

# Tek Screw Installation Guide

**Tip:** Set your PDF viewer to "Actual size" before printing to maintain scale.

## Drill Speed & Torque Settings

- **Starting speed:** Medium (1500-2000 RPM) to establish initial hole position
- **Drilling phase:** Full speed once drill point engages and begins cutting
- **Threading phase:** Reduce speed as threads begin to engage in material
- **Too fast:** Overheats drill point, damages threads, burns coating
- **Too slow:** Point won't cut cleanly, causes binding and point breakage
- **Torque setting:** Set clutch to stop when screw is seated (avoid over-tightening)

## Proper Installation Technique

- Hold drill perpendicular (90°) to work surface at all times
- Apply firm, steady pressure throughout entire operation
- Let drill point establish position for 1-2 seconds before full speed
- Maintain constant pressure - don't hesitate or stop mid-drilling
- Watch for metal chips clearing through flutes (confirms drilling is working)
- Listen for sound change when point breaks through (threads will engage next)
- Reduce speed as threads engage and screw begins to seat
- Stop immediately when washer compresses or screw is fully seated

## Troubleshooting Common Problems

- **Point breaks:** Drill point too short for material thickness OR excessive pressure  
→ *Solution: Use longer point type (Tek 4 instead of Tek 3), reduce pressure*
- **Screw spins without gripping:** Point didn't fully penetrate before threads engaged  
→ *Solution: Use longer point type, verify combined thickness measurement*
- **Stripped drive head:** Wrong bit size OR worn/damaged driver bit  
→ *Solution: Use correct bit size, replace bits every 500-1000 screws*
- **Material tears around hole:** Drill speed too slow OR dull/damaged drill point  
→ *Solution: Increase drill speed, replace screws if points are worn*
- **Screws overheat and smoke:** Excessive speed OR inadequate chip clearance  
→ *Solution: Reduce speed slightly, ensure flutes are clearing chips*
- **Won't start drilling:** Smooth surface causes wandering before point bites  
→ *Solution: Use center punch to create starting dimple, or pre-mark location*

## Safety & Quality Checks

- Always wear safety glasses - metal chips fly during drilling operation
- Check screw perpendicularity - angled screws have reduced holding strength
- Verify no gaps between materials after installation
- Test pull strength on sample joints before production work
- Replace driver bits frequently for consistent performance
- Practice technique on scrap material before starting actual project

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