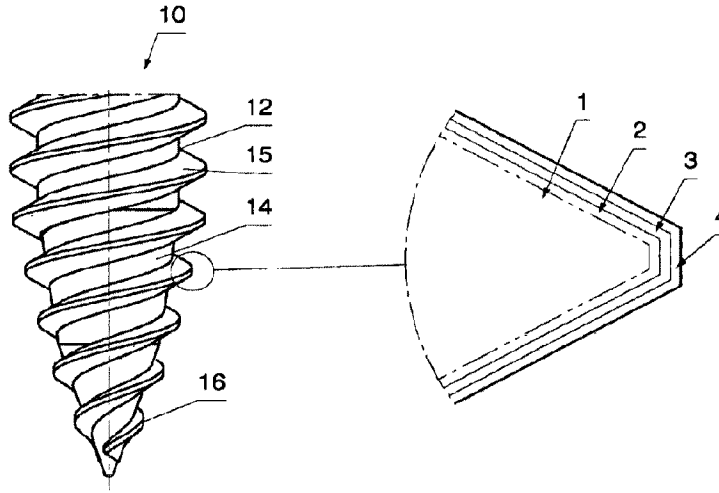




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(57) Abrégé/Abstract:

A drilling screw composed of an austenitic or some other non-corrosive base material (1) is described, having a shank (12), having a cutting or shaping drilling or threaded tip (16) arranged at one shank end and having a hard coating (3) applied at least to the drilling or threaded tip (16) by electrodeposition, said hard coating (3) comprising a layer containing a transition metal, for example a hard chromium layer. The shank (12) has a hard edge layer (2) at least under the hard coating (3). A topcoat (4) composed of a lubricating and heat-dissipating material, which preferably comprises metal, wax and/or lacquer, is applied to the hard coating (3).



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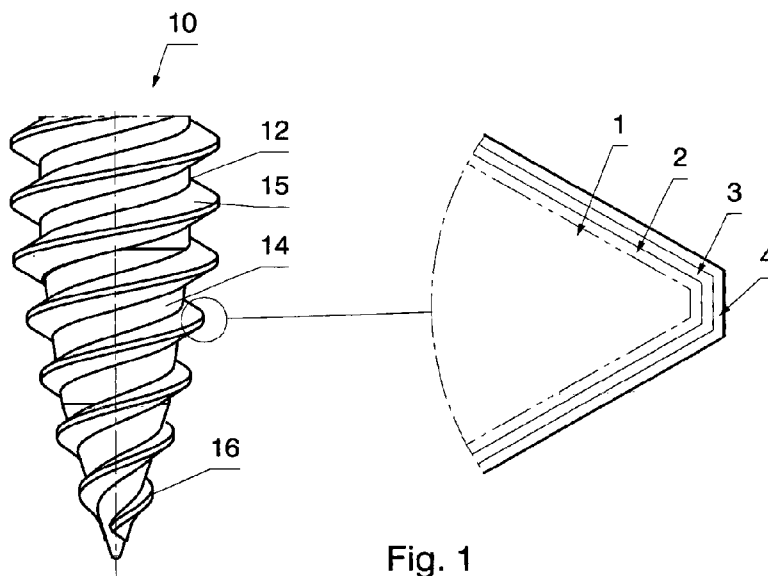


Fig. 1

(57) Abstract: A drilling screw composed of an austenitic or some other non-corrosive base material (1) is described, having a shank (12), having a cutting or shaping drilling or threaded tip (16) arranged at one shank end and having a hard coating (3) applied at least to the drilling or threaded tip (16) by electrodeposition, said hard coating (3) comprising a layer containing a transition metal, for example a hard chromium layer. The shank (12) has a hard edge layer (2) at least under the hard coating (3). A topcoat (4) composed of a lubricating and heat-dissipating material, which preferably comprises metal, wax and/or lacquer, is applied to the hard coating (3).

(57) Zusammenfassung:

[Fortsetzung auf der nächsten Seite]

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Beschrieben ist eine Bohrschraube aus einem austenitischen oder anderem nicht rostenden Grundmaterial (1), mit einem Schaft (12), mit einer an einem Schaftende angeordneten schneidenden oder formenden Bohr- oder Gewindespitze (16) und mit einer wenigstens auf die Bohr- oder Gewindespitze (16) galvanisch aufgetragenen harten Beschichtung (3), die eine in ein Übergangsmetall enthaltende Schicht, zum Beispiel eine Hartchromschicht, umfasst. Der Schaft (12) weist wenigstens unter der harten Beschichtung (3) eine harte Randschicht (2) auf. Auf die harte Beschichtung (3) ist ein Topcoat (4) aus einem schmierenden und wärmeabführenden Stoff aufgebracht, der vorzugsweise Metall, Wachs und/oder Lack umfasst.

Drilling screw

Field

5 The invention relates to a self-drilling screw produced from an austenitic or other stainless base material, comprising a shank which has a cutting or forming boring tip or thread crest arranged on a shank end and a hard edge layer formed on the surface of the shank in the region of the boring tip or thread crest and at least in the region of a thread connecting thereto.

10 Context

DE 10 2012 009 400 B4, which relates to a patent also by the applicant, discloses a self-drilling screw formed in one piece. This known self-drilling screw has a simpler design than a two-part self-drilling screw in which the two parts are welded together, one of these two parts comprising the boring tip and the thread-forming region and, by way of example,
15 consisting of carbon steel which has, in a final step, been hardened by induction or flame hardening.

This known screw is only ever used once. A hard coating which is galvanically applied to the boring tip or thread crest and comprises a transition metal layer or chromium layer has
20 been found to be stable for the single drilling process required for this purpose. Simple coating such as chromating or hard chromating or, more generally, galvanically applying the hard coating as a layer that contains a transition metal, is sufficient at least with suitable additives to be able to use the known self-drilling screw at least once. In this case, contrary to the opinion of a person skilled in the art, hard coatings of this type can be
25 achieved without the eggshell effect occurring. The self-drilling screw according to the aforementioned document achieves, owing to the coating applied, the required drilling capacity and the required thread formation.

A self-drilling screw of the type mentioned at the outset is known from US 5 419 948 A. In
30 order to harden said known self-drilling screw, it is chemically reacted, i.e. nitrated, with nitrogen trifluoride on its surface. As a result of the nitration, the known screw, which is stainless per se, produces an ultra-hard surface layer which is susceptible to rust and has to be removed again after the nitration, specifically in the region of the screw head.

35 US 4 802 807 A discloses a self-drilling screw for which corrosion resistance by galvanising, i.e. by galvanically applied zinc, is achieved. In addition, for this known self-drilling screw, an aluminium protective layer is produced on the zinc protective layer. The aluminium protective layer is applied to the galvanised screw by means of ion vapour

precipitation technology. The composite protective layer thus produced is intended not only to improve corrosion resistance but also to reduce the torque when screwing in the self-drilling screw. Finally, a topcoat is applied to the self-drilling screw in order to prevent the aluminium protective coating from oxidising.

5

Proceeding from a self-drilling screw according to the above-cited document US 5 419 948 A, the object of the invention is to improve the drilling capacity and the thread formation in a simple manner.

Summary

10 Proceeding from this known self-drilling screw, the sought further improvement in the drilling capacity and the thread formation is achieved according to the invention in that a hard coating is galvanically applied at least to the hard edge layer of the boring tip or thread crest, which hard coating comprises a layer containing a transition metal, and in that a topcoat made of a lubricating and heat-dissipating material is applied to the hard
15 coating.

In the self-drilling screw according to the invention, the hard edge layer improves the adhesiveness of the hard coating galvanically applied thereto. In turn, the hard coating improves the adhesiveness of the topcoat applied thereto. Since the topcoat is produced
20 from a lubricating and heat-dissipating material, it in turn improves the stability of the hard coating. This improvement in the stability of the hard coating leads to the sought improvement in the drilling capacity and the thread formation. The sought improvement in the drilling capacity and the thread formation is achieved for the self-drilling screw according to the invention, which is inherently stainless, without the self-drilling screw
25 being placed in a state in which it is susceptible to rust that has to be removed again at least in part.

Also disclosed is a self-drilling screw produced from an austenitic or stainless steel base material, comprising a shank which has a cutting or forming boring tip or thread crest arranged on a shank end and a hard edge layer formed on a surface of the shank in a
30 region of the boring tip or thread crest and at least in the region of a thread connecting thereto, a hard coating galvanically applied at least to the hard edge layer of the boring tip or thread crest, said hard coating comprising a layer containing a transition metal, and a top coat made of a lubricating and heat-dissipating material applied to the hard coating.

The prevention of the eggshell effect mentioned at the outset is reliably achieved for the
35 self-drilling screw according to the invention owing to the hard edge layer, which the shank has under the hard coating.

Topcoats made of a lubricating antifriction lacquer are already known, for example the lubricating lacquer F 417, according to technical product information available to the applicant from the company Tevier Öl-Fenkart GmbH, which is based in 6845 Hohenems, Austria. This antifriction lacquer, which contains MoS_2 , is pressure-resistant and is intended to achieve lifetime lubrication of general mechanical engineering components, automobile industry components and supplier industry components. Specifically, said antifriction lacquer can also be used for screws; however, the use of such antifriction lacquers for self-drilling screws is not known to the applicant.

10 The topcoat that is applied to the hard coating in accordance with the invention and that is made of a lubricating and heat-dissipating material not only improves heat-dissipation but also reduces the heat produced during the screwing-in process of the self-drilling screw according to the invention by reducing friction, and therefore said topcoat not only dissipates heat but also reduces the amount of heat to be dissipated overall.

15 The hard edge layer can be achieved in particular by selecting a suitable strain when the self-drilling screw is formed and before the hard coating is galvanically applied to the shank of the self-drilling screw.

20 For the self-drilling screw according to the invention, the hard edge layer and the hard coating applied thereto as well as the topcoat applied to the hard coating ensure one-time drilling and the formation of the thread in steel along with optimal drilling capacity and optimal thread formation.

25 For the self-drilling screw according to the invention, heat dissipation is ensured over a large surface area and owing to a special topology of the surface, which also encourages the adhesion of the topcoat.

30 The characteristics of the hard coating and of the topcoat such as layer thickness, hardness, adhesiveness, antifriction properties, roughness, temperature resistance and thermal conductivity can each be optimised depending on the use.

The dependent claims relate to advantageous embodiments of the invention.

35 In an embodiment of the self-drilling screw according to the invention, the lubricating and heat-dissipating material comprises metal, wax and/or lacquer. As a result of this alone,

the above-mentioned characteristics of the hard coating can be optimised depending on the use.

5 In another embodiment of the self-drilling screw according to the invention, the hard coating, together with the topcoat, has a thermal conductivity of $\lambda > 9 \text{ W/mK}$, as a result of which the sought optimisation in terms of drilling capacity and thread formation is achieved even more reliably.

10 In another embodiment of the self-drilling screw according to the invention, the topcoat comprises a layer which intrinsically has differences in layer thickness of up to $\pm 60 \%$, as a result of which the adhesion of the topcoat to the hard coating is ensured even more securely.

15 In another embodiment of the self-drilling screw according to the invention, the topcoat comprises a layer which intrinsically has differences in layer thickness of up to $\pm 30 \%$. These maximum differences in layer thickness are easier to achieve than for the previously mentioned embodiment of the self-drilling screw according to the invention, but also ensure sufficient adhesion of the topcoat to the hard coating and sufficient heat dissipation through the topcoat.

20 In another embodiment of the self-drilling screw according to the invention, the topcoat is mixed with metal particles. These particles can, as is known per se, consist of MoS_2 , i.e. of at least lubricating particles. The inventors have identified that an improvement in the heat dissipation during the screwing-in process of the self-drilling screw according to the invention can also be achieved by means of such particles used per se for lubrication.

30 However, an improvement in heat dissipation surprisingly also results from using only heat-dissipating particles made of Au, Ag, Cu or the like, which constitute another embodiment of the self-drilling screw according to the invention. As a general principle, most of the heat is given off via the cutting that results during the drilling process, lacquer and/or wax (having and not having metal particles or metal powder) still positively assisting this effect, however.

35 In another embodiment of the self-drilling screw according to the invention, the base material has a hardness of from 100 to 300 HV0.1 and preferably from 150 to 200 HV0.1. A base material having such a hardness has proven to be particularly advantageous.

In another embodiment of the self-drilling screw according to the invention, the hard edge layer has a hardness of from 300 to 600 HV0.1. A hard edge layer having such a hardness has proven to be particularly advantageous.

5 In another embodiment of the self-drilling screw according to the invention, the hard coating has a serrated or beaded topography. It had been found that both types of topography ensure sufficient differences in thickness, which ensure sufficient adhesion of the topcoat.

10 In another embodiment of the self-drilling screw according to the invention, the hard coating has a hardness of at least 700 HV0.1. A hard coating having such a hardness has proven to be advantageous.

In another embodiment of the self-drilling screw according to the invention, the hard
15 coating has a hardness of between 800 and 1400 HV0.1. A hard coating having such a hardness has proven to be particularly advantageous.

In another embodiment of the self-drilling screw according to the invention, the hard
20 coating has a maximum thickness of 60 µm. This thickness of the hard coating has proven to be appropriate for ensuring drilling capacity and thread formation of the self-drilling screw and for the adhesion of the topcoat to the hard coating.

The invention further provides a connection comprising the self-drilling screw as described above connected to at least one steel connecting element through which the self-drilling
25 screw is drilled, this connection being particularly suitable when one of at least two components to be fastened to one another is exposed to weathering. The production of the self-drilling screw according to the invention from a stainless base material means that the part of the self-drilling screw which is exposed to weathering does not require additional rust protection as is the case for the conventional two-part self-drilling screw
30 according to the German patent DE 10 2012 009 400 B4 which is mentioned at the outset, or as is the case for the self-drilling screw according to US 4 802 807 A. The boring tip, that is to say the part of the conventional two-part self-drilling screw that is exposed to weathering, requires special measures for the corrosion resistance thereof because the boring tip consists of carbon steel so that it can be hardened. The thread-forming region of
35 the conventional two-part screw consists of stainless steel.

Brief description of the drawings

Advantageous embodiments of the invention are described in greater detail in the following with reference to the drawings, in which:

- 5 Fig. 1 shows, as a first embodiment of the invention, a metal self-drilling screw which is provided with a thread crest and, as a larger scale detail, a thread flank;
- 10 Fig. 2 shows a boring tip of a second embodiment of the self-drilling screw according to the invention, together with a larger scale detail of a corner of the boring tip;
- 15 Fig. 3 is an even larger scale detail of a part of the detail according to Fig. 2 or Fig. 3;
- Fig. 4 symbolically shows the heat dissipation from a thread flank or boring tip via a cutting;
- 20 Fig. 5 shows, in the same view as Fig. 4, heat dissipation mainly over the surface of the thread flank or boring tip in a region adjacent to a cutting;
- Fig. 6 shows, as a first example of a use of the self-drilling screw according to the invention, the fastening of a corrugated metal sheet to a vertical spar;
- 25 Fig. 7 shows, as a second example of a use of the self-drilling screw according to the invention, the fastening of a trapezoidal metal sheet to a Double T support; and
- 30 Fig. 8 shows, as a third example of a use of the self-drilling screw according to the invention, a mutual fastening of two trapezoidal metal sheets.

Detailed description

Variants, examples and preferred embodiments of the invention are described therein below.

35

Fig. 1 shows, as a first embodiment of the invention, a metal self-drilling screw 10 comprising a shank 12 which has a thread-forming region 14 and a thread crest 16. The screw has a head, for example a conventional hexagonal head (not shown in Fig. 1, however). The metal self-drilling screw 10 is produced in a single piece from an austenitic or other stainless steel, which forms the base material of the screw. Fig. 1 also shows, as a larger scale detail, a thread flank of the metal self-drilling screw 10. In this detail, the base material of the screw is denoted by reference sign 1. The shank 12 is designed so as to be harder, at the surface in the region of the drill tip 16 and at least in the region of a thread 15 connected thereto, than the remainder of the metal self-drilling screw 10. This harder design of the surface is important in order for the metal self-drilling screw 10 to be able to perform its function, specifically to drill a hole using the thread crest 16 and subsequently to form a thread in the hole. The austenitic or other stainless base material 1 of the self-drilling screw 10 would specifically not be inherently suitable for this purpose. The base material would be too soft for this purpose.

In the harder region, the metal self-drilling screw 10 is provided with a hard edge layer 2 and this in turn is provided with a hard coating 3. The self-drilling screw 10 comprises a hard edge layer 2 at least in the region below the hard coating 3. The hard coating 3 is galvanically applied as a thin layer, for example as a hard chromium layer, in particular according to German patent DE 25 02 284 C2, to the hard edge layer 2. Instead of a hard chromium layer, a layer containing a transition metal can generally be selected, which layer can be galvanically applied.

The hard edge layer 2 can be achieved in particular by selecting a suitable strain when the metal self-drilling screw 10 is formed and before the hard coating 3 is galvanically applied to the shank 12 and the thread crest 16 of the metal self-drilling screw. Aside from the hard coating 3, the metal self-drilling screw 10 is produced in a conventional manner by a screw blank being mechanically shaped, i.e. rolled, and in the process being provided with the thread crest 16 and remaining thread of the metal self-drilling screw 10. The larger the strain, the harder the hard edge layer 2 is formed.

The base material 1, which is used in the metal self-drilling screw according to the invention, has a hardness of from 100 to 300 HV0.1 and preferably from 150 to 200 HV0.1. The hard edge layer 2 has a hardness of from 300 to 600 HV0.1.

The hard coating 3 has a serrated or beaded topography and has a maximum thickness of 60 μm . The hard coating also has a hardness of at least 700 HV0.1 and preferably a hardness of between 800 and 1400 HV0.1.

5 Fig. 2 shows a boring tip of a second embodiment of a self-drilling screw 17 shown in Fig. 8, which is provided with a boring tip 18 instead of a thread crest as is the case for the metal self-drilling screw 10 according to Fig. 1. A shank such as the shank 12 is attached to the top of said boring tip 18, which shank has a thread such as the thread of the shank 12 in Fig. 1 (now shown in Fig. 2, however). The boring tip 18 is integrally moulded on the
10 shank (not shown in Fig. 2) just as the thread crest 16 is integrally moulded on the shank 12. Unlike the thread crest 16, the boring tip 18 has a bit 20 having a cutting edge 22. The above comments made in relation to the metal self-drilling screw 10 thus also apply to the self-drilling screw shown in Fig. 2 only by its boring tip 18. Fig. 2 also shows a corner of the boring tip 18 in a larger-scale detail. This detail shows that the self-drilling screw
15 according to Fig. 2 has the hard edge layer 2 and the hard coating 3 on the base material 1 thereof. Both for the metal self-drilling screw 10 according to Fig. 1 and for the self-drilling screw 17 according to Fig. 2 and 8, a topcoat 4 made of a lubricating and heat-dissipating material is applied to the hard coating 3. A suitable lubricating and heat-dissipating material comprises metal, wax and/or lacquer. The topcoat is preferably mixed
20 with metal particles which comprise MoS_2 , Au, Ag or Cu.

Fig. 3 is an even larger scale detail of a part of the detail according to Fig. 2 or Fig. 3. In the embodiment shown in Fig. 3, the hard coating 3 has a jagged structure. The topcoat 4 applied to the hard coating 3 thus comprises a layer which intrinsically has differences in
25 layer thickness. These differences in layer thickness are at most $\pm 60\%$, preferably a maximum of $\pm 30\%$.

The hard coating 3 together with the topcoat 4 has a thermal conductivity of $\lambda > 9 \text{ W/mK}$.

30 Fig. 4 symbolically shows the heat dissipation from the thread flank 15 or the boring tip 18 via a cutting 26 in the event that a hole is drilled into a workpiece 28, which hole is intended to be provided with threads. In Fig. 4, the workpiece 28 consists of a highly thermally conductive material, as a result of which the cutting 26 dissipates heat effectively, which heat is represented by a row of arrows 30 in Fig. 4. If the workpiece 28
35 consists of a poorly thermally conductive material or of a heat-insulating material, the heat resulting during the boring or -tapping process is introduced into the thread flank 15 or the

boring tip 18 and is conveyed via the topcoat 4 to the outside, as is shown in Fig. 5 by a row of arrows 30 and an arrow 32.

Fig. 6 to 8 show the use of the self-drilling screw 17 for producing a connection to at least
5 one steel connection element, through which the self-drilling screw is drilled. The
connection element is shown in these figures as a corrugated metal sheet 34 or as a
trapezoidal metal sheet 36, 42 and 44. Fig. 6 shows, as a first example of the use of the
self-drilling screw 17, the fastening of a corrugated metal sheet 34 to a vertical spar 38.
Fig. 7 shows, as a second example of the use of the self-drilling screw 17, the fastening of
10 a trapezoidal metal sheet 36 to a Double T support 40. Fig. 8 shows, as a third example of
the use of the self-drilling screw 17, a mutual fastening of two trapezoidal metal sheets 42,
44. The screws 17 are shown in Fig. 6-8 having different heads.

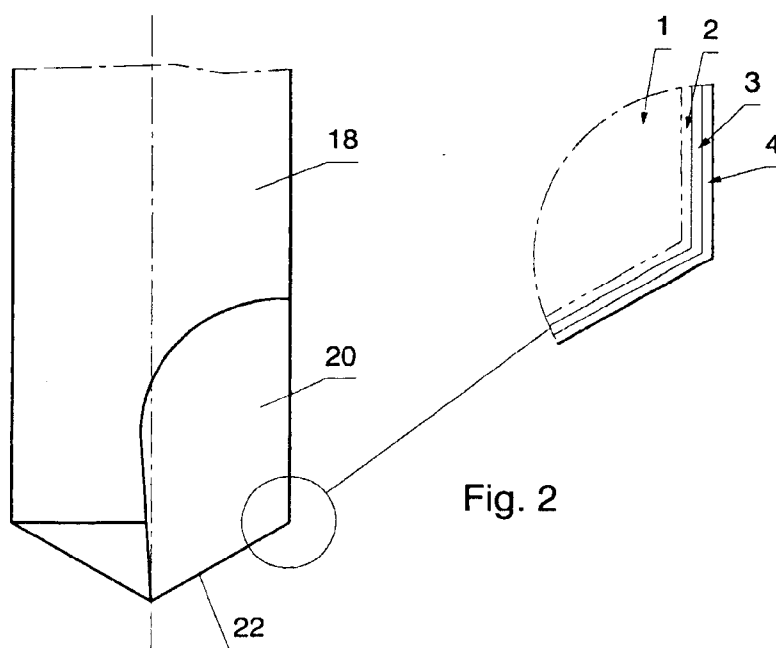
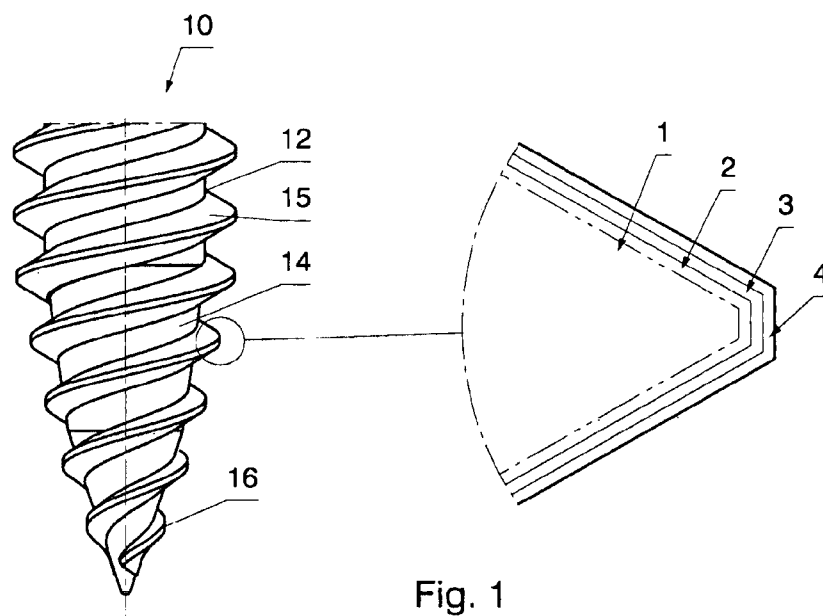
List of reference numerals

	1	base material
	2	hard edge layer
5	3	hard coating
	4	topcoat
	10	metal self-drilling screw
	12	shank
	14	thread-forming region
10	15	thread flank
	16	thread crest
	17	self-drilling screw
	18	boring tip
	20	bit
15	22	cutting edge
	24	topcoat
	26	cutting
	28	workpiece
	30	arrow
20	32	arrow
	34	corrugated metal sheet
	36	trapezoidal metal sheet
	38	spar
	40	double T support
25	42	trapezoidal metal sheet
	44	trapezoidal metal sheet

Claims

1. A self-drilling screw produced from an austenitic or stainless steel base material, comprising a shank which has a cutting or forming boring tip or thread crest arranged on a shank end and a hard edge layer formed on a surface of the shank in a region of the boring tip or thread crest and at least in the region of a thread connecting thereto, a hard coating galvanically applied at least to the hard edge layer of the boring tip or thread crest, said hard coating comprising a layer containing a transition metal, and a topcoat made of a lubricating and heat-dissipating material applied to the hard coating.
2. The self-drilling screw according to claim 1, wherein the lubricating and heat-dissipating material comprises metal, wax and/or lacquer.
3. The self-drilling screw according to Claim 1 or 2, wherein the hard coating, together with the top coat, has a thermal conductivity of $\lambda > 9 \text{ W/mK}$.
4. The self-drilling screw according to any one of claims 1 to 3, wherein the top coat comprises a layer which intrinsically has differences in layer thickness of a maximum of $\pm 60\%$.
5. The self-drilling screw according to any one of claims 1 to 3, wherein the top coat comprises a layer which intrinsically has differences in layer thickness of a maximum of $\pm 30\%$.
6. The self-drilling screw according to any one of claims 1 to 5, wherein the top coat is mixed with metal particles.
7. The self-drilling screw according to claim 6, wherein the metal particles comprise MoS_2 , Au, Ag or Cu.
8. The self-drilling screw according to any one of claims 1 to 7, wherein the base material has a hardness of 100 to 300 HV0.1.
9. The self-drilling screw according to claim 8, wherein the base material has a hardness of 150 to 200 HV0.1.
10. The self-drilling screw according to any one of claims 1 to 9, wherein the hard edge layer has a hardness of 300 to 600 HV0.1.

11. The self-drilling screw according to any one of claims 1 to 10, wherein the hard coating has a serrated or beaded topography.
12. The self-drilling screw according to any one of claims 1 to 11, wherein the hard coating has a hardness of at least 700 HV0.1.
13. The self-drilling screw according to any one of claims 1 to 12, wherein the hard coating has a hardness of between 800 and 1400 HV0.1.
14. The self-drilling screw according to any one of claims 1 to 13, wherein the hard coating has a maximum thickness of 60 μm .
15. A connection comprising the self-drilling screw according to any one of claims 1 to 14 connected to at least one steel connecting element through which the self-drilling screw is drilled.



2/3

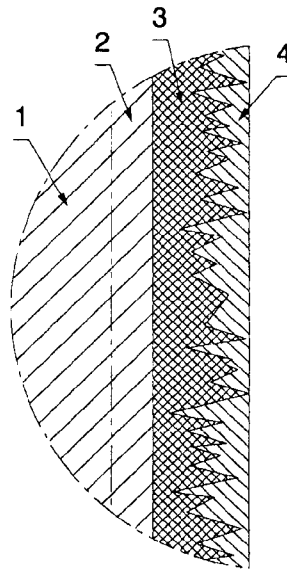


Fig. 3

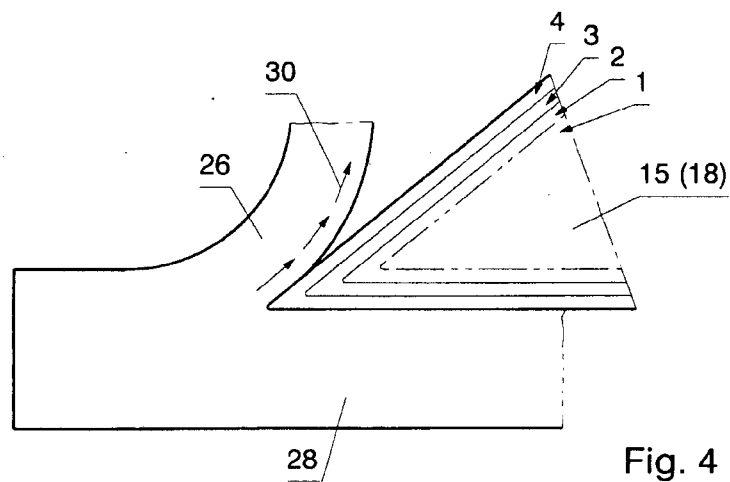


Fig. 4

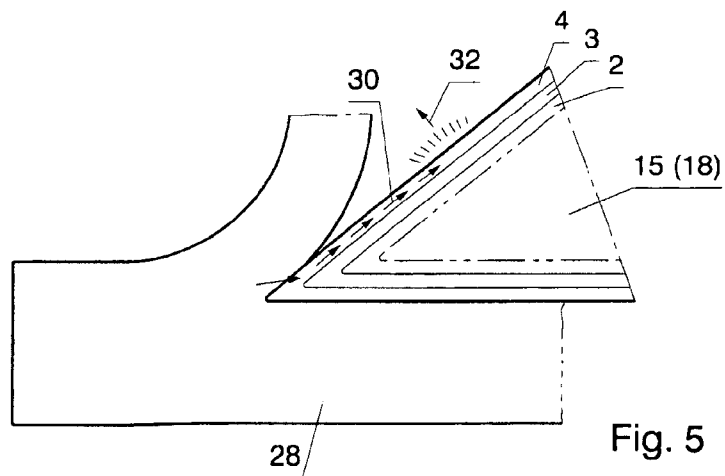


Fig. 5

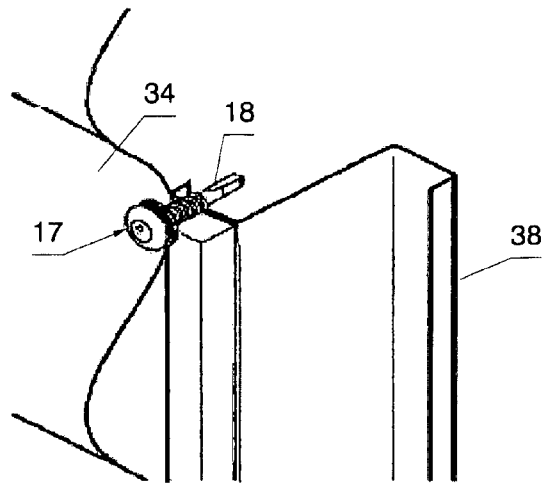


Fig. 6

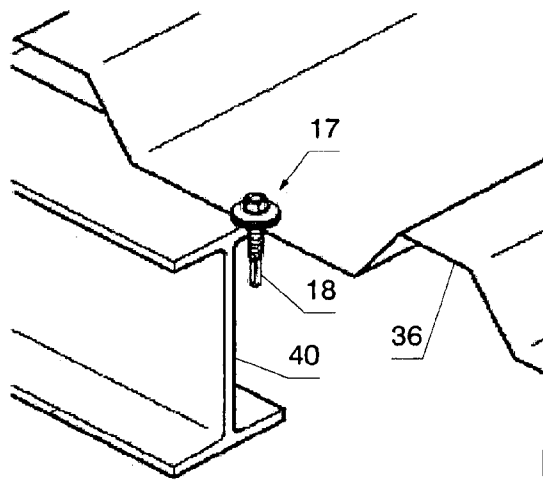


Fig. 7

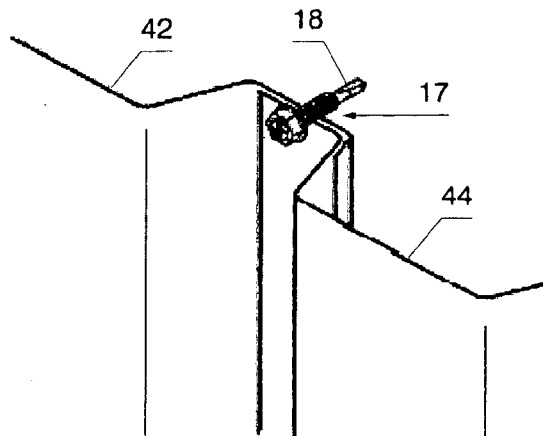


Fig. 8

