

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. PRESS KNURLED SHANK OF NUT INTO HOLE USING A DOLLY AND ANVIL AS SHOWN IN FIGURES 2 AND 3 UNTIL THE SHOULDER OF THE NUT CONTACTS THE STRUCTURE FOR A FULL 360°.
4. USING THE DOLLY 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.

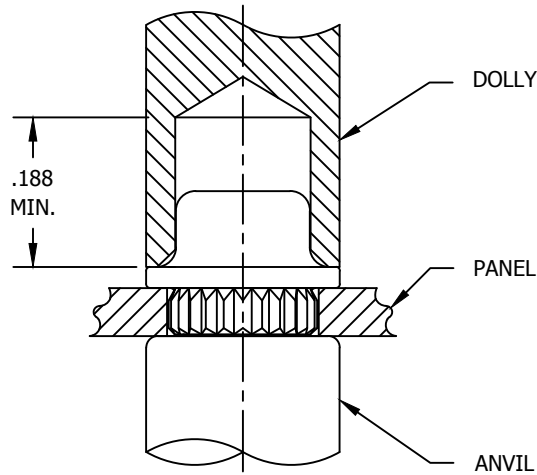


FIGURE 2 - INSTALLATION DIAGRAM

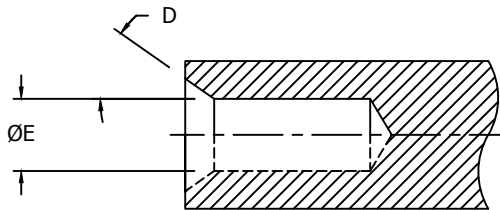


FIGURE 3 - DOLLY

NUT SIZE	ØE +.003 -.000	D ±1°
.0860	.151	35°
.1120	.183	
.1380	.243	21°
.1640	.269	
.1900	.288	

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