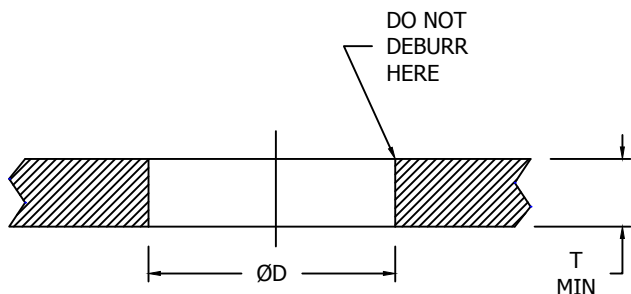


# CLINCHNUT, FLUSH MOUNTED, SELF-LOCKING

## HOLE PREPARATION



## INSTALLATION

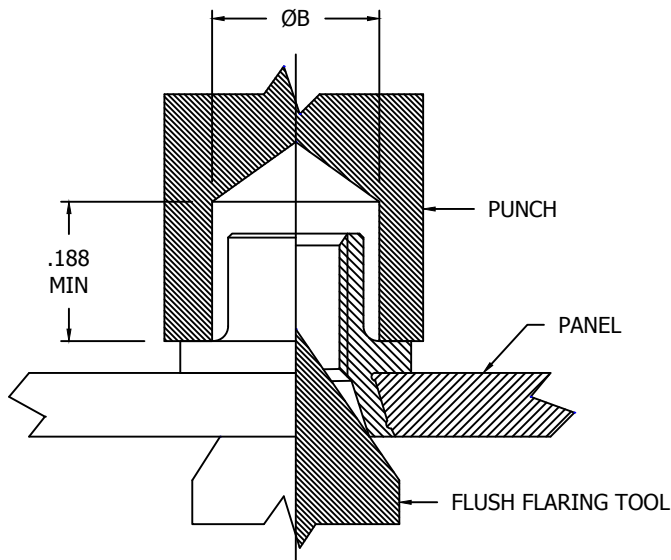


TABLE II - DIMENSIONS AND DASH NUMBERS

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	.155	.159	.030 TO .059	750 LBS.	40 IN-LBS.	5 IN-LBS.	CE1003-40	CE1002-40
NA2097-40-6			.060 TO .089					
NA2097-40-9	.183	.191	.090 AND UP	1000 LBS.	60 IN-LBS.	10 IN-LBS.	CE1003-62	CE1002-62
NA2097-62-4			.030 TO .059					
NA2097-62-6			.060 TO .089					
NA2097-62-9	.208	.226	.090 AND UP	1500 LBS.	80 IN-LBS.	15 IN-LBS.	CE1003-82	CE1002-82
NA2097-82-4			.030 TO .059					
NA2097-82-6			.060 TO .089					
NA2097-82-9	.232	.253	.090 AND UP	2500 LBS.	100 IN-LBS.	18 IN-LBS.	CE1003-02	CE1002-02
NA2097-02-4			.030 TO .059					
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**  
 FSC / CAGE CODE: 32387