



CLINCHNUT SELF-LOCKING

RECOMMENDED INSTALLATION PROCEDURE:

1. DRILL OR PUNCH HOLE IN SHEET (SEE TABLE II FOR SIZES).
2. DO NOT CHAMFER OR DEBURR HOLE ON SIDE FROM WHICH NUT IS INSERTED.
3. INSERT NUT SHANK SQUARELY IN HOLE WHILE SUPPORTING THE STRUCTURE. PLACE THE PUNCH (SEE FIGURE 3) ON THE NUT CROWN AND USE A LIGHT HAMMER BLOW OR SMALL PRESS TO FORCE THE NUT INTO THE STRUCTURE. THE NUT BASE MUST BE FULLY AND SQUARELY SEATED AGAINST THE STRUCTURE.
4. USING THE PUNCH TO SUPPORT THE NUT HEAD, FLARE THE SHANK OUTWARD USING THE CORRECT TOOLS (SEE FIGURE 4 OR FIGURE 5). DO NOT EXCEED THE INSTALLATION FORCES SPECIFIED IN TABLE II.
5. INSTALL THE SCREW OR BOLT FROM THE SHANK END OF THE NUT.

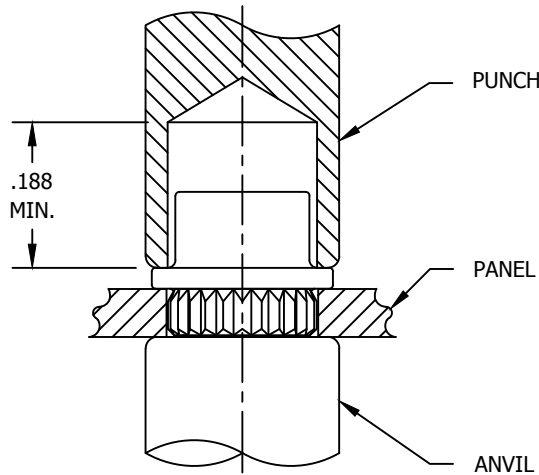


FIGURE 2 - INSTALLATION DIAGRAM

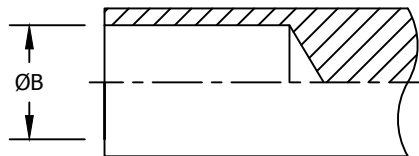


FIGURE 3 - PUNCH (DOLLY, MANDREL)

NUT SIZE	ØB +.003 -.000
.0860	.119
.1120	.155
.1380	.183
.1640	.208
.1900	.232
.2500	.307

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