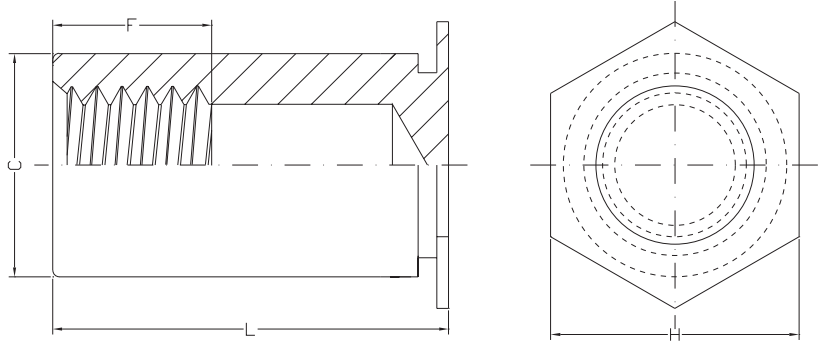
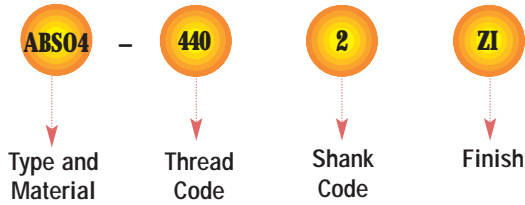


SELF-CLINCHING STANDOFFS



TYPE ABSO4 BLIND THREADED STANDOFFS FOR INSTALLATION INTO STAINLESS STEEL

Part Number Designation



GENERAL DIMENSIONAL DATA

UNIFIED (inch)	Thread Code	Min. Sheet Thickness	Hole Size In Sheet + .003 - .000	C + .000 - .005	H Nom.	Min. Dist. Hole C/L To Edge
	440	.040	.166	.165	.187	.23
	6440	.040	.213	.212	.250	.28
	632	.040	.213	.212	.250	.28
	8632	.050	.281	.280	.312	.33
	832	.050	.281	.280	.312	.33
	032	.050	.281	.280	.312	.33

METRIC (mm)	Thread Code	Min. Sheet Thickness	Hole Size In Sheet +0.08	C -0.13	H Nom.	Min. Dist. Hole C/L To Edge
	M3	1.02	4.22	4.2	4.8	6
	3.5M3	1.02	5.41	5.39	6.4	7.1
	M3.5	1.02	5.41	5.39	6.4	7.1
	M4	1.27	7.14	7.12	7.9	8.4
	M5	1.27	7.14	7.12	7.9	8.4

THREAD SIZE AND LENGTH SELECTION DATA

UNIFIED (inch)	Thread Size	Type	Thread Code	Length "L" + .002 - .005 (Length Code in 32nds of an inch)													
				.312	.375	.437	.500	.562	.625	.687	.750	.812	.875	.937	1.00	1.062	
.112-40 (#4-40)	ABSO4	440 6440 ⁽¹⁾	10	12	14	16	18	20	22	24	26	28	30	32	34		
				10	12	14	16	18	20	22	24	26	28	30	32	34	
.138-32 (#6-32)	ABSO4	632 8632 ⁽¹⁾	10	12	14	16	18	20	22	24	26	28	30	32	34		
				10	12	14	16	18	20	22	24	26	28	30	32	34	
.164-32 (#8-32)	ABSO4	832	10	12	14	16	18	20	22	24	26	28	30	32	34		
				10	12	14	16	18	20	22	24	26	28	30	32	34	
.190-32 (#10-32)	ABSO4	032	10	12	14	16	18	20	22	24	26	28	30	32	34		
				10	12	14	16	18	20	22	24	26	28	30	32	34	
F Dimension Min.				.156	.187	.250										.375	

METRIC (mm)	Thread Size x Pitch	Type	Thread Code	Length "L" + 0.05 - 0.13 (Length Code in millimeters)											
				6	8	10	12	14	16	18	20	22	25		
M3 X 0.5	ABSO4	M3 3.5M3 ⁽¹⁾	6	8	10	12	14	16	18	20	22	25			
				6	8	10	12	14	16	18	20	22	25		
M3.5 X 0.6	ABSO4	M3.5	6	8	10	12	14	16	18	20	22	25			
				6	8	10	12	14	16	18	20	22	25		
M4 X 0.7	ABSO4	M4	6	8	10	12	14	16	18	20	22	25			
				6	8	10	12	14	16	18	20	22	25		
M5 X 0.8	ABSO4	M5	6	8	10	12	14	16	18	20	22	25			
				6	8	10	12	14	16	18	20	22	25		
F Dimension Min.				3.2	4	5	6.5			9.5					

(1) Standoffs with thread codes 6440, 8632, and 3.5M3 offer greater wall thickness for thread sizes 440, 632, and M3 respectively.

SELF-CLINCHING STANDOFFS



TYPE ABSO4 BLIND THREADED STANDOFFS FOR INSTALLATION INTO STAINLESS STEEL

MATERIAL & FINISH SPECIFICATIONS

Type	Threads ⁽¹⁾	Fastener Materials					Standard Finishes			For Use In Sheet Hardness:				
	Internal, ANSI B1.1 2B ANSI/ASME B1.13M, 6H	Heat-treated Carbon Steel	Non-heat Treated Carbon Steel	7075-T6 Aluminum	303 Stainless Steel	400 Series Stainless Steel	Zinc Per ASTM B 633 SC1 (5µm) Type III, Colorless	Passivated and/or Tested Per ASTM A380	None	88 or less on the Rockwell "B" Scale	80 or less on the Rockwell "B" Scale	70 or less on the Rockwell "B" Scale	60 or less on the Rockwell "B" Scale	50 or less on the Rockwell "B" Scale
ABSO4	•					•		•		•				
Part Number Codes For Finishes							ZI	None	None					

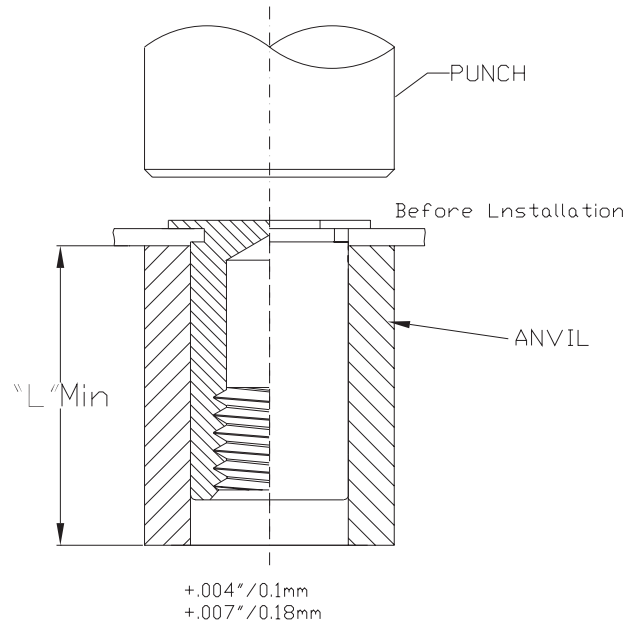
(1) Where applicable.

*Available on special order only.

INSTALLATION

Types ABSO4

1. Punch or drill properly sized mounting hole in sheet. Do not perform any secondary operation such as deburring.
2. Insert standoff through mounting hole of sheet and into anvil as shown in drawing.
3. With punch and anvil surfaces parallel, apply only enough squeezing force to embed the standoff's head flush in the sheet. Drawing at right shows suggested tooling for applying these forces.



PERFORMANCE DATA⁽¹⁾

Types ASO4 and ABSO4

UNIFIED (inch)	Thread Code	Max. Rec. Tightening Torque For Mating Screw (in. lbs.)	Test Sheet Material			
			.050" 300 Series Stainless Steel			
			Installation (lbs.)	Pushout (lbs.)	Torque-out (in. lbs.)	Pull-thru (lbs.)
440	4.75	5500	336	17	600	
6440	4.75	9500	647	17	680	
632	8.75	9500	647	30	680	
8632	8.75	10500	900	30	1392	
832	18	10500	900	53	1517	
032	32	10500	900	71	1368	

METRIC (mm)	Thread Code	Max. Rec. Tightening Torque For Mating Screw (N • m)	Test Sheet Material			
			1.3 mm 300 Series Stainless Steel			
			Installation (kN)	Pushout (N)	Torque-out (N • m)	Pull-thru (N)
M3	0.55	24.5	1493	2.36	2650	
3.5M3	0.55	42.3	2877	2.36	3025	
M3.5	0.91	42.3	2877	3.06	3025	
M4	2	46.7	4003	6.34	6458	
M5	3.6	46.7	4003	8.89	6226	

- (1) The installation, pushout, torque-out and pull-thru values reported are averages when all installation specifications and procedures are followed. Variations in mounting hole size, sheet material and installation procedure will affect this data. Performance testing of this product in your application is recommended. We will be happy to provide samples for this purpose.
- (2) Standoffs installed in sheets thinner than .060" / 1.5 mm will have pull-thru, pushout, and torque-out values at 80% of tabulated values.
- (3) Not recommended.