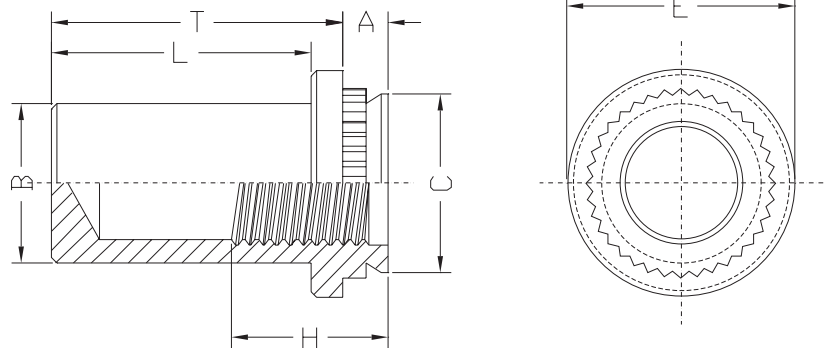
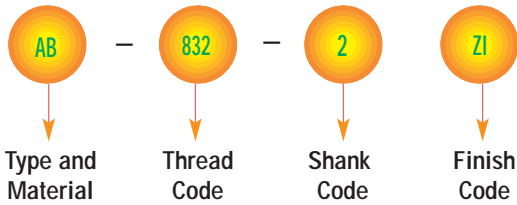


SELF-CLINCHING BLIND FASTENER



Part Number Designation



TYPES AB, ABS
FOR SHEETS AS THIN AS .040" / 1MM

UNIFIED (inch)	Thread Size	Type		Thread Code	Shank Code	A Max.	Min. Sheet Thickness	Hole Size in Sheet + .003 - .000	Barrel Diameter B Max.	Shank Diameter C Max.	E ± .010	Min. Depth Full Threads H	L Max.	T ± .010	Min. Dist. Hole C/L to Edge
		Steel	Stainless Steel												
.112-40 (#4-40)	AB	ABS	440	1	.038	.040	.166	.150	.165	.25	.21	.335	.38	.19	
				2	.054	.056									
.138-32 (#6-32)	AB	ABS	632	1	.038	.040	.1875	.169	.187	.28	.23	.335	.38	.22	
				2	.054	.056									
.164-32 (#8-32)	AB	ABS	832	1	.038	.040	.213	.204	.212	.31	.28	.385	.44	.27	
				2	.054	.056									
.190-32 (#10-32)	AB	ABS	032	1	.038	.040	.250	.235	.249	.34	.28	.385	.44	.28	
				2	.054	.056									
.250-20 (1/4-20)	AB	ABS	0420	1	.054	.056	.344	.305	.343	.43	.31	.500	.56	.34	
				2	.087	.090									

METRIC (mm)	Thread Size x Pitch	Type		Thread Code	Shank Code	A Max.	Min. Sheet Thickness	Hole Size in Sheet + 0.08	Barrel Diameter B Max.	Shank Diameter C Max.	E ± 0.25	Min. Depth Full Threads H	L Max.	T ± 0.25	Min. Dist. Hole C/L to Edge
		Steel	Stainless Steel												
M3 x 0.5	AB	ABS	M3	1	0.97	1	4.25	3.84	4.22	6.35	5.3	8.5	9.6	4.8	
				2	1.38	1.4									
M4 x 0.7	AB	ABS	M4	1	0.97	1	5.4	5.2	5.38	7.95	7.1	9.8	11.2	6.9	
				2	1.38	1.4									
M5 x 0.8	AB	ABS	M5	1	0.97	1	6.4	6.02	6.38	8.75	7.1	9.8	11.2	7.1	
				2	1.38	1.4									
M6 x 1	AB	ABS	M6	1	1.38	1.4	8.75	7.8	8.72	11.1	7.8	12.7	14.3	8.6	
				2	2.21	2.3									

MATERIAL & FINISH SPECIFICATIONS

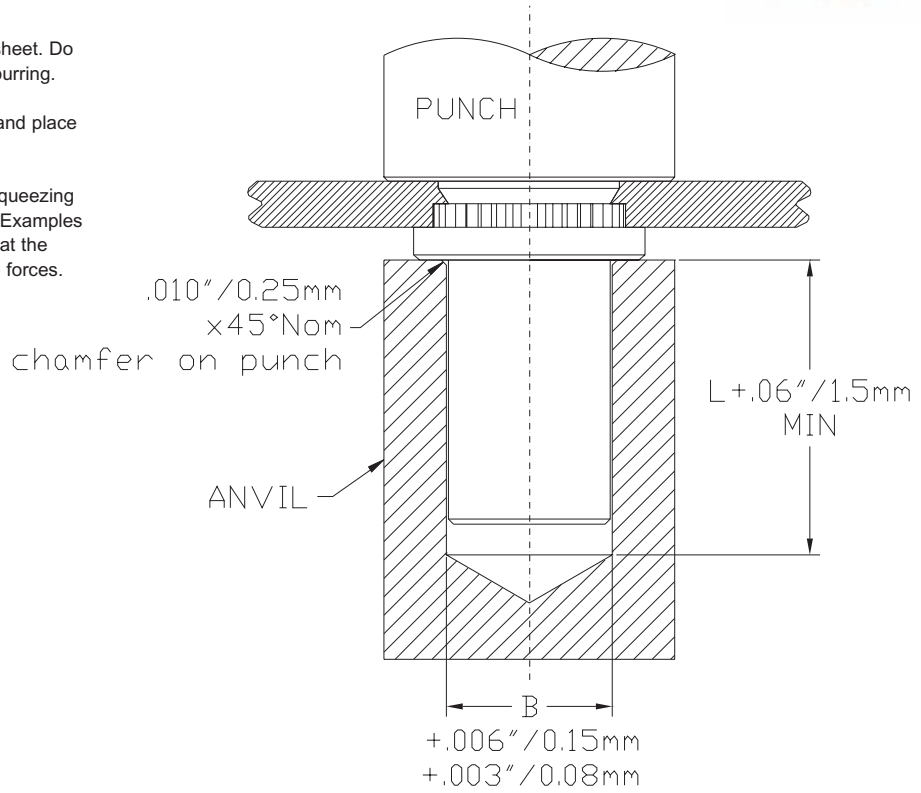
Type	Threads	Fastener Materials		Standard Finishes		For Use in Sheet Hardness:	
	Internal, ANSI B1.1, 2B / ANSI / ASME B1.13M, 6H	Heat-Treated Carbon Steel	300 Series Stainless Steel	Passivated and/or Tested Per ASTM A380	Zinc Per ASTM B 633 SC1 (5µm), Type III, Colorless	80 or Less on the Rockwell "B" Scale	70 or Less on the Rockwell "B" Scale
AB		•			•	•	
ABS	•		•	•			•
Part Number Code For Finishes				None	ZI		

SELF-CLINCHING BLIND FASTENER



INSTALLTION

1. Punch or drill properly sized mounting hole in the sheet. Do not perform any secondary operations such as deburring.
2. Place the barrel of the fastener into the anvil hole and place the mounting hole over the shank of the fastener
3. With the punch and anvil surfaces parallel, apply squeezing force until the flange contacts the mounting sheet. Examples of installation forces are shown below. The sketch at the right indicates suggested tooling for applying these forces.



PERFORMANCE DATA⁽¹⁾

UNIFIED (in ch)	Thread Code	Shank Code	Sheet Thickness (in.)	Test Sheet Material					
				5052-H34 Aluminum			Cold-Rolled Steel		
				Installation (lbs.) Approx.	Pushout (lbs.) Min.	Torque-out (in. lbs.) Min.	Installation (lbs.) Approx.	Pushout (lbs.) Min.	Torque-out (in. lbs.) Min.
440	1	2	.040	1600	100	12	2500	125	13
			.056	2000	170	13	3500	230	18
632	1	2	.040	1800	105	17	3000	130	18
			.056	2800	190	22	4000	260	28
832	1	2	.040	2000	110	25	3500	135	30
			.056	3000	220	35	5000	285	45
032	1	2	.040	2100	110	34	4000	140	35
			.056	3500	270	50	5000	320	60
0420	1	2	.056	4000	315	100	6000	400	105
			.090						

METRIC (mm)	Thread Code	Shank Code	Sheet Thickness (mm)	Test Sheet Material					
				5052-H34 Aluminum			Cold-Rolled Steel		
				Installation (kN) Approx.	Pushout (N) Min.	Torque-out (N·m) Min.	Installation (kN) Approx.	Pushout (N) Min.	Torque-out (N·m) Min.
M3	1	2	1	7.1	440	1.4	11.1	560	1.5
			1.4	9	750	1.47	14	1010	2.13
M4	1	2	1	8.9	490	2.8	15.6	600	3.4
			1.4	12.5	970	4	20	1250	5.1
M5	1	2	1	9.3	490	3.8	17.8	620	4
			1.4	14	1190	5.7	25	1410	6.8
M6	1	2	1.4	17.8	1400	11.3	25.7	1780	11.9
			2.3						

⁽¹⁾ The installation, pushout and torque-out 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.