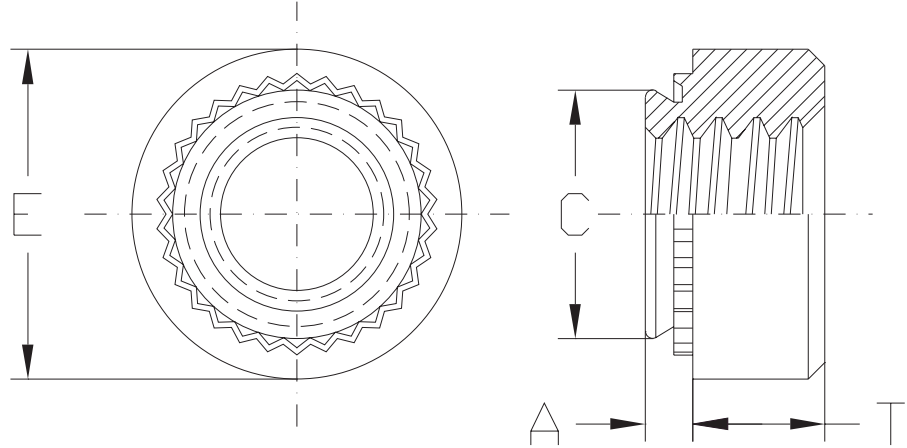
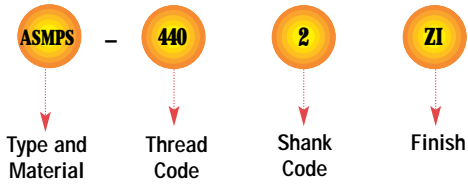


SELF-CLINCHING NUTS

SELF-CLINCHING NUTS FOR ULTRA-THIN SHEETS TYPE ASMPs.



Part Number Designation



UNIFIED (inch)	Thread Size	Type	Thread 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
	.086-56 (#2-56)	ASMPs	256	.024	.025	.136	.135	.220	.065	.145
	.112-40 (#4-40)	ASMPs	440	.024	.025	.166	.165	.220	.065	.170
	.138-32 (#6-32)	ASMPs	632	.024	.025	.187	.186	.252	.065	.200

METRIC (mm)	Thread Size	Type	Thread 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
	M2.5 x 0.45	ASMPs	M2.5	0.61	0.64	3.8	3.79	5.6	1.4	4.6
	M3 x 0.5	ASMPs	M3	0.61	0.64	4.24	4.22	5.6	1.4	4.3
	M3.5 x 0.6	ASMPs	M3.5	0.61	0.64	4.75	4.73	6.4	1.4	5.1

PERFORMANCE DATA⁽¹⁾

UNIFIED (inch)	Type	Thread Code	Test Sheet Material		
			Cold-rolled Steel		
			Installation (lbs.)	Pushout (lbs.)	Torque-out (in. lbs.)
ASMPs	256	1500	35	8	
ASMPs	440	1800	60	12	
ASMPs	632	2000	65	14	

METRIC (mm)	Type	Thread Code	Test Sheet Material		
			Cold-rolled Steel		
			Installation (kN)	Pushout (N)	Torque-out (N·m)
ASMPs	M2.5	7.5	156	1.13	
ASMPs	M3	8	267	1.35	
ASMPs	M3.5	8.8	289	1.58	

SELF-CLINCHING NUTS

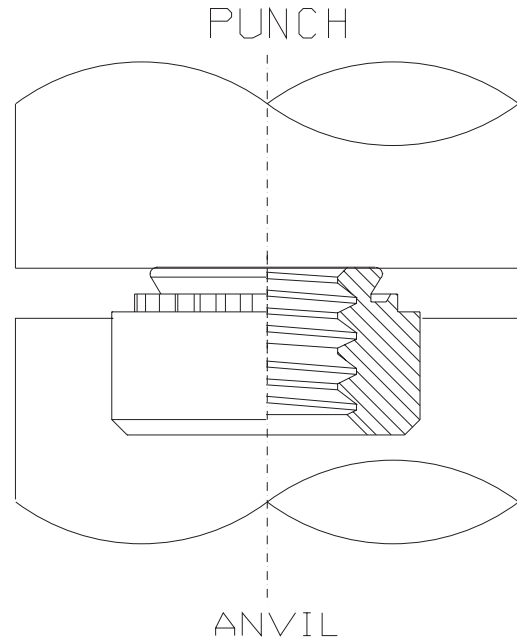
SELF-CLINCHING NUTS FOR ULTRA-THIN SHEETS TYPE ASMPS.



INSTALLATION

Types ASMPS

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	
ASMPS	•				•				•							•			
Part number codes for finishes									None	ZI	CI	X	C						

(1) Special order with additional charge.

(3) Unplated threads are sized to accept a basic go gauge after .00025" plating.

(2) Part numbers for aluminum nuts have no plating suffix.