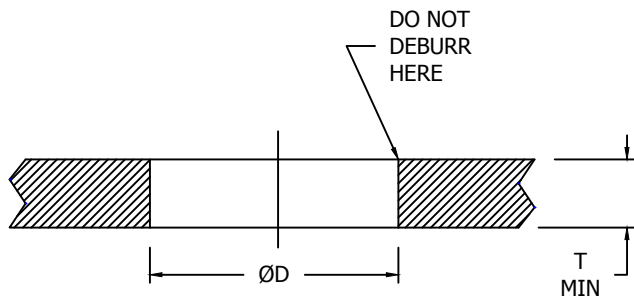




CLINCHNUT, FLUSH MOUNTED, SELF-LOCKING

HOLE PREPARATION



INSTALLATION

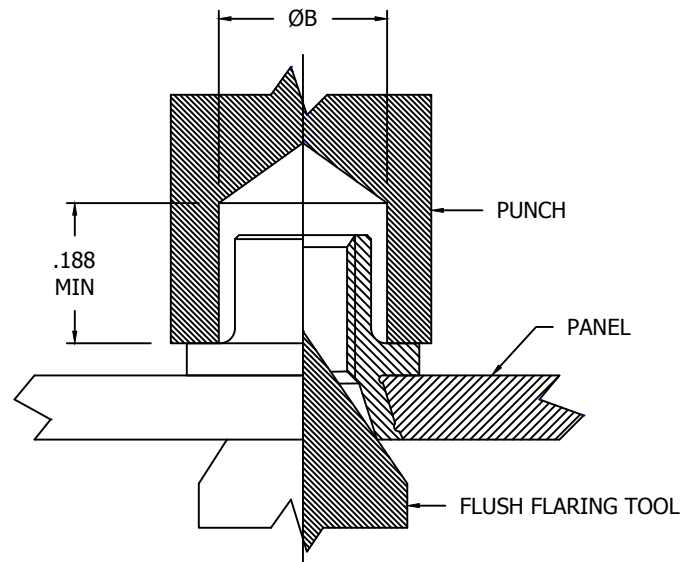


TABLE II - DIMENSIONS AND DASH NUMBERS

NAFCO DASH NUMBER	B +.003 -.000	D +.004 -.001	T MIN. SHEET THICKNESS	APPROX. INSTALL FORCE	PUSH-OUT MIN.	TORQUE-OUT MIN.	PUNCH PART NUMBERS	
							PUNCH TOOL	FLUSH FLARING TOOL
NA2097-26-4	.119	.128	.030 TO .059	500 LBS.	20 IN-LBS.	5 IN-LBS.	CE1003-26	CE1002-26
NA2097-26-6			.060 TO .089					
NA2097-40-4			.030 TO .059					
NA2097-40-6	.155	.159	.060 TO .089	750 LBS.	40 IN-LBS.	5 IN-LBS.	CE1003-40	CE1002-40
NA2097-40-9			.090 AND UP					
NA2097-62-4	.183	.191	.030 TO .059	1000 LBS.	60 IN-LBS.	10 IN-LBS.	CE1003-62	CE1002-62
NA2097-62-6			.060 TO .089					
NA2097-62-9			.090 AND UP					
NA2097-82-4	.208	.226	.030 TO .059	1500 LBS.	80 IN-LBS.	15 IN-LBS.	CE1003-82	CE1002-82
NA2097-82-6			.060 TO .089					
NA2097-82-9			.090 AND UP					
NA2097-02-4	.232	.253	.030 TO .059	2500 LBS.	100 IN-LBS.	18 IN-LBS.	CE1003-02	CE1002-02
NA2097-02-6			.060 TO .089					
NA2097-02-9			.090 AND UP					

NOTES:

- (1) 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.
- (2) DO NOT CHAMFER HOLE ON SIDE FROM WHICH NUT IS INSERTED.

CONFORMS TO:

NASM25027
AS8879
K7000/K7001

NAFCO USA, LLC
CARSON CITY, NV 89706

PART NUMBER

NA2097, NA2097C

FEDERAL SUPPLY CODE: 32387