



JIFFYNUT

NUT, PLAIN, CLINCH AND NUT, SELF-LOCKING, CLINCH
(SELF-CLINCHING, KNURLED COLLAR, MINIATURE,
FLOATING, 450°F AND 600°F)

NOTES:

- 1.) DIMENSIONS ARE IN INCHES AND APPLY AFTER FINISH AND PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- 2.) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- 3.) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- 4.) REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.
- 5.) THREADS SHALL BE IN ACCORDANCE WITH AS8879 AND SHALL APPLY BEFORE APPLICATION OF SOLID FILM LUBRICANT. THE UPPER PORTION OF THE NUT ELEMENT SHALL BE DEFORMED TO PROVIDE SELF-LOCKING FEATURE.
- 6.) PUSH-OUT AND TORQUE-OUT VALUES OF ALLOY STEEL NUTS SHALL BE AS SPECIFIED IN TABLE II WHEN PROPERLY INSTALLED IN 6061-T6 ALUMINUM ALLOY.
- 7.) NOTED VALUES REPRESENT NUT ELEMENT TORQUING-OUT OF RETAINER PORTION OF NUT, RETAINER REMAINS IN PARENT MATERIAL.
- 8.) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

TABLE II- 6061-T6 ALUMINUM ALLOY PARENT MATERIAL

SIZE	APPROX. INSTALL FORCE LB	PUSH-OUT LB MIN	TORQUE-OUT IN-LB MIN /7/
.0860	2500	129	30
.1120	2500	129	30
.1380	2500	129	30
.1640	3800	237	100
.1900	3800	237	100
.2500	4800	544	130

RECOMMENDED INSTALLATION PROCEDURES:

- A.) DRILL OR PUNCH HOLE (CRES SHALL BE DRILLED).
- B.) LOCATE PILOT SQUARELY IN HOLE. USE EXIT SIDE OF PUNCHED HOLE.
- C.) USING A DRIVE TOOL AND ANVIL AS SHOWN IN FIGURE 2, APPLY SUFFICIENT FORCE TO CAUSE A .015 INCH MINIMUM PENETRATION INTO THE STRUCTURE FOR A FULL 360°. TOOL SHOWN IS A DEPTH-STOP TYPE TOOL WHICH INSTALLS NUT TO PROPER DEPTH WHEN TOOL BOTTOMS AGAINST SHEET SURFACE. USE OF NUT MANUFACTURER'S DRIVE TOOL AND ANVIL IS MANDATORY.

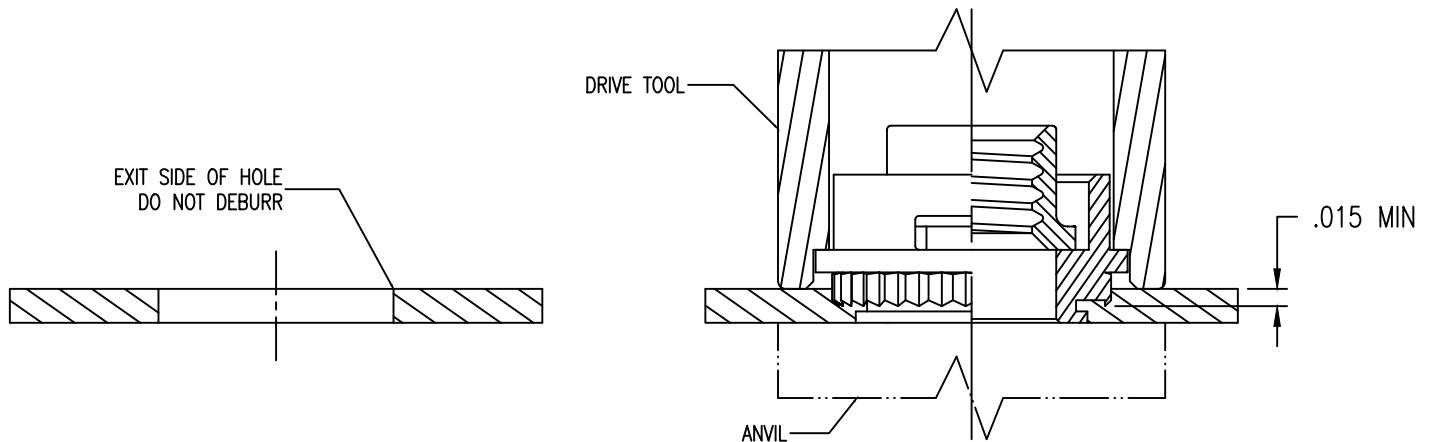


FIGURE 2 - HOLE PREPARATION AND INSTALLATION

SHEET 2 OF 2

CONFORMS TO:
NASM45938
AS8879

NAFCO USA, LLC

CARSON CITY, NV 89706

PART NUMBER

NA1210

FSC / CAGE CODE: 32387