

CLINCHNUT SELF-LOCKING

RECOMMENDED INSTALLATION PROCEDURE:

- 1. DRILL OR PUNCH HOLE IN SHEET (SEE TABLE II FOR SIZES).
- 2. DO NOT CHAMFER OR DEBURR HOLE ON SIDE FROM WHICH NUT IS INSERTED.
- 3. INSERT NUT SHANK SQUARELY IN HOLE WHILE SUPPORTING THE STRUCTURE. PLACE THE PUNCH (SEE FIGURE 3) ON THE NUT CROWN AND USE A LIGHT HAMMER BLOW OR SMALL PRESS TO FORCE THE NUT INTO THE STRUCTURE. THE NUT BASE MUST BE FULLY AND SQUARELY SEATED AGAINST THE STRUCTURE.
- 4. USING THE PUNCH TO SUPPORT THE NUT HEAD, FLARE THE SHANK OUTWARD USING THE CORRECT TOOLS (SEE FIGURE 4 OR FIGURE 5). DO NOT EXCEED THE INSTALLATION FORCES SPECIFIED IN TABLE II.
- 5. INSTALL THE SCREW OR BOLT FROM THE SHANK END OF THE NUT.

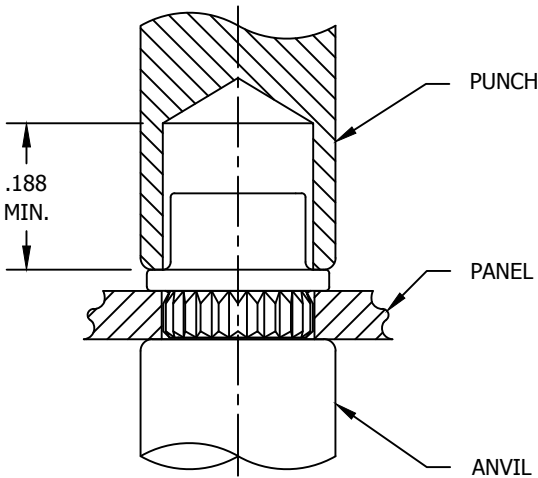


FIGURE 2 - INSTALLATION DIAGRAM

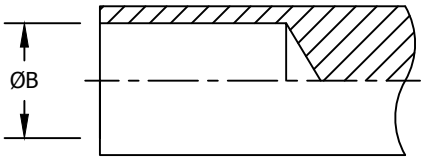


FIGURE 3 - PUNCH (DOLLY, MANDREL)

NUT SIZE	ØB +.003 -.000
.0860	.119
.1120	.155
.1380	.183
.1640	.208
.1900	.232
.2500	.307

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NASM25027
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NAFCO USA, LLC
CARSON CITY, NV 89706

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