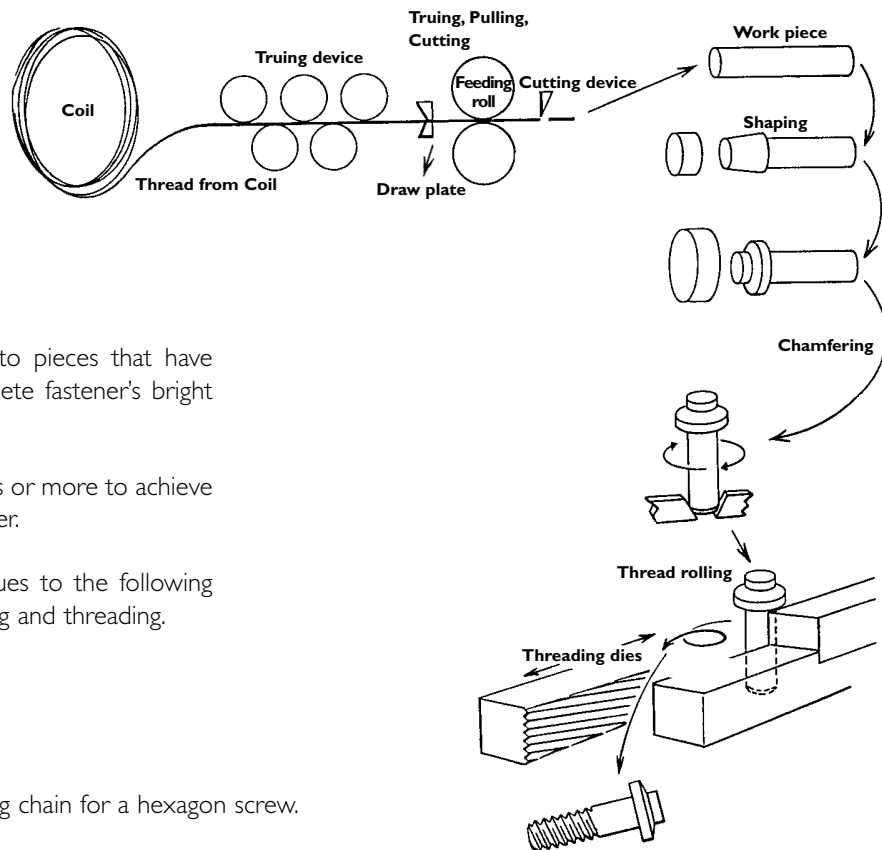


Manufacturing methods



Cold working

The wire is adjusted and cut to pieces that have the same volume as the complete fastener's bright shape.

The piece is shaped in two steps or more to achieve the final geometry of the fastener.

The finished piece then continues to the following operations, which are chamfering and threading.

Table 1. Schematic manufacturing chain for a hexagon screw.

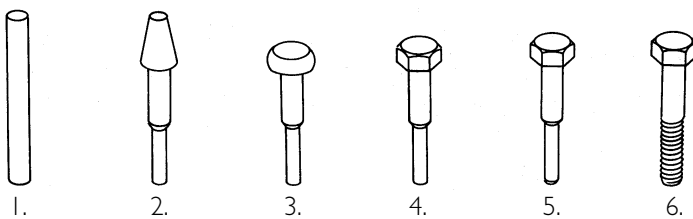


Table 2. Schematic manufacturing chain for a nut.

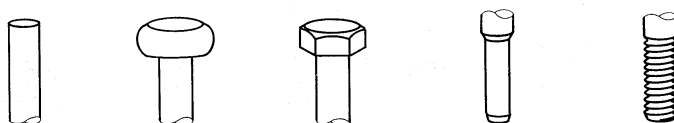


Advantages with cold working

1. Through reshaping the yield and the tensile values are increased.
2. In the reshaped zone a harder surface and an improved material structure are created.
3. A smoother surface that is suitable for surface treatment, for example zincplating.

Hot working

Table 3. Schematic manufacturing chain for a hexagon screw.



Turning

Schematic manufacturing chain for a nut.

