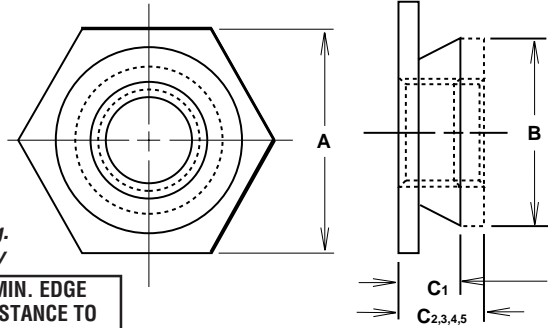


STAINLESS STEEL

Inch Sizes

Self-Clinching FLUSHNUTS add strong load-bearing threads in panels too thin or too ductile to tap — also they provide a flush-with-the-panel fastening. Installation requires only squeezing pressure with any pneumatic or hydraulic parallel-acting press.



DIMENSIONS & SPECIFICATIONS:

Unit Pkg.
100 only

SPAENAUR No.	THREAD SIZE	SHANK C MAX.	SHEET THICKNESS	* HOLE SIZE	A	B MAX.	MIN. EDGE DISTANCE TO CENTER OF HOLE
200-828	2-56	-1 .060"	.060-.090"	.172"	3/16"	.171"	.23"
200-829		-2 .090"	.091"-up				
200-830	4-40	-1 .060"	.060-.090"	.172"	3/16"	.171"	.23"
200-831		-2 .090"	.091"-up				
200-832	6-32	-1 .060"	.060-.090"	.213"	1/4"	.212"	.27"
200-833		-2 .090"	.091"-up				
200-834	8-32	-1 .060"	.060-.090"	.290"	5/16"	.289"	.28"
200-835		-2 .090"	.091"-up				
200-836	10-32	-1 .060"	.060-.090"	.312"	11/32"	.311"	.32"
200-837		-2 .090"	.091"-up				
200-838	1/4"-20	-3 .120"	.125-.155"	.344"	3/8"	.343"	.34"
200-839		-4 .151"	.156-.186"				
200-840		-5 .182"	.187"-up				

Note: Clinching profile may vary.

MATERIAL:

300 Series Stainless Steel (Passivated per QQ-P-35)

USE IN :

Materials with Rockwell Hardness of B-70 or less

Don't over-squeeze or hammer Flushnuts. Aluminum panels should be preanodized before fastener insertion.

*tol. +.003 to -.000

PERFORMANCE DATA

INSTALLATION

Drill or punch the correct diameter hole in sheet, referring to table at top. Place shank of fastener in hole and apply a squeezing force between two parallel surfaces sufficient only to embed hexagonal head flush in sheet. The metal displaced by the head flows evenly and smoothly around the back-tapered shank of the fastener, securely locking it into place with high pull-out resistance while at the same time, the embedded hexagonal head provides high torque resistance.

THREAD SIZE	PULL-THRU LB.	*TORQUE (INCH-LBS.)	5052-H34 ALUMINUM		COLD ROLLED STEEL	
			INSTALLATION FORCE (LB.)	PUSH-OUT LB.	INSTALLATION FORCE (LB.)	PUSH-OUT (LB.)
2-56	600	2-1/4	2000	200	3000	200
4-40	650	4-3/4	2000	200	3000	200
6-32	800	8-3/4	2000	200	3000	200
8-32	1050	18	2000	240	4000	240
10-32	1050	32	2500	240	4000	240
1/4"-20	2750	80	3500	640	4500	840

Note: These values are for general reference only. Variations in mounting hole size, panel material, panel thickness and installation procedures will affect these data.

INSTALLATION & PERFORMANCE DATA

For
SELF-CLINCHING NUTS
Per Page C163.

STEEL:

Carbon Steel, Heat Treated,
Zinc per **ASTM B 633-85 SC1** (5µm),
Type III, Colourless

STAINLESS STEEL (S.S)

300 Series Stainless Steel
(Passivated, QQ-P-35, Type 1)

ALUMINUM (ALUM.)

2024-T4 Aluminum

THREAD:

Class 2B (MIL-S-7742)

THREAD SIZE	SHANK	5052-H34 ALUMINUM			R/B 75 COLD ROLLED STEEL				
		INSTALLATION (LBS.)	PUSH-OUT (LBS.)	*TORQUE (INCH-LBS.)	INSTALLATION (LBS.)	PUSH-OUT (LBS.)	*TORQUE (INCH-LBS.)		
2-56	-0 (.030)	2000	80	10	3000	90	12		
	-1 (.038)							125	12
	-2 (.054)							200	12
	-3 (.087)							200	10
3-48	-0 (.030)	2000	80	10	3000	90	12		
	-1 (.038)							125	12
	-2 (.054)							200	12
	-3 (.087)							200	10
4-40	-0 (.030)	2000	80	10	3000	90	16		
	-1 (.038)							125	18
	-2 (.054)							200	18
	-3 (.087)							200	10
6-32	-0 (.030)	2800	80	18	3500	100	25		
	-1 (.038)							120	25
	-2 (.054)							250	35
	-3 (.087)							200	30
8-32	-0 (.030)	3500	80	25	4500	100	30		
	-1 (.038)							140	30
	-2 (.054)							260	50
	-3 (.087)							240	40
10-24 and 10-32	-0 (.030)	4300	80	25	5000	100	40		
	-1 (.038)							125	40
	-2 (.054)							200	75
	-3 (.087)							260	50
1/4"-20 and 1/4"-28	-1 (.054)	5000	350	110	6500	600	160		
	-2 (.087)								
	-3 (.120)								
5/16"	-1 (.054)	5500	400	200	7500	650	300		
	-2 (.087)								
	-3 (.120)								

*Maximum screw tightening values.

CATALOG 13