



JIFFYNUT

NUT, PLAIN, CLINCH AND NUT, SELF-LOCKING, CLINCH
(SELF-CLINCHING, KNURLED COLLAR,
FLOATING, 450°F AND 600°F)

NOTES:

- 1.) DIMENSIONS ARE IN INCHES AND APPLY AFTER FINISH AND PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
- 2.) THREADS SHALL BE IN ACCORDANCE WITH AS8879 AND DIMENSIONS SHALL APPLY BEFORE APPLICATION OF SOLID FILM LUBRICANT. THE UPPER PORTION OF THE NUT ELEMENT SHALL BE DEFORMED TO PROVIDE SELF-LOCKING FEATURE.
- 3.) PUSH-OUT AND TORQUE-OUT VALUES OF ALLOY STEEL NUTS SHALL BE AS SPECIFIED IN TABLE II OR TABLE III WHEN PROPERLY INSTALLED IN COLD ROLLED STEEL OR IN 5052-0 ALUMINUM ALLOY.
- 4.) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- 5.) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- 6.) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.
- 7.) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

TABLE II- COLD ROLLED STEEL PARENT MATERIAL

SIZE	APPROX. INSTALL FORCE LBF	PUSH-OUT LBF MIN	TORQUE-OUT IN-LBF MIN /a/
.1120	4,500	630	22
.1380	4,500	630	31
.1640	5,500	900	54
.1900	5,500	900	67
.2500	8,400	1,620	112

TABLE III- 5052-0 ALUMINUM ALLOY PARENT MATERIAL

SIZE	APPROX. INSTALL FORCE LBF	PUSH-OUT LBF MIN	TORQUE-OUT IN-LBF MIN /a/
.1120	2,600	360	22
.1380	2,600	360	31
.1640	3,000	450	54
.1900	3,000	450	67
.2500	4,500	1,080	112

RECOMMENDED INSTALLATION PROCEDURES:

- A.) DRILL OR PUNCH HOLE (CRES SHALL BE DRILLED).
- B.) LOCATE PILOT SQUARELY IN HOLE. USE EXIT SIDE OF PUNCHED HOLE.
- C.) USING A DRIVE TOOL AND ANVIL AS SHOWN IN FIGURE 2, APPLY SUFFICIENT FORCE TO CAUSE A .015 INCH MINIMUM PENETRATION INTO THE STRUCTURE FOR A FULL 360°. TOOL SHOWN IS A DEPTH-STOP TYPE TOOL WHICH INSTALLS NUT TO PROPER DEPTH WHEN NYLON STOP BOTTOMS AGAINST SHEET SURFACE.

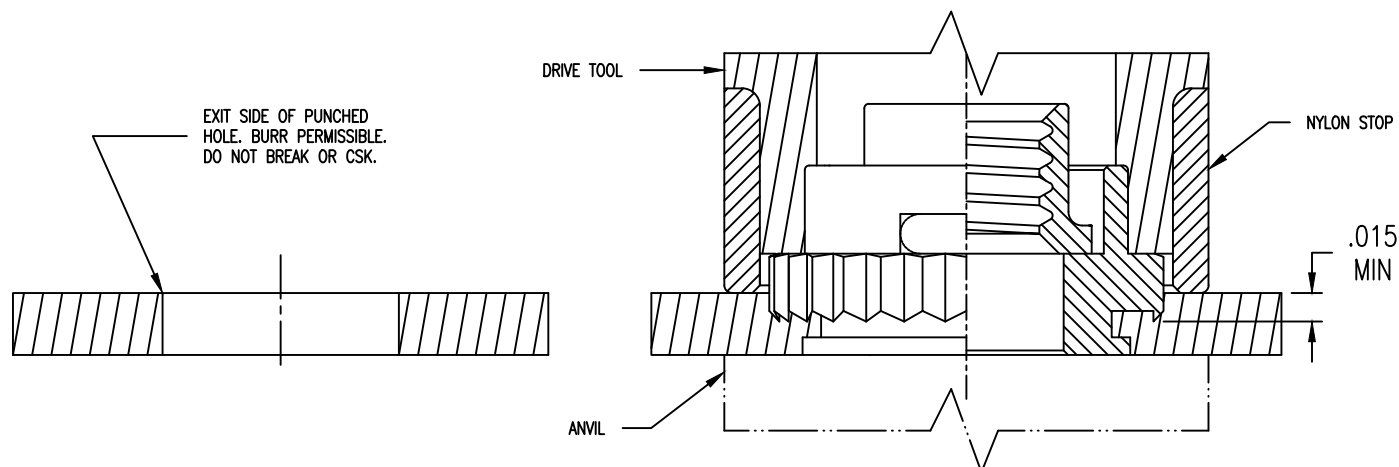


FIGURE 2 - HOLE PREPARATION AND INSTALLATION

SHEET 2 OF 2

CONFORMS TO:
NASM45938
AS8879

NAFCO USA, LLC
CARSON CITY, NV 89706

PART NUMBER
NA2364
FSC / CAGE CODE: 32387