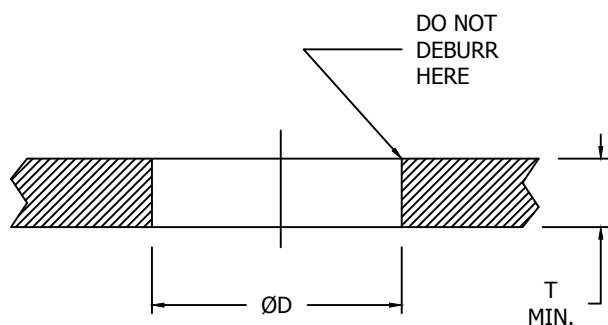




CLINCHNUT SELF-LOCKING

HOLE PREPARATION



INSTALLATION

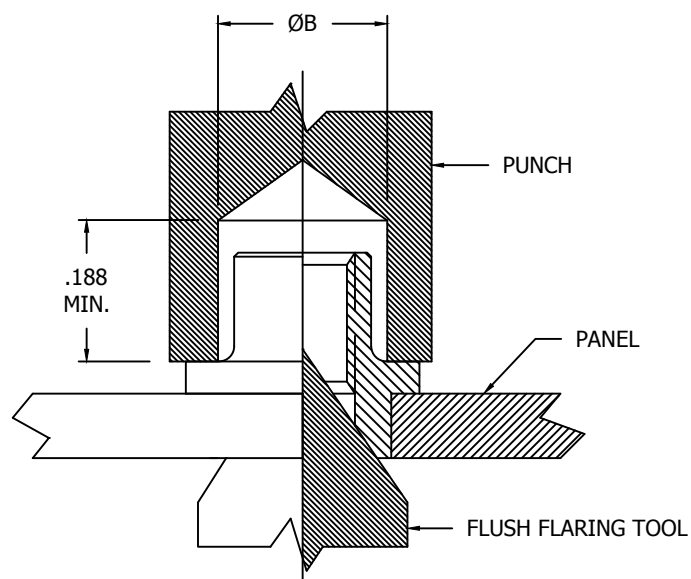


TABLE II - INSTALLATION PROCEDURE VALUES

NAFCO PART NUMBER	ØB HOLE +.003 -.000	ØD HOLE +.004 -.001	"T" MINIMUM SHEET THICKNESS	APPROX. INSTALL FORCE	PUSH-OUT MIN.	TORQUE-OUT MIN.	PUNCH PART NUMBERS	
							PUNCH TOOL	FLUSH FLARING TOOL
NA2168-26-1	.119	.125	.030 - .049	500 LBS.	20 IN-LBS.	5 IN-LBS.	CE1003-26	CE1002-26
NA2168-26-2			.050 AND UP					
NA2168-40-1	.155	.156	.030 - .049	750 LBS.	40 IN-LBS.	5 IN-LBS.	CE1003-40	CE1002-40
NA2168-40-2			.050 AND UP					
NA2168-62-1	.183	.188	.030 - .049	1000 LBS.	60 IN-LBS.	10 IN-LBS.	CE1003-62	CE1002-62
NA2168-62-2			.050 AND UP					
NA2168-82-1	.208	.219	.030 - .049	1500 LBS.	80 IN-LBS.	15 IN-LBS.	CE1003-82	CE1002-82
NA2168-82-2			.050 AND UP					
NA2168-02-1	.232	.250	.030 - .049	2500 LBS.	100 IN-LBS.	18 IN-LBS.	CE1003-02	CE1002-02
NA2168-02-2			.050 AND UP					
NA2168-048-1	.307	.312	.030 - .049	3000 LBS.	125 IN-LBS.	30 IN-LBS.	CE1003-048	CE1002-048
NA2168-048-2			.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:
NASM25027
AS8879

NAFCO USA, LLC
CARSON CITY, NV 89706

PART NUMBER
NA2168
FEDERAL SUPPLY CODE: 32387