

- 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 the head of the nut comes into contact with the sheet material.
- Sheet hardness must be less than HRB 88.
- Hole Punch should be kept sharp to minimize work hardening around hole.
- Nuts should not be installed near bends or other highly cold worked areas where sheet hardness may be greater than HRB 88.

UNIFIED	THREAD CODE	ANVIL DIMENSIONS (in)			
		A	B	P	R
		+0.002 -0.001	Nom.	+0.001 -0.000	Max
	440	.199	.261	.009	.003
	632	.218	.280	.009	.003
	832	.243	.305	.009	.003
	1032	.288	.350	.009	.003
	420	.385	.450	.012	.005

METRIC	THREAD CODE	ANVIL DIMENSIONS (mm)			
		A	B	P	R
		+0.05	Nom.	+0.03	Max
	M3	5.05	6.63	.23	.08
	M3.5	5.54	7.11	.23	.08
	M4	6.17	7.75	.23	.08
	M5	7.34	8.89	.23	.08
	M6	9.75	12.2	.23	.08

