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I General Part

Technical Assessment Body issuing the ETA and designated according to Article 29 of the Regulation (EU) No 305/2011: ETA-Danmark A/S

Trade name of the construction product:

E.u.r.o. Tec screws type KonstruX", "KonstruX Duo", "Paneltwistec", "Topduo", "Terrassotec", "SP FK", "Speedo", "Hobotec", "Hapatec", "SP ZK", "Ecotec", "WBS", "Sawtec", "FBAS", "VSS", "Duratec", "LBS", "Transportanker screw", "WBS Strong" and "WBS ZK Hardwood" screws and "BRUTUS" threaded rods

Product family to which the above construction product belongs:

Screws for use in timber constructions

Manufacturer:

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Manufacturing plant:

Held on file by ETA-Danmark A/S

This European Technical Assessment contains:

67 pages including 7 annexes which form an integral part of the document

This European Technical Assessment is issued in accordance with Regulation (EU) No 305/2011, on the basis of:

European Assessment document (EAD) no. EAD 130118-01-0603 "Screws and threaded rods for timber constructions"

This version replaces:

The previous ETA with the same number issued on 2024-03-01

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II SPECIFIC PART OF THE EUROPEAN TECHNICAL ASSESSMENT

1 Technical description of product

E.u.r.o.Tec “KonstruX”, “KonstruX Duo”, “Paneltwistec”, “Topduo“, “Terrassotec“, “SP FK”, “Speedo”, “Hobotec”, “Hapatec”, “SP ZK”, “Ecotec”, “WBS”, “VSS”, “Sawtec”, “FBAS”, “Duratec”, “LBS”, “Transportanker screw”, “WBS Strong” and “WBS ZK Hardwood” screws and BRUTUS threaded rods are self-tapping screws to be used in timber structures. E.u.r.o.Tec “Paneltwistec”, “Topduo“, “Terrassotec“, “SP FK”, “Speedo”, “Hobotec”, “Hapatec”, “SP ZK”, “Sawtwc”, “FBAS” and “Duratec” screws shall be threaded over a part of the length. E.u.r.o.Tec “KonstruX”, “Transportanker screw”, “WBS”, “VSS” screws and BRUTUS threaded rods screws shall be threaded over the full length. E.u.r.o.Tec “Ecotec” and “LBS” screws may be threaded over a part or over the full length. “KonstruX Duo” screws have two threads, one close to the tip and one close to the head. The screws shall be produced from carbon steel wire for nominal diameters of 3,5 mm to 13,0 mm and from stainless steel wire for nominal diameters of 3,5 mm to 10,0 mm. The nominal diameter of BRUTUS threaded rods is 16 mm. E.u.r.o.Tec “Taurus” washers are used for self-tapping screws with countersunk head in timber structures. The washers shall be produced from carbon steel. Where corrosion protection is required, the material or coating shall be declared in accordance with the relevant specification given in Annex A of EN 14592.

Geometry and Material

The nominal diameter (outer thread diameter), d , shall not be less than 3,5 mm and shall not be greater than 16,0 mm. The overall length, L , of screws shall not be less than 25 mm and shall not be greater than 1000 mm. The overall length of the threaded rods shall not be greater than 3000 mm. Other dimensions are given in Annex A.

The ratio of inner thread diameter to outer thread diameter d_i/d ranges from 0,57 to 0,77.

The screws are threaded over a minimum length ℓ_g of $4 \cdot d$ (i.e. $\ell_g \geq 4 \cdot d$).

The lead p (distance between two adjacent thread flanks) ranges from $0,38 \cdot d$ to $0,97 \cdot d$.

No breaking shall be observed at a bend angle, α , of less than $(45/d^{0.7} + 20)$ degrees.

2 Specification of the intended use in accordance with the applicable European Assessment Document (hereinafter EAD)

The screws and threaded rods are used for connections in load bearing timber structures between members of solid timber (softwood), glued laminated timber, cross-laminated timber, and laminated veneer lumber (softwood and hardwood), similar glued members, wood-based panels or steel. E.u.r.o. Tec “KonstruX” screws and BRUTUS threaded rods are also used as tensile or compressive reinforcement perpendicular to the grain.

Furthermore E.u.r.o. Tec screws with diameters between 6 mm and 12 mm may also be used for the fixing of thermal insulation on rafters.

Steel plates and wood-based panels except solid wood panels, LVL and cross laminated timber shall only be located on the side of the screw head. The following wood-based panels may be used:

- Plywood according to EN 636 or ETA
- Particleboard according to EN 312 or ETA
- Oriented Strand Board, Type OSB/3 and OSB/4 according to EN 300 or ETA
- Fibreboard according to EN 622-2 and 622-3 or ETA (minimum density 650 kg/m³)
- Cement bonded particleboard
- Solid wood panels according to EN 13353 and EN 13986 and cross laminated timber according to ETA
- Laminated Veneer Lumber, LVL
- FST according to ETA-14/0354
- Engineered wood products according to ETA, provided that the ETA for the product provides provisions for the use of self-tapping screws and these provisions are applied

The screws shall be driven into softwood without pre-drilling or after pre-drilling with a diameter not larger than the inner thread diameter for the length of the threaded part and with a maximum of the smooth shank diameter for the length of the smooth shank. The threaded rods and the stainless steel KonstruX screws shall be driven into softwood after pre-drilling with the following diameter:

Threaded rod 16 mm: Pre-drilling diameter 13 mm.

KonstruX 10 mm austenitic stainless steel: Pre-drilling diameter 6 mm.

KonstruX 13 mm carbon steel: Pre-drilling diameter 9 mm.

Threaded rods or 10 mm KonstruX screws made from stainless steel shall only be driven into pre-drilled holes. 13 mm KonstruX screws shall only be driven in LVL into pre-drilled holes.

8 mm Paneltwistec screws made from stainless steel with insertion lengths exceeding 140 mm in softwood members shall only be driven into pre-drilled holes. The holes in Beech LVL according to EN 14374 or in FST according to ETA-14/0354 must always be pre-drilled.

8 mm Paneltwistec FT screws made from stainless steel with insertion lengths exceeding 300 mm in softwood members shall only be driven into pre-drilled holes. The holes in Beech LVL according to EN 14374 or in FST according to ETA-14/0354 must always be pre-drilled.

The screws are intended to be used in timber connections for which requirements for mechanical resistance and stability and safety in use in the sense of the Basic Works Requirements 1 and 4 of Regulation 305/2011 (EU) shall be fulfilled.

The design of the connections shall be based on the characteristic load-carrying capacities of the screws. The design capacities shall be derived from the characteristic capacities in accordance with Eurocode 5 or an appropriate national code.

The screws are intended for use for connections subject to static or quasi static loading.

Section 3.5 of this ETA contains corrosion protection for E.u.r.o. Tec screws made from carbon steel and the material number of stainless steel. The martensitic stainless steel screws are for use in timber structures subject to the conditions defined by the service classes 1, 2 and 3 of EN 1995-1-1 (Eurocode 5).

The scope of the screws regarding resistance to corrosion shall be defined according to national provisions that apply at the installation site considering environmental conditions.

The provisions made in this European Technical Assessment are based on an assumed intended working life of the screws of 50 years.

The indications given on the working life cannot be interpreted as a guarantee given by the producer or Assessment Body, but are to be regarded only as a means for choosing the right products in relation to the expected economically reasonable working life of the works.

3 Performance of the product and references to the methods used for its assessment

Characteristic	Assessment of characteristic
3.1 Mechanical resistance and stability*) (BWR1)	
Dimensions	See annex A
Characteristic yield moment	See section 3.4
Bending angle	No performance assessed
Characteristic withdrawal parameter	See section 3.4
Characteristic head pull-trough parameter of screws	See section 3.4
Tensile strength	Characteristic value $f_{tens,k}$:
Screws made of carbon steel or martensitic stainless steel except KonstruX, KonstruX Duo, Transportanker screw, WBS Strong and LBS	Screw d = 3,5 mm: 3,8 kN Screw d = 4,0 mm: 5,0 kN Screw d = 4,5 mm: 6,4 kN Screw d = 5,0 mm: 7,9 kN Screw d = 6,0 mm: 11 kN Screw d = 8,0 mm: 20 kN Screw d = 10,0 mm: 28 kN Screw d = 12,0 mm: 25 kN
KonstruX, KonstruX Duo, Transportanker screw and WBS Strong screws made of carbon steel	Screw d = 5,2 mm: 13 kN Screw d = 5,9 mm: 17 kN Screw d = 6,5 mm: 17 kN Screw d = 8,0 mm: 25 kN Screw d = 9,0 mm: 30 kN Screw d = 10,0 mm: 33 kN Screw d = 11,3 mm: 50 kN Screw d = 13,0 mm: 75 kN
LBS or WBS ZK Hardwood screws made of carbon steel	Screw d = 5,6 mm: 14 kN Screw d = 8,0 mm: 30 kN
Screws made of austenitic stainless steel except KonstruX, WBS Strong and Paneltwistec FT	Screw d = 3,5 mm: 2,1 kN Screw d = 4,0 mm: 2,8 kN Screw d = 4,5 mm: 3,5 kN Screw d = 4,8 mm: 5,0 kN Screw d = 5,0 mm: 4,3 kN Screw d = 5,3 mm: 6,0 kN Screw d = 6,0 mm: 6,2 kN Screw d = 6,5 mm: 10 kN Screw d = 8,0 mm: 11 kN Screw d = 10,0 mm: 20 kN
KonstruX, WBS, WBS Strong and Paneltwistec FT screws made of austenitic stainless steel	Screw d = 5,0 mm: 6,2 kN Screw d = 6,5 mm: 10 kN Screw d = 8,0 mm: 14 kN Screw d = 10,0 mm: 20 kN
BRUTUS threaded rod	Rod d = 16 mm: 115 kN
Characteristic yield strength	See section 3.4
Insertion moment	Ratio of the characteristic torsional strength to the mean insertion moment: $f_{tor,k} / R_{tor,mean} \geq 1,5$

Characteristic	Assessment of characteristic
Torsional strength	Characteristic value $f_{tor,k}$:
Screws made of carbon steel or martensitic stainless steel except KonstruX, KonstruX Duo, Transportanker screw, WBS Strong and LBS	Screw d = 3,5 mm: 2,0 Nm
	Screw d = 4,0 mm: 3,0 Nm
	Screw d = 4,5 mm: 4,2 Nm
	Screw d = 5,0 mm: 5,6 Nm
	Screw d = 6,0 mm: 9,5 Nm
	Screw d = 8,0 mm: 22 Nm
	Screw d = 10,0 mm: 40 Nm
	Screw d = 12,0 mm: 52 Nm
KonstruX, KonstruX Duo, Transportanker screw and WBS Strong screws made of carbon steel	Screw d = 5,2 mm: 10 Nm
	Screw d = 5,9 mm: 15 Nm
	Screw d = 6,5 mm: 19 Nm
	Screw d = 8,0 mm: 28 Nm
	Screw d = 9,0 mm: 51 Nm
	Screw d = 10,0 mm: 48 Nm
	Screw d = 11,3 mm: 80 Nm
LBS or WBS ZK Hardwood screws made of carbon steel	Screw d = 5,6 mm: 13 Nm
	Screw d = 8,0 mm: 40 Nm
Screws made of austenitic stainless steel except KonstruX, WBS Strong and Paneltwistec FT	Screw d = 3,5 mm: 1,2 Nm
	Screw d = 4,0 mm: 1,8 Nm
	Screw d = 4,5 mm: 2,5 Nm
	Screw d = 4,8 mm: 4,3 Nm
	Screw d = 5,0 mm: 4,4 Nm
	Screw d = 5,3 mm: 5,0 Nm
	Screw d = 6,0 mm: 5,7 Nm
	Screw d = 6,5 mm: 10,0 Nm
	Screw d = 8,0 mm: 13,0 Nm
KonstruX, WBS, WBS Strong and Paneltwistec FT screws made of austenitic stainless steel	Screw d = 6,5 mm: 11 Nm
	Screw d = 8,0 mm: 16 Nm
	Screw d = 10,0 mm: 28 Nm
BRUTUS threaded rod	Rod d = 16 mm: 180 Nm
Spacing, end and edge distances of the screws or threaded rods and minimum thickness of the timber material	See annex B
Slip modulus for mainly axially loaded screws and threaded rods	See section 3.4
Durability against corrosion	See section 3.5
3.2 Safety in case of fire (BWR2)	
Reaction to fire	The screws are made from steel classified as performance class A1 of the characteristic reaction to fire, in accordance with the provisions of EC decision 96/603/EC, amended by EC Decision 2000/605/EC.
3.3 General aspects related to the performance of the product	
	The screws have been assessed as having satisfactory durability and serviceability when used in timber structures using the timber species described in Eurocode 5 and subject to the conditions defined by service classes 1, 2 and 3

*) See additional information in section 3.4 – 3.6.

3.4 Mechanical resistance and stability

The load-carrying capacities for E.u.r.o.Tec screws are applicable to the wood-based materials mentioned in paragraph 1 even though the term timber has been used in the following.

The characteristic lateral load-carrying capacities and the characteristic axial withdrawal capacities of E.u.r.o.Tec screws should be used for designs in accordance with Eurocode 5 or an appropriate national code.

Point side penetration length must be $\ell_{ef} \geq 4 \cdot d$, where d is the outer thread diameter of the screw or threaded rod. For the fixing of rafters, point side penetration must be at least 40 mm, $\ell_{ef} \geq 40$ mm.

The mathematical penetration length of the threaded rods shall be limited to 1000 mm even if the actual penetration length is longer.

ETA's for structural members or wood-based panels must be considered where applicable.

Lateral load-carrying capacity

The characteristic lateral load-carrying capacity of E.u.r.o.Tec screws or threaded rods shall be calculated according to Eurocode 5 using the outer thread diameter d as the nominal diameter of the screw. The contribution from the rope effect may be considered.

For steel-to-timber connections with "WBS" screws $d = 5$ mm or "WBS ZK Hardwood" with $d = 5,6$ mm, a thick steel plate may be assumed for steel plate thickness $t \geq 2,0$ mm. For steel-to-timber connections with or "WBS ZK Hardwood" $d = 5,6$ mm in Beech LVL according to EN 14374 or in FST according to ETA-14/0354, a thick steel plate may be assumed for steel plate thickness $t \geq 3,0$ mm.

The characteristic yield moment shall be calculated from:

E.u.r.o.Tec screws for $3,5 \text{ mm} \leq d \leq 10,0 \text{ mm}$ made of carbon steel or martensitic stainless steel except KonstruX, KonstruX Duo, Transportanker screw and WBS Strong:
 $M_{y,k} = 0,15 \cdot 600 \cdot d^{2,6}$ [Nmm]

Paneltwistec screws:

Screw $d = 12,0 \text{ mm}$: 40000 Nmm

E.u.r.o.Tec threaded rods:

Rod $d = 16,0 \text{ mm}$: 240000 Nmm

KonstruX, KonstruX Duo, Transportanker screw and WBS Strong screws made of carbon steel:

Screw $d = 5,2 \text{ mm}$: 10000 Nmm

Screw $d = 5,9 \text{ mm}$: 15000 Nmm

Screw $d = 6,5 \text{ mm}$: 15000 Nmm

Screw $d = 8,0 \text{ mm}$: 25000 Nmm

Screw $d = 9,0 \text{ mm}$: 40000 Nmm

Screw $d = 10,0 \text{ mm}$: 40000 Nmm

Screw $d = 11,3 \text{ mm}$: 70000 Nmm

Screw $d = 13,0 \text{ mm}$: 120000 Nmm

E.u.r.o.Tec LBS screws:

Screw $d = 8,0 \text{ mm}$: 35000 Nmm

E.u.r.o.Tec WBS ZK Hardwood screws:

Screw $d = 5,6 \text{ mm}$: 13000 Nmm

E.u.r.o.Tec screws for $3,5 \text{ mm} \leq d \leq 10,0 \text{ mm}$ made of austenitic stainless steel except FBAS, KonstruX and WBS Strong:

$$M_{y,k} = 0,15 \cdot 320 \cdot d^{2,6} \quad [\text{Nmm}]$$

E.u.r.o.Tec FBAS screws:

Screw $d = 4,8 \text{ mm}$: 3800 Nmm

Screw $d = 5,3 \text{ mm}$: 5000 Nmm

E.u.r.o.Tec KonstruX, WBS and WBS strong screws made of austenitic stainless steel:

Screw $d = 5,0 \text{ mm}$: 4300 Nmm

Screw $d = 6,5 \text{ mm}$: 10000 Nmm

Screw $d = 8,0 \text{ mm}$: 16000 Nmm

Screw $d = 10,0 \text{ mm}$: 26000 Nmm

where

d outer thread diameter [mm]

The embedding strength for screws in non-pre-drilled holes in softwood arranged at an angle between screw axis and grain direction, $0^\circ \leq \varepsilon \leq 90^\circ$ is:

$$f_{h,k} = \frac{0,082 \cdot \rho_k \cdot d^{-0,3}}{2,5 \cdot \cos^2 \varepsilon + \sin^2 \varepsilon} \quad [\text{N/mm}^2]$$

and accordingly for screws in pre-drilled holes:

$$f_{h,k} = \frac{0,082 \cdot \rho_k \cdot (1 - 0,01 \cdot d)}{2,5 \cdot \cos^2 \varepsilon + \sin^2 \varepsilon} \quad [\text{N/mm}^2]$$

Where

ρ_k characteristic timber density [kg/m^3];

d outer thread diameter [mm];

ε angle between screw axis and grain direction.

The embedding strength for screws arranged parallel to the plane of cross laminated timber, independent of the angle between screw axis and grain direction, $0^\circ \leq \varepsilon \leq 90^\circ$, may be calculated from:

$$f_{h,k} = 20 \cdot d^{-0,5} \quad [\text{N/mm}^2]$$

Where

d outer thread diameter [mm]

The embedding strength for screws or threaded rods in the wide face of cross laminated timber should be assumed as for solid timber based on the characteristic density of the outer layer. If relevant, the angle between force and grain direction of the outer layer should be taken into account.

The direction of the lateral force shall be perpendicular to the screw axis and parallel to the wide face of the cross laminated timber.

The embedding strength for screws in non-pre-drilled holes in softwood LVL arranged at an angle between screw axis and grain direction, $0^\circ \leq \varepsilon \leq 90^\circ$ is:

$$f_{h,k} = \frac{0,082 \cdot \rho_k \cdot d^{-0,3}}{(2,5 \cdot \cos^2 \varepsilon + \sin^2 \varepsilon)(1,5 \cdot \cos^2 \beta + \sin^2 \beta)} \quad [\text{N/mm}^2]$$

and accordingly for screws in pre-drilled holes in softwood LVL:

$$f_{h,k} = \frac{0,082 \cdot \rho_k \cdot (1 - 0,01 \cdot d)}{(2,5 \cdot \cos^2 \varepsilon + \sin^2 \varepsilon)(1,5 \cdot \cos^2 \beta + \sin^2 \beta)} \quad [\text{N/mm}^2]$$

Where:

- ρ_k characteristic timber density [kg/m^3],
 d outer thread diameter [mm],
 ε angle between screw axis and grain direction,
 β angle between screw axis and the LVL's wide face ($0^\circ \leq \beta \leq 90^\circ$).

The embedding strength for screws in pre-drilled or non-pre-drilled holes in Beech LVL according to EN 14374 or in FST according to ETA-14/0354 is:

$$f_{h,k} = \frac{0,082 \cdot \rho_k \cdot d^{-0,15}}{(2,5 \cdot \cos^2 \varepsilon + \sin^2 \varepsilon) \cdot k_\varepsilon \cdot k_\beta} \quad [\text{N/mm}^2]$$

Where

- ρ_k characteristic density [kg/m^3];
 d outer thread diameter [mm];
 ε angle between screw axis and grain direction, $0^\circ \leq \varepsilon \leq 90^\circ$;
 $k_\alpha = (0,5 + 0,024 \cdot d) \cdot \sin^2 \alpha + \cos^2 \alpha$;
 α angle between load and grain direction; $0^\circ \leq \alpha \leq 90^\circ$;
 $k_\beta = 1,2 \cdot \cos^2 \beta + \sin^2 \beta$;
 β angle between screw axis and wide face of LVL or FST member, $0^\circ \leq \beta \leq 90^\circ$.

Axial withdrawal capacity

The characteristic axial withdrawal capacity of E.u.r.o.Tec screws in solid timber (softwood), glued laminated timber or cross-laminated timber members at an angle of $0^\circ \leq \varepsilon \leq 90^\circ$ (screws without tip type BS or Paneltwistec or KonstruX screws in Beech LVL or FST according to ETA-14/0354) or $30^\circ \leq \varepsilon \leq 90^\circ$ (screws with tip type BS) to the grain shall be calculated from:

$$F_{ax,\varepsilon,Rk} = \frac{n_{ef} \cdot k_{ax} \cdot f_{ax,k} \cdot d \cdot \ell_{ef}}{k_\beta} \left(\frac{\rho_k}{\rho_a} \right)^{0,8} \quad [\text{N}]$$

Where

- $F_{ax,\varepsilon,Rk}$ characteristic withdrawal capacity of the group of screws at an angle ε to the grain [N]
 n_{ef} effective number of screws according to EN 1995-1-1:2008
 k_{ax} $k_{ax} = 1,0$ for $45^\circ \leq \varepsilon \leq 90^\circ$
 $k_{ax} = a + \frac{b \cdot \varepsilon}{45^\circ}$ for $0^\circ \leq \varepsilon < 45^\circ$

$$a = \begin{cases} 0,5 & \text{for LVL or FST} \\ 0,3 & \text{for timber} \end{cases}$$

$$b = \begin{cases} 0,5 & \text{for LVL or FST} \\ 0,7 & \text{for timber} \end{cases}$$

k_β

$k_\beta = 1,0$ for timber

$k_\beta = 1,5 \cdot \cos^2 \beta + \sin^2 \beta$ for LVL or FST

$f_{ax,k}$

Characteristic withdrawal parameter

Screws with tip type BS in softwood and $\rho_a = 350 \text{ kg/m}^3$:

Screw $d \leq 10 \text{ mm}$: $f_{ax,k} = 9,0 \text{ N/mm}^2$

Screw $d = 11,3 \text{ mm}$: $f_{ax,k} = 8,0 \text{ N/mm}^2$

Screws without tip type BS except KonstruX

Duo $d = 6,5 \text{ mm}$ and KonstruX with tip type

rBS DAG in softwood and $\rho_a = 350 \text{ kg/m}^3$:

Screw $d = 3,5 \text{ mm}$: $f_{ax,k} = 13,3 \text{ N/mm}^2$

Screw $d = 4,0 \text{ mm}$: $f_{ax,k} = 12,9 \text{ N/mm}^2$

Screw $d = 4,5 \text{ mm}$: $f_{ax,k} = 12,5 \text{ N/mm}^2$

Screw $d = 4,8 \text{ mm}$: $f_{ax,k} = 12,1 \text{ N/mm}^2$

Screw $d = 5,0 \text{ mm}$: $f_{ax,k} = 12,1 \text{ N/mm}^2$

Screw $d = 5,3 \text{ mm}$: $f_{ax,k} = 11,4 \text{ N/mm}^2$

Screw $d = 5,6 \text{ mm}$: $f_{ax,k} = 12,1 \text{ N/mm}^2$

Screw $d = 6,0 \text{ mm}$: $f_{ax,k} = 11,4 \text{ N/mm}^2$

Screw $d = 6,5 \text{ mm}$: $f_{ax,k} = 11,4 \text{ N/mm}^2$

Screw $d = 8,0 \text{ mm}$: $f_{ax,k} = 11,1 \text{ N/mm}^2$

KonstruX Duo screw

$d = 6,5 \text{ mm}$ $f_{ax,k} = 4,0 \text{ N/mm}^2$

KonstruX screw with tip type rBS DAG

$d \leq 6,5 \text{ mm}$ $f_{ax,k} = 15,5 \text{ N/mm}^2$

$d = 8,0 \text{ mm}$ $f_{ax,k} = 12,5 \text{ N/mm}^2$

$d = 10,0 \text{ mm}$ $f_{ax,k} = 11,5 \text{ N/mm}^2$

Screw or threaded rod

$d \geq 10,0 \text{ mm}$: $f_{ax,k} = 10,8 \text{ N/mm}^2$

Paneltwistec, WBS, Duratec or KonstruX

screws in softwood LVL and $\rho_a = 500 \text{ kg/m}^3$:

Screw $5 \text{ mm} \leq d \leq 12 \text{ mm}$: $f_{ax,k} = 15 \text{ N/mm}^2$

Paneltwistec, LBS, WBS or KonstruX screws

in pre-drilled hardwood LVL or FST (ETA-

14/0354) and $\rho_a = 730 \text{ kg/m}^3$:

Screw $5 \text{ mm} \leq d \leq 7 \text{ mm}$: $f_{ax,k} = 31 \text{ N/mm}^2$

Screw $8 \text{ mm} \leq d \leq 10 \text{ mm}$: $f_{ax,k} = 25 \text{ N/mm}^2$

LBS or WBS ZK Hardwood screws in non-

pre-drilled hardwood LVL or FST (ETA-

14/0354) and $\rho_a = 730 \text{ kg/m}^3$:

Screw $d = 5,6 \text{ mm}$: $f_{ax,k} = 40 \text{ N/mm}^2$

Screw $d = 8,0 \text{ mm}$: $f_{ax,k} = 30 \text{ N/mm}^2$

d

ℓ_{ef}

outer thread diameter [mm]

point or head side penetration length of the threaded part excluding the head according to EN 1995-1-1:2008 [mm]

ε

angle between screw axis and grain ($\varepsilon \geq 30^\circ$ for screws with tip type BS)

β

angle between screw axis and the LVL's wide face ($0^\circ \leq \beta \leq 90^\circ$)

ρ_k

characteristic density [kg/m^3]

ρ_a

associated density for $f_{ax,k}$ [kg/m^3]

For screws penetrating more than one layer of cross laminated timber, the different layers may be taken into account proportionally.

The axial withdrawal capacity for screws arranged parallel to the plane of cross laminated timber, independent of the angle between screw axis and grain direction, $0^\circ \leq \varepsilon \leq 90^\circ$, may be calculated from:

$$F_{ax,Rk} = 20 \cdot d^{0,8} \cdot \ell_{ef}^{0,9} \quad [N]$$

The axial withdrawal capacity is limited by the head pull-through capacity and the tensile or compressive capacity of the screw.

For axially loaded screws or threaded rods in tension, where the external force is parallel to the screw axes, the rules in EN 1995-1-1, 8.7.2 (8) should be applied.

For inclined screws or threaded rods in timber-to-timber or steel-to-timber shear connections, where the screws or threaded rods are arranged under an angle $30^\circ \leq \alpha \leq 60^\circ$ between the shear plane and the screw axis, the effective number of screws n_{ef} should be determined as follows:

For one row of n screws or threaded rods parallel to the load, the load-carrying capacity should be calculated using the effective number of fasteners n_{ef} , where:

$$n_{ef} = \max\{n^{0,9}; 0,9 \times n\}$$

and n is the number of inclined screws or threaded rods in a row. If crossed pairs of screws or threaded rods are used in timber-to-timber connections, n is the number of crossed pairs of screws or threaded rods in a row.

Note: For screws or threaded rods as reinforcement or inclined screws or threaded rods as fasteners in mechanically jointed beams or columns or for the fixing of thermal insulation material, $n_{ef} = n$.

Head pull-through capacity

The characteristic head pull-through capacity of E.u.r.o.Tec screws shall be calculated according to EN 1995-1-1:2008 from:

$$F_{ax,\varepsilon,Rk} = n_{ef} \cdot f_{head,k} \cdot d_h^2 \cdot \left(\frac{\rho_k}{350}\right)^{0,8} \quad [N]$$

where:

$F_{ax,\varepsilon,Rk}$	characteristic head pull-through capacity of the connection at an angle $\varepsilon \geq 30^\circ$ to the grain [N]
n_{ef}	effective number of screws according to EN 1995-1-1:2008
$f_{head,k}$	characteristic head pull-through parameter [N/mm ²]
d_h	diameter of the screw head [mm]
ρ_k	characteristic density [kg/m ³], for wood-based panels $\rho_k = 380 \text{ kg/m}^3$

Characteristic head pull-through parameter for E.u.r.o.Tec screws with head type FK and FK2 in connections with timber and in connections with wood-based panels with thicknesses above 20 mm:

$$f_{head,k} = 10,0 \text{ N/mm}^2$$

Characteristic head pull-through parameter for E.u.r.o.Tec screws except screws with head type FK and FK2 in connections with timber and in connections with wood-based panels with thicknesses above 20 mm:

$$f_{head,k} = 12,0 \text{ N/mm}^2$$

Characteristic head pull-through parameter for Paneltwistec, LBS, KonstruX or WBS Strong screws with a head diameter $d_h \leq 25 \text{ mm}$ in connections with LVL and FST (ETA-14/0354) members with characteristic density $700 \text{ kg/m}^3 \leq \rho_k \leq 750 \text{ kg/m}^3$ with thicknesses of at least 40 mm:

$$f_{head,k} = 47 - 1,5 \cdot d_h \text{ N/mm}^2$$

Characteristic head pull-through parameter for screws in connections with wood-based panels with thicknesses between 12 mm and 20 mm:

$$f_{head,k} = 8 \text{ N/mm}^2$$

Screws in connections with wood-based panels with a thickness below 12 mm (minimum thickness of the wood based panels of $1,2 \cdot d$ with d as outer thread diameter):

$$f_{head,k} = 8 \text{ N/mm}^2$$

limited to $F_{ax,Rk} = 400 \text{ N}$

For “KonstruX” or “LBS” screws, the withdrawal capacity of the thread in the member with the screw head may be taken into account instead of the head pull-through capacity.

The head diameter d_h shall be greater than $1,8 \cdot d_s$, where d_s is the smooth shank or the wire diameter. Otherwise the characteristic head pull-through capacity $F_{ax,\varepsilon,Rk} = 0$.

The minimum thickness of wood-based panels according to the clause 2.1 must be observed.

In steel-to-timber connections the head pull-through capacity may be disregarded.

Tensile capacity

The characteristic tensile strength $f_{tens,k}$ of E.u.r.o.Tec screws or threaded rods made of carbon steel or martensitic stainless steel 1.4006 except KonstruX, KonstruX Duo, Transportanker screw, WBS Strong or LBS is:

Screw $d = 3,5 \text{ mm}$:	3,8 kN
Screw $d = 4,0 \text{ mm}$:	5,0 kN
Screw $d = 4,5 \text{ mm}$:	6,4 kN
Screw $d = 5,0 \text{ mm}$:	7,9 kN
Screw $d = 6,0 \text{ mm}$:	11 kN
Screw $d = 8,0 \text{ mm}$:	20 kN
Screw $d = 10,0 \text{ mm}$:	28 kN
Screw $d = 12,0 \text{ mm}$:	25 kN

Rod d = 16,0 mm: 115 kN

The characteristic tensile strength $f_{\text{tens},k}$ of E.u.r.o.Tec KonstruX, KonstruX Duo, Transportanker screw and WBS Strong screws made of carbon steel is:

Screw d = 5,2 mm: 13 kN
 Screw d = 5,9 mm: 17 kN
 Screw d = 6,5 mm: 17 kN
 Screw d = 8,0 mm: 25 kN
 Screw d = 9,0 mm: 30 kN
 Screw d = 10,0 mm: 33 kN
 Screw d = 11,3 mm: 50 kN
 Screw d = 13,0 mm: 75 kN

The characteristic tensile strength $f_{\text{tens},k}$ of E.u.r.o.Tec LBS and WBS ZK Hardwood screws made of carbon steel is:

WBS ZK Hardwood Screw d = 5,6 mm: 14 kN
 LBS Screw d = 8 mm: 30 kN

The characteristic tensile strength $f_{\text{tens},k}$ of E.u.r.o.Tec screws made of austenitic stainless steel except KonstruX, WBS Strong and Paneltwistec FT is:

Screw d = 3,5 mm: 2,1 kN
 Screw d = 4,0 mm: 2,8 kN
 Screw d = 4,5 mm: 3,5 kN
 Screw d = 4,8 mm: 5,0 kN
 Screw d = 5,0 mm: 4,3 kN
 Screw d = 5,3 mm: 6,0 kN
 Screw d = 6,0 mm: 6,2 kN
 Screw d = 8,0 mm: 11 kN
 Screw d = 10,0 mm: 20 kN

The characteristic tensile strength $f_{\text{tens},k}$ of E.u.r.o.Tec KonstruX, WBS, WBS Strong and Paneltwistec FT screws made of austenitic stainless steel is:

Screw d = 5,0 mm: 6,2 kN
 Screw d = 6,5 mm: 10 kN
 Screw d = 8,0 mm: 14 kN
 Screw d = 10,0 mm: 20 kN

For screws used in combination with steel plates, the tear-off capacity of the screw head should be greater than the tensile strength of the screw.

Compressive capacity

The characteristic buckling capacity $F_{\text{ki},\text{Rk}}$ of E.u.r.o.Tec KonstruX, Transportanker screw, WBS Strong or LBS screws or “BRUTUS” threaded rods embedded in timber shall be calculated from:

$$F_{\text{ki},\text{Rk}} = \kappa_c \cdot N_{\text{pl},k} \quad [\text{N}]$$

where

$$\kappa_c = \begin{cases} 1 & \text{for } \bar{\lambda}_k \leq 0,2 \\ \frac{1}{k + \sqrt{k^2 - \bar{\lambda}_k^2}} & \text{for } \bar{\lambda}_k > 0,2 \end{cases}$$

$$k = 0,5 \cdot \left[1 + 0,49 \cdot (\bar{\lambda}_k - 0,2) + \bar{\lambda}_k^2 \right]$$

The relative slenderness ratio shall be calculated from:

$$\bar{\lambda}_k = \sqrt{\frac{N_{\text{pl},k}}{N_{\text{ki},k}}}$$

Where

$$N_{\text{pl},k} = \pi \cdot \frac{d^2}{4} \cdot f_{y,k} \quad [\text{N}]$$

is the characteristic value for the axial capacity in case of plastic analysis referred to the inner thread cross section.

Characteristic yield strength:

$f_{y,k} = 1000$ [N/mm²] for KonstruX, Transportanker screw, WBS Strong (d < 12 mm) or LBS screws made of carbon steel or martensitic stainless steel

$f_{y,k} = 750$ [N/mm²] for BRUTUS threaded rods

$f_{y,k} = 550$ [N/mm²] for KonstruX screws (d = 13 mm) made of carbon steel

$f_{y,k} = 500$ [N/mm²] for KonstruX or WBS Strong screws made of austenitic stainless steel

Characteristic ideal elastic buckling load:

$$N_{\text{ki},k} = \sqrt{c_h \cdot E_s \cdot I_s} \quad [\text{N}]$$

Elastic foundation of the screw:

$$c_h = (0,19 + 0,012 \cdot d) \cdot \rho_k \cdot \left(\frac{\varepsilon}{180^\circ} + 0,5 \right) \quad [\text{N/mm}^2]$$

Modulus of elasticity:

$$E_s = 205000 \quad [\text{N/mm}^2]$$

Second moment of area:

$$I_s = \frac{\pi}{64} \cdot d_1^4 \quad [\text{mm}^4]$$

d_1 = inner thread diameter [mm]

ε = angle between screw axis and grain direction [°]

Note: When determining design values of the compressive capacity it should be considered that $f_{\text{ax},d}$ is to be calculated using k_{mod} and γ_M for timber according to EN 1995 while $N_{\text{pl},d}$ is calculated using $\gamma_{M,0}$ for steel according to EN 1993.

Mechanically jointed beams

“KonstruX” or “LBS” screws with a full thread or “BRUTUS” threaded rods may be used for connections in structural members which are composed of several parts in mechanically jointed beams or columns.

The axial slip modulus K_{ser} of a screw or threaded rod with a full thread for the serviceability limit state should be taken independent of angle ε to the grain as:

$C = K_{\text{ser}} = 25 \cdot d \cdot \ell_{\text{ef}}$ [N/mm] for screws in softwood
 $C = K_{\text{ser}} = 30 \cdot d \cdot \ell_{\text{ef}}$ [N/mm] for screws in hardwood
 $C = K_{\text{ser}} = 250 \cdot \ell_{\text{ef}}$ [N/mm] for threaded rods

Where

d outer thread diameter [mm]
 ℓ_{ef} penetration length in the structural member [mm]
 (see Annex B)

Combined laterally and axially loaded screws

For screwed connections subjected to a combination of axial and lateral load, the following expression should be satisfied:

$$\left(\frac{F_{ax,Ed}}{F_{ax,Rd}} \right)^2 + \left(\frac{F_{la,Ed}}{F_{la,Rd}} \right)^2 \leq 1$$

where

$F_{ax,Ed}$ axial design load of the screw
 $F_{la,Ed}$ lateral design load of the screw
 $F_{ax,Rd}$ design load-carrying capacity of an axially loaded screw
 $F_{la,Rd}$ design load-carrying capacity of a laterally loaded screw.

3.5 Aspects related to the performance of the product

3.5.1 Corrosion protection in service class 1, 2 and 3.

The E.u.r.o. Tec screws with nominal diameters of 3,5 mm to 16,0 mm are produced from carbon wire. Screws made from carbon steel are electrogalvanised or otherwise coated appropriate for the expected working life and service class. The mean thickness of the zinc coating is 5µm.

Screws with nominal diameters of 3,5 mm to 10,0 mm are produced from martensitic stainless steel no. 1.4006 or austenitic stainless steel no. 1.4301, 1.4401, 1.4529, 1.4539, 1.4567 and 1.4578.

3.6 General aspects related to the intended use of the product

The screws or threaded rods are manufactured in accordance with the provisions of the European Technical Assessment using the automated manufacturing process and laid down in the technical documentation.

The installation shall be carried out in accordance with Eurocode 5 or an appropriate national code unless otherwise is defined in the following. Instructions from E.u.r.o.Tec GmbH should be considered for installation.

The screws or threaded rods are used for connections in load bearing timber structures between members of solid timber (softwood), glued laminated timber, cross-laminated timber, and laminated veneer lumber, similar glued members, wood-based panels or steel members.

The screws or threaded rods may be used for connections in load bearing timber structures with structural members according to an associated ETA, if according to the associated ETA of the structural member a connection in load bearing timber structures with screws according to a ETA is allowed.

E.u.r.o.Tec fully threaded „KonstruX” or “LBS” screws or threaded rods are also used as tensile or compressive reinforcement perpendicular to the grain.

Furthermore the screws with diameters of at least 6 mm may also be used for the fixing of insulation on top of rafters.

A minimum of two screws or threaded rods should be used for connections in load bearing timber structures.

For screws arranged under an angle between screw axis and grain direction of less than 90°, the minimum penetration depth of the screw tip is:

$$\ell_{ef} \geq \min (4 \cdot d / \sin \varepsilon ; 20 \cdot d).$$

Wood-based panels and steel plates should only be arranged on the side of the screw head. The minimum thickness of wood-based panels should be 1,2·d. Furthermore the minimum thickness for following wood-based panels should be:

- Plywood, Fibreboards: 6 mm
- Particleboards, OSB, Cement Particleboards: 8 mm
- Solid wood panels: 12 mm

For structural members according to ETA's the terms of the ETA's must be considered.

If screws with an outer thread diameter $d \geq 8$ mm are used in load bearing timber structures, the structural solid or glued laminated timber, laminated veneer lumber and similar glued members must be from spruce, pine or fir. This does not apply for screws or threaded rods in pre-drilled holes or for screws with tip type BS or rBS DAG in non-pre-drilled holes.

The minimum angle between the screw axis of screws with tip type BS or BRUTUS threaded rods and the grain direction is $\varepsilon = 30^\circ$. For other screws: $0^\circ \leq \varepsilon \leq 90^\circ$.

The screws shall be driven into softwood with or without pre-drilling. The maximum pre-drilling diameter is the inner thread diameter for the length of the threaded part and the smooth shank diameter for the depth of the smooth shank.

The drill hole diameters are:

Outer thread diameter [mm]	Drill hole diameter [mm]	
	Softwood	Beech LVL or FST
4,0	2,5	-
4,5	2,5	-
5,0 or 5,2	3,0	3,5
5,9	3,5	4,0
6,0	4,0	4,5
6,5	4,0	5,0
8,0	5,0	6,0
10,0	6,0	8,0
12,0	7,0	-
13,0	9,0	-

The threaded rods shall be driven into softwood after pre-drilling with the following diameter:

BRUTUS threaded rod 16 mm: Pre-drilling diameter 13 mm

BRUTUS threaded rod shall only be driven into pre-drilled holes.

The hole diameter in steel members must be predrilled with a suitable diameter.

Only the equipment prescribed by E.u.r.o.Tec GmbH shall be used for driving the screws.

In connections with screws with countersunk head according to Annex A the head must be flush with the surface of the connected structural member. A deeper countersink is not allowed.

For structural timber members, minimum spacing and distances for screws or threaded rods in predrilled holes are given in Eurocode 5 clause 8.3.1.2 and table 8.2 as for nails in predrilled holes. Here, the outer thread diameter d must be considered.

For screws in non-predrilled holes, minimum spacing and distances are given in Eurocode 5 clause 8.3.1.2 and table 8.2 as for nails in non-predrilled holes.

For Douglas fir members minimum spacing and distances parallel to the grain shall be increased by 50%.

Minimum distances from loaded or unloaded ends must be $15 \cdot d$ for screws in non-predrilled holes with outer thread diameter $d \geq 8$ mm and timber thickness $t < 5 \cdot d$.

Minimum distances from the unloaded edge perpendicular to the grain may be reduced to $3 \cdot d$ also for timber thickness $t < 5 \cdot d$, if the spacing parallel to the grain and the end distance is at least $25 \cdot d$.

Minimum distances and spacing for exclusively axially loaded screws in non-predrilled holes in members with a minimum thickness $t = 10 \cdot d$ and a minimum width of $8 \cdot d$ or 60 mm, whichever is the greater, may be taken as:

Spacing a_1 parallel to the grain	$a_1 = 5 \cdot d$
Spacing a_2 perpendicular to the grain	$a_2 = 5 \cdot d$
Distance $a_{1,c}$ from centre of the screw-part in timber to the end grain	$a_{1,c} = 10 \cdot d$
Distance $a_{2,c}$ from centre of the screw-part in timber to the edge	$a_{2,c} = 4 \cdot d$

Spacing a_2 perpendicular to the grain may be reduced from $5 \cdot d$ to $2,5 \cdot d$, if the condition $a_1 \cdot a_2 \geq 25 \cdot d^2$ is fulfilled.

Minimum distances and spacing for WBS ZK Hardwood screws in non-predrilled holes in steel-to-timber connections in members with minimum thickness $t = 15 \cdot d$ and minimum width of $15 \cdot d$ may be taken as:

Spacing a_1 parallel to the grain	$a_1 = 20$ mm
Spacing a_2 perpendicular to the grain	$a_2 = 20$ mm

Loaded end distance $a_{3,t}$	$a_{3,t} = 85$ mm
Unloaded end distance $a_{3,c}$	$a_{3,c} = 60$ mm
Loaded edge distance $a_{4,t}$	$a_{4,t} = 50$ mm
Unloaded edge distance $a_{4,c}$	$a_{4,t} = 30$ mm

Spacing a_2 perpendicular to the grain may be reduced from 20 mm to 10 mm if the condition $a_1 \cdot a_2 \geq 400$ mm² is fulfilled.

Minimum distances and spacing for 8 mm “LBS” screws in non-predrilled holes in Beech LVL or FST members with a minimum thickness $t = 14 \cdot d$ and a minimum width of $14 \cdot d$ may be taken as:

Spacing a_1 parallel to the grain	$a_1 = 15 \cdot d$
Spacing a_2 perpendicular to the grain	$a_2 = 7 \cdot d$
Loaded end distance $a_{3,t}$	$a_{3,t} = 20 \cdot d$
Unloaded end distance $a_{3,c}$	$a_{3,c} = 15 \cdot d$
Loaded edge distance $a_{4,t}$	$a_{4,t} = 10 \cdot d$
Unloaded edge distance $a_{4,c}$	$a_{4,c} = 7 \cdot d$

Minimum distances and spacing for exclusively axially loaded screws in predrilled holes or for screws with tip type BS or rBS DAG in non-predrilled holes in members with a minimum thickness $t = 10 \cdot d$ and a minimum width of $8 \cdot d$ or 60 mm, whichever is the greater, may be taken as:

Spacing a_1 parallel to the grain	$a_1 = 5 \cdot d$
Spacing a_2 perpendicular to the grain	$a_2 = 5 \cdot d$
Distance $a_{1,c}$ from centre of the screw-part in timber to the end grain	$a_{1,c} = 5 \cdot d$
Distance $a_{2,c}$ from centre of the screw-part in timber to the edge	$a_{2,c} = 3 \cdot d$

Spacing a_2 perpendicular to the grain may be reduced from $5 \cdot d$ to $2,5 \cdot d$, if the condition $a_1 \cdot a_2 \geq 25 \cdot d^2$ is fulfilled.

For a crossed screw couple the minimum spacing between the crossing screws is $1,5 \cdot d$.

Minimum thickness for structural members is $t = 24$ mm for screws with outer thread diameter $d < 8$ mm, $t = 30$ mm for screws with outer thread diameter $d = 8$ mm, and $t = 40$ mm for screws with outer thread diameter $d = 10$ mm.

Unless specified otherwise in the technical specification (ETA or hEN) of cross laminated timber, minimum distances and spacing for screws in the wide face of cross laminated timber members with a minimum thickness $t = 10 \cdot d$ may be taken as (see Annex B):

Spacing a_1 parallel to the grain	$a_1 = 4 \cdot d$
Spacing a_2 perpendicular to the grain	$a_2 = 2,5 \cdot d$
Distance $a_{3,c}$ from centre of the screw-part in timber to the unloaded end grain	$a_{3,c} = 6 \cdot d$
Distance $a_{3,t}$ from centre of the screw-part in timber to the loaded end grain	$a_{3,t} = 6 \cdot d$
Distance $a_{4,c}$ from centre of the screw-part in	

timber to the unloaded edge	$a_{4,c} = 2,5 \cdot d$
Distance $a_{4,t}$ from centre of the screw-part in	
timber to the loaded edge	$a_{4,t} = 6 \cdot d$

Unless specified otherwise in the technical specification (ETA or hEN) of cross laminated timber, minimum distances and spacing for screws in the edge surface of cross laminated timber members with a minimum thickness $t = 10 \cdot d$ and a minimum penetration depth perpendicular to the edge surface of $10 \cdot d$ may be taken as (see Annex B):

Spacing a_1 parallel to the CLT plane	$a_1 = 10 \cdot d$
Spacing a_2 perpendicular to the CLT plane	$a_2 = 4 \cdot d$
Distance $a_{3,c}$ from centre of the screw-part in	
timber to the unloaded end	$a_{3,c} = 7 \cdot d$
Distance $a_{3,t}$ from centre of the screw-part in	
timber to the loaded end	$a_{3,t} = 12 \cdot d$
Distance $a_{4,c}$ from centre of the screw-part in	
timber to the unloaded edge	$a_{4,c} = 3 \cdot d$
Distance $a_{4,t}$ from centre of the screw-part in	
timber to the loaded edge	$a_{4,t} = 6 \cdot d$

4 Assessment and verification of constancy of performance (hereinafter AVCP) system applied, with reference to its legal base

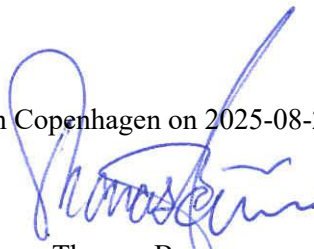
4.1 AVCP system

According to the decision 97/176/EC of the European Commission¹, as amended, the system(s) of assessment and verification of constancy of performance (see Annex V to Regulation (EU) No 305/2011) is 3.

5 Technical details necessary for the implementation of the AVCP system, as provided for in the applicable EAD

Technical details necessary for the implementation of the AVCP system are laid down in the control plan deposited at ETA-Danmark prior to CE marking.

Issued in Copenhagen on 2025-08-28 by



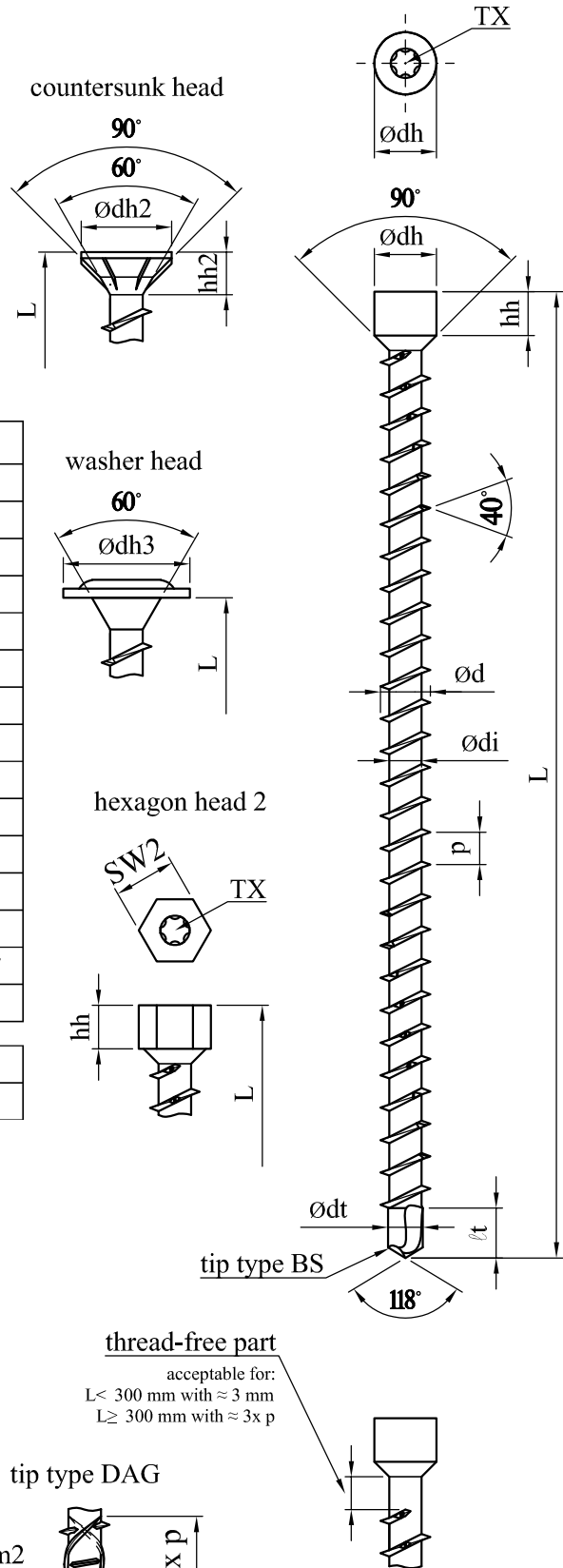
Thomas Bruun
Managing Director, ETA-Danmark

Annex A
KonstruX HF
carbon steel¹

nominal size	Ø6,5	Ø8,0	Ø9,0	Ø10,0	Ø11,3
d	6,5	8,0	9,0	10,0	11,3
di	4,5	5,2	6,4	6,0	8,0
dh	8,0	10,0	10,0	13,0	13,0
hh	5,5	6,5	6,5	6,5	6,5
p	4,9	5,2	5,6	5,6	5,6
dt	4,9	6,0	6,4	6,5	8,3
ℓ _t	7,0	8,0	8,0	11,5	12,0
dh2	12,0	14,5	14,5	17,8	18,5
hh2	5,7	7,4	7,0	8,7	7,0
dh3	-	22,0	22,0	25,0	22,0
dm	-	5,6	-	7,0	-
hm	-	4,5	-	4,0	-
dm2	-	6,2	-	7,2	-
SW	-	SW13	-	-	SW17
SW2	SW8	SW10	SW10	SW13	SW13

L min	39	47	51	60	64
L max	195	480	600	600	1000

All dimensions in mm.²⁾



¹⁾ Material specification held on file by ETA Danmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

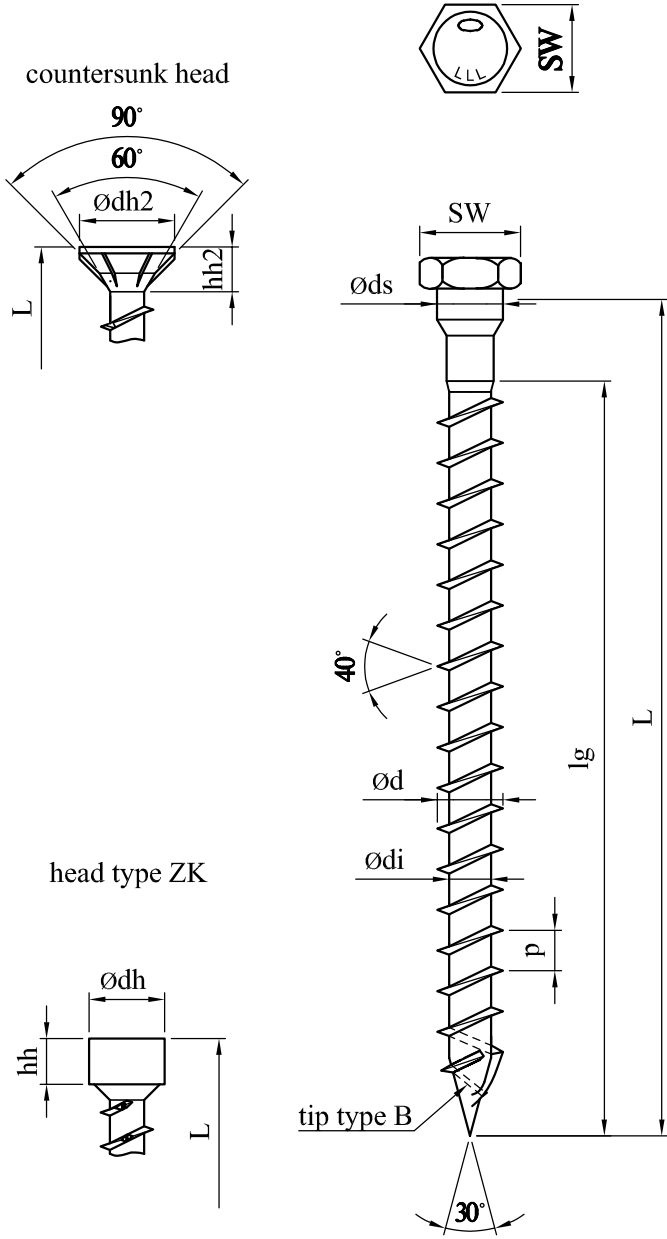
Transportanker screw
carbon steel¹⁾

nominal size	Ø11,0
d	11,3
di	8,0
dh	13,0
hh	6,5
p	5,6
dh2	18,5
hh2	7,0
SW	SW17

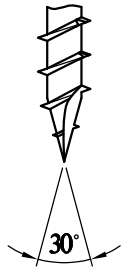
lg min	44
lg max	980

L min	51
L max	1000

All dimensions in mm.²⁾



tip type 17



¹⁾ Material specification held on file by ETA Denmark.

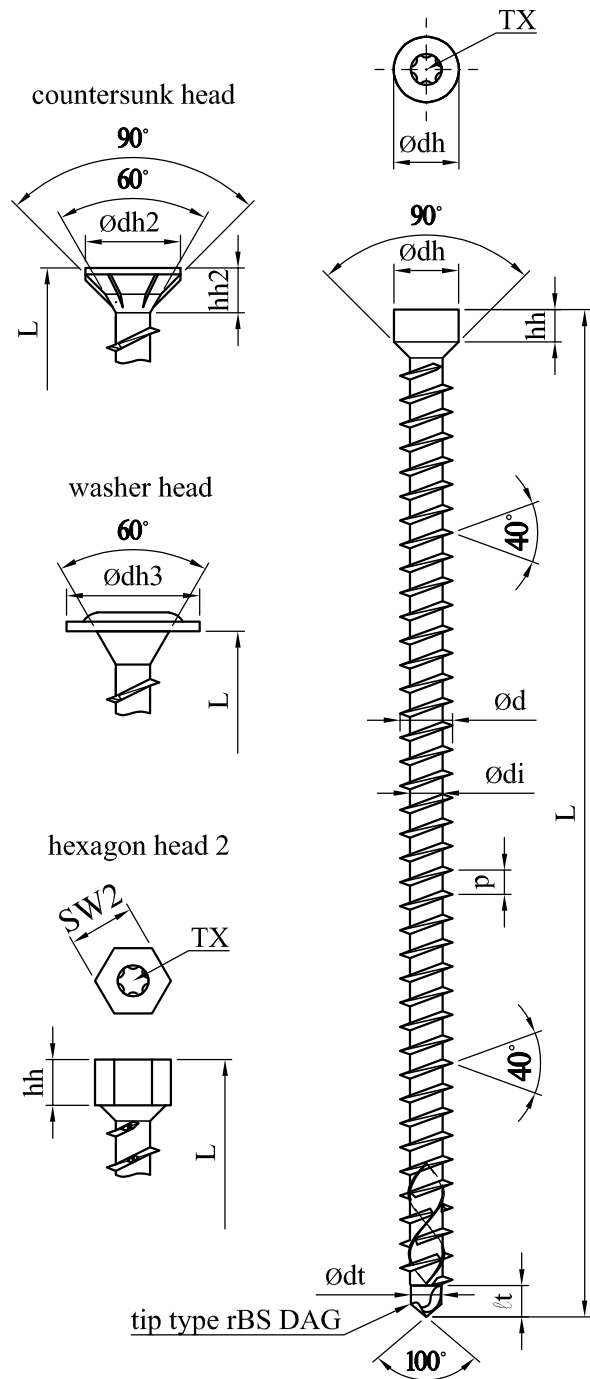
²⁾ Tolerances according to EAD 130118-XX-0603.

KonstruX ST
carbon steel¹

nominal size	Ø5,2	Ø5,9	Ø6,5	Ø8,0	Ø10,0
d	5,2	5,9	6,5	8,0	10,0
di	3,6	4,0	4,5	5,2	5,9
dh	6,4	8,0	8,0	10,0	13,0
hh	4,9	5,5	5,5	6,5	6,5
p	2,4	2,7	3,0	3,8	4,6
dt	3,5	3,8	4,3	4,9	5,5
ℓ _t	4,2	3,7	4,0	5,0	6,0
dh2	9,8	12,0	12,0	14,5	17,8
hh2	4,8	5,7	5,7	7,4	8,7
dh3	12,0	14,0	14,0	22,0	25,0
dm	3,9	4,1	4,9	5,8	6,5
SW	-	-	-	SW13	-
SW2	-	SW8	SW8	SW10	SW13

L min	30	33	36	44	55
L max	160	200	195	580	600

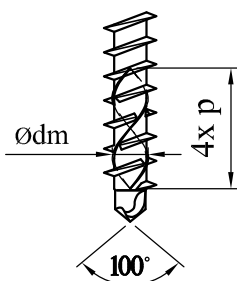
All dimensions in mm.²⁾



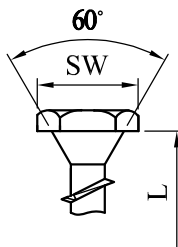
thread-free part

acceptable for:
 $L < 300 \text{ mm}$ with $\approx 3 \text{ mm}$
 $L \geq 300 \text{ mm}$ with $\approx 3 \times p$

tip type rBS DAG



hexagon head



¹⁾ Material specification held on file by ETA Danmark.

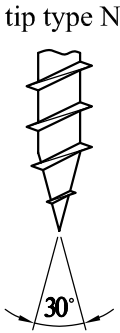
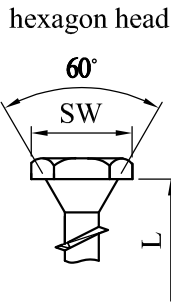
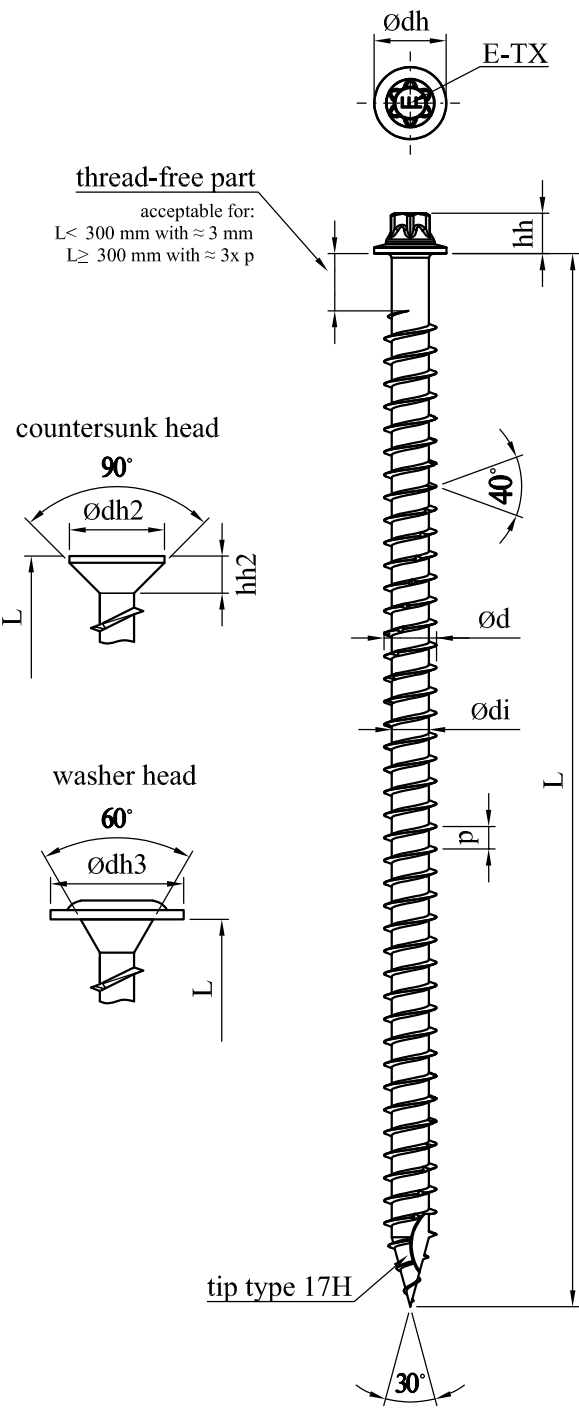
²⁾ Tolerances according to EAD 130118-XX-0603.

KonstruX 13 mm
carbon steel¹

nominal size	Ø13,0
d	13,0
di	9,2
dh	18,0
hh	10,0
p	5,6
dh2	22,0
hh2	7,4
dh3	22,0
SW	SW15

L min	59
L max	1000

All dimensions in mm.²⁾



¹⁾ Material specification held on file by ETA Danmark.

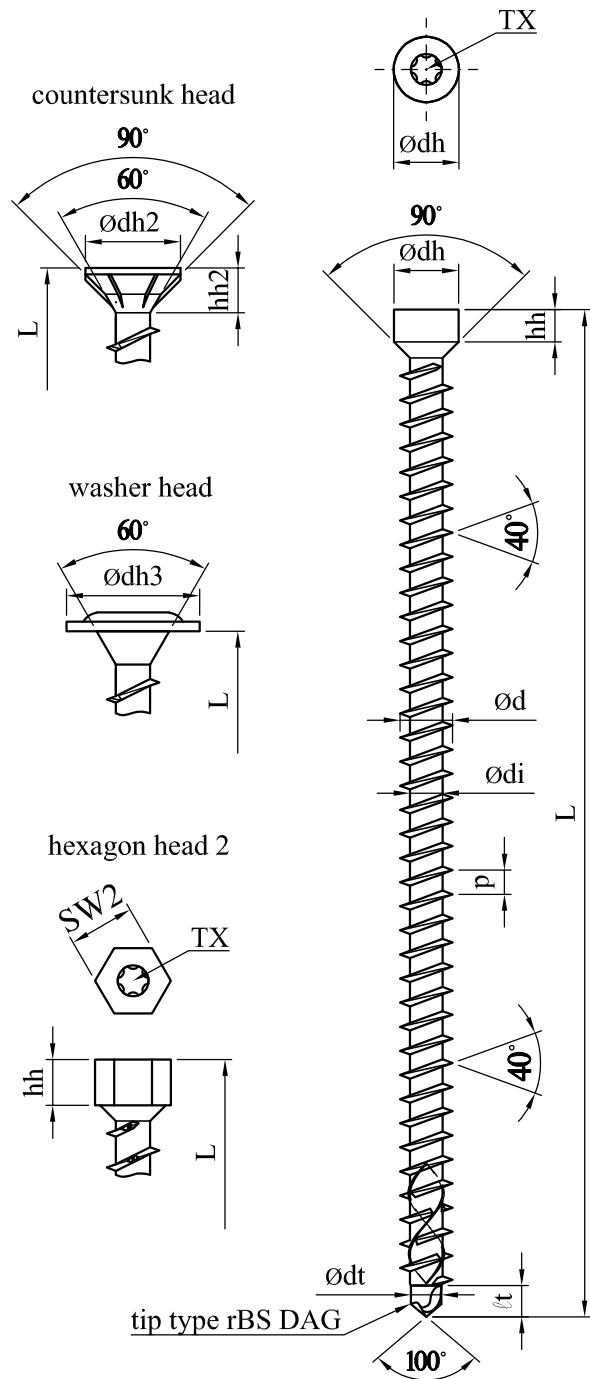
²⁾ Tolerances according to EAD 130118-XX-0603.

KonstruX ST V4A
austenitic stainless steel¹

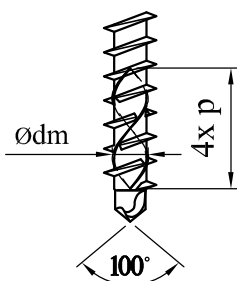
nominal size	Ø6,5	Ø8,0
d	6,5	8,0
di	4,5	5,2
dh	8,0	10,0
hh	5,5	6,5
p	3,0	3,8
dt	4,3	4,9
ℓ_t	4,0	5,0
dh2	12,0	14,5
hh2	5,7	7,4
dh3	-	22,0
dm	4,9	5,8
SW	-	SW13
SW2	SW8	SW10

L min	36	44
L max	195	400

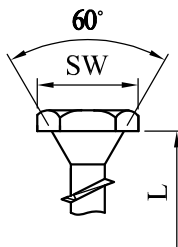
All dimensions in mm.²⁾



tip type rBS DAG

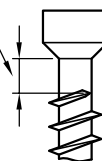


hexagon head



thread-free part

acceptable for:
 $L < 300 \text{ mm}$ with $\approx 3 \text{ mm}$
 $L \geq 300 \text{ mm}$ with $\approx 3 \times p$



¹⁾ Material specification held on file by ETA Danmark.

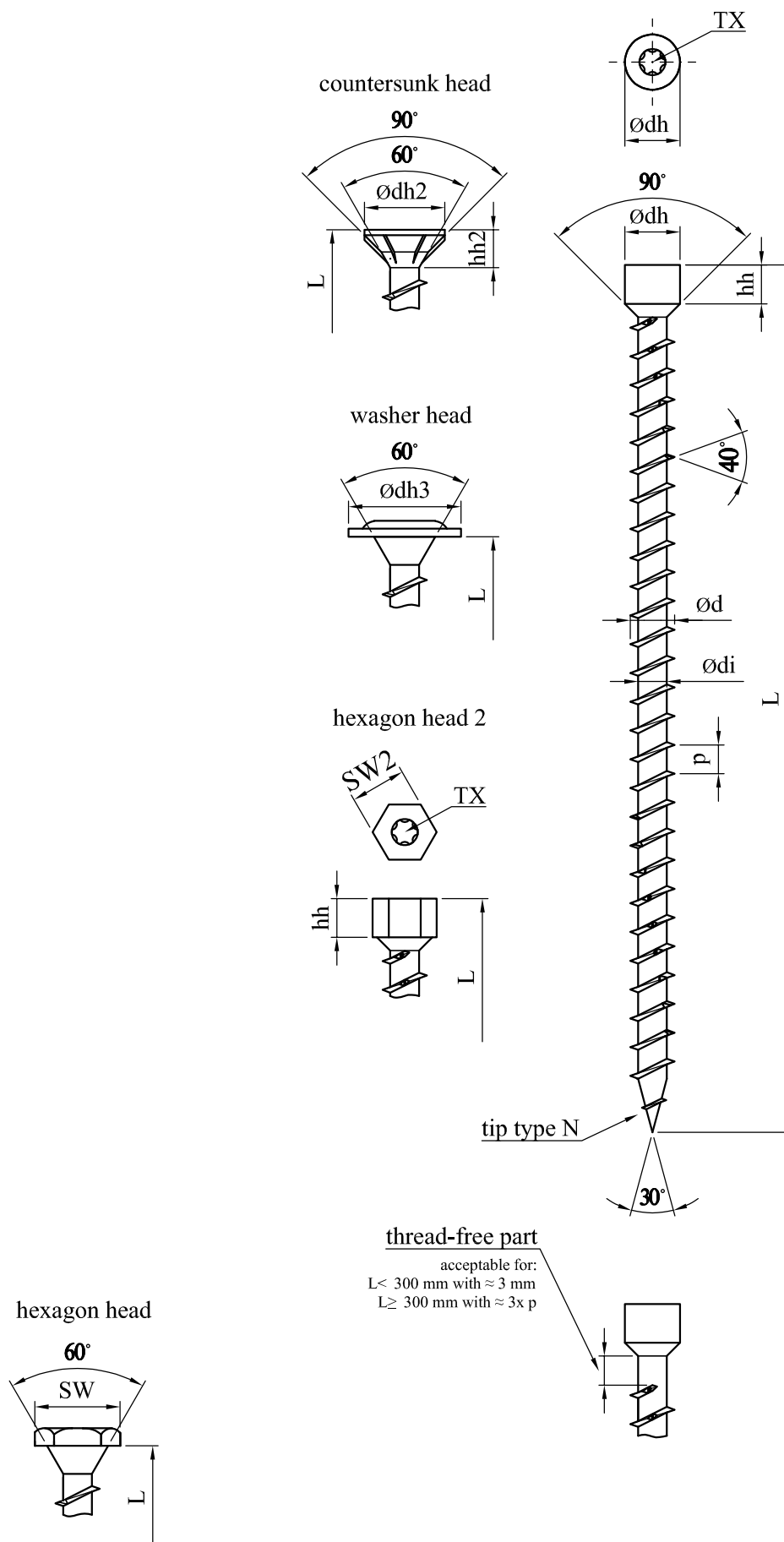
²⁾ Tolerances according to EAD 130118-XX-0603.

KonstruX ST V4A
austenitic stainless steel¹

nominal size	Ø10,0
d	10,0
di	6,0
dh	13,0
hh	6,5
p	4,6
dh2	17,8
hh2	8,7
dh3	25,0
SW2	SW13

L min	49
L max	500

All dimensions in mm.²⁾



¹⁾ Material specification held on file by ETA Danmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

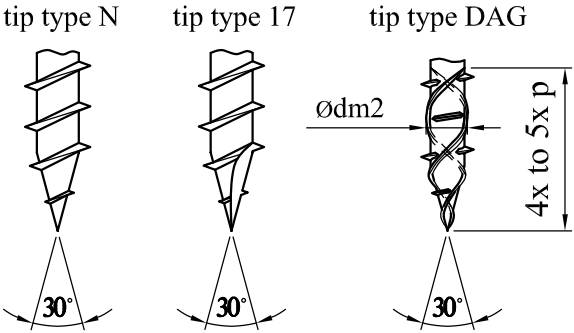
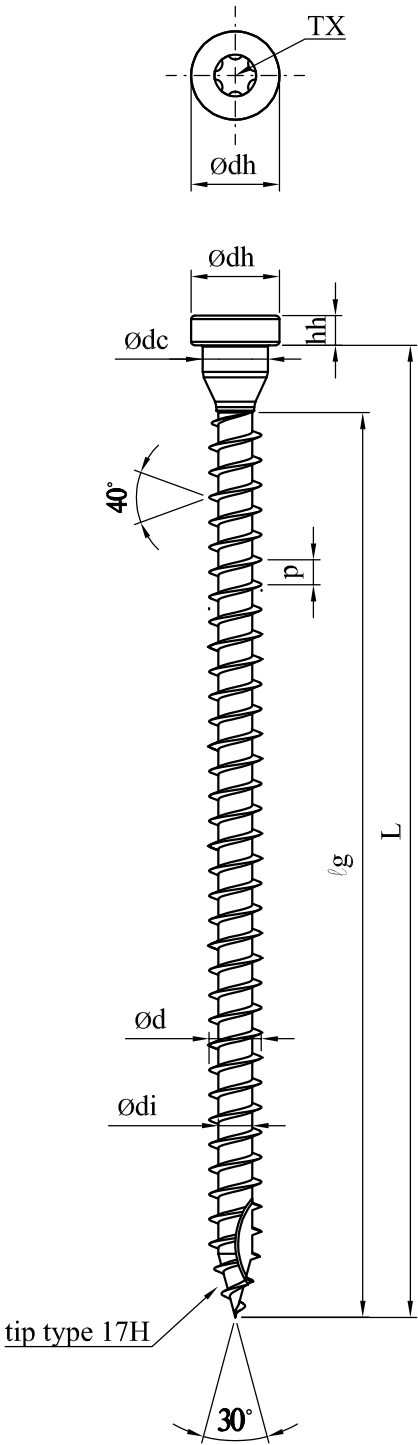
WBS Strong
carbon steel¹
austenitic stainless steel¹

nominal size	Ø8,0	Ø10,0
d	8,0	10,0
di	5,2	5,9
dh	13,5	16,5
hh	4,5	5,0
p	3,8	4,6
dc	10,0	12,0

lg min	32	40
lg max	160	180

L min	46	57
L max	160	180

All dimensions in mm. ²⁾



¹⁾ Material specification held on file by ETA Denmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

KonstruX Duo
carbon steel¹

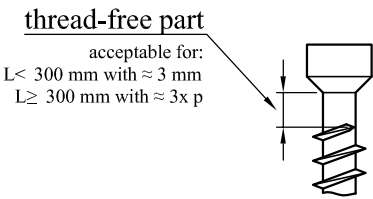
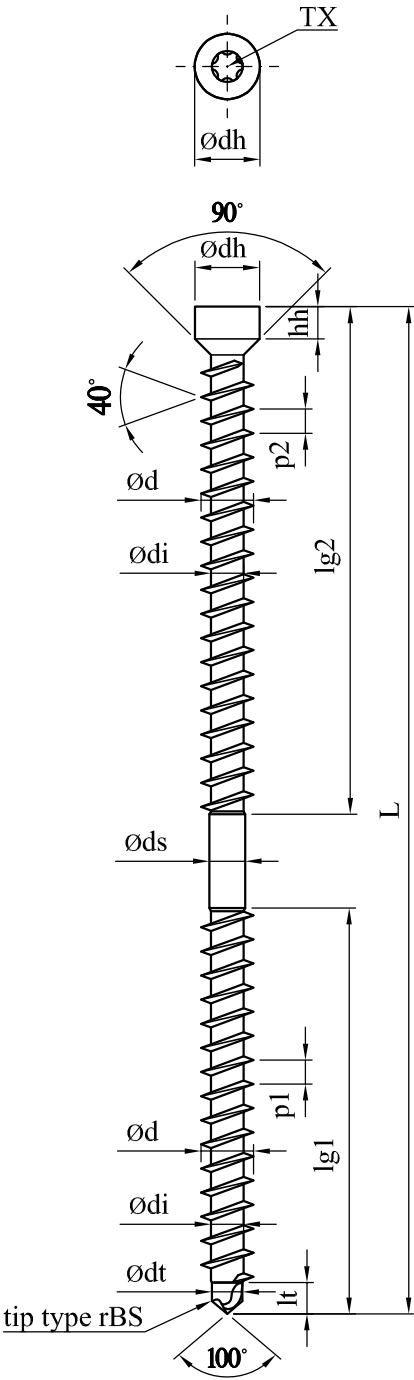
nominal size	Ø6,5	Ø8,0
d	6,5	8,0
di	4,5	5,2
dh	8,0	10,0
hh	5,5	6,5
p1	3,0	3,8
p2	2,8	3,7
ds	5,0	5,8
dt	4,3	4,9
lt	4,0	5,0

lg1 min	30	37
lg1 max	97	137

lg2 min	32	39
lg2 max	97	137

L min	87	102
L max	220	400

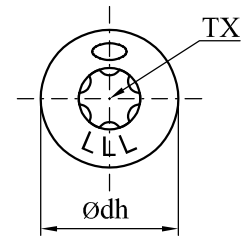
All dimensions in mm.²⁾



¹⁾ Material specification held on file by ETA Danmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

Paneltwistec countersunk head 90°
carbon steel¹
martensitic stainless steel¹

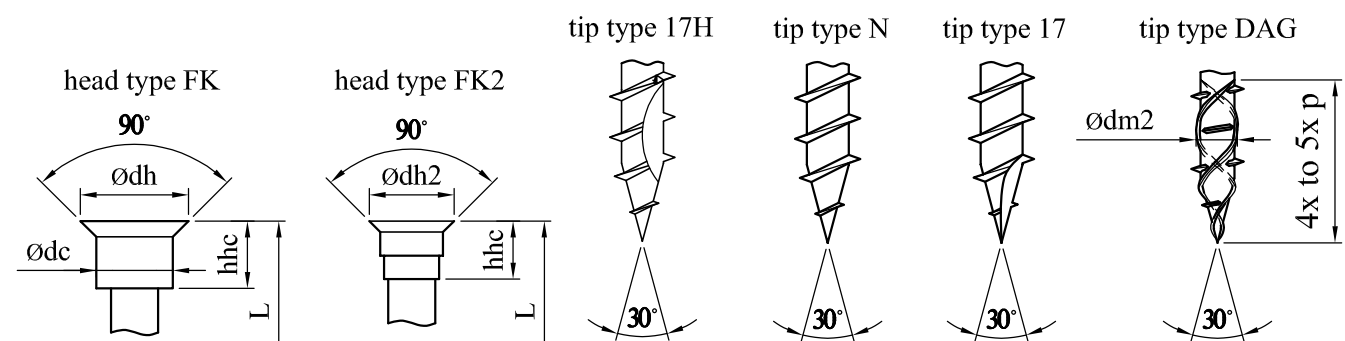
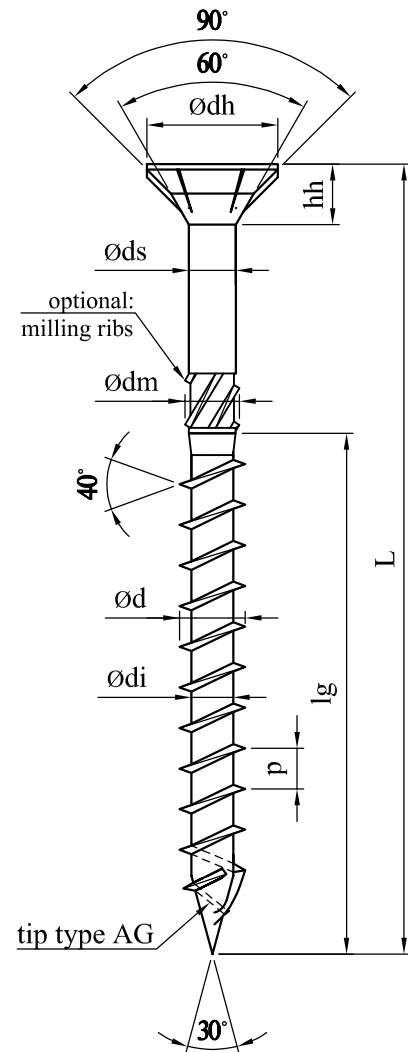


nominal size	Ø3,5	Ø4,0	Ø4,5	Ø5,0	Ø6,0	Ø8,0	Ø10,0	Ø12,0
d	3,5	4,0	4,5	5,0	6,0	8,0	10,0	12,0
di	2,1	2,5	2,7	3,3	4,0	5,3	6,3	7,1
dh	7,0	8,0	9,0	10,0	12,0	14,5	17,8	20,0
hh	3,5	4,0	4,4	4,8	5,7	7,0	8,7	9,3
p	2,25	2,5	2,8	3,1	4,9	5,6	6,6	6,6
ds	2,3	2,8	3,0	3,6	4,3	5,7	6,9	8,1
dm	2,7	2,9	3,4	3,9	4,8	6,5	7,9	9,6
dc	3,5	4,0	5,4	6,0	7,2	8,0	10,0	-
hhc	3,8	4,2	4,7	5,3	5,6	7,3	8,3	-
dh2	-	5,5	7,0	8,5	11,5	-	-	-
dm2	2,45	2,8	3,2	3,8	4,6	6,2	7,2	-

lg min	14	16	18	20	24	32	40	48
lg max	30	48	48	70	70	120	100	120

L min	18	20	23	25	30	39	49	57
L max	50	80	80	120	400	600	600	600

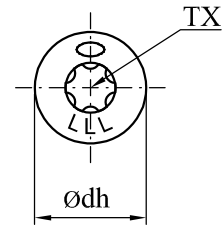
All dimensions in mm. ²⁾



¹⁾ Material specification held on file by ETA Danmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

Paneltwistec countersunk head 60°
carbon steel¹
martensitic stainless steel¹

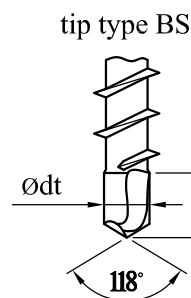
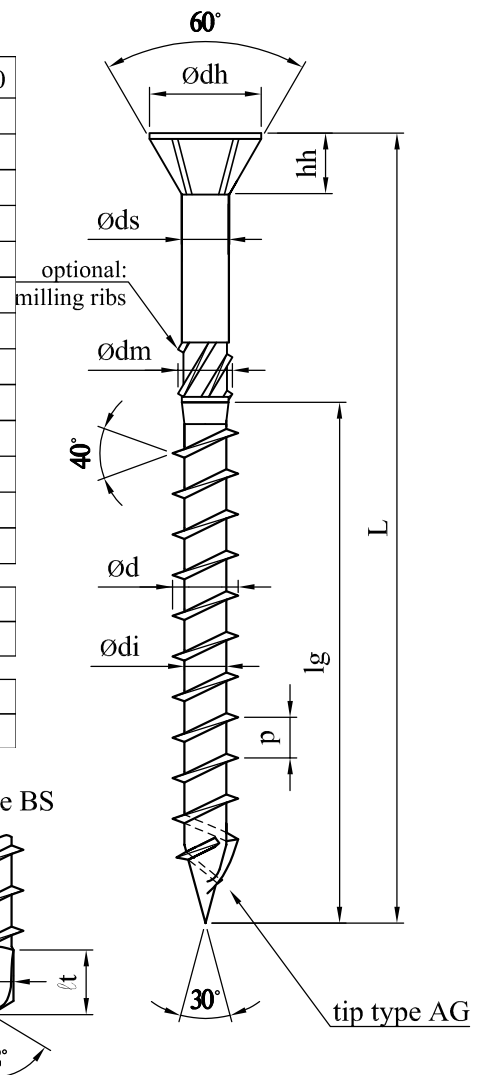


nominal size	Ø3,5	Ø4,0	Ø4,5	Ø5,0		Ø6,0	Ø8,0	Ø10,0
d	3,5	4,0	4,5	5,0		6,0	8,0	10,0
di	2,1	2,5	2,7	3,3		4,0	5,3	6,3
dh	5,0	6,0	7,0	7,5	9,5*	11,0	13,0	16,5
hh	1,9	3,6	4,3	4,8		5,8	6,3	8,2
p	2,25	2,5	2,8	3,1		4,9	5,6	6,6
ds	2,3	2,8	3,0	3,6		4,3	5,7	6,9
dm	2,7	2,9	3,4	3,9		4,8	6,5	7,9
dt	2,0	2,3	2,5	2,9		3,4	5,3	6,3
t	3,4	3,9	4,4	4,9		4,9	5,1	6,1
dc	3,5	4,0	5,4	6,0		7,2	8,0	10,0
hhc	3,8	4,2	4,7	5,3		5,6	7,3	8,3
dh2	-	5,5	7,0	8,5		11,5	-	-
dm2	2,45	2,8	3,2	3,8		4,6	6,2	7,2

lg min	14	16	18	20	24	32	40
lg max	30	48	48	70	70	120	100

L min	18	20	23	25	30	39	48
L max	50	80	80	120	400	600	600

All dimensions in mm.²⁾
*dh= 7,5 mm standard version
dh= 9,5 mm special version

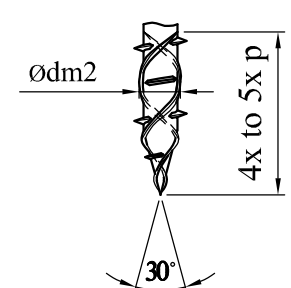
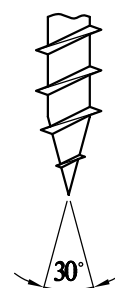
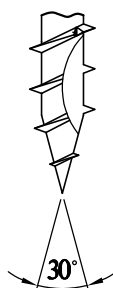
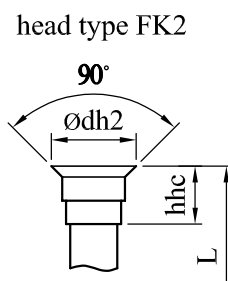
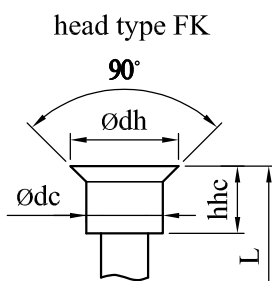


tip type 17H

tip type N

tip type 17

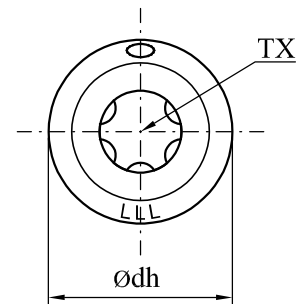
tip type DAG



¹⁾ Material specification held on file by ETA Danmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

Paneltwistec washer head
carbon steel¹
martensitic stainless steel¹

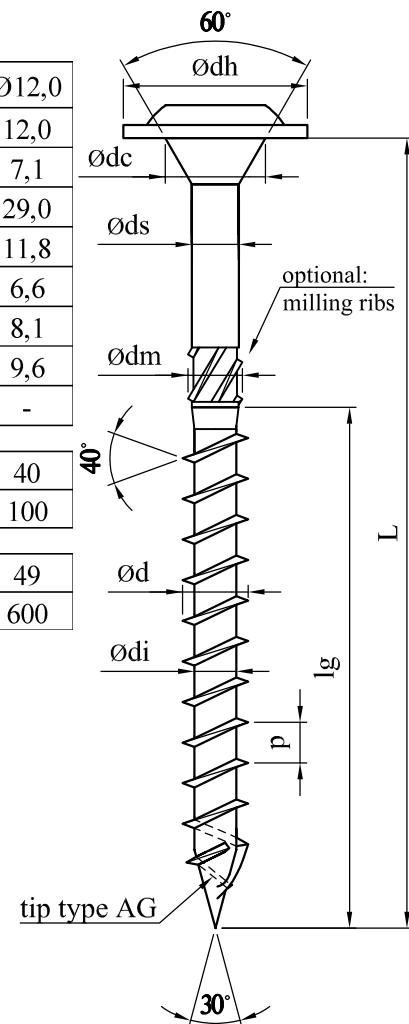


nominal size	Ø3,5	Ø4,0	Ø4,5	Ø5,0	Ø6,0	Ø8,0	Ø10,0	Ø12,0
d	3,5	4,0	4,5	5,0	6,0	8,0	10,0	12,0
di	2,1	2,5	2,7	3,3	4,0	5,3	6,3	7,1
dh	8,0	10,0	11,0	12,0	14,0	22,0	25,0	29,0
dc	4,3	4,8	5,5	6,0	7,0	10,0	12,0	11,8
p	2,25	2,5	2,8	3,1	4,9	5,6	6,6	6,6
ds	2,3	2,8	3,0	3,6	4,3	5,7	6,9	8,1
dm	2,7	2,9	3,4	3,9	4,8	6,5	7,9	9,6
dm2	2,45	2,8	3,2	3,8	4,6	6,2	7,2	-

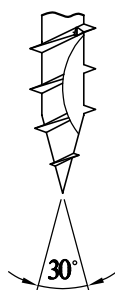
lg min	14	16	18	20	24	32	40	40
lg max	30	48	48	70	70	120	100	100

L min	15	17	19	21	25	33	41	49
L max	50	80	80	120	400	600	600	600

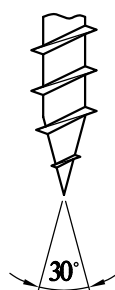
All dimensions in mm.²⁾



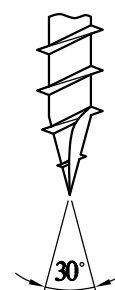
tip type 17H



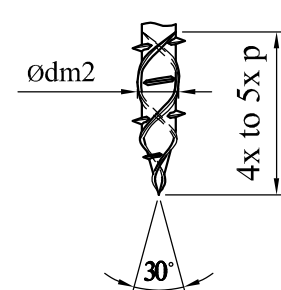
tip type N



tip type 17



tip type DAG



¹⁾ Material specification held on file by ETA Danmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

Paneltwistec small washer head
carbon steel¹
martensitic stainless steel¹

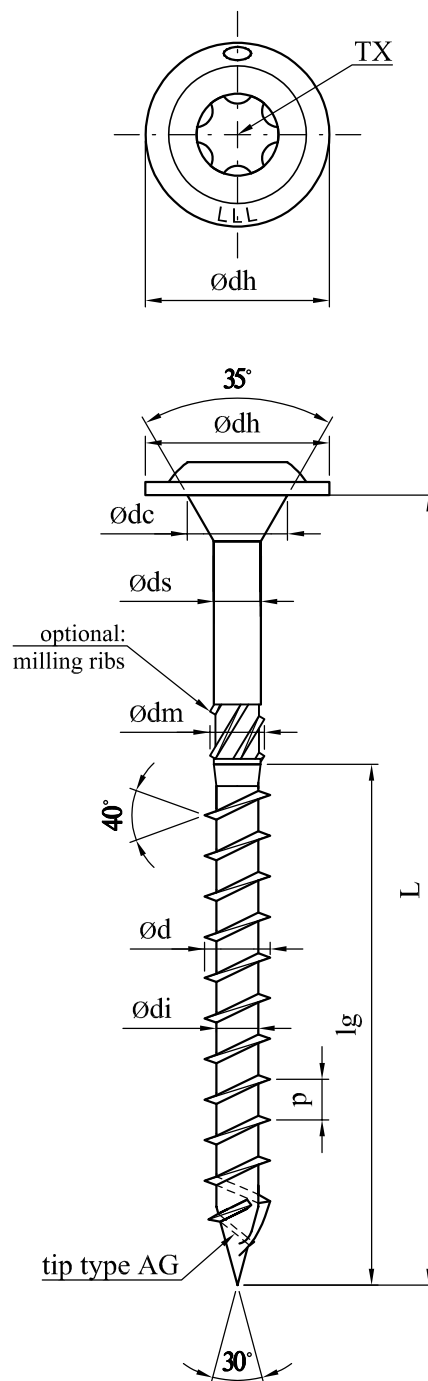
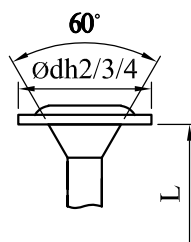
nominal size	Ø8,0
d	8,0
di	5,3
dh	18,0
dh2	16,0
dh3	21,5
dh4	24,5
dc	8,0
p	5,6
ds	5,8
dm	6,7
dm2	6,2

lg min	32
lg max	120

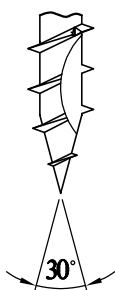
L min	33
L max	600

All dimensions in mm.²⁾

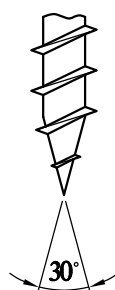
washer head 2 / 3 / 4



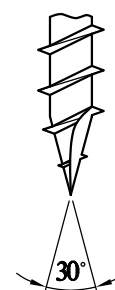
tip type 17H



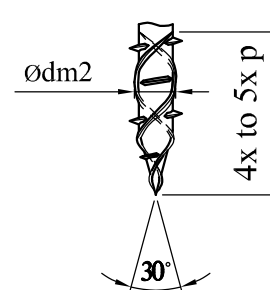
tip type N



tip type 17



tip type DAG



¹⁾ Material specification held on file by ETA Denmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

Paneltwistec V2A and V4A 8 mm
austenitic stainless steel¹⁾

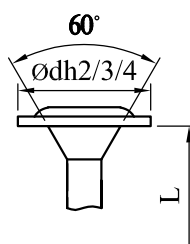
nominal size	Ø8,0
d	8,0
di	5,3
dh	14,5
hh	7,0
p	5,6
ds	5,7
dm	6,5
dc	8,0
hhc	7,3
dh2	16,0
dh3	21,5
dh4	24,0

lg min	32
lg max	80

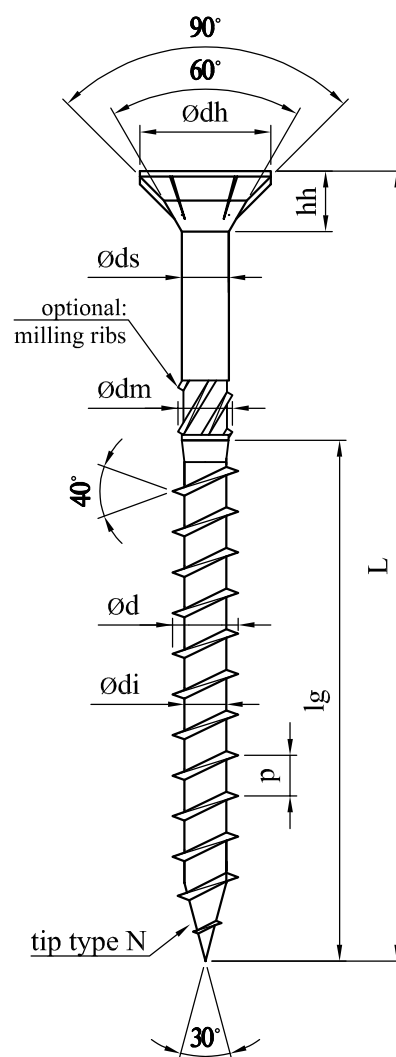
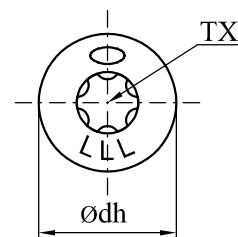
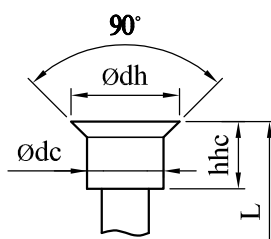
L min	39
L max	340

All dimensions in mm.²⁾

washer head 2 / 3 / 4



head type FK



¹⁾ Material specification held on file by ETA Danmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

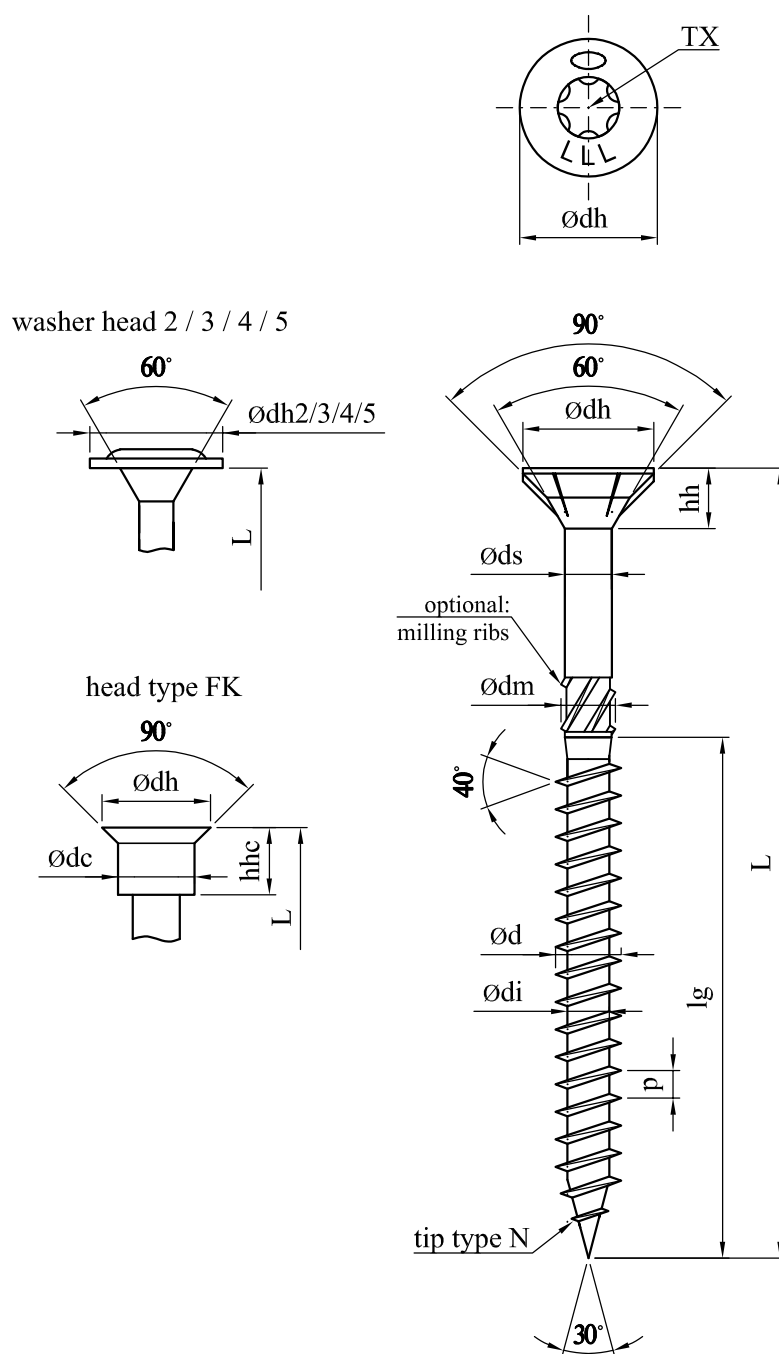
Paneltwistec FT V2A and V4A 8 mm
austenitic stainless steel¹⁾

nominal size	Ø8,0
d	8,0
di	5,3
dh	14,5
hh	7,0
p	3,6
ds	5,9
dm	6,5
dc	8,0
hhc	7,3
dh2	16,0
dh3	19,5
dh4	21,5
dh5	24,0

lg min	32
lg max	80

L min	39
L max	400

All dimensions in mm.²⁾



¹⁾ Material specification held on file by ETA Denmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

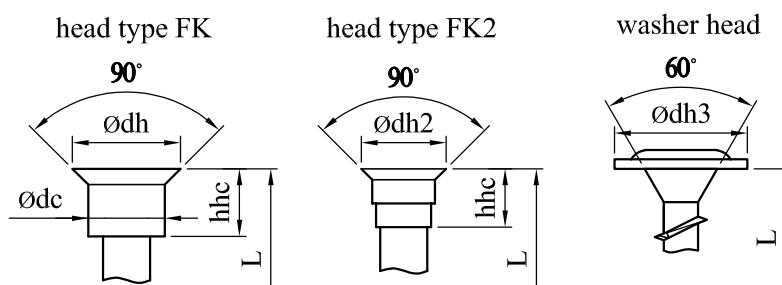
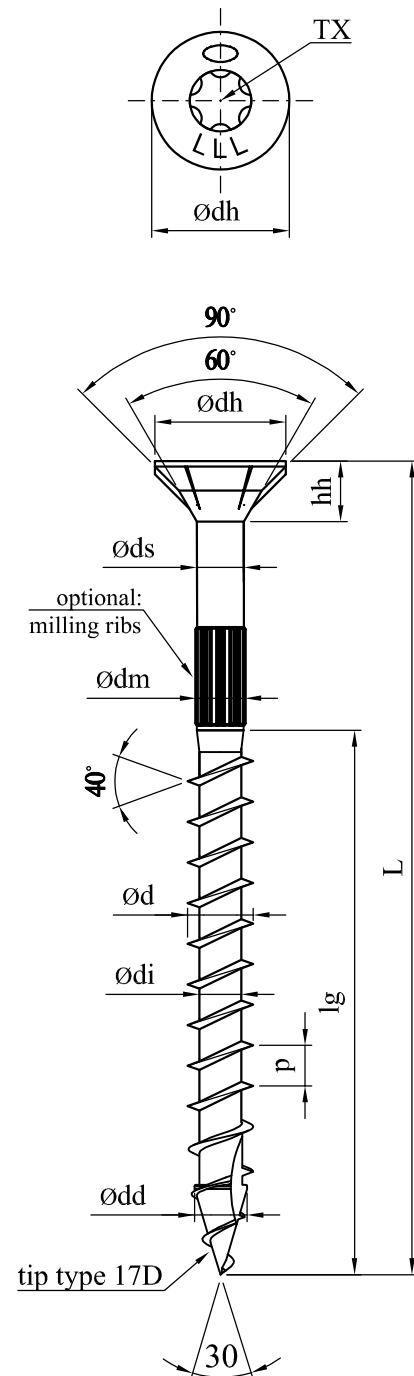
Duratec
carbon steel¹

nominal size	Ø3,5	Ø4,0	Ø4,5	Ø5,0	Ø6,0	Ø8,0	Ø10,0
d	3,5	4,0	4,5	5,0	6,0	8,0	10,0
di	2,1	2,5	2,7	3,3	4,0	5,3	6,3
dh	7,0	8,0	9,0	10,0	12,0	14,5	17,8
hh	3,5	4,0	4,4	4,8	5,7	7,0	8,7
p	2,24	2,5	2,8	3,1	4,9	5,6	6,6
ds	2,3	2,8	3,0	3,6	4,3	5,7	6,9
dm	2,7	2,9	3,4	3,9	4,8	6,5	7,9
dc	3,5	4,0	5,4	6,0	7,2	8,0	10,0
hhc	3,8	4,2	4,7	5,3	5,6	7,3	8,3
dh2	-	5,5	7,0	8,5	11,5	-	-
dh3	8,0	10,0	11,0	12,0	14,0	22,0	25,0
dd	2,5	2,9	3,2	3,7	4,6	6,2	7,3

lg min	14	16	18	20	24	32	40
lg max	30	48	48	70	70	80	90

L min	18	20	23	25	30	39	49
L max	50	80	80	120	400	600	600

All dimensions in mm.²⁾



¹⁾ Material specification held on file by ETA Danmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

Topduo
carbon steel¹
martensitic stainless steel¹

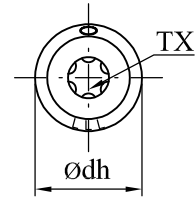
nominal size	Ø8,0
d	8,0
di	5,3
dh	16,0
dc	8,0
p	5,6
ds	5,8
dm	6,5
dh2	14,5
hh2	7,4
dh3	10,0
hh3	6,5
dh4	18,3
hh4	7,3
dm2	6,20

lg1 min	32
lg1 max	120

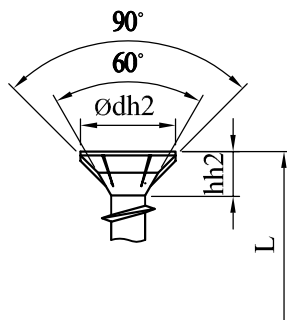
lg2 min	32
lg2 max	60

L min	94
L max	472

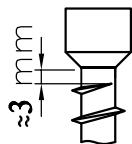
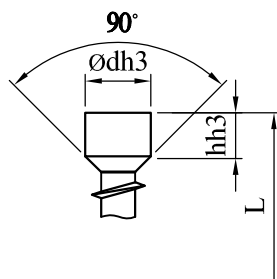
All dimensions in mm. ²⁾



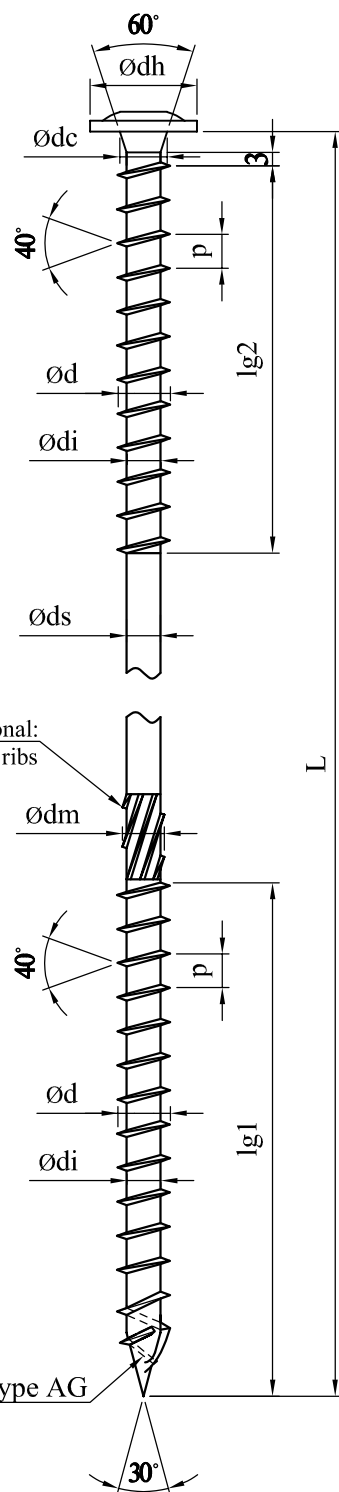
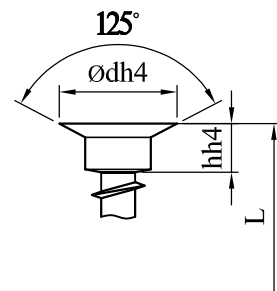
countersunk head



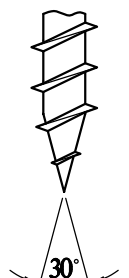
head type ZK



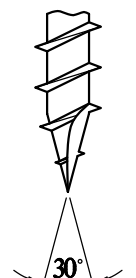
head type FK



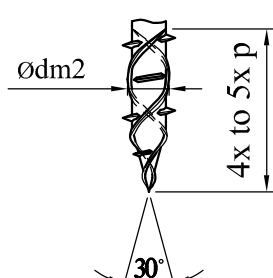
tip type N



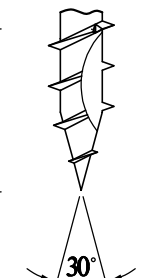
tip type 17



tip type DAG



tip type 17H



tip type AG



¹⁾ Material specification held on file by ETA Danmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

Terrassotec, S-L-SP, SP FK
carbon steel¹
martensitic stainless steel¹

Terrassotec, S-L-SP FK					
nominal size	Ø3,5	Ø4,0	Ø4,5	Ø5,0	Ø6,0
d	3,5	4,0	4,5	5,0	6,0
di	2,1	2,5	2,7	3,3	4,0
dh	5,0	5,5	7,0	8,5	12,0
dc	3,5	4,0	5,4	6,0	7,2
hh	2,0	4,3	4,8	5,4	5,6
β	90°	90°	90°	90°	90°
p	2,25	2,5	2,8	3,1	3,6
ds	2,3	2,8	3,0	3,6	4,4
dh2	-	5,5	7,0	8,5	11,5
hh2	-	4,2	4,7	5,3	5,6
dm	2,9	3,4	3,9	4,0	5,0
dm2	2,45	2,8	3,2	3,8	4,6

lg min	14	16	18	20	24
lg max	30	48	48	70	70

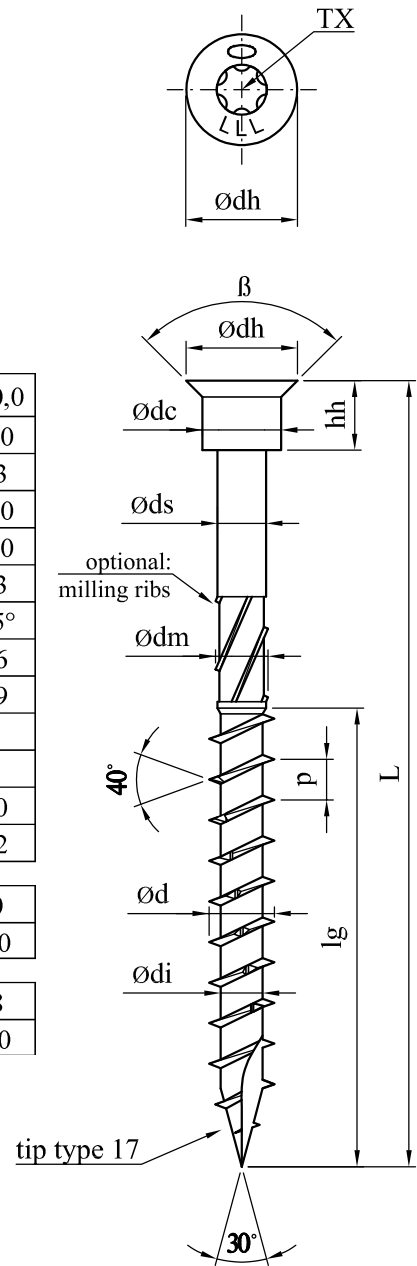
L min	16	21	23	26	36
L max	50	80	80	120	400

All dimensions in mm.²⁾

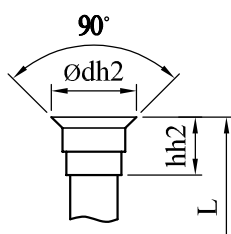
SP FK		
Ø6,0	Ø8,0	Ø10,0
6,0	8,0	10,0
4,0	5,3	6,3
13,5	18,0	21,0
6,5	10,3	11,0
6,0	7,2	8,3
125°	125°	125°
4,9	5,6	6,6
4,3	5,7	6,9
-	-	-
-	-	-
3,9	4,0	5,0
4,6	6,2	7,2

24	32	40
70	120	100

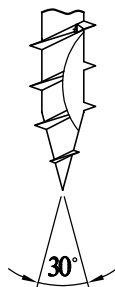
30	39	48
400	600	600



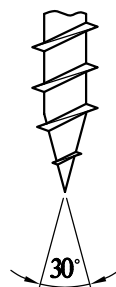
head type FK2



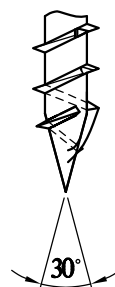
tip type 17H



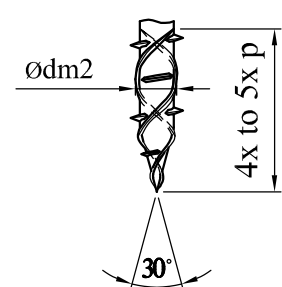
tip type N



tip type AG



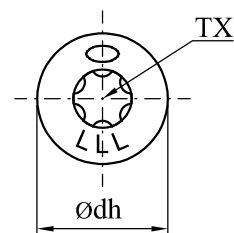
tip type DAG



¹⁾ Material specification held on file by ETA Denmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

Speedo
carbon steel¹

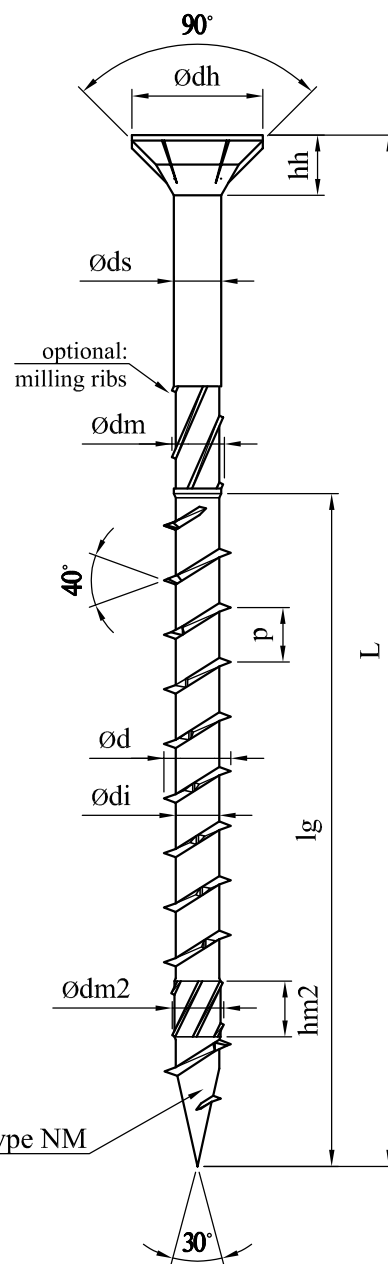


nominal size	Ø3,5	Ø4,0	Ø4,5	Ø5,0	Ø6,0	Ø8,0	Ø10,0
d	3,5	4,0	4,5	5,0	6,0	8,0	10,0
di	2,1	2,5	2,6	3,2	3,9	5,4	6,3
dh	7,0	8,0	9,0	10,0	12,0	14,5	17,8
hh	3,5	4,0	4,4	4,8	5,7	7,0	8,7
p	2,25	2,5	2,8	3,1	4,9	6,5	6,2
ds	2,3	2,8	3,0	3,6	4,4	5,8	7,1
dm	2,7	3,1	3,5	3,9	4,7	6,8	8,0
dm2	2,7	3,1	3,4	3,9	4,4	6,0	7,3
hm2	2,50	2,5	3,0	3,0	5,0	5,7	7,4
dh2	-	-	-	-	14,0	22,0	25,0

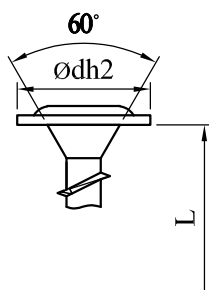
lg min	14	16	18	20	24	32	40
lg max	30	48	48	70	70	100	100

L min	18	20	22	25	30	39	49
L max	50	80	80	120	300	500	400

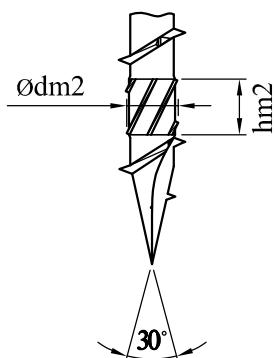
All dimensions in mm.²⁾



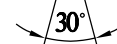
washer head



tip type 17M



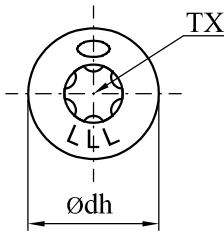
tip type NM



¹⁾ Material specification held on file by ETA Danmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

Speedo 4K
carbon steel¹

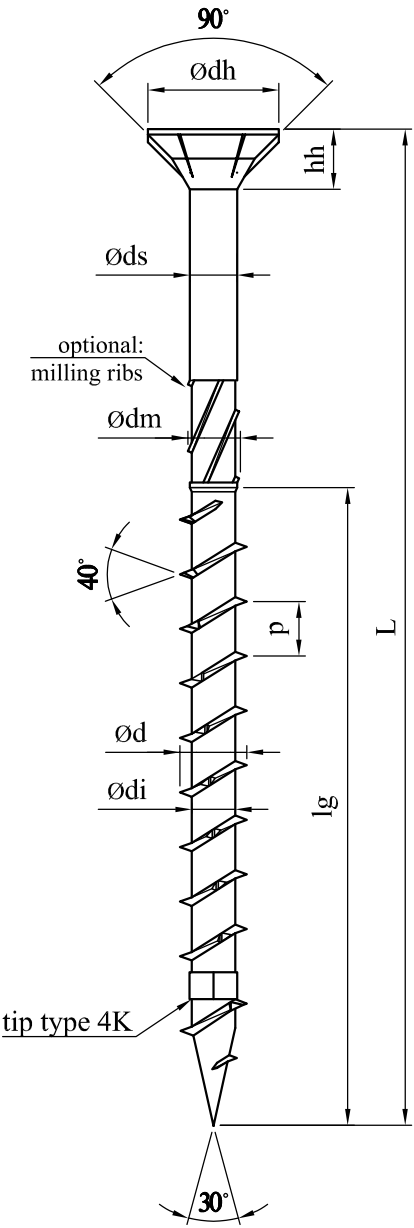


nominal size	Ø3,5	Ø4,0	Ø4,5	Ø5,0	Ø6,0	Ø8,0	Ø10,0
d	3,5	4,0	4,5	5,0	6,0	8,0	10,0
di	2,1	2,5	2,7	3,3	4,0	5,3	6,3
dh	7,0	8,0	9,0	10,0	12,0	14,5	17,8
hh	3,5	4,0	4,4	4,8	5,7	7,0	8,7
p	2,25	2,5	2,8	3,1	4,9	5,6	6,6
ds	2,3	2,8	3,0	3,6	4,3	5,7	6,9
dm	2,7	2,9	3,4	3,9	4,8	6,5	7,9
dh2	-	-	-	-	14,0	22,0	25,0
e	2,45	2,8	3,2	3,5	4,2	5,6	7,0
h4K	2,50	2,5	3,0	3,0	3,0	3,5	4,0

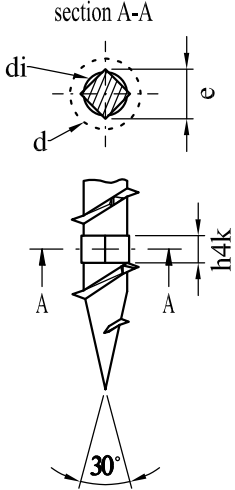
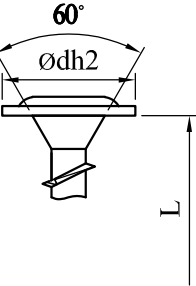
lg min	14	16	18	20	24	32	40
lg max	30	48	48	70	70	100	100

L min	18	20	22	25	30	39	49
L max	50	80	80	120	300	500	400

All dimensions in mm.²⁾



washer head



¹⁾ Material specification held on file by ETA Danmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

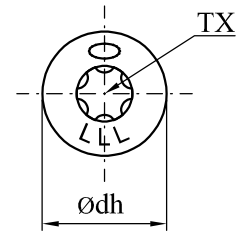
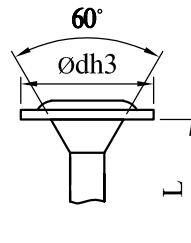
Hobotec, Hapatec, Paneltwistec V4A countersunkhead 90°

carbon steel¹

martensitic stainless steel¹

austenitic stainless steel¹

washer head

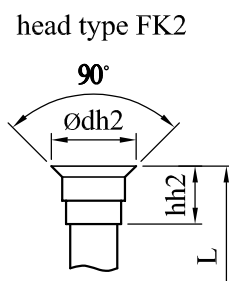
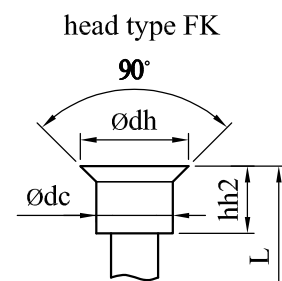
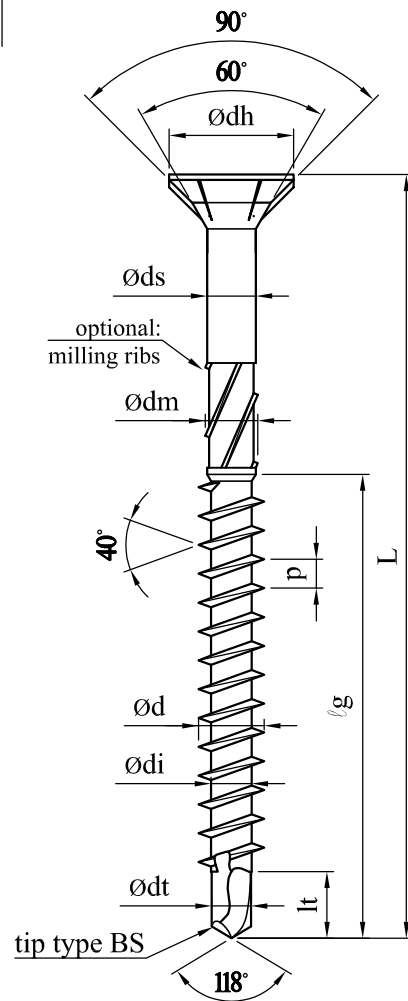


nominal size	Ø3,5	Ø4,0	Ø4,5	Ø5,0	Ø6,0
d	3,5	4,0	4,5	5,0	6,0
di	2,1	2,5	2,7	3,3	4,0
dh	5,0	8,0	9,0	10,0	12,0
hh	3,8	4,3	4,8	5,4	5,7
p	1,60	1,8	2,0	2,2	2,6
ds	2,3	2,8	3,0	3,6	4,0
dh2	-	4,2	4,7	5,3	5,6
dh3	-	12,0	13,0	14,0	15,0
hh2	-	5,5	7,0	8,5	11,5
dm	2,9	3,4	3,9	4,0	4,6
dm2	2,45	2,8	3,2	3,8	4,6
dt	2,0	2,3	2,5	3,0	3,4
lt	3,40	3,9	4,4	3,8	4,9

lg min	18	20	23	24	29
lg max	30	48	48	70	70

L min	21	25	29	32	40
L max	50	80	80	120	300

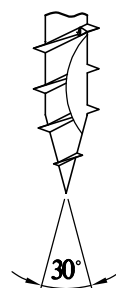
All dimensions in mm.²⁾



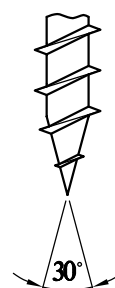
¹⁾ Material specification held on file by ETA Danmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

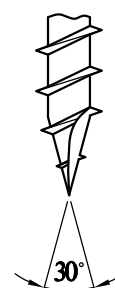
tip type 17H



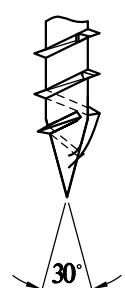
tip type N



tip type 17



tip type AG



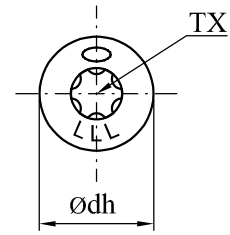
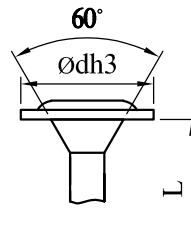
Hobotec, Hapatec, Paneltwistec V4A countersunkhead 60°

carbon steel¹

martensitic stainless steel¹

austenitic stainless steel¹

washer head

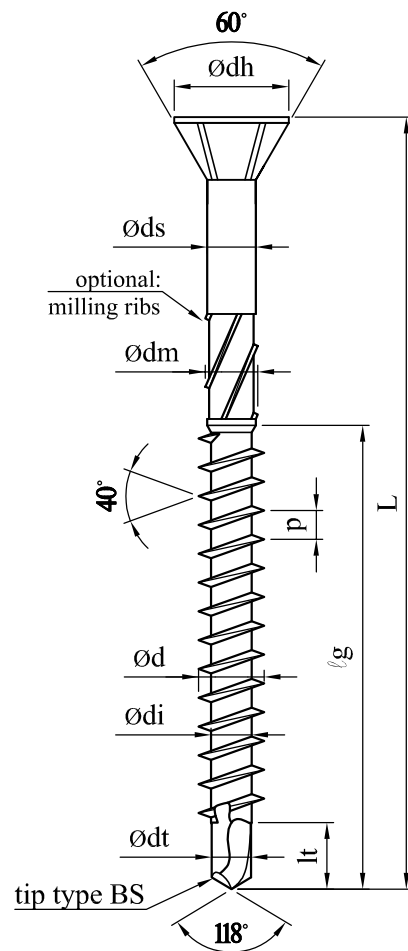


nominal size	Ø3,5	Ø4,0	Ø4,5	Ø5,0	Ø6,0
d	3,5	4,0	4,5	5,0	6,0
di	2,1	2,5	2,7	3,3	4,0
dh	5,0	6,0	7,0	7,5	8,5
hh	2,0	2,5	2,5	2,8	3,5
p	1,60	1,8	2,0	2,2	2,6
ds	2,3	2,8	3,0	3,6	4,0
dh2	-	4,2	4,7	5,3	5,6
dh3	-	12,0	13,0	14,0	15,0
hh2	-	5,5	7,0	8,5	11,5
dm	2,9	3,4	3,9	4,0	4,6
dm2	2,45	2,8	3,2	3,8	4,6
dt	2,0	2,3	2,5	3,0	3,4
lt	3,40	3,9	4,4	3,8	4,9

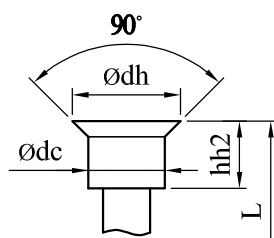
lg min	18	20	23	24	29
lg max	30	48	48	70	70

L min	19	25	29	32	40
L max	50	80	80	120	300

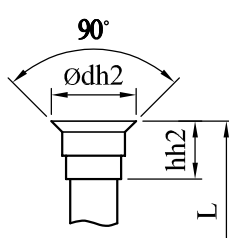
All dimensions in mm.²⁾



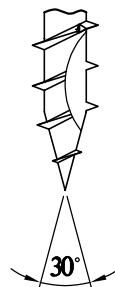
head type FK



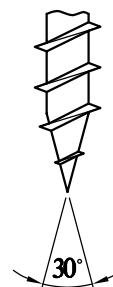
head type FK2



tip type 17H



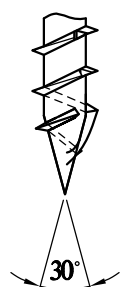
tip type N



tip type 17



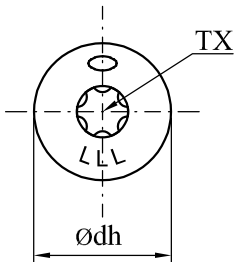
tip type AG



¹⁾ Material specification held on file by ETA Danmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

SP ZK
carbon steel¹

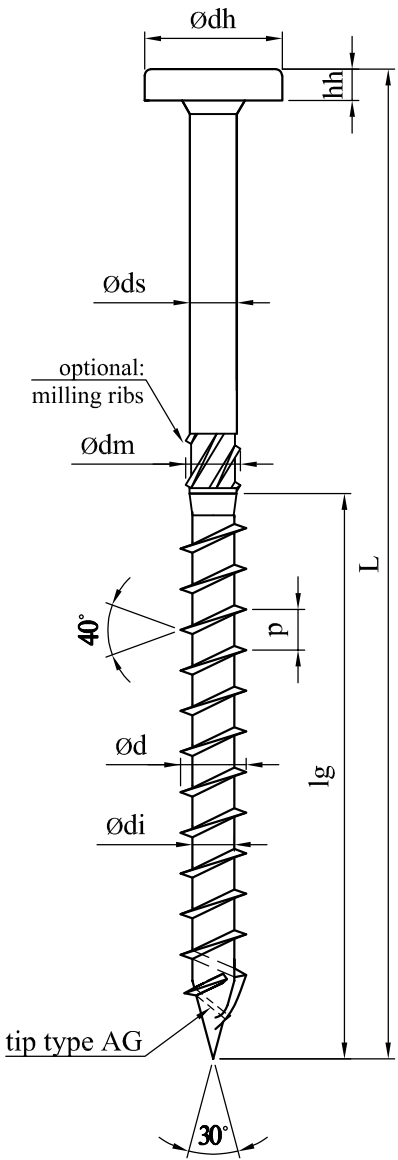


nominal size	Ø6,0	Ø8,0	Ø10,0
d	6,0	8,0	10,0
di	4,0	5,3	6,3
dh	13,4	17,0	21,0
hh	3,6	4,0	4,8
p	4,9	5,6	6,6
ds	4,3	5,7	6,9
dm	4,8	6,5	7,9

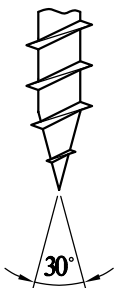
lg min	24	32	40
lg max	70	120	100

L min	28	36	45
L max	400	600	600

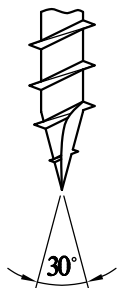
All dimensions in mm. ²⁾



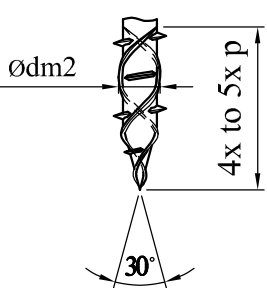
tip type N



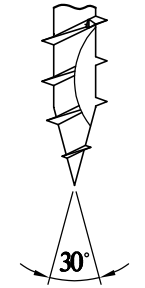
tip type 17



tip type DAG



tip type 17H



¹⁾ Material specification held on file by ETA Danmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

Ecotec countersunk head 90°
carbon steel¹
austenitic stainless steel¹

nominal size	Ø3,5	Ø4,0	Ø4,5	Ø5,0	Ø6,0
d	3,5	4,0	4,5	5,0	6,0
di	2,1	2,5	2,7	3,2	3,7
dh	7,0	8,0	9,0	10,0	12,0
hh	3,8	4,3	4,8	5,4	5,7
p	1,60	1,8	2,0	2,2	2,6
ds	2,3	2,8	3,0	3,6	4,0
dm	2,9	3,4	3,9	4,0	4,6

All dimensions in mm.²⁾

Ecotec part thread

lg min	14	16	18	20	24
lg max	30	48	48	70	70

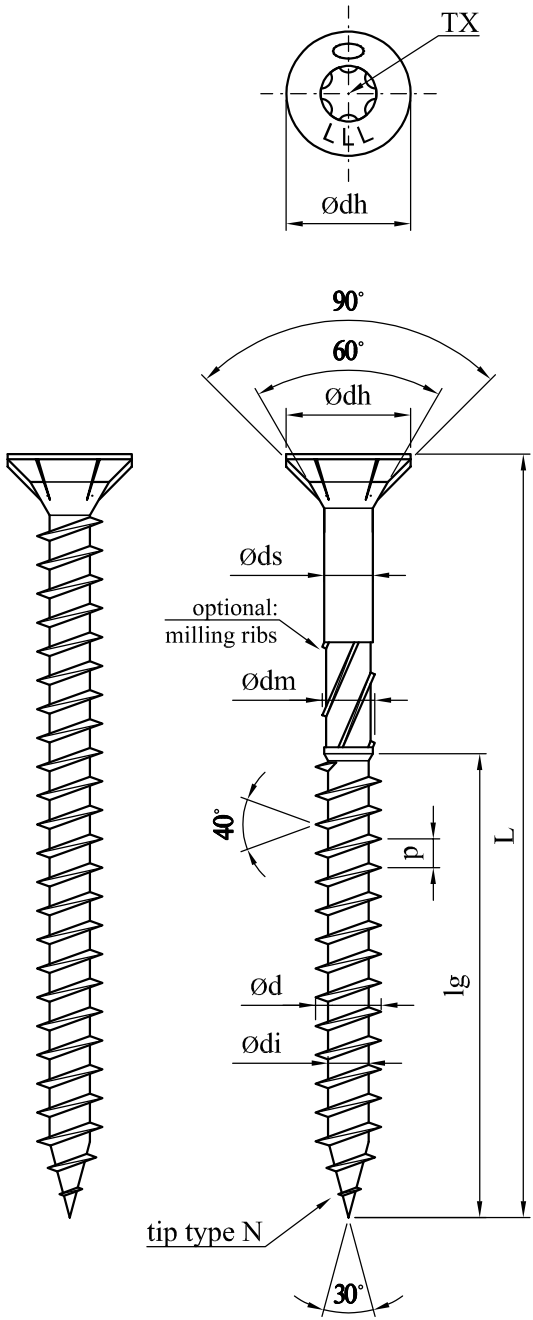
L min	18	20	23	25	30
L max	50	80	80	120	300

All dimensions in mm.²⁾

Ecotec full thread

L min	18	20	23	25	30
L max	30	50	50	60	70

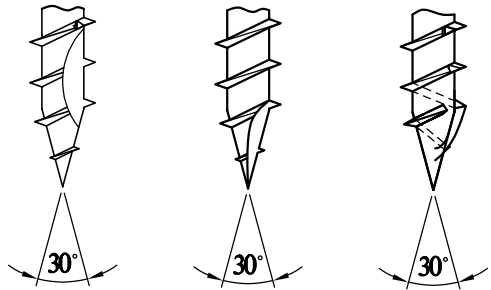
All dimensions in mm.²⁾



tip type 17H

tip type 17

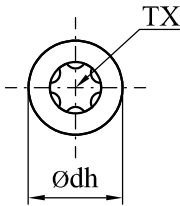
tip type AG



¹⁾ Material specification held on file by ETA Danmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

WBS - Winkelbeschlagsschraube
carbon steel¹
austenitic stainless steel¹

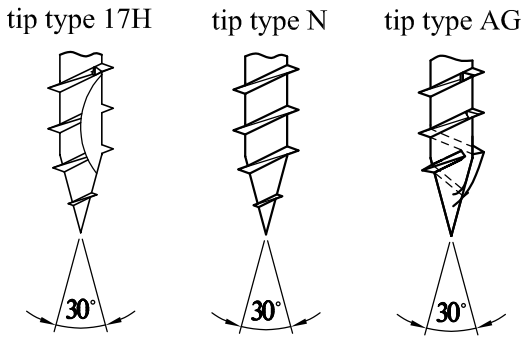
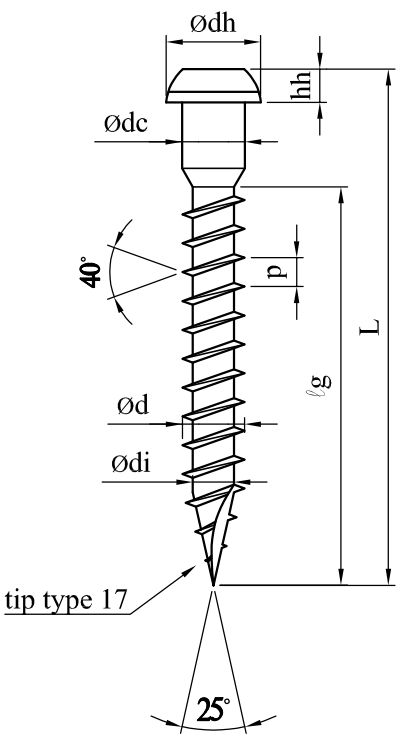


nominal size	Ø5,0
d	5,0
di	3,2
dh	7,2
hh	3,0
p	2,2
dc	4,8

lg min	20
lg max	70

L min	29
L max	80

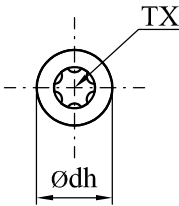
All dimensions in mm. ²⁾



¹⁾ Material specification held on file by ETA Danmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

WBS ZK Hardwood
carbon steel¹

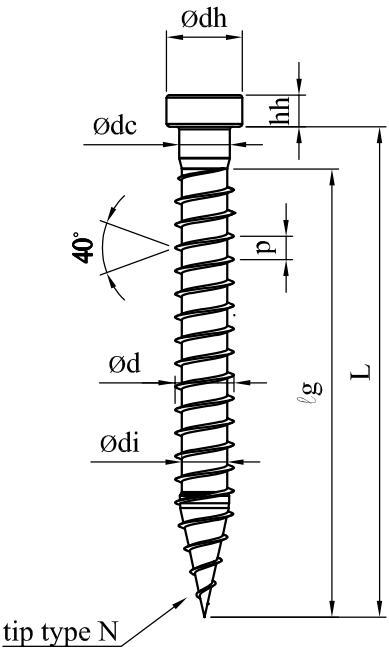


nominal size	Ø5,6
d	5,6
di	4,3
dh	7,2
hh	3,0
p	2,2
dc	4,8

lg min	23
lg max	71

L min	27
L max	80

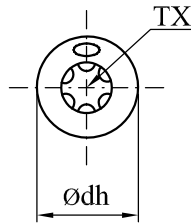
All dimensions in mm. ²⁾



¹⁾ Material specification held on file by ETA Denmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

VSS - Verbinder-Systemschraube
carbon steel¹
for Ø5,0 also austenitic stainless steel and special coated¹

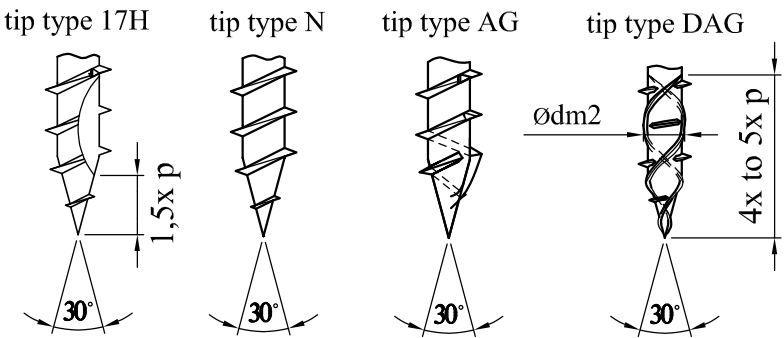
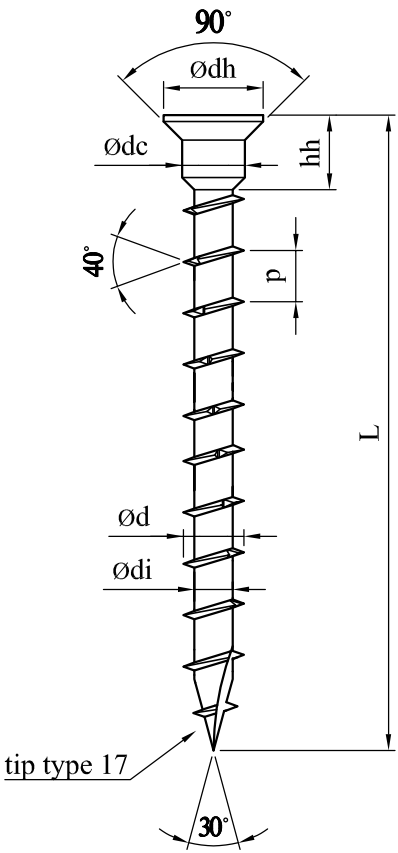


nominal size	Ø4,0	Ø5,0	Ø6,0	Ø8,0
d	4,0	5,0	6,0	8,0
di	2,3	3,2	3,9	5,5
dh	5,5	8,1	9,5	12,0
hh	4,2	5,6	6,7	8,8
p	2,5	3,1	2,2*	4,9
dc	4,0	5,0	6,0	8,0
dm2	2,80	3,80	-*	4,60

L min	20	26	31	41
L max	60	80	100	160

All dimensions in mm. ²⁾

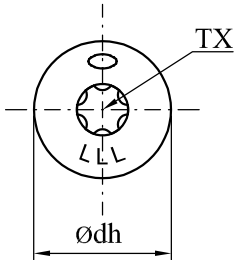
* p for Ø5,0 austenitic stainless steel
resp. dm2 not for austenitic stainless steel



¹⁾ Material specification held on file by ETA Danmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

Sawtec
carbon steel¹

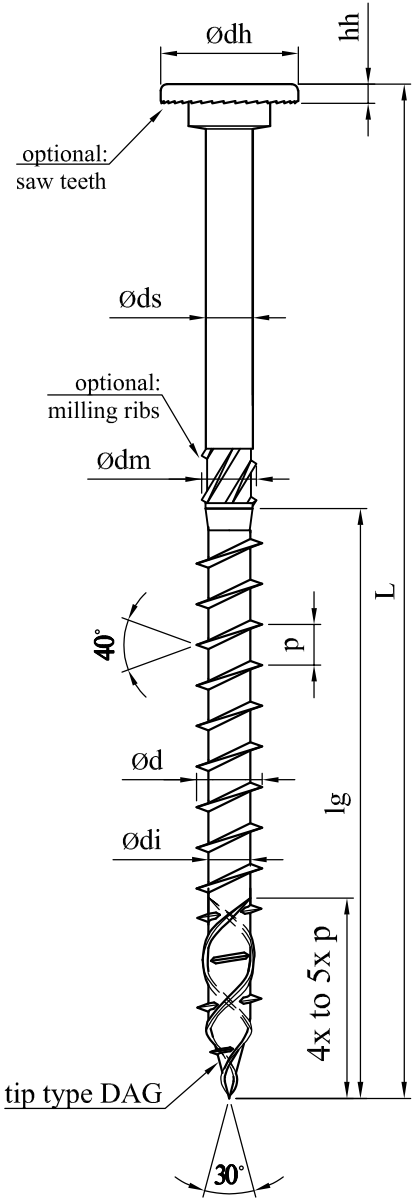
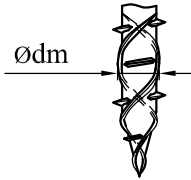


nominal size	Ø4,0	Ø4,5	Ø5,0	Ø6,0	Ø8,0	Ø10,0
d	4,0	4,5	5,0	6,0	8,0	10,0
di	2,5	2,7	3,3	4,0	5,3	6,3
dh	8,5	9,5	10,5	13,0	18,0	22,0
hh	1,7	1,7	2,3	2,4	2,6	3,1
p	2,5	2,8	3,1	4,9	5,6	6,6
ds	2,8	3,0	3,6	4,4	5,8	7,1
dm	2,9	3,4	3,9	4,9	6,7	7,9
dm2	2,8	3,2	3,8	4,6	6,2	7,2

lg min	16	18	20	24	32	40
lg max	48	48	70	70	120	100

L min	18	20	22	26	35	43
L max	80	80	120	400	600	600

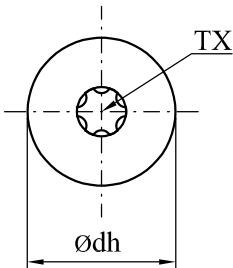
All dimensions in mm. ²⁾



¹⁾ Material specification held on file by ETA Denmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

FBAS
austenitic stainless steel¹

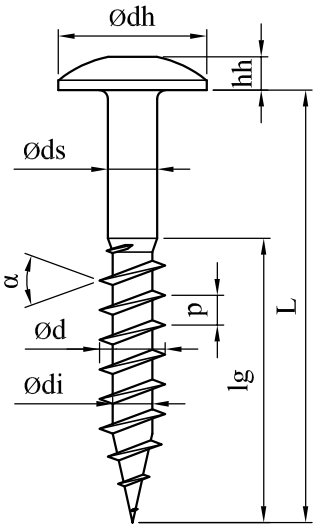


nominal size	Ø4,8	Ø5,3
d	4,8	5,3
di	3,1	3,2
dh	12,0	12,0
hh	2,7	2,7
p	2,1	2,4
ds	3,8	4,0

lg min	20	22
lg max	48	48

L min	20	22
L max	60	60

All dimensions in mm. ²⁾



¹⁾ Material specification held on file by ETA Danmark.

²⁾ Tolerances according to EAD 130118-XX-0603.

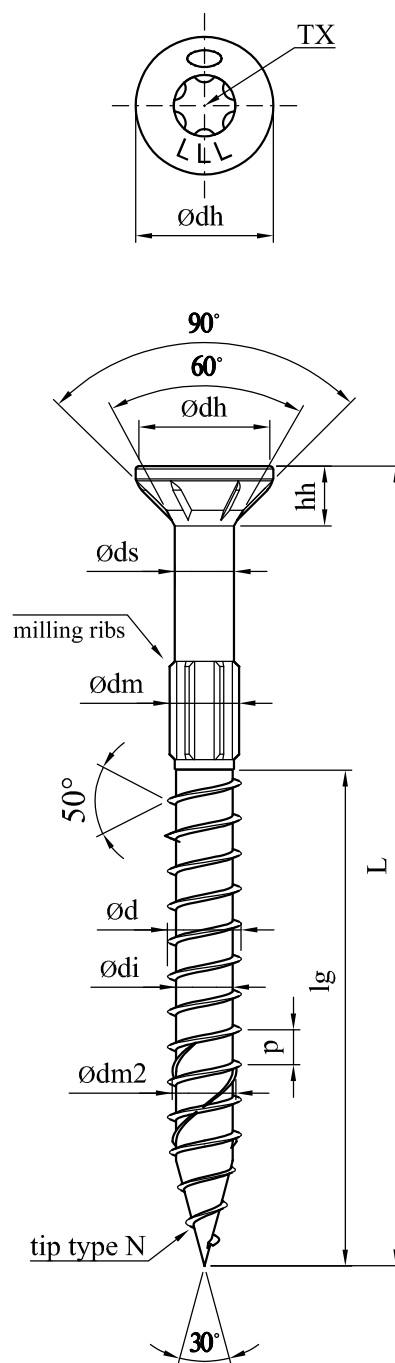
LBS TG SK
carbon steel¹

nominal size	Ø8,0
d	8,0
di	6,1
dh	15,0
hh	6,7
p	3,7
ds	6,4
dm	6,9
ℓ _m	10,5
dm2	6,9

lg min	32
lg max	80

L min	39
L max	240

All dimensions in mm. ²⁾



¹⁾ Material specification held on file by ETA Denmark.

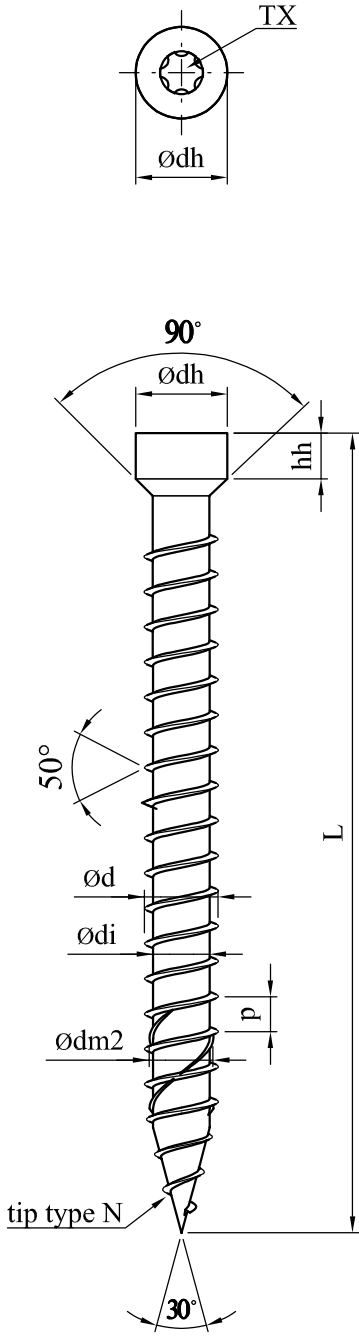
²⁾ Tolerances according to EAD 130118-XX-0603.

LBS VG ZK
carbon steel¹

nominal size	Ø8,0
d	8,0
d _i	6,1
d _h	10,0
h _h	6,5
p	3,8
d _m	6,9

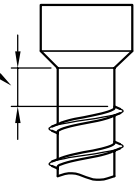
L min	39
L max	400

All dimensions in mm. ²⁾



thread-free part

acceptable for:
 $L < 300$ mm with ≈ 3 mm
 $L \geq 300$ mm with $\approx 3 \times p$



¹⁾ Material specification held on file by ETA Denmark.

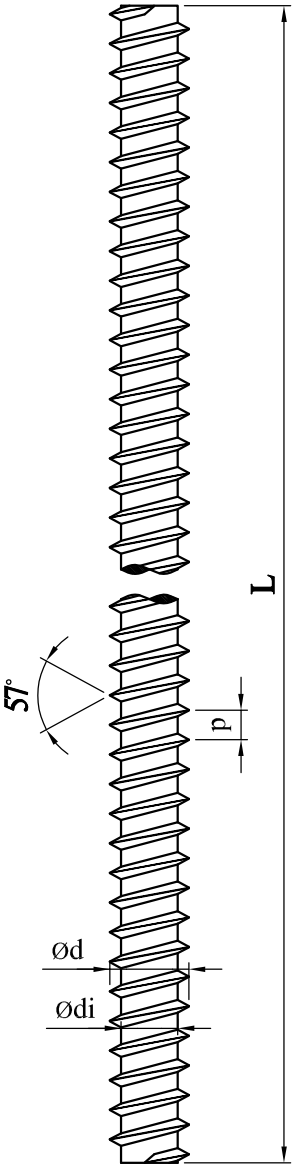
²⁾ Tolerances according to EAD 130118-XX-0603.

Brutus
carbon steel¹

nominal size	Ø16,0
d	16,0
di	11,8
p	2,1

L min	64
L max	3000

All dimensions in mm. ²⁾
Threaded rod may be cut to length.



¹⁾ Material specification held on file by ETA Denmark.

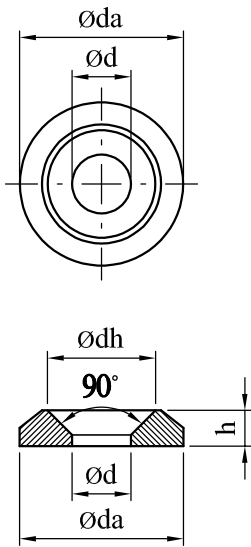
²⁾ Tolerances according to EAD 130118-XX-0603.

Washer
carbon steel¹

Washer for countersunk head 90°

nominal size		Ø5,0	Ø6,0	Ø8,0	Ø10,0
d	min	5,35	7,70	8,70	11,60
	max	5,85	8,30	9,30	12,40
da	min	15,50	19,50	24,50	31,50
	max	16,50	20,50	25,50	32,50
dh	min	9,90	13,60	16,00	22,00
	max	10,70	14,40	17,00	23,00
h	min	2,50	4,30	5,30	6,30
	max	2,90	4,70	5,70	6,70

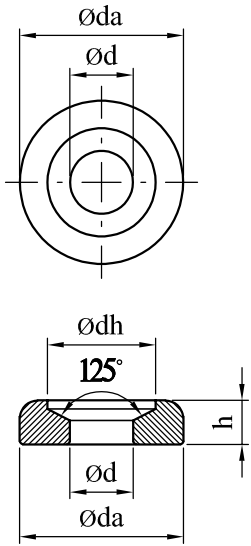
All dimensions in mm.



Washer for head type FK 125°

nominal size		Ø8,0
d	min	10,30
	max	10,90
da	min	27,00
	max	28,00
dh	min	18,20
	max	19,00
h	min	7,00
	max	7,80

All dimensions in mm.



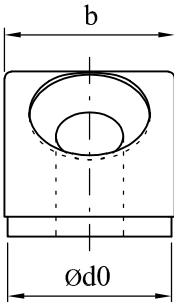
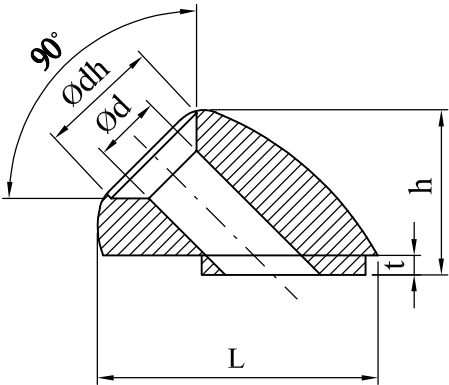
¹Material specification held on file by ETA Danmark.

Taurus 45° angle washer
carbon steel¹

Angle washer for countersunk head 90°

nominal size		Ø6,5	Ø8,0	Ø10,0
d	min	6,8	8,3	10,3
	max	7,5	9,0	11,0
d0	min	13,7	15,7	24,7
	max	15,5	16,5	25,5
dh	min	14,8	14,9	17,9
	max	13,8	15,9	18,9
L	min	27,2	28,2	42,2
	max	28,8	29,8	43,8
b	min	15,2	18,2	26,0
	max	16,8	19,8	27,0
h	min	17,0	18,7	24,2
	max	19,6	20,3	25,8
t	min	2,6	2,8	2,8
	max	3,3	3,5	3,5

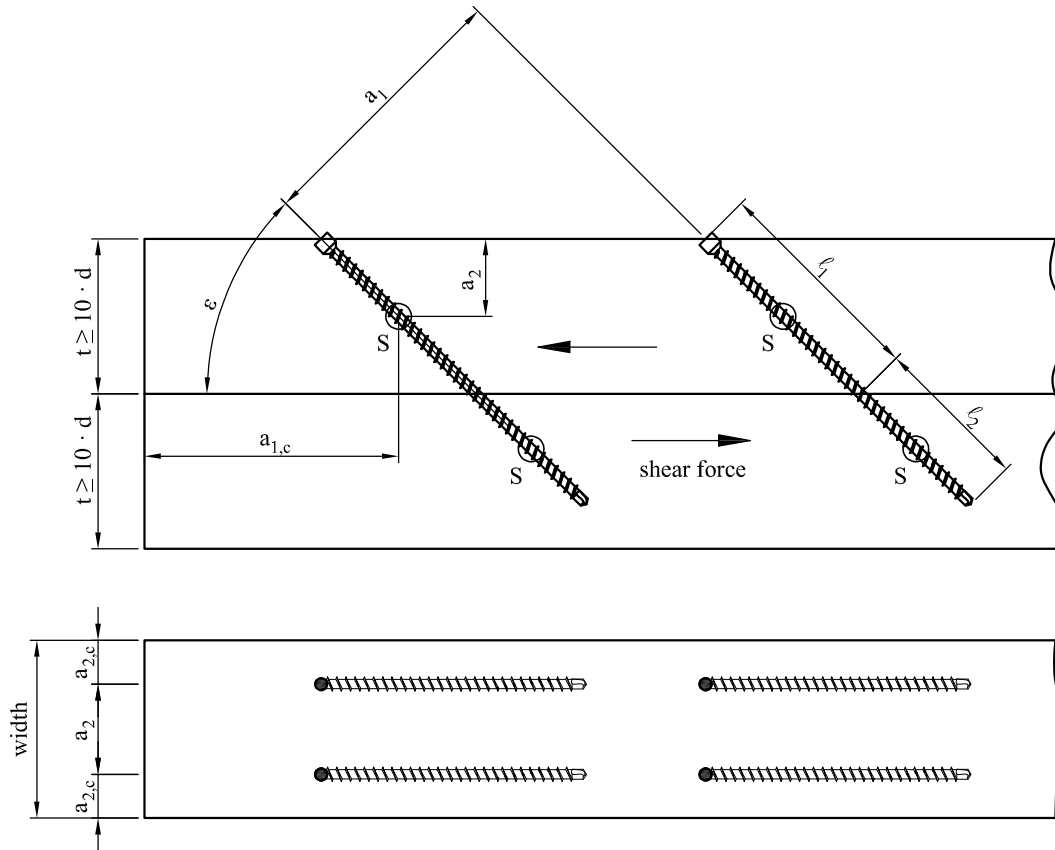
All dimensions in mm.



¹Material specification held on file by ETA Danmark.

Annex B Minimum distances and spacing

Axially loaded screws
Single configuration



S = centroid of the part of the screw in the timber

Minimum distances and spacings for exclusively axially loaded screws in non-predrilled holes.
Minimum timber thickness $t = 10 \cdot d$, minimum timber width $w = \max \{8 \cdot d; 60 \text{ mm}\}$.

$$a_1 \geq 5 \cdot d \quad a_2 \geq 5 \cdot d \quad a_{1,c} \geq 10 \cdot d \quad a_{2,c} \geq 4 \cdot d$$

Minimum distances and spacings for exclusively axially loaded screws in predrilled holes or for screws with tip type BS or rBS DAG in non-predrilled holes. Minimum timber thickness $t = 10 \cdot d$, minimum timber width $w = \max \{8 \cdot d; 60 \text{ mm}\}$.

$$a_1 \geq 5 \cdot d \quad a_2 \geq 5 \cdot d \quad a_{1,c} \geq 5 \cdot d \quad a_{2,c} \geq 3 \cdot d$$

Spacing a_2 may be reduced from $5 \cdot d$ to $2,5 \cdot d$, if the condition $a_1 \cdot a_2 \geq 25 \cdot d^2$ is fulfilled.

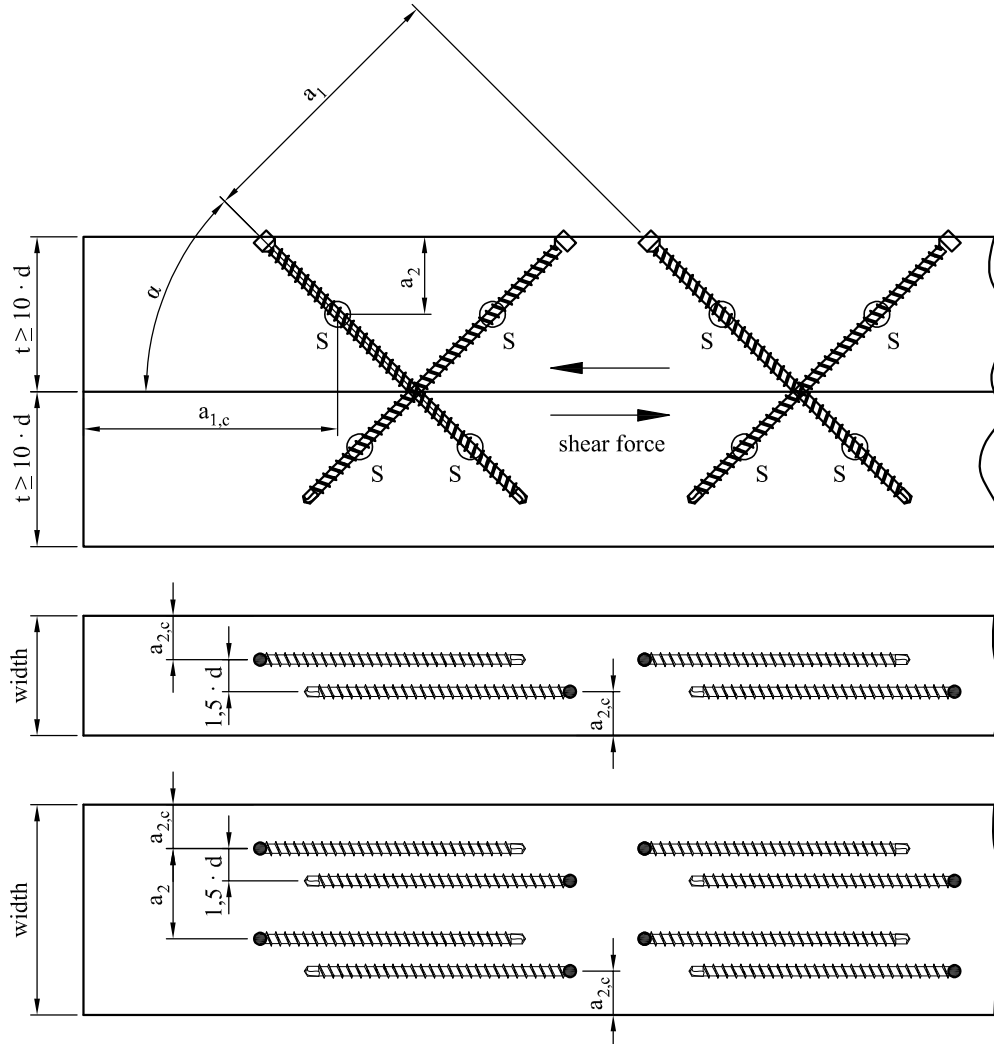
For a crossed screw couple the minimum spacing between the crossing screws is $1,5 \cdot d$.

Minimum distances and spacings, see also 3.12

$0^\circ \leq \varepsilon \leq 90^\circ$ for all tip types except tip type BS, see also 3.9

$30^\circ \leq \varepsilon \leq 90^\circ$ for screws with tip type BS, see also 3.9

Axially loaded screws Crosswise configuration



S = centroid of the part of the screw in the timber

Minimum distances and spacings for exclusively axially loaded screws in non-predrilled holes.

Minimum timber thickness $t = 10 \cdot d$, minimum timber width $w = \max \{8 \cdot d; 60 \text{ mm}\}$.

$$a_1 \geq 5 \cdot d \quad a_2 \geq 5 \cdot d \quad a_{1,c} \geq 10 \cdot d \quad a_{2,c} \geq 4 \cdot d$$

Minimum distances and spacings for exclusively axially loaded screws in predrilled holes or for screws with tip type BS or rBS DAG in non-predrilled holes. Minimum timber thickness $t = 10 \cdot d$, minimum timber width $w = \max \{8 \cdot d; 60 \text{ mm}\}$.

$$a_1 \geq 5 \cdot d \quad a_2 \geq 5 \cdot d \quad a_{1,c} \geq 5 \cdot d \quad a_{2,c} \geq 3 \cdot d$$

Spacing a_2 may be reduced from $5 \cdot d$ to $2,5 \cdot d$, if the condition $a_1 \cdot a_2 \geq 25 \cdot d^2$ is fulfilled.

For a crossed screw couple the minimum spacing between the crossing screws is $1,5 \cdot d$.

Minimum distances and spacings, see also 3.12

$0^\circ \leq \epsilon \leq 90^\circ$ for all tip types except tip type BS, see also 3.9

$30^\circ \leq \epsilon \leq 90^\circ$ for screws with tip type BS, see also 3.9

Axially or laterally loaded screws in the plane or edge surface of cross laminated timber

Figure 1: Definition of spacing, end and edge distances in the plane surface (wide face) unless otherwise specified in the technical specification (ETA or hEN) for the cross laminated timber:

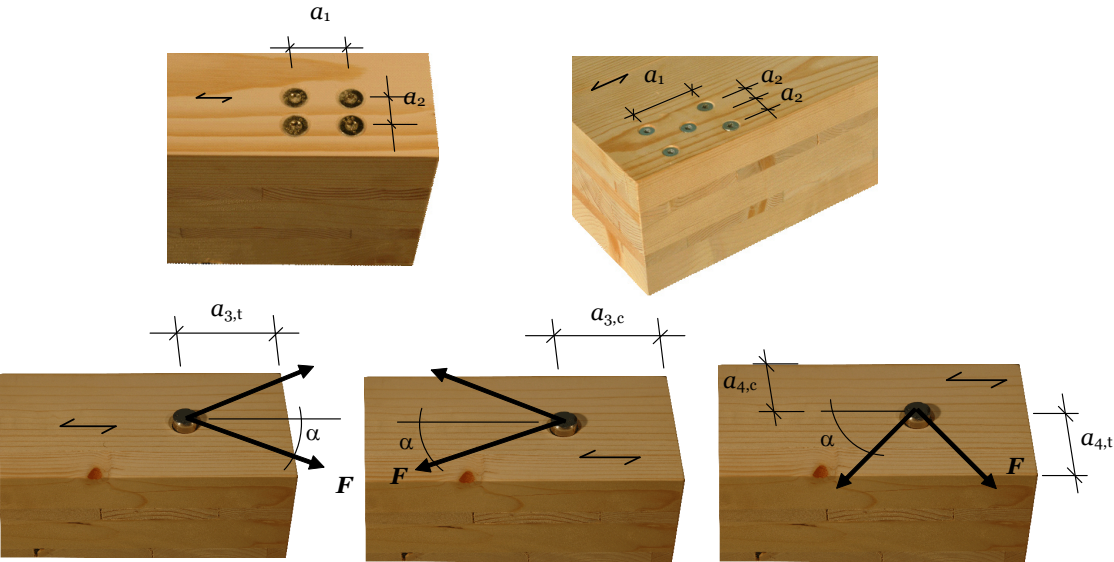
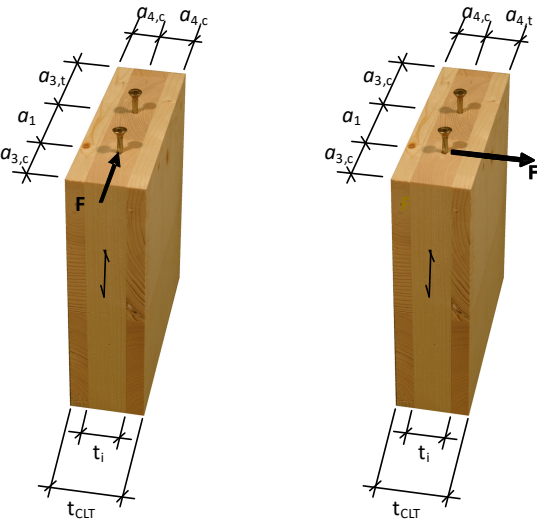


Figure 2: Definition of spacing, end and edge distances in the edge surface unless otherwise specified in the technical specification (ETA or hEN) for the cross laminated timber:



Minimum distances and spacing for screws in the plane surface (wide surface) or edge surface of cross laminated timber

	a_1	$a_{3,t}$	$a_{3,c}$	a_2	$a_{4,t}$	$a_{4,c}$
Plane surface (wide face), see figure 1	$4 \cdot d$	$6 \cdot d$	$6 \cdot d$	$2,5 \cdot d$	$6 \cdot d$	$2,5 \cdot d$
Edge surface, see figure 2	$10 \cdot d$	$12 \cdot d$	$7 \cdot d$	$4 \cdot d$	$6 \cdot d$	$3 \cdot d$

Annex C

Compression reinforcement

„KonstruX" screws or "Brutus" threaded rods with a full thread may be used for reinforcement of timber members with compression stresses at an angle α to the grain of $45^\circ \leq \alpha \leq 90^\circ$. The compression force must be evenly distributed over all screws.

The characteristic load-carrying capacity for a contact area with screws with a full thread at an angle α to the grain of $45^\circ < \alpha < 90^\circ$ shall be calculated from:

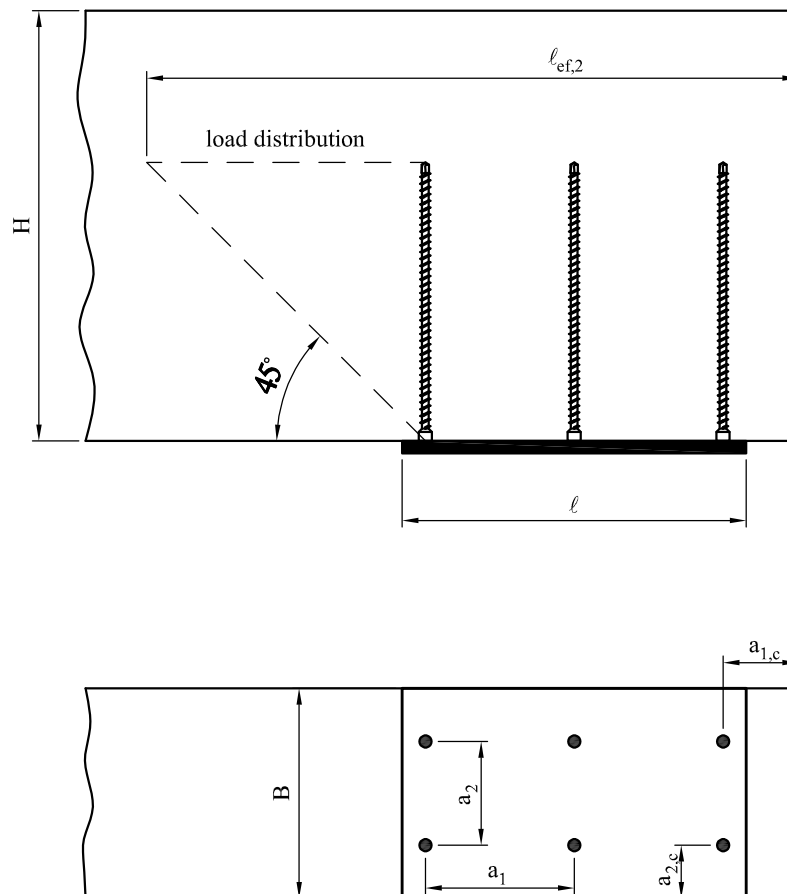
$$F_{90,Rd} = \min \left\{ \begin{array}{l} k_{c,90} \cdot B \cdot \ell_{ef,1} \cdot f_{c,90,d} + n \cdot \min (F_{ax,Rd} ; F_{ki,Rd}) \\ B \cdot \ell_{ef,2} \cdot f_{c,90,d} \end{array} \right\}$$

Where

- $F_{90,Rd}$ design load-carrying capacity of reinforced contact area [N]
- $k_{c,90}$ factor for compression perpendicular to the grain according to EN 1995-1-1
- B bearing width [mm]
- $\ell_{ef,1}$ effective length of contact area according to EN 1995-1-1 [mm]
- $f_{c,90,d}$ design compressive strength perpendicular to the grain [N/mm²]
- n number of reinforcement screws, $n = n_0 \cdot n_{90}$
- n_0 number of reinforcement screws arranged in a row parallel to the grain
- n_{90} number of reinforcement screws arranged in a row perpendicular to the grain
- $F_{ax,Rd}$ design axial withdrawal capacity [N]
- $F_{ki,Rd}$ design buckling capacity [N]
- $\ell_{ef,2}$ effective distribution length in the plane of the screw tips [mm]
- $\ell_{ef,2} = \ell_{ef} + (n - 1) \cdot a + \min (\ell_{ef} ; a_{1,c})$ for end bearings [mm]
- $\ell_{ef,2} = 2 \cdot \ell_{ef} + (n_0 - 1) \cdot a_1$ for centre-bearings [mm]
- a_1 spacing parallel to the grain [mm]
- $a_{1,c}$ end distance [mm]

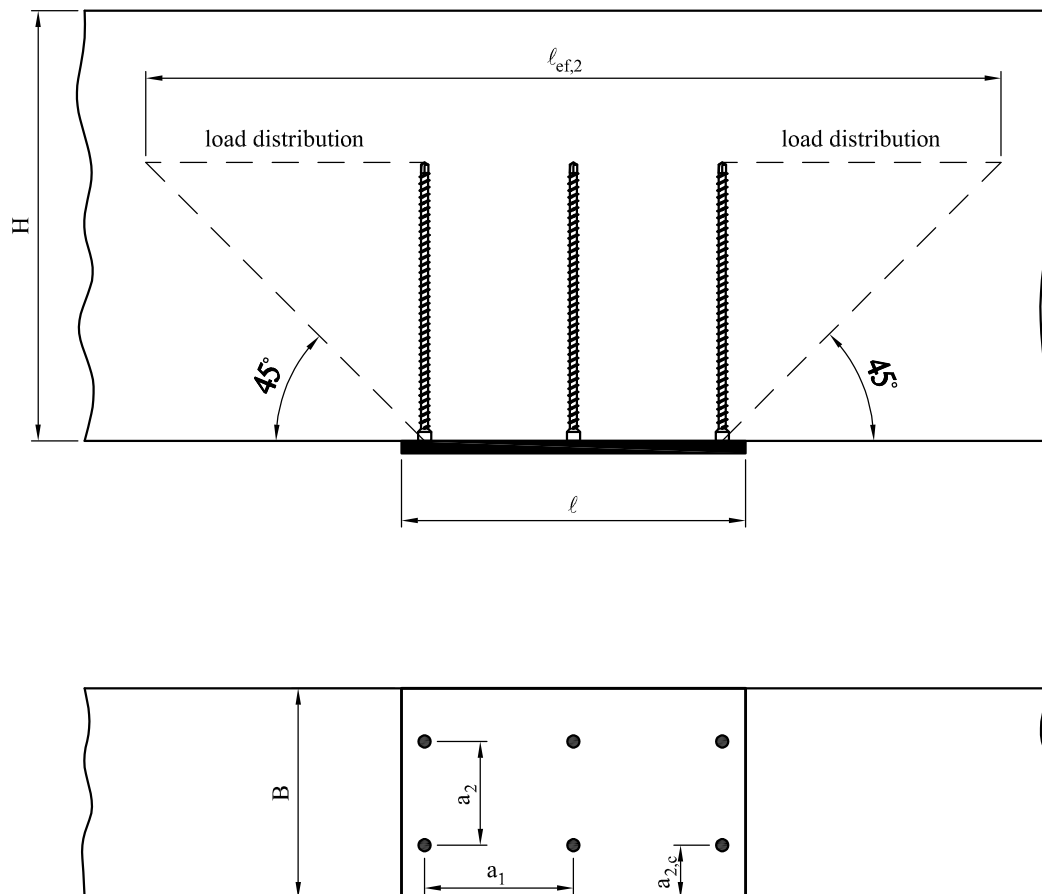
Reinforcing screws or threaded rods for wood-based panels are not covered by this European Technical Assessment.

Reinforced end bearing



- H component height [mm]
 B bearing width [mm]
 ℓ_{ef} point side penetration length [mm]
 $\ell_{ef,2}$ effective distribution length in the plane of the screw tips [mm]
 $= \ell_{ef} + (n_0 - 1) \cdot a_1 + \min(\ell_{ef} ; a_{1,c})$ for end bearings

Reinforced centre-bearing



- H component height [mm]
- B bearing width [mm]
- ℓ_{ef} point side penetration length [mm]
- $\ell_{\text{ef},2}$ effective distribution length in the plane of the screw tips [mm]
 $= 2 \cdot \ell_{\text{ef}} + (n_b - 1) \cdot a_1$ for centre-bearings

Annex D

Tensile reinforcement perpendicular to grain

Timber member loaded by a connection force perpendicular to the grain

„KonstruX" screws or "Brutus" threaded rods with a full thread may be used for reinforcement of timber members with tensile stresses perpendicular to the grain. The tensile force must be evenly distributed over all screws.

Unless specified otherwise in national provisions that apply at the installation site, the axial capacity of a reinforcement of a timber member loaded by a connection force perpendicular to the grain shall fulfil the following condition:

$$\frac{[1 - 3 \cdot \alpha^2 + 2 \cdot \alpha^3] \cdot F_{90,d}}{F_{ax,Rd}} \leq 1$$

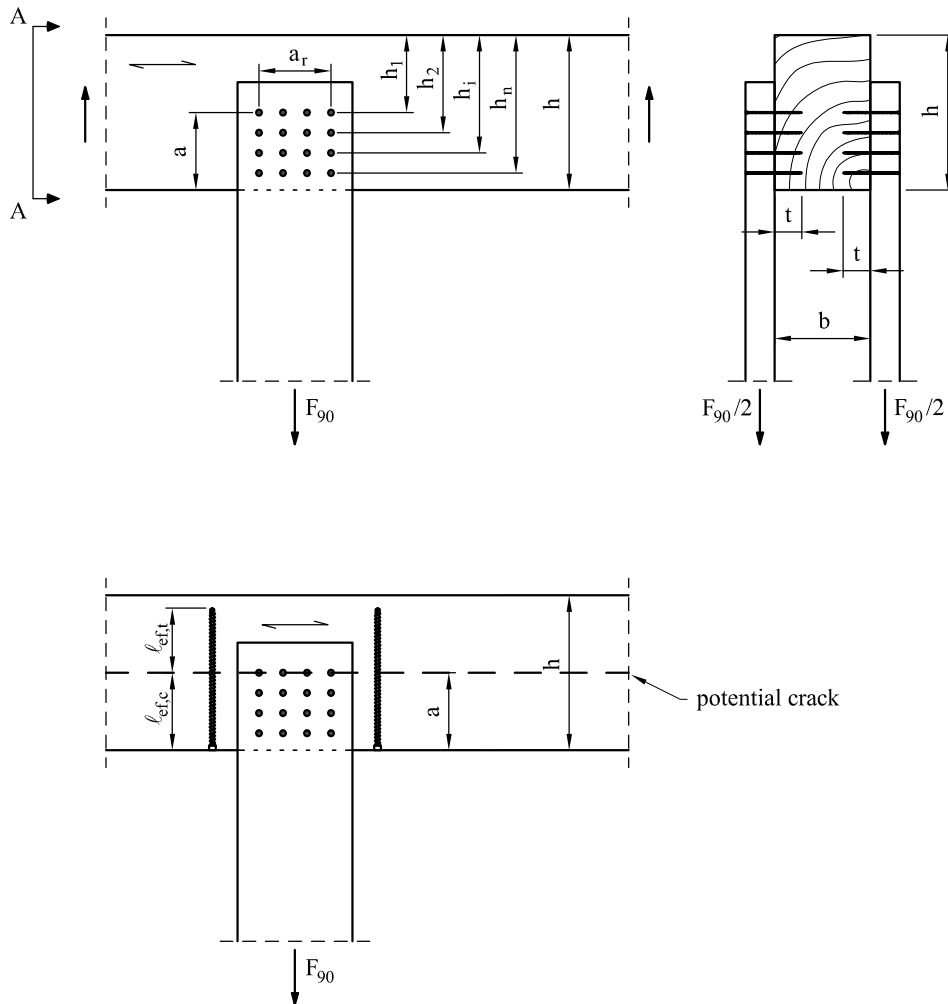
Where

$F_{90,d}$ design value of the force component perpendicular to the grain [N]

$\alpha = a/h$ [mm]

h member depth [mm]

$F_{ax,Rd}$ minimum of the design values of the withdrawal capacity and the tensile capacity of the reinforcing screws or threaded rods where ℓ_{ef} is the smaller value of the penetration depth below or above the potential crack [N]



Notched beam support

Unless specified otherwise in national provisions that apply at the installation site, the axial capacity of a reinforcement of a notched beam support shall fulfil the following condition:

$$\frac{1,3 \cdot V_d \cdot [3 \cdot (1 - \alpha)^2 - 2 \cdot (1 - \alpha)^3]}{F_{ax,Rd}} \leq 1$$

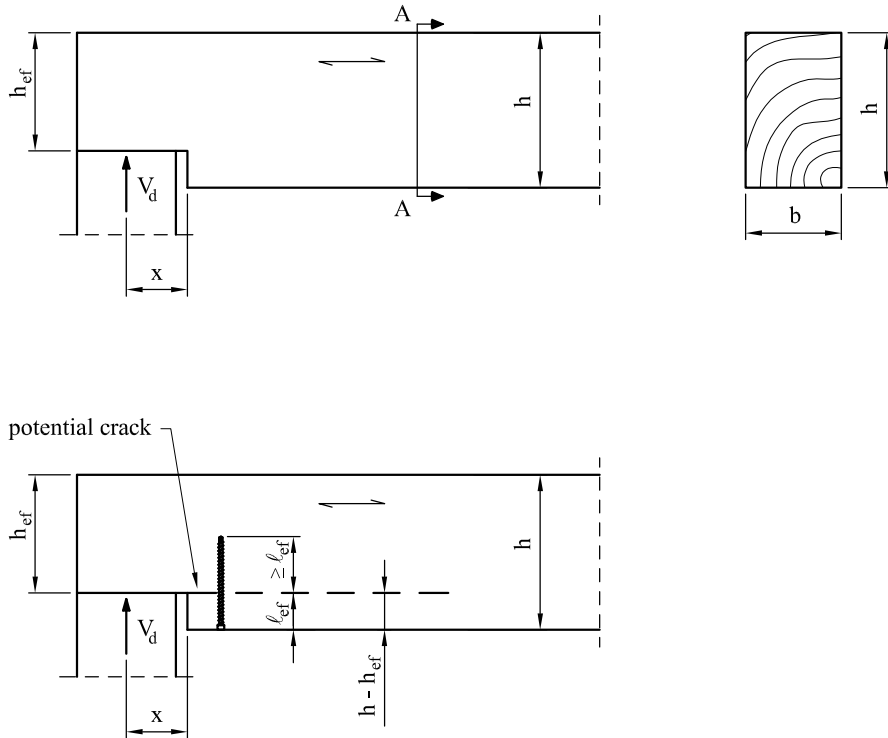
Where

V_d design value of the shear force [N]

$\alpha = h_{ef}/h$ [mm]

h member depth [mm]

$F_{ax,Rd}$ minimum of the design values of the withdrawal capacity and the tensile capacity of the reinforcing screws or threaded rods where ℓ_{ef} is the smaller value of the penetration depth below or above the potential crack [N]



Beam hole

Unless specified otherwise in national provisions that apply at the installation site, the axial capacity of a reinforcement of a hole in a beam shall fulfil the following condition:

$$\frac{F_{t,V,d} + F_{t,M,d}}{F_{ax,Rd}} \leq 1$$

Where

$F_{t,V,d}$ design value of the force perpendicular to the grain due to shear force:

$$F_{t,V,d} = \frac{V_d \cdot h_d}{4 \cdot h} \cdot \left[3 - \frac{h_d^2}{h^2} \right] \quad [\text{N}]$$

V_d design value of the shear force [N]

h member depth [mm]

h_d hole depth for rectangular holes [mm]

h_d 70 % of hole diameter for circular holes [mm]

$F_{t,M,d}$ design value of the force perpendicular to the grain due to bending moment:

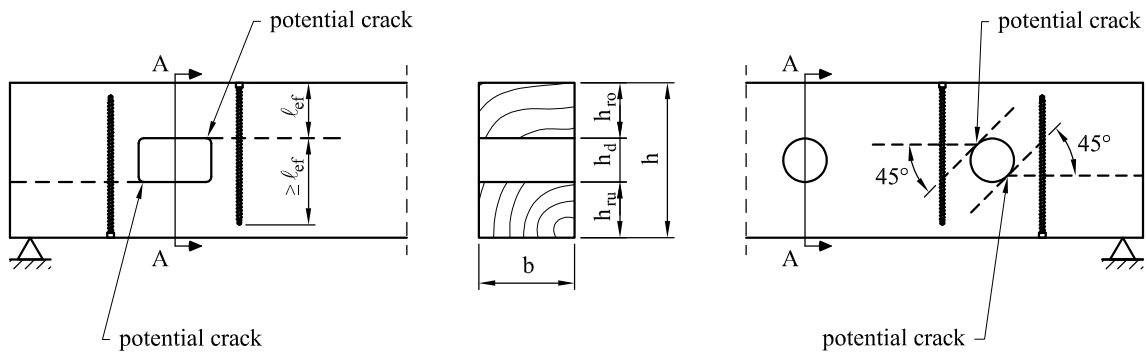
$$F_{t,M,d} = 0,008 \cdot \frac{M_d}{h_r} \quad [\text{N}]$$

M_d design value of the member bending moment at the hole end [Nmm]

$h_r = \min(h_{ro}; h_{ru})$ for rectangular holes [mm]

$h_r = \min(h_{ro}; h_{ru}) + 0,15 \cdot h_d$ for circular holes [mm]

$F_{ax,Rd}$ minimum of the design values of the withdrawal capacity and the tensile capacity of the reinforcing screws or threaded rods where ℓ_{ef} is the smaller value of the penetration depth below or above the potential crack [N]



Annex E

Thermal insulation on top of rafters

E.u.r.o.Tec screws with an outer thread diameter $6 \text{ mm} \leq d \leq 12 \text{ mm}$ may be used for the fixing of heat insulation on top of rafters.

The thickness of the insulation shall not exceed 400 mm. The rafter insulation must be placed on top of solid timber or glued laminated timber rafters or cross-laminated timber members and be fixed by battens arranged parallel to the rafters or by wood-based panels on top of the insulation layer. The insulation of vertical facades is also covered by the rules given here.

Screws must be screwed in the rafter through the battens or panels and the insulation without pre-drilling in one sequence.

The angle ε between the screw axis and the grain direction of the rafter should be between 30° and 90° .

The rafter consists of solid timber (softwood) according to EN 338, glued laminated timber according to EN 14080, cross-laminated timber, or laminated veneer lumber according to EN 14374 or to European Technical Assessment or similar glued members according to European Technical Assessment.

The battens must be from solid timber (softwood) according to EN 338. The minimum thickness t and the minimum width b of the solid timber battens is given as follows:

Screws $d \leq 8,0 \text{ mm}$:	$b_{\min} = 50 \text{ mm}$	$t_{\min} = 30 \text{ mm}$
Screws $d = 10,0 \text{ mm}$:	$b_{\min} = 60 \text{ mm}$	$t_{\min} = 40 \text{ mm}$
Screws $d = 12,0 \text{ mm}$:	$b_{\min} = 80 \text{ mm}$	$t_{\min} = 100 \text{ mm}$

The insulation must comply with a European Technical Assessment.

Friction forces shall not be considered for the design of the characteristic axial capacity of the screws.

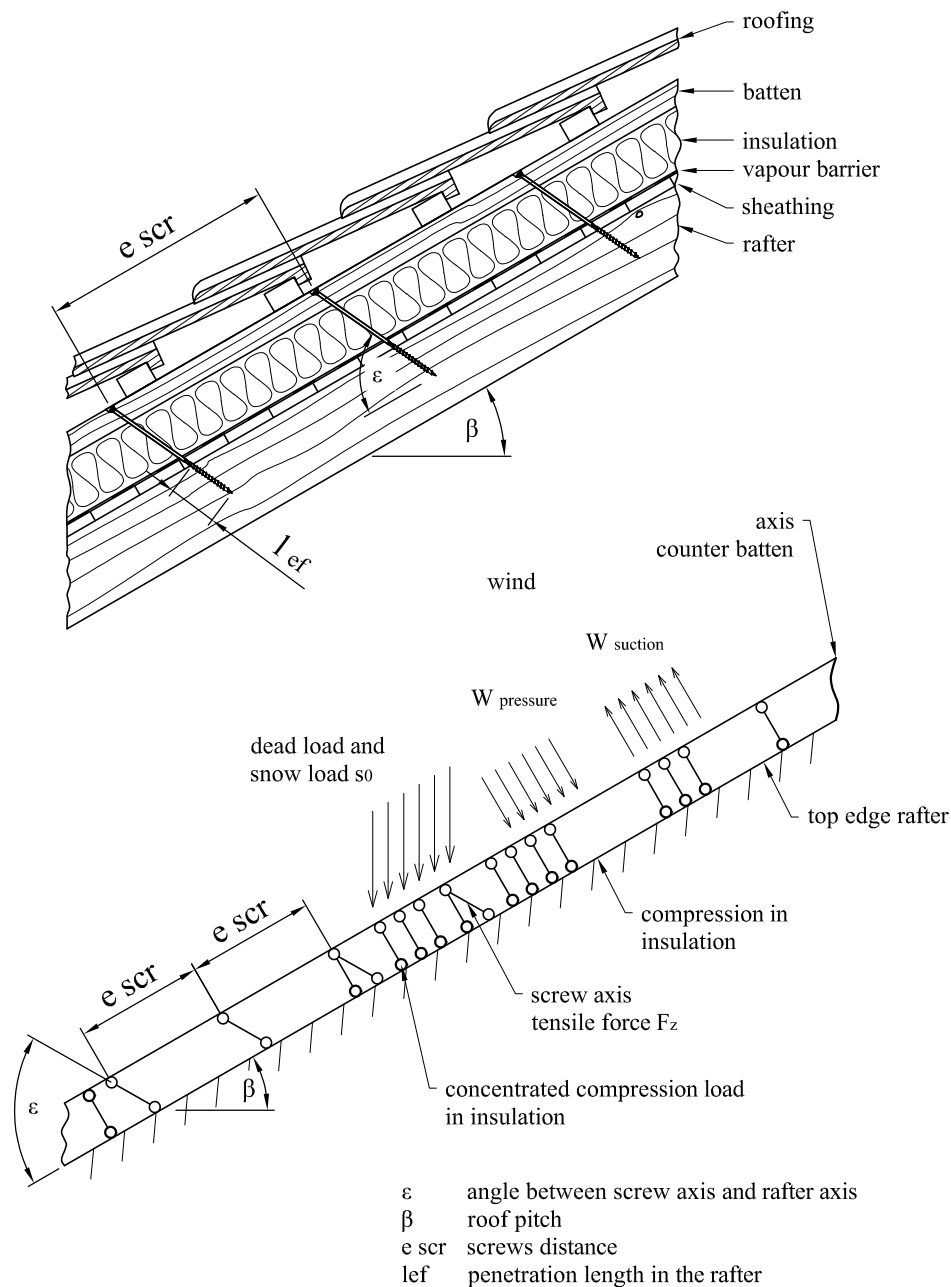
The anchorage of wind suction forces as well as the bending stresses of the battens or the boards, respectively, shall be considered in design. Additional screws perpendicular to the grain of the rafter (angle $\varepsilon = 90^\circ$) may be arranged if necessary.

The maximum screw spacing is $e_s = 1,75 \text{ m}$.

Thermal insulation on rafters with parallel inclined screws

Mechanical model

The system of rafter, heat insulation material on top of rafter and battens parallel to the rafter may be considered as a beam on elastic foundation. The batten represents the beam, and the heat insulation material on top of the rafter the elastic foundation. The minimum compression stress of the heat insulation material at 10 % deformation, measured according to EN 826¹, shall be $\sigma_{10\%} = 0,05 \text{ N/mm}^2$. The batten is loaded perpendicular to the axis by point loads F_b . Further point loads F_s are from the shear load of the roof due to dead and snow load, which are transferred from the screw heads into the battens.



¹ EN 826:1996 Thermal insulating products for building applications - Determination of compression behaviour

Thermal insulation on rafters with parallel inclined screws

Design of the battens

The bending stresses are calculated as:

$$M = \frac{(F_b + F_s) \cdot \ell_{\text{char}}}{4}$$

Where

F_b point loads perpendicular to the battens [N]

F_s point loads perpendicular to the battens, load application in the area of the screw heads [N]

ℓ_{char} characteristic length $\ell_{\text{char}} = \sqrt[4]{\frac{4 \cdot EI}{w_{\text{ef}} \cdot K}}$ [mm]

EI bending stiffness of the batten [$\text{N/mm}^2 \cdot \text{mm}^4$]

w_{ef} effective width of the thermal insulation material [mm]

K coefficient of subgrade

The coefficient of subgrade K may be calculated from the modulus of elasticity E_{HI} and the thickness t_{HI} of the heat insulation material if the effective width w_{ef} of the heat insulation material under compression is known. Due to the load extension in the heat insulation material the effective width w_{ef} is greater than the width of the batten or rafter, respectively. For further calculations, the effective width w_{ef} of the heat insulation material may be determined according to:

$$w_{\text{ef}} = w + t_{\text{HI}} / 2$$

Where

w minimum width of the batten or rafter, respectively [mm]

t_{HI} thickness of the heat insulation [mm]

$$K = \frac{E_{\text{HI}}}{t_{\text{HI}}}$$

The following condition shall be satisfied:

$$\frac{\sigma_{\text{m,d}}}{f_{\text{m,d}}} = \frac{M_d}{W \cdot f_{\text{m,d}}} \leq 1$$

For the calculation of the section modulus W of the net cross section has to be considered.

The shear stresses shall be calculated according to:

$$V = \frac{(F_b + F_s)}{2}$$

The following condition shall be satisfied:

$$\frac{\tau_d}{f_{\text{v,d}}} = \frac{1,5 \cdot V_d}{A \cdot f_{\text{v,d}}} \leq 1$$

Design of the heat insulation material

The compressive stresses in the thermal insulation material shall be calculated according to:

$$\sigma = \frac{1,5 \cdot F_b + F_s}{2 \cdot \ell_{\text{char}} \cdot w}$$

The design value of the compressive stress shall not be greater than 110 % of the compressive stress at 10 % deformation calculated according to EN 826.

Thermal insulation on rafters with parallel inclined screws

Design of the screws

Alternatively to the battens, wood-based panels with a minimum thickness of 20 mm from plywood according to EN 636, particle board according to EN 312, oriented strand board OSB/3 and OSB/4 according to EN 300 or European Technical Approval and solid wood panels according to EN 13353 or cross laminated timber may be used.

The insulation must have a minimum compressive stress of $\sigma_{10\%} = 0,05 \text{ N/mm}^2$ at 10 % deformation according to EN 826.

The analysis of the fixing of the insulation and battens or boards, respectively, may be carried out using the static model showed on previous pages. The battens or boards, respectively, must have sufficient strength and stiffness. The maximum design value of the compressive stress between the battens or boards, respectively, and the insulation shall not exceed $1,1 \cdot \sigma_{10\%}$.

The screws are loaded predominantly axially. The axial tension force in the screw may be calculated from the shear loads of the roof R_s :

$$T_s = \frac{R_s}{\cos \varepsilon}$$

The design axial capacity of the "Paneltwistec", "Sawtec", "SP FK", "Speedo" and "SP ZK" screws for rafter or facade insulation shall be calculated from:

$$F_{ax,\varepsilon,Rd} = \min \left\{ \frac{k_{ax} \cdot f_{ax,d} \cdot d \cdot \ell_{ef,r} \cdot k_1 \cdot k_2}{k_\beta} \cdot \left(\frac{\rho_{k,r}}{350} \right)^{0,8} ; f_{head,d} \cdot d_h^2 \cdot \left(\frac{\rho_{k,b}}{350} \right)^{0,8} ; \frac{f_{tens,k}}{\gamma_{M2}} \right\}$$

The design axial capacity of the "KonstruX" or "Topduo" screws for rafter or facade insulation shall be calculated from:

$$F_{ax,\varepsilon,Rd} = \min \left\{ \frac{k_{ax} \cdot f_{ax,d} \cdot d \cdot \ell_{ef,r} \cdot k_1 \cdot k_2}{k_\beta} \cdot \left(\frac{\rho_{k,r}}{350} \right)^{0,8} ; \max \left\{ f_{head,d} \cdot d_h^2 ; \frac{k_{ax} \cdot f_{ax,d} \cdot d \cdot \ell_{ef,b} \cdot k_1 \cdot k_2}{k_\beta} \right\} \cdot \left(\frac{\rho_{k,b}}{350} \right)^{0,8} ; \frac{f_{tens,k}}{\gamma_{M2}} \right\}$$

Where

$F_{ax,\varepsilon,Rd}$ design axial capacity of the screw at an angle α to the grain [N]

$k_{ax} = 1,0$ for $45^\circ \leq \varepsilon \leq 90^\circ$

$= 0,3 + (0,7 \cdot \varepsilon/45^\circ)$ for $0^\circ \leq \varepsilon < 45^\circ$

$f_{ax,d}$ design withdrawal parameter [N/mm²]

d outer thread diameter [mm]

d_h head diameter [mm]

$\ell_{ef,r}$ point side penetration length of the threaded part according to EN 1995-1-1 [mm]

$\ell_{ef,b}$ length of the threaded part in the batten [mm]

ε angle between grain and screw axis ($\alpha \geq 30^\circ$)

$k_1 = \min \{1; 220/t_{HI}\}$

$k_2 = \min \{1; \sigma_{10\%}/0,12\}$

If equation k_1 and k_2 are considered, the deflection of the battens does not need to be considered.

t_{HI} thickness of the heat insulation [mm]

$\sigma_{10\%}$ compressive stress of the heat insulation under 10 % deformation [N/mm²]

$\sigma_{10\%} \geq 0,05 \text{ N/mm}^2$

$\rho_{k,r}$ characteristic density of the rafter [kg/m³]

$\rho_{k,b}$ characteristic density of the batten [kg/m³]

$f_{head,d}$ design head pull-through parameter [N/mm²]

$f_{tens,k}$ characteristic tensile capacity [N]

γ_{M2} partial safety factor according to EN 1993-1-1 or according to national annex

Thermal insulation on rafters with parallel inclined screws

Fixing of battens with parallel screws perpendicular to the roof plane

Alternatively to the battens, wood-based panels with a minimum thickness of 20 mm from plywood according to EN 636, particle board according to EN 312, oriented strand board OSB/3 and OSB/4 according to EN 300 or European Technical Assessment and solid wood panels according to EN 13353 or cross laminated timber may be used.

The insulation must have a minimum compressive stress of $\sigma_{0\%} = 0,05 \text{ N/mm}^2$ at 10 % deformation according to EN 826.

The battens or wood-based panels, respectively, must have sufficient strength and stiffness. The maximum design value of the compressive stress between the battens or boards, respectively, and the insulation shall not exceed $1,1 \cdot \sigma_{10\%}$.

The characteristic load-carrying capacity of the screws loaded in shear may be calculated from:

$$F_{v,Rk} = \min \left\{ \begin{array}{l} f_{h,b,k} \cdot d \cdot t_b \\ f_{h,r,k} \cdot d \cdot t_r \\ \frac{f_{h,b,k} \cdot d \cdot \beta}{1 + \beta} \cdot \left(\sqrt{4t_{il}^2 + \left(2 + \frac{1}{\beta}\right)t_b^2 + (2 + \beta)t_r^2 + 4t_{il}(t_b + t_r) + 2t_b t_r - 2t_{il} - t_b - t_r} \right) + \frac{F_{ax,Rk}}{4} \\ 1,05 \cdot \frac{f_{h,b,k} \cdot d \cdot \beta}{\frac{1}{2} + \beta} \cdot \left(\sqrt{t_{il}^2 + t_{il}t_b + \frac{t_b^2}{2}\left(1 + \frac{1}{\beta}\right) + \frac{M_{y,k}}{f_{h,b,k} \cdot d} \left(1 + \frac{2}{\beta}\right) - t_{il} - \frac{t_b}{2}} \right) + \frac{F_{ax,Rk}}{4} \\ 1,05 \cdot \frac{f_{h,b,k} \cdot d \cdot \beta}{\frac{1}{2} + \beta} \cdot \left(\sqrt{t_{il}^2 + t_{il}t_r + \frac{t_r^2}{2}\left(1 + \beta\right) + \frac{M_{y,k}}{f_{h,b,k} \cdot d} \left(2 + \frac{1}{\beta}\right) - t_{il} - \frac{t_r}{2}} \right) + \frac{F_{ax,Rk}}{4} \\ 1,15 \cdot \frac{f_{h,b,k} \cdot d \cdot \beta}{1 + \beta} \cdot \left(\sqrt{\beta^2 t_{il}^2 + 4\beta(\beta + 1) \cdot \frac{M_{y,k}}{f_{h,b,k} \cdot d} - \beta t_{il}} \right) + \frac{F_{ax,Rk}}{4} \end{array} \right.$$

Where

$f_{h,b,k}$	characteristic batten embedding strength [N/mm ²]
$f_{h,r,k}$	characteristic rafter embedding strength [N/mm ²]
β	$f_{h,r,k}/f_{h,b,k}$
d	outer thread diameter [mm]
t_b	batten thickness [mm]
t_r	lower value of rafter thickness or screw penetration length [mm]
t_{il}	interlayer thickness [mm]
$M_{y,k}$	characteristic fastener yield moment [Nmm]
$F_{ax,Rk}$	characteristic axial capacity of the screw [N]

Thermal insulation on rafters with alternatively inclined screws

Mechanical model

Depending on the screw spacing and the arrangement of tensile and compressive screws with different inclinations the battens are loaded by significant bending moments. The bending moments are derived based on the following assumptions:

- The tensile and compressive loads in the screws are determined based on equilibrium conditions from the actions parallel and perpendicular to the roof plane. These actions are constant line loads q_{\parallel} and q_{\perp} .
- The screws act as hinged columns supported 10 mm within the batten or rafter, respectively. The effective column length consequently equals the length of the screw between batten and rafter plus 20 mm.
- The batten is considered as a continuous beam with a constant span $\ell = A + B$. The compressive screws constitute the supports of the continuous beam while the tensile screws transfer concentrated loads perpendicular to the batten axis.

The screws are predominantly loaded in withdrawal or compression, respectively. The screw's normal forces are determined based on the loads parallel and perpendicular to the roof plane:

$$\text{compressive screw: } F_{c,Ed} = (A + B) \cdot \left(-\frac{q_{\parallel}}{\cos \varepsilon_1 + \sin \varepsilon_1 / \tan \varepsilon_2} - \frac{q_{\perp} \cdot \sin(90^\circ - \varepsilon_2)}{\sin(\varepsilon_1 + \varepsilon_2)} \right)$$

$$\text{tensile screw: } F_{t,Ed} = (A + B) \cdot \left(\frac{q_{\parallel}}{\cos \varepsilon_2 + \sin \varepsilon_2 / \tan \varepsilon_1} - \frac{q_{\perp} \cdot \sin(90^\circ - \varepsilon_1)}{\sin(\varepsilon_1 + \varepsilon_2)} \right)$$

The bending moments in the batten follow from the constant line load q_{\perp} and the load components perpendicular to the batten from the tensile screws. The span of the continuous beam is $(A + B)$. The load component perpendicular to the batten from the tensile screw is:

$$F_{ZS,Ed} = (A + B) \cdot \left(\frac{q_{\parallel}}{1 / \tan \varepsilon_1 + 1 / \tan \varepsilon_2} - \frac{q_{\perp} \cdot \sin(90^\circ - \varepsilon_1) \cdot \sin \varepsilon_2}{\sin(\varepsilon_1 + \varepsilon_2)} \right)$$

Where

q_{\parallel} constant line load parallel to batten

q_{\perp} constant line load perpendicular to batten

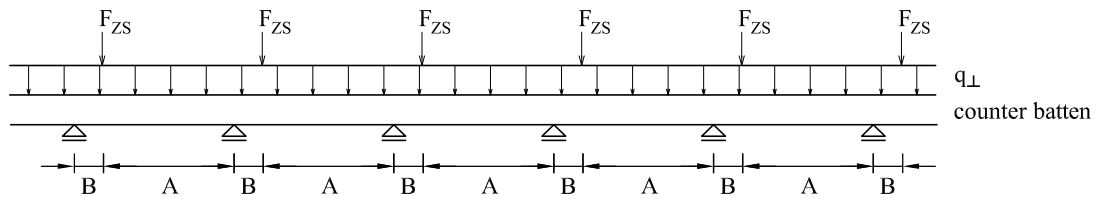
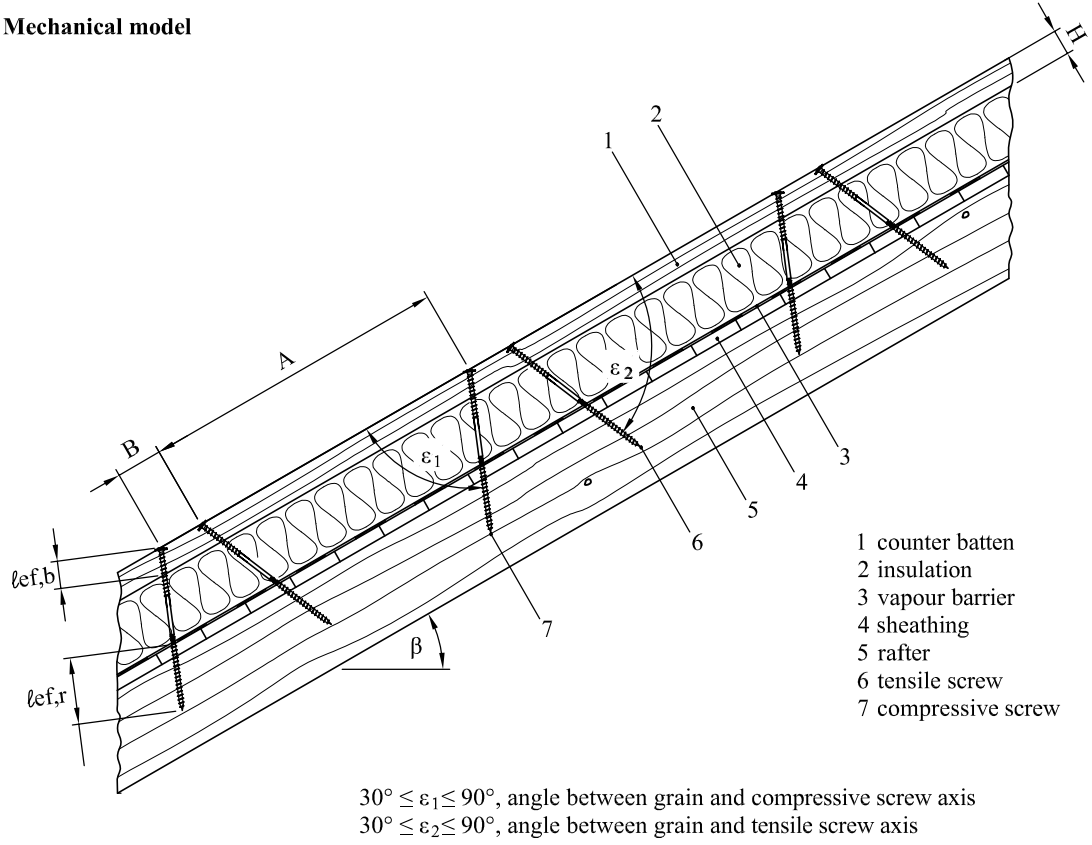
ε_1 angle between compressive screw axis and grain direction

ε_2 angle between tensile screw axis and grain direction

A positive value for F_{ZS} means a load towards the rafter, a negative value a load away from the rafter.

Thermal insulation on rafters with alternatively inclined screws

Mechanical model



$$\text{compressive screw: } F_{c,Ed} = (A + B) \cdot \left(-\frac{q_{\parallel}}{\cos \varepsilon_1 + \sin \varepsilon_1 / \tan \varepsilon_2} - \frac{q_{\perp} \cdot \sin(90^\circ - \varepsilon_2)}{\sin(\varepsilon_1 + \varepsilon_2)} \right)$$

$$\text{tensile screw: } F_{t,Ed} = (A + B) \cdot \left(\frac{q_{\parallel}}{\cos \varepsilon_2 + \sin \varepsilon_2 / \tan \varepsilon_1} - \frac{q_{\perp} \cdot \sin(90^\circ - \varepsilon_1)}{\sin(\varepsilon_1 + \varepsilon_2)} \right)$$

$$\text{concentrated load: } F_{ZS,Ed} = (A + B) \cdot \left(\frac{q_{\parallel}}{1 / \tan \varepsilon_1 + 1 / \tan \varepsilon_2} - \frac{q_{\perp} \cdot \sin(90^\circ - \varepsilon_1) \cdot \sin \varepsilon_2}{\sin(\varepsilon_1 + \varepsilon_2)} \right)$$

Where

q_{\parallel} constant line load parallel to batten

q_{\perp} constant line load perpendicular to batten

ε_1 angle between compressive screw axis and grain direction

ε_2 angle between tensile screw axis and grain direction

A positive value for F_{ZS} means a load towards the rafter, a negative value a load away from the rafter.

Thermal insulation on rafters with alternatively inclined screws

Design of the screws

The analysis of the fixing of the insulation and battens may be carried out using the static model showed on previous page. The battens must have sufficient strength and stiffness.

The design axial tensile capacity of the "KonstruX" or "Topduo" screws for rafter or facade insulation shall be calculated from:

$$F_{ax,\varepsilon,Rd} = \min \left\{ \frac{k_{ax} \cdot f_{ax,d} \cdot d \cdot \ell_{ef,r} \cdot k_1 \cdot k_2}{k_{\beta}} \cdot \left(\frac{\rho_{k,r}}{350} \right)^{0,8} ; \max \left\{ f_{head,d} \cdot d_h^2 ; \frac{k_{ax} \cdot f_{ax,d} \cdot d \cdot \ell_{ef,b} \cdot k_1 \cdot k_2}{k_{\beta}} \right\} \cdot \left(\frac{\rho_{k,b}}{350} \right)^{0,8} ; \frac{f_{tens,k}}{\gamma_{M2}} \right\}$$

The design axial compressive capacity of the "KonstruX" or "Topduo" screws for rafter or facade insulation shall be calculated from:

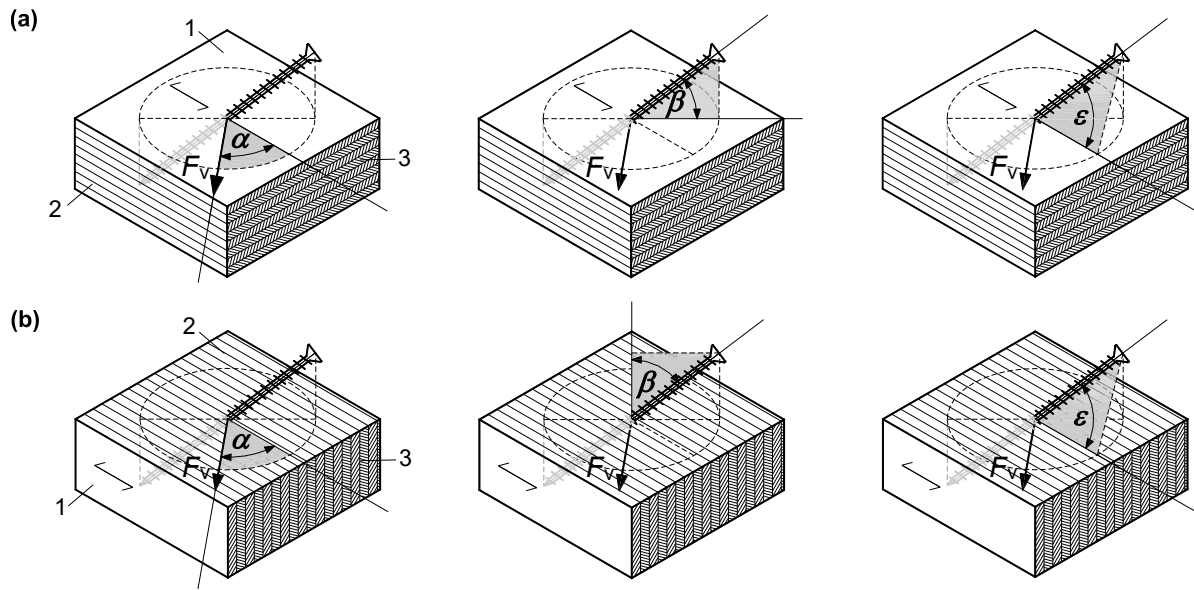
$$F_{ax,\varepsilon,Rd} = \min \left\{ \frac{k_{ax} \cdot f_{ax,d} \cdot d \cdot \ell_{ef,r} \cdot k_1 \cdot k_2}{k_{\beta}} \cdot \left(\frac{\rho_{k,r}}{350} \right)^{0,8} ; \frac{k_{ax} \cdot f_{ax,d} \cdot d \cdot \ell_{ef,b} \cdot k_1 \cdot k_2}{k_{\beta}} \cdot \left(\frac{\rho_{k,b}}{350} \right)^{0,8} ; \frac{F_{ki,Rk}}{\gamma_{M1}} \right\}$$

Where

$F_{ax,\varepsilon,Rd}$	design axial capacity of the screw at an angle ε to the grain [N]
$f_{head,d}$	design head pull-through parameter [N/mm ²]
d_h	head diameter [mm]
k_{ax}	= 1,0 for $45^\circ \leq \varepsilon \leq 90^\circ$ = $0,3 + (0,7 \cdot \varepsilon/45^\circ)$ for $0^\circ \leq \varepsilon < 45^\circ$
$f_{ax,d}$	design withdrawal parameter [N/mm ²]
d	outer thread diameter [mm]
$\ell_{ef,b}$	length of the threaded part in the batten [mm]
$\ell_{ef,r}$	point side penetration length of the threaded part according to EN 1995-1-1 [mm]
ε	angle between grain and screw axis ($\varepsilon \geq 30^\circ$)
$\rho_{k,b}$	characteristic density of the batten [kg/m ³]
$\rho_{k,r}$	characteristic density of the rafter [kg/m ³]
$f_{tens,k}$	characteristic tensile capacity [N]
$F_{ki,Rk}$	characteristic compressive capacity depending on free screw length between counter batten and rafter [N]
γ_{M1}, γ_{M2}	partial safety factor according to EN 1993-1-1 or according to national annex

Free screw length [mm]	KonstruX					Topduo
	Ø6,5	Ø8,0	Ø9,0	Ø10,0	Ø11,3	Ø8,0
	$F_{ki,Rk}$ [kN]	$F_{ki,Rk}$ [kN]	$F_{ki,Rk}$ [kN]	$F_{ki,Rk}$ [kN]	$F_{ki,Rk}$ [kN]	$F_{ki,Rk}$ [kN]
≤ 120	2,32	4,28	8,56	6,76	18,80	5,97
140	1,75	3,27	6,62	5,21	14,90	4,59
160	1,38	2,57	5,25	4,12	12,00	3,62
180	1,10	2,08	4,26	3,33	9,85	2,93
200	0,91	1,71	3,52	2,75	8,20	2,42
220	0,76	1,43	2,97	2,31	6,93	2,03
240	0,64	1,21	2,52	1,96	5,92	1,72
260	0,55	1,04	2,17	1,69	5,12	1,48
280	0,48	0,91	1,89	1,47	4,48	1,29
300	0,42	0,79	1,66	1,29	3,94	1,13
320	0,37	0,70	1,47	1,14	3,49	1,00
340	0,33	0,62	1,31	1,01	3,12	0,89
360	0,29	0,56	1,17	0,91	2,80	0,80
380	0,26	0,50	1,06	0,82	2,52	0,72
400	0,24	0,46	0,96	0,74	2,29	0,65
420	0,22	0,42	0,87	0,68	2,09	0,59

Annex F Definition of angles in LVL



Key:

- 1 wide face
- 2 edge face
- 3 end grain

α : angle between load and grain direction ($0^\circ \leq \alpha \leq 90^\circ$)

ϵ : angle between screw axis and grain direction

β : angle between screw axis and the LVL's wide side ($0^\circ \leq \beta \leq 90^\circ$)

Annex G

Shear reinforcement

Unless specified otherwise in national provisions that apply at the installation site, the shear stress in reinforced areas of timber members with a stress component parallel to the grain shall fulfil the following condition:

$$\tau_d \leq f_{v,d} \cdot \min \left\{ 1, 3, \frac{k_\tau}{\eta_H} \right\}$$

Where: τ_d is the design shear stress disregarding the reinforcement [N/mm²];

$f_{v,d}$ is the design shear strength [N/mm²];

$$k_\tau = 1 - 0,46 \cdot \sigma_{90,d} - 0,052 \cdot \sigma_{90,d}^2$$

$\sigma_{90,d}$ is the design stress perpendicular to the grain (negative value for compression) [N/mm²];

$$\sigma_{90,d} = \frac{n_{90} \cdot F_{ax,d}}{\sqrt{2} \cdot b \cdot a_1}$$

$$F_{ax,d} = \frac{\sqrt{2} \cdot (1 - \eta_H) \cdot V_d \cdot a_1}{n_{90} \cdot H}$$

$$\eta_H = \frac{G \cdot b}{G \cdot b + \frac{1}{\frac{2 \cdot \sqrt{2}}{n_{90}} \left(\frac{6 \cdot a_1}{\pi \cdot d \cdot H^2 \cdot k_{ax}} + \frac{a_1}{EA_S} \right)}}$$

V_d is the design shear force [N];

G is the shear modulus of the timber member, $G = 650 \text{ N/mm}^2$,

b is the width of the timber member in mm,

d is the outer thread diameter in mm,

H is the depth of the timber member in mm,

k_{ax} is the connection stiffness between screw or rod and timber member in N/mm³,

$k_{ax} = 5 \text{ N/mm}^3$ for Rotho Blaas RTR rods $d = 16 \text{ mm}$,

$k_{ax} = 12,5 \text{ N/mm}^3$ for Rotho Blaas VGZ screws $d = 9 \text{ mm}$,

a_1 is the spacing parallel to the grain of the screws or rods ~~arranged in one row~~ in mm,

n_{90} is the number of screws or rod rows within the member width b . Multiple fastener rows should be arranged evenly and symmetrically over the width of the timber.

EA_S is the axial stiffness of one rod or screw [N],

$$EA_S = \frac{E \cdot \pi \cdot d_1^2}{4} = 165.000 d_1^2$$

d_1 is the inner thread diameter of the rod or screw in mm.

The axial capacity of a threaded screw or rod shall fulfil the following condition:

$$\frac{F_{ax,d}}{F_{ax,Rd}} \leq 1$$

Where:

$F_{ax,Rd}$ Minimum of the design values of the withdrawal capacity and the tensile capacity of the reinforcing rods or screws [N]. The effective penetration length is 50 % of the threaded length.

A minimum of four screws or rods in a row are required in each reinforced area. Outside reinforced areas (shaded area in Figure G.1) the shear design shall fulfil the conditions for unreinforced members.

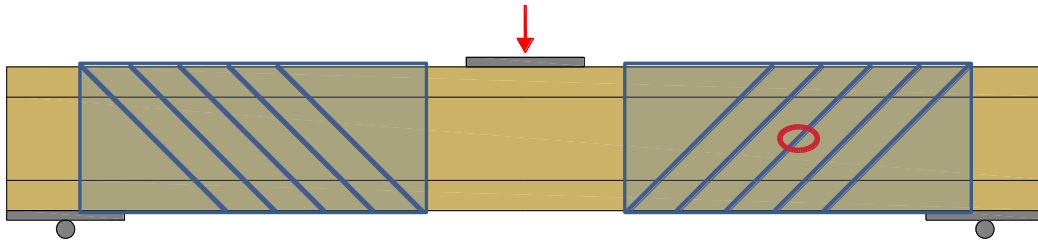


Figure G.1: Timber member with shear reinforcement; shaded areas: reinforced areas with screws arranged under 45°