw head was fixed by a steel plate with an adapted bore hole. The speed of loading was adjusted in such a manner that failure occurred within a time span of approximately 10 seconds.

#### **3.3 Yield moment**

The yield moment  $M_y$  and the maximum bending angle  $\alpha_{\text{max}}$  of the screws were determined according to EN 409. Each screw was bent only along its threaded part.

Ten tests were conducted by using a free length (cf. EN 409, Annex A) of  $l_2 = 2 d$  ( $d$  = outer diameter of the screws) in a specifically designed bending device.

#### **3.4 Torsional strength**

The determination of the torsional strength  $f_{\text{tor}}$  (= breaking torque) of the screws was carried out following EN ISO 10666. Ten screws were twisted until rupture occurred.

The tests were carried out in a torsion test machine with a stepless adjustable electro-mechanical drive. The test speed was regulated in such a manner that failure occurred within a time span of approximately 10 seconds. The torsional moment was measured by using an intermediary calibrated torque rod equipped with strain gauges.

### **3.5 Torsional resistance**

Ten screws were drilled in glued-laminated timber in order to determine the characteristic torsional resistance  $R_{tor,k}$  (= insertion moment). The drill-in tests were conducted following EN 14592, Annex B, by using a mobile torque and a rotation angle measuring instrument, type Schatz Inspect+.

The cross section of the glued-laminated timber specimens used for the drill-in tests were (height  $H$  x width  $B$ )  $H \times B = 300 \text{ mm} \times 120 \text{ mm}$ .

The scheme of the drill-in tests in order to determine the torsional resistance is sketched in Figure 2, Annex 1. All screws have been screwed-in perpendicular to the width of the glued-laminated timber specimen without any previous pre-drilling while using a suitable electric driven screw driller. The annual growth rings of the lamellas were orientated perpendicular to the screw-in direction.

For each screw-in test, a torque-rotation angle graph was recorded. The torsional resistance, respectively, was determined from the recorded graphs as maximum value by the time, the screw head barely did not yet touch the glued-laminated timber surface (cf. Figure 2, Annex 1).

### **3.6 Withdrawal parameter**

The pull-out tests according to EN 1382 conducted in order to determine the characteristic withdrawal parameter  $f_{ax,k}$  from solid soft wood were performed using ten screws.

The scheme of the pull-out tests is shown in Figure 3, Annex 2. Also given are the screw-in depth  $s_g$  as well as the dimensions of the solid wood specimens.

According to EN 1382, Section 6.3.1, in total five tests with annual growth rings running parallel and five tests with annual growth rings running perpendicular to the screw-in direction (cf. Figure 3, Annex 2) were conducted. In both cases, the angle between the screw axis and the direction of the wood fibres was  $90^\circ$ . All screws have been screwed-in without any previous pre-drilling.

All tests were conducted at a constant displacement rate of 5 mm/min until maximum load was reached.

### **3.7 Head pull-through parameter**

The head pull-through tests according to EN 1382 were conducted in order to determine the characteristic head pull-through parameter  $f_{head,k}$  with respect to solid soft wood (sample size: ten screws).

The scheme of the head pull-through tests is shown in Figure 4, Annex 3. Each screw was fixed in the wood in a pre-drilled hole; the pre-drill diameter corresponded to the outer thread diameter  $d$  of the screw (cf. Figure 4, Annex 3).

The measurements of the solid wood test specimens were (height H x width B)  $H \times B = 40 \text{ mm} \times 160 \text{ mm}$ . Five tests each were conducted with annual growth rings oriented parallel and perpendicular to the screw-in direction of the screws (cf. Figure 4, Annex 3).

All tests were conducted at a constant displacement rate of 5 mm/min until maximum load was reached.

## **4 Test Results**

### **4.1 General remarks**

For the test results obtained, the following statistical quantities were calculated:

$x_{\text{mean}}$  : mean value

$s$  : standard deviation

COV : coefficient of variation

$x_k$  : characteristic value (5%- or 95%-fractile)

The characteristic values were calculated according to EN 14358 assuming a minimum standard deviation  $s_y = 0,05$  for the logarithmized data in such cases where the coefficient of variation of the original data was smaller than 5 %.

The test results (single values) obtained with screws type “Tecfi TM” and the related statistical quantities discussed above are reported subsequently.

### **4.2 Dimensions**

The results of the revised dimensions are given in Table 1, Annex 4. Also given are the nominal values (based on the drawings submitted by the company Tecfi S.p.A.) along with the respective tolerance limits (minimum and maximum values) calculated on the basis of the permissible limit deviations according to EN 14592, Section 5.

**Remark:** Concerning the length and the nominal diameter (= outer thread diameter), the tolerance limits have been calculated according to EN 14592, Sections 5.2 and 5.3, allowing a maximum deviation of  $\pm 2,5 \%$  of the given nominal dimension. For all further dimensions (e.g. thread length, inner thread, shank and head diameter, etc.), the calculation of the tolerances was performed according to EN 14592, Section 5.4, allowing a maximum deviation of  $\pm 5 \%$  of the respective given nominal value.

### **4.3 Tensile capacity**

The obtained tensile capacities  $f_{\text{tens}}$ , determined by tensile tests according to EN 1383, are given in Table 2, Annex 5.

The characteristic tensile capacity was obtained as  $f_{\text{tens},k} = 8571 \text{ N} \approx 8570 \text{ N}$ .

#### **4.4 Yield moment**

According to EN 14592, Section 6.3.4.2, the yield moment of screws in general has to be determined at a bending angle of  $\alpha_1 = 45/d^{0.7}$  degrees ( $d$  = outer thread diameter). In any case, all bending tests have been continued up to a maximum bending angle of  $\alpha_{\max} = 45^\circ$  in order to make sure that the screws had no cracks when the bending angle of at least  $\alpha_2 = (45/d^{0.7} + 10)$  degrees was reached.

The moment-angle graphs of the bending tests according to EN 409 are pictured in Figure 5, Annex 6. As becomes evident from the graphs, all screws reached the required bending angle according to EN 14592, Section 6.3.4.2, in the amount of  $\alpha_2 = (45/d^{0.7} + 10)$  degrees undamaged and without any visible cracks.

Table 3, Annex 7, summarizes the test results of the bending tests conducted according to EN 409 (yield moment and maximum bending angle).

The characteristic yield moment was obtained as  $M_{y,k} = 5,5 \text{ Nm}$ .

#### **4.5 Torsional strength**

Table 4, Annex 8, summarizes the test results of the torsional strength  $f_{\text{tor}}$  (= breaking torque) of the screws, obtained in torsional tests according to EN ISO 10666.

The characteristic torsional strength was obtained as  $f_{\text{tor},k} = 6,3 \text{ Nm}$ .

#### **4.6 Torsional resistance**

Table 5, Annex 9, summarizes the test results of the screw-in tests conducted according to EN 14592, Annex B, up to a maximum screw-in depth of  $l_{\max}$  (screw head barely sticking out of the wood surface).

The measured values for the torsional resistance  $R_{\text{tor}}$  (= insertion moment) were normalized to a density of  $450 \text{ kg/m}^3$  (correction factor  $k_p = 450 / \rho$ ).

The characteristic torsional resistance was obtained as  $R_{\text{tor},k} = 2,7 \text{ Nm}$ .

#### **4.7 Withdrawal parameter**

The results of the withdrawal tests with respect to solid soft wood specimen according to EN 1382 are given in Table 6, Annex 10. For each test conducted, the obtained maximum load  $R_{\text{ax},p}$ , the normalized load  $R_{\text{ax}}$  (normalization to a characteristic wood density of  $\rho_k = 350 \text{ kg/m}^3$ , correction factor  $k_p = \rho_k / \rho = 350 / \rho$ ) and the hereof deduced withdrawal parameter  $f_{\text{ax}}$  are listed in the table, respectively.

The withdrawal parameter was calculated according to EN 1382:

$$f_{ax} = R_{ax} / (d \cdot s_g)$$

with

$R_{ax}$  maximum load of the withdrawal test (normalized with regard to the density),

$d$  outer thread diameter of the screw,

$s_g$  screw-in depth of the screw in the solid wood.

The characteristic withdrawal parameter was obtained as  $f_{ax,k} = 12,5 \text{ N/mm}^2$ .

#### **4.8 Head pull-through parameter**

The results of the head pull-through tests conducted according to EN 1382 are given in Table 7, Annex 11. For each test conducted, the obtained maximum load  $R_{head,\rho}$ , the normalized loads  $R_{head}$  (normalization to a characteristic wood density of  $\rho_k = 350 \text{ kg/m}^3$ , correction factor  $k_p = \rho_k / \rho = 350 / \rho$ ) and the hereof deduced head pull-through parameter  $f_{head}$  are listed in the table, respectively.

The head pull-through parameter was calculated according to EN 1383:

$$f_{head} = R_{head} / (d_h^2)$$

with

$R_{head}$  maximum load of the head pull-through test (adjusted with regard to the density),

$d_h$  head diameter of the screw.

The characteristic head pull-through parameter was obtained as  $f_{head,k} = 26,3 \text{ N/mm}^2$ .

### **5 Summary of the essential results and expertise**

#### **5.1 General**

The company Tecfi S.p.A., 81050 Pastorano/Italy, commissioned MPA University of Stuttgart to perform the Initial Type Testing (ITT) according to EN 14592:2008 on self-tapping wood screws type „Tecfi TM“ with a diameter of  $d = 5,0 \text{ mm}$ . The tests conducted comprised the determination of the essential dimensions of the screws as well as the determination of the mechanical properties tensile capacity, torsional strength and yield moment in conjunction with the related bending angle. Furthermore, screw-in tests in glued-laminated timber, pull-out tests from solid wood and head pull-through tests through solid wood have been conducted.

All tests have been conducted with screws of the dimension  $d \times L = 5,0 \times 90$  mm (= maximum screw length produced).

The calculation of the respective characteristic values was carried out according to EN 14358.

## 5.2 Dimensions

The recorded actual dimensions of the inspected screw type "Tecfi TM" (cf. Table 1, Annex 4; tested dimension  $d \times L = 5,0 \times 90$  mm) were consistently within the tolerance limits according to EN 14592, Sections 5.2 to 5.4, with regard to the nominal values (cf. Figure 1, Annex 1) provided by the manufacturer.

Furthermore, the requirements according to EN 14592, Section 6.3.3, were fulfilled:

- Nominal diameter  $d$  (= outer thread diameter) within the range of  $2,4 \text{ mm} \leq d \leq 24 \text{ mm}$ ,
- Inner thread diameter  $d_1$  of the screws within the range of 60 % to 90 % of the outer thread diameter  $d$  ( $0,6 d \leq d_1 \leq 0,9 d$ ),
- Thread length  $L_t$  at least 6 times the outer thread diameter ( $L_t \geq 6 d$ ).

## 5.3 Summary of the test results obtained when determining the mechanical properties tensile capacity, yield moment and torsional strength of the screws

The Summaries 1 to 3 give an overview of the statistical quantities (mean value, standard deviation, coefficient of variation and characteristic value) obtained when determining the mechanical properties tensile capacity  $f_{\text{tens}}$ , yield moment  $M_y$  and torsional strength  $f_{\text{tor}}$  (= breaking torque) of the screws.

screw type	tested dimension  $d \times L$ [mm x mm]	tensile capacity $f_{\text{tens}}$			
		mean value	standard deviation	coefficient of variation	characteristic value
		$f_{\text{tens,mean}}$ [N]	$s$ [N]	COV [%]	$f_{\text{tens,k}}$ [N]
"Tecfi TM", carbon steel (zinc plated)	5,0 x 90	9747	549	5,6	8571

**Summary 1:** Overview of the statistical values (mean value, standard deviation, coefficient of variation and characteristic value) of the test results regarding the tensile capacity  $f_{\text{tens}}$  of wood screws type "Tecfi TM" (carbon steel; tested dimension:  $d \times L = 5,0 \times 90$  mm)



screw type	tested dimension  d x L [mm x mm]	yield moment $M_y$			
		mean value  $M_{y,mean}$ [Nm]	standard deviation  s [Nm]	coefficient of variation  COV [%]	characteristic value  $M_{y,k}$ [Nm]
"Tecfi TM", carbon steel (zinc plated)	5,0 x 90	6,2	0,2	3,0	5,5

**Summary 2:** Overview of the statistical values (mean value, standard deviation, coefficient of variation and characteristic value) of the test results regarding the yield moment  $M_y$  of wood screws type "Tecfi TM" (carbon steel; tested dimension: d x L = 5,0 x 90 mm)

According to EN 14592, Section 6.3.4.2, screws designated for the use in load bearing timber structures must not have any cracks up to a bending angle of  $\alpha_{lim} = (45/d^{0,7} + 10)$  degrees. This requirement was fulfilled by all tested screws type „Tecfi TM“.

screw type	tested dimension  d x L [mm x mm]	torsional strength $f_{tor}$			
		mean value  $f_{tor,mean}$ [Nm]	standard deviation  s [Nm]	coefficient of variation  COV [%]	characteristic value  $f_{tor,k}$ [Nm]
"Tecfi TM", carbon steel (zinc plated)	5,0 x 90	7,0	0,1	2,1	6,3

**Summary 3:** Overview of the statistical values (mean value, standard deviation, coefficient of variation and characteristic value) of the test results regarding the torsional strength  $f_{tor}$  (= breaking torque) of wood screws type "Tecfi TM" (carbon steel; tested dimension: d x L = 5,0 x 90 mm)

#### 5.4 Summary of the test results obtained when determining the torsional resistance of the screws

Summary 4 gives an overview of the statistical quantities (mean value, standard deviation, coefficient of variation and characteristic value) obtained when determining the torsional resistance  $R_{tor}$  (= insertion moment) by means of screw-in tests. Also given are the characteristic torsional strength  $f_{tor,k}$  (cf. Summary 3) and the characteristic torsional ratio  $f_{tor,k} / R_{tor,k}$  (= ratio between torsional strength and torsional resistance).

screw type	tested dimension  d x L [mm x mm]	torsional resistance $R_{tor}$				charact. torsional strength  $f_{tor,k}$ [Nm]	charact. torsional ratio  $f_{tor,k} / R_{tor,k}$ [-]
		mean value  $R_{tor,mean}$ [Nm]	standard deviation  s [Nm]	coeff. of variation  COV [%]	charact. value  $R_{tor,k}$ [Nm]		
"Tecfi TM", carbon steel (zinc plated)	5,0 x 90	2,4	0,1	4,5	2,7	6,3	2,36

**Summary 4:** Overview of the statistical values (mean value, standard deviation, coefficient of variation and characteristic value) obtained when determining the torsional resistance  $R_{tor}$  of wood screws type "Tecfi TM" (carbon steel; tested dimension: d x L = 5,0 x 90 mm); additionally, the associated characteristic torsional strength  $f_{tor,k}$  and the characteristic torsional ratio  $f_{tor,k} / R_{tor,k}$  (= ratio between torsional strength and torsional resistance) are given

According to EN 14592, Section 6.3.4.6, for screws used in load bearing timber structures, a ratio of at least  $f_{tor,k} / R_{tor,k} \geq 1,5$  is mandatory. As shown in Summary 4, this requirement was fulfilled by the screw type „Tecfi TM“, dimension d x L = 5,0 x 90 mm, under consideration.

## 5.5 Summary of the test results obtained when determining the withdrawal parameter and the head pull-through parameter of the screws

The Summaries 5 and 6 give an overview of the statistical quantities (mean value, standard deviation, coefficient of variation and characteristic value) obtained when determining the withdrawal parameter  $f_{ax}$  and the head pull-through parameter  $f_{head}$  of the screws. The underlying characteristic density of the wood was, for both mechanical properties,  $\rho_k = 350 \text{ kg/m}^3$ .

screw type	tested dimension  d x L [mm x mm]	withdrawal parameter $f_{ax}$			
		mean value  $f_{ax,mean}$ [N/mm <sup>2</sup> ]	standard deviation  s [Nm]	coefficient of variation  COV [%]	characteristic value  $f_{ax,k}$ [N/mm <sup>2</sup> ]
"Tecfi TM", carbon steel (zinc plated)	5,0 x 90	15,5	1,7	10,9	12,5

**Summary 5:** Overview of the statistical values (mean value, standard deviation, coefficient of variation and characteristic value) obtained when determining the withdrawal parameter  $f_{ax}$  of wood screws type "Tecfi TM" (carbon steel; tested dimension: d x L = 5,0 x 90 mm)

screw type	tested dimension  d x L [mm x mm]	head pull-through parameter $f_{\text{head}}$			
		mean value	standard deviation	coefficient of variation	characteristic value
		$f_{\text{head,mean}}$ [N/mm <sup>2</sup> ]	s [Nm]	COV [%]	$f_{\text{head,k}}$ [N/mm <sup>2</sup> ]
"Tecfi TM", carbon steel (zinc plated)	5,0 x 90	33,6	4,2	12,6	26,3

**Summary 6:** Overview of the statistical values (mean value, standard deviation, coefficient of variation and characteristic value) obtained when determining the head pull-through parameter  $f_{\text{head}}$  of wood screws type "Tecfi TM" (carbon steel; tested dimension: d x L = 5,0 x 90 mm)

## 5.6 Conclusion

The tested self-tapping wood screws with type designation "Tecfi TM", diameter d = 5,0 mm, have successfully passed the Initial Type Testing (ITT) according to EN 14592:2008.

The requirements given in EN 14592, Table 4, regarding the measurements of the tested screws (tolerance limits acc. to EN 14592, Section 5 and Section 6.3.3) as well as the ratio between the torsional strength and the torsional resistance ( $f_{\text{tor,k}} / R_{\text{tor,k}} \geq 1,5$ ) have been fulfilled.

The following characteristic values have been determined:

- characteristic tensional capacity acc. to EN 1383:  $f_{\text{tens,k}} = 8570 \text{ N}$
- characteristic yield moment acc. to EN 409:  $M_{y,k} = 5,5 \text{ Nm}$
- characteristic withdrawal parameter acc. to EN 1382  
(characteristic wood density  $\rho_k = 350 \text{ kg/m}^3$ ):  $f_{\text{ax,k}} = 12,5 \text{ N/mm}^2$
- charact. head pull-through parameter acc. to EN 1383  
(characteristic wood density  $\rho_k = 350 \text{ kg/m}^3$ ):  $f_{\text{ax,k}} = 26,3 \text{ N/mm}^2$
- characteristic torsional ratio acc. to EN ISO 10666  
and EN 14592, annex B:  $f_{\text{tor,k}} / R_{\text{tor,k}} = 2,36$

All tests referred to in the present report have been conducted with self-tapping screws type "Tecfi TM" with Pan Head and partial thread made of carbon steel; the dimension tested was  $d \times L = 5,0 \times 90$  mm.

The determined characteristic values may also be used for screws of the type under consideration with a length  $L < 90$  mm (with a thread length  $L_t < 70$  mm, respectively). However, according to EN 14592, Section 6.3.3, the minimum required thread length for screws with a nominal diameter (= outer thread diameter) of  $d = 5,0$  mm is  $L_{t,min} = 6 \cdot d = 30$  mm.

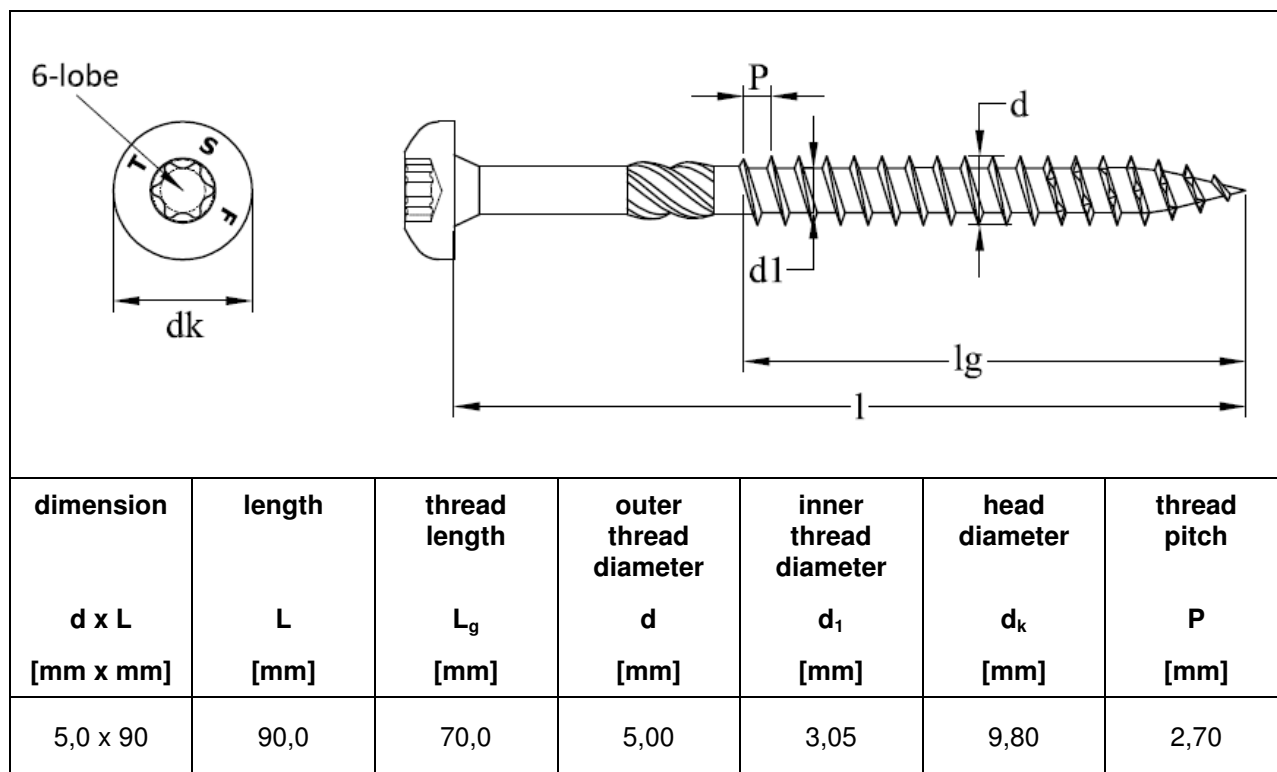
Abteilung Holzkonstruktionen  
Referat Verbindungstechnik, Klebstoffe

Der Bearbeiter

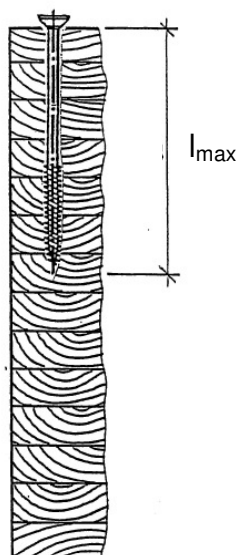
Der Abteilungsleiter

Dipl.-Ing. S. Weber

Dr. S. Aicher  
Leitender Akad. Direktor



**Figure 1:** Shape and dimension of self-tapping screws type „Tecfi TM“ with Pan Head and partial thread made of carbon steel; tested dimension:  $d \times L = 5,0 \times 90$  mm



**Figure 2:** Scheme of the drill-in tests in order to determine the torsional resistance of self-tapping screws type „Tecfi TM“ (carbon steel; tested dimension:  $d \times L = 5,0 \times 90$  mm; maximum screw-in depth:  $l_{\max} = 90$  mm)