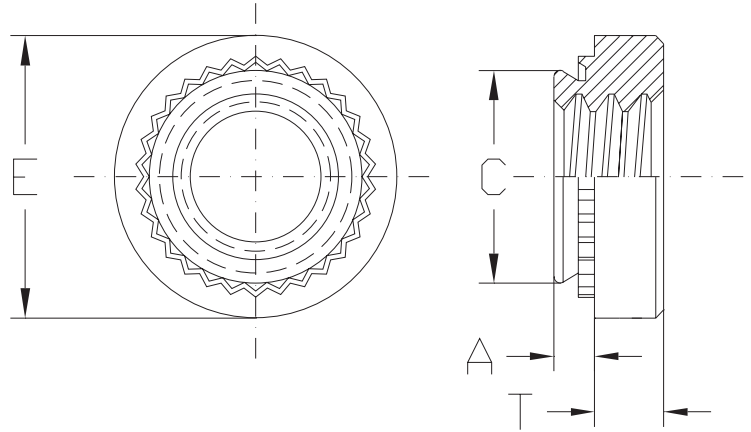
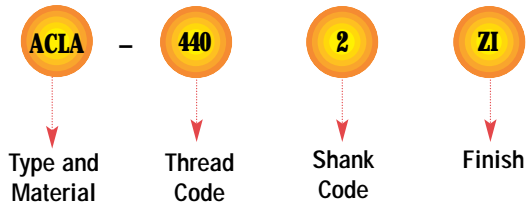


# SELF-CLINCHING NUTS

## ALUMINUM SELF-CLINCHING NUTS (Unified) - TYPE ACLA



### Part Number Designation



UNIFIED (Inch)	Thread Size	Type	Thread Code	Shank Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet +.003 -.000	C Max.	E ±.010	T ±.010	Min. Dist. Hole C/L To Edge(1)
		Aluminum									
	.086-56 (#2-56)	ACLA	256	1	.038	.040	.166	.165	.25	.07	.19
				2	.054	.056					
	.112-40 (#4-40)	ACLA	440	1	.038	.040	.1875	.187	.25	.09	.22
				2	.054	.056					
	.138-32 (#6-32)	ACLA	632	1	.038	.040	.213	.212	.28	.09	.27
				2	.054	.056					
	.164-32 (#8-32)	ACLA	832	1	.038	.040	.234	.233	.31	.13	.28
				2	.054	.056					
	.190-24 (#10-24)	ACLA	024	1	.038	.040	.296	.295	.38	.16	.31
				2	.054	.056					
	.190-32 (#10-32)	ACLA	032	1	.038	.040	.296	.295	.38	.16	.31
				2	.054	.056					
	.250-20 (1/4-20)	ACLA	0420	1	.054	.056	.344	.343	.44	.17	.34
				2	.087	.091					
				3	.120	.125					

(1) For closer distances consult our Engineering Department.

METRIC (mm)	Thread Size x Pitch	Type	Thread Code	Shank Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet +0.08	C Max.	E ±0.25	T ±0.25	Min. Dist. Hole C/L To Edge(1)
		Aluminum									
	M2 x 0.4	ACLA	M2	1	0.98	1	4.25	4.22	6.3	1.5	4.8
				2	1.38	1.4					
	M3 x 0.5	ACLA	M3	1	0.98	1	4.75	4.73	6.3	2	5.6
				2	1.38	1.4					
	M3.5 x 0.6	ACLA	M3.5	1	0.98	1	5.4	5.38	7.1	2	6.9
				2	1.38	1.4					
	M4 x 0.7	ACLA	M4	1	0.98	1	6	5.97	7.9	3	7.1
				2	1.38	1.4					
	M5 x 0.8	ACLA	M5	1	0.98	1	7.5	7.47	9.5	3.8	7.9
				2	1.38	1.4					
	M6 x 1	ACLA	M6	1	1.38	1.4	8.75	8.72	11.05	4.08	8.6
				2	2.21	2.3					

# SELF-CLINCHING NUTS

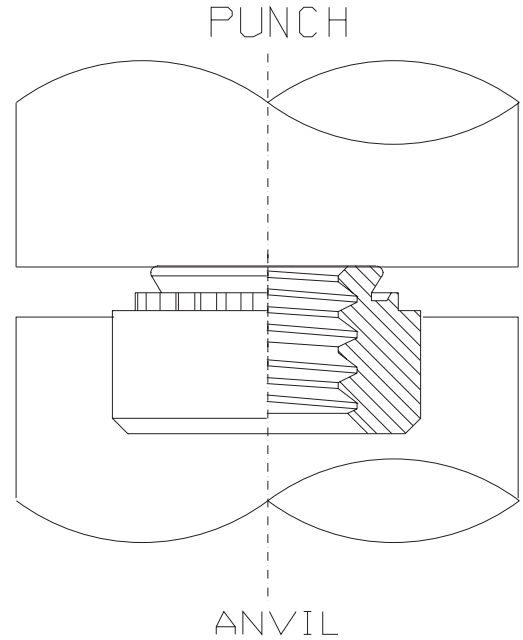
## ALUMINUM SELF-CLINCHING NUTS (Unified) - TYPE ACLA



### INSTALLATION

#### Types ACLA

1. Punch or drill properly sized mounting hole in sheet. Do not perform any secondary operations such as deburring.
2. Place fastener into the anvil hole and place the mounting hole over the shank of the fastener as shown in diagram to the right.
3. With punch and anvil surfaces parallel, apply squeezing force until the head of the nut comes into contact with the sheet material.



### MATERIAL & FINISH SPECIFICATIONS

Type	Threads			Fastener Materials					Standard Finishes				Optional Finish (1)	For Use in Sheet Hardness:				
	Internal, ANSI B1.1 2B/ANSI/ASME B1.13M, 6H	Meets Torque Requirements for IFI 100/107 Grade B (unified) and ANSI B18.16.1M (metric) Locknuts	3 Cycle Locking Performance PEM spec PRS-C90	Heat Treated Carbon Steel	#302/303 Stainless Steel	2024-T4 Aluminum	Carbon Steel	Precipitation Hardening Grade Stainless Steel	Passivated and/or Tested per ASTM A380	Zinc per ASTM B 633 SC1 (5µm), Type III, Colorless	Cadmium Spec SAE AMS-QQ-P-416, Type I, Class 3, Plus Clear Chromate Passivation	No Finish (2) (3)	Zinc per ASTM B 633 SC1 (5µm), Type II, Yellow	90 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
ACLA	•					•						•						•
Part number codes for finishes									None	Zi	Cl	X	C					

- (1) Special order with additional charge.
- (2) Part numbers for aluminum nuts have no plating suffix.
- (3) Unplated threads are sized to accept a basic go gauge after .00025" plating.