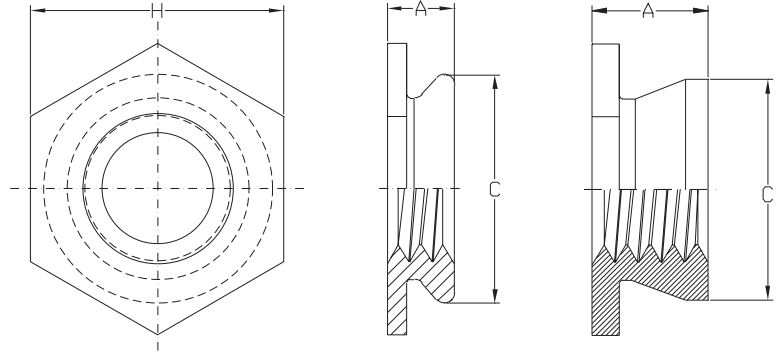
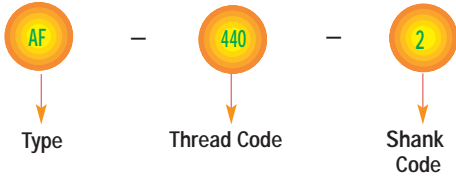


FLUSH SELF-CLINCHING FASTENERS



TYPE AF

Part Number Designation



UNIFIED (inch)	Thread Size	Type Stainless Steel	Thread Code	Shank Code	A Max.	Sheet Thickness	Hole Size In Sheet +.003 -.000	C Max.	H Nom.	Min. Dist. Hole C/L To Edge
	.086-56 (#2-56)	AF	256	1	1	.060	.060-.090	.172	.171	.188
2					.090	.091-UP				
.112-40 (#4-40)	AF	440	1	1	.060	.060-.090	.172	.171	.188	.23
				2	.090	.091-UP				
.138-32 (#6-32)	AF	632	1	1	.060	.060-.090	.213	.212	.250	.27
				2	.090	.091-UP				
.164-32 (#8-32)	AF	832	1	1	.060	.060-.090	.290	.289	.312	.28
				2	.090	.091-UP				
.190-32 (#10-32)	AF	032	1	1	.060	.060-.090	.312	.311	.343	.31
				2	.090	.091-UP				
.250-20 (1/4-20)	AF	0420	3	3	.120	.125-.155	.344	.343	.375	.34
				4	.151	.156-.186				
				5	.182	.187-UP				

METRIC (mm)	Thread Size x Pitch	Type Stainless Steel	Thread Code	Shank Code	A Max.	Sheet Thickness	Hole Size In Sheet +0.08	C Max.	H Nom.	Min. Dist. Hole C/L To Edge
	M2x0.4	AF	M2	1	1	1.53	1.53-2.3	4.37	4.35	4.8
2					2.3	2.32-UP				
M2.5x0.45	AF	M2.5	1	1	1.53	1.53-2.3	4.37	4.35	4.8	6
				2	2.3	2.32-UP				
M3x0.5	AF	M3	1	1	1.53	1.53-2.3	4.37	4.35	4.8	6
				2	2.3	2.32-UP				
M4x0.7	AF	M4	1	1	1.53	1.53-2.3	7.37	7.35	7.9	7.2
				2	2.3	2.32-UP				
M5x0.8	AF	M5	1	1	1.53	1.53-2.3	7.92	7.9	8.7	8
				2	2.3	2.32-UP				
M6x1	AF	M6	3	3	3.05	3.18-3.94	8.74	8.72	9.5	8.8
				4	3.84	3.96-4.72				
				5	4.63	4.75-UP				

MATERIAL & FINISH SPECIFICATIONS

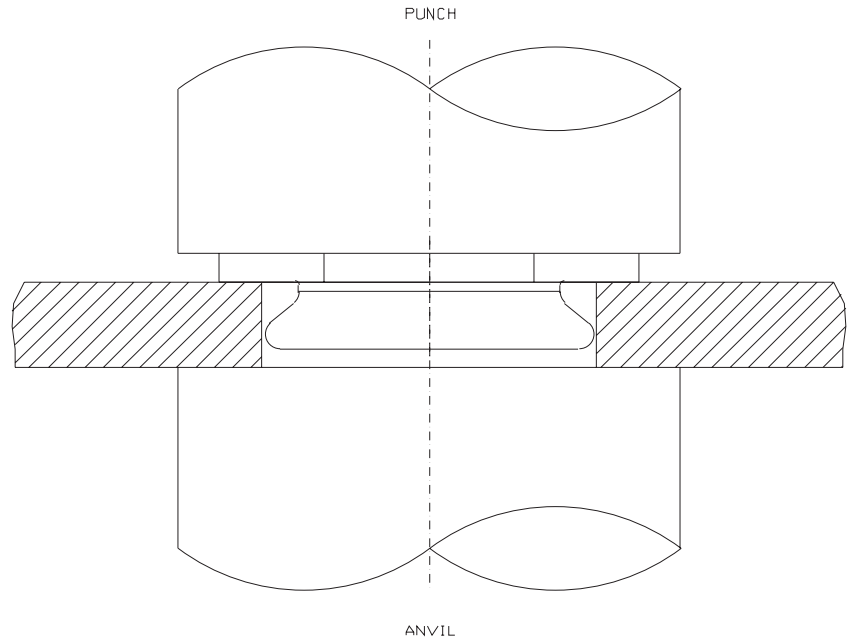
	Threads	Fastener Materials	Finishes	For Use In Sheet Hardness
Type	Internal, ANSI B1.1, 2B/ ANSI/ASME B1.13M, 6H	300 Series Stainless Steel	Passivated and/or tested per ASTM A380.	70 or Less on the Rockwell "B" Scale
AF	•	•	•	•

FLUSH SELF-CLINCHING FASTENERS



INSTALLATION

1. Punch or drill properly sized mounting hole in sheet. Do not perform any secondary operations such as deburring.
2. Place shank of fastener into mounting hole, preferably the punch side.
3. With punch and anvil surfaces parallel, apply sufficient squeezing force 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 pullout resistance while at the same time, the embedded hexagonal head provides high torque resistance.



PERFORMANCE DATA⁽¹⁾

UNIFIED (inch)	Thread Code	Shank Code	Axial Tensile Strength (in. lbs.)	Max. Screw ⁽²⁾ Tightening Torque (in. lbs.)	TestSheet Material			
					5052-H34 Aluminum		Cold-rolled Steel	
					Installation (lbs.)	Pushout (lbs.)	Installation (lbs.)	Pushout (lbs.)
256	1	2	130	1.50	2000	200	3000	200
		2						
440	1	2	165	2.50	2000	200	3000	200
		2						
632	1	2	190	3.50	2000	200	3000	200
		2						
832	1	2	230	5.25	2000	240	4000	240
		2						
032	1	2	280	7.50	2500	240	4000	240
		2						
0420	3	4	1035	36	3500	640	4500	840
		4						
		5						

METRIC (mm)	Thread Code	Shank	Axial Tensile Strength (kN)	Max. Screw ⁽²⁾ Tightening Torque (N•m)	TestSheet Material			
					5052-H34 Aluminum		Cold-rolled Steel	
					Installation (kN)	Pushout (N)	Installation (kN)	Pushout (N)
M2	1	2	0.57	0.16	8.9	890	13.3	890
		2						
M2.5	1	2	0.68	0.23	8.9	890	13.3	890
		2						
M3	1	2	0.85	0.36	8.9	890	13.3	890
		2						
M4	1	2	1	0.58	8.9	1068	17.8	1068
		2						
M5	1	2	1.3	0.88	11.1	1068	17.8	1068
		2						
M6	3	4	4.5	3.7	15.6	2847	20	3736
		4						
		5						

(1) The installation and pushout 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) Head may bend and/or fail if screw is over-torqued beyond these values.