

INSTALLATION OF CAPTIVE FASTENER CPL, CPLC

- Punch or drill properly sized mounting hole in sheet. Do not perform any secondary operations such as deburring.
- Place shank of nut into mounting hole, preferably the punch side.
- With punch and anvil surfaces parallel, apply squeezing force until knurled collar is flush with the top sheet for sheets .060"/1.5 mm thick and up, or until the shank is flush with the bottom of the sheet for sheets .040"/1mm to .060"/1.5mm thick.
- When is it necessary to install a fastener in a sheet thickness that is slightly less than the pilot area of the fastener, instead of flushing off the top of the knurled collar and the top surface of the sheet, bring the bottom of the fastener shank smooth with the underside of the sheet. When this method is used, note that care must be taken to protect the fastener against crushing which would damage the threads. This method will result in reduced push-out and torque-out values,

