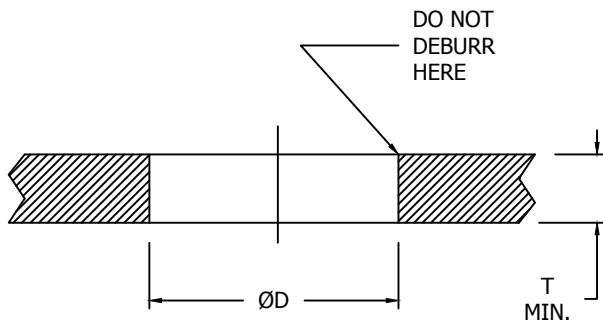




# CLINCHNUT SELF-LOCKING, MINIMAL DISPLACEMENT KNURL FORM

## HOLE PREPARATION



## INSTALLATION

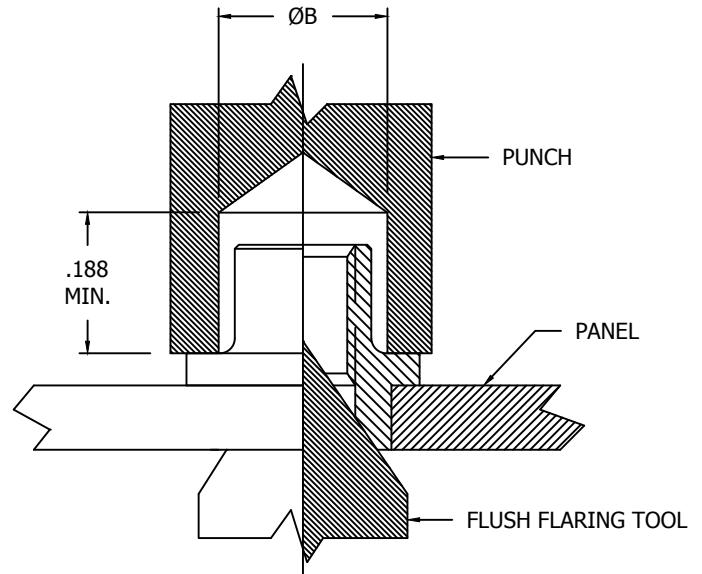


TABLE II - DIMENSIONS AND DASH NUMBERS

NAFCO PART NUMBER	ØB HOLE +.003 -.000	ØD HOLE +.004 -.001	"T" MINIMUM SHEET THICKNESS	APPROX. INSTALL FORCE	PUSH-OUT MIN.	TORQUE-OUT MIN.
NA2336-26-1	.119	.125	.030 - .049	500 LBS.	20 IN-LBS.	5 IN-LBS.
NA2336-26-2			.050 AND UP			
NA2336-40-1	.155	.156	.030 - .049	750 LBS.	40 IN-LBS.	5 IN-LBS.
NA2336-40-2			.050 AND UP			
NA2336-62-1	.183	.188	.030 - .049	1000 LBS.	60 IN-LBS.	10 IN-LBS.
NA2336-62-2			.050 AND UP			
NA2336-82-1	.208	.219	.030 - .049	1500 LBS.	80 IN-LBS.	15 IN-LBS.
NA2336-82-2			.050 AND UP			
NA2336-02-1	.232	.250	.030 - .049	2500 LBS.	100 IN-LBS.	18 IN-LBS.
NA2336-02-2			.050 AND UP			
NA2336-048-1	.307	.312	.030 - .049	3000 LBS.	125 IN-LBS.	30 IN-LBS.
NA2336-048-2			.050 AND UP			

**NOTES:**

- 2.) INSTALLATION PROCEDURE IS AS FOLLOWS:
  - (A) PREPARE HOLE PER TABLE ABOVE.
  - (B) SELECT PROPER LENGTH NUT AS SHOWN IN TABLE (REFER TO "T" DIMENSION).
  - (C) PRESS NUT IN UNTIL IT IS BOTTOMED ON FLANGE.
  - (D) FLARE SKIRT WITH RECOMMENDED PUNCH AND FLUSH FLARING TOOL, APPLYING FORCE SUFFICIENT FOR COMPLETE FLARING.
- 3.) DO NOT CHAMFER OR DEBURR HOLE ON SIDE FROM WHICH NUT IS INSERTED.

CONFORMS TO:  
M45938  
AS8879

**NAFCO USA, LLC**  
CARSON CITY, NV 89706

PART NUMBER  
**NA2336**  
FSC / CAGE CODE: 32387