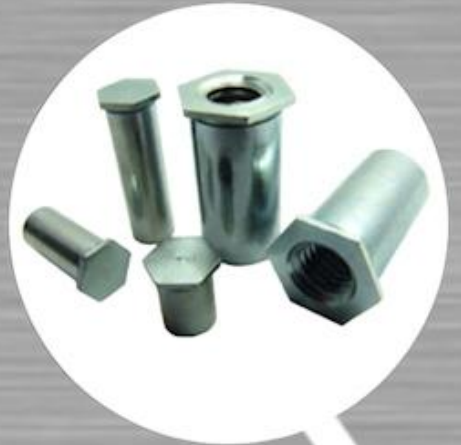
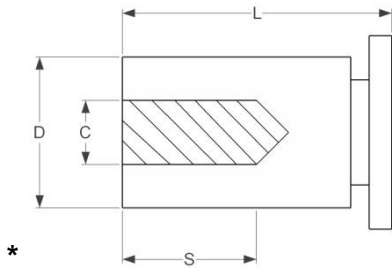


# DABOTEK

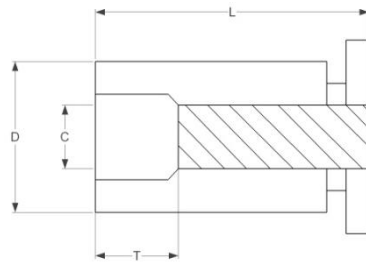
## *CLINCHING PARTS*



# Self-Clinching Standoffs



BLIND THREAD



THROUGH THREAD



INSTALLATION & PERFORMANCE DATA										
SHEET MATERIAL: 1.5 mm 5052-H34 ALUMINIUM						SHEET MATERIAL: 1.5 mm 5 COLD-ROLLED STEEL				
PART NO.	STANDOFF MATERIAL	INSTALLATION (kN)	PUSHOUT (N)	TORQUE-OUT (N_m)	PULL THROUGH (N)	INSTALLATION (kN)	PUSHOUT (N)	TORQUE-OUT (N_m)	PULL THROUGH (N)	REC TIGHTEN TORQUE MAX. (N_m)
350	STEEL	4.7								
	STAINLESS STEEL	4.7								
	ALUMINIUM	4.7								
3508	STEEL	7.4								
	STAINLESS STEEL	7.4								
	ALUMINIUM	7.4								
470 580	STEEL	10.5								
	STAINLESS STEEL	10.5								
	ALUMINIUM	10.5								
SHEET MATERIAL: 0.060 IN. 5052-H34 ALUMINIUM						SHEET MATERIAL: 0.060 IN. 5 COLD-ROLLED STEEL				
PART NO.	STANDOFF MATERIAL	INSTALLATION (LBS.)	PUSHOUT (LBS.)	TORQUE-OUT (IN.-LBS)	PULL THROUGH (LBS.)	INSTALLATION (kN)	PUSHOUT (LBS)	TORQUE-OUT (IN.-LBS)	PULL THROUGH (LBS.)	REC TIGHTEN TORQUE MAX. (IN.-LBS.)
440	STEEL									
	STAINLESS STEEL									
	ALUMINIUM									
440B 632	STEEL									
	STAINLESS STEEL									
	ALUMINIUM									
632B 832 1032	STEEL									
	STAINLESS STEEL									
	ALUMINIUM									

## NR-NOT RECOMMENDED

### RECOMMENDED INSTALLATION PRODEDURE

1. INSERT STANDOFF THROUGH HOE IN SHEET INTO ANVIL

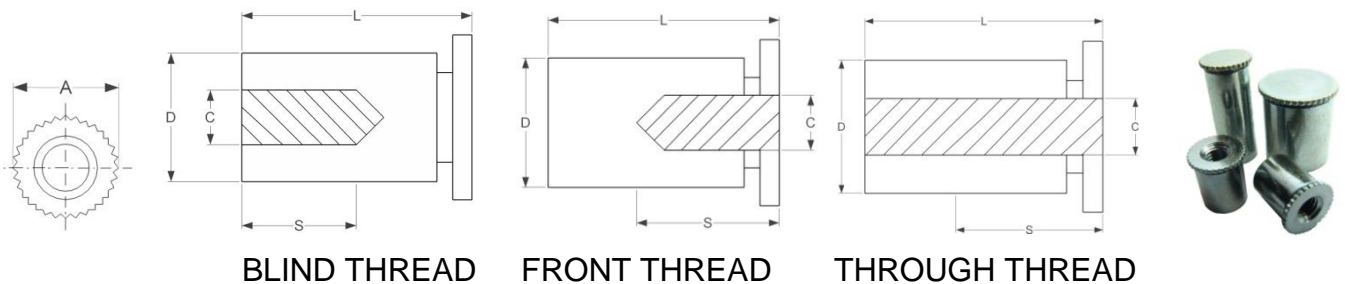
2. APPLY ONLY SUFFICIENT SQUEEZING FORCE BETWEEN PARALLEL SURFACES OF PUNCH AND ANVIL TO EMBED HEX HEAD FLUSH IN SHEET. AVOID EXCESSIVE PRESSURES.

# Self-Clinching Standoffs

DIMENSION & SPECIFICATIONS																			
THRAD SIZE	PART NO	L LENGTH + .05 / - 0.13													D DIM + .00 - .00	H HEX DIM (NOM.)	C COUNTER BORE ±0.13		
		3	4	6	8	10	12	14	16	18	20	22	25						
M3x0.5	350	3	4	6	8	10	12	14	16	18	20	22	25	4.2	4.19	4.8	3.2	6.0	1.0
	350B	3	4	6	8	10	12	14	16	18	20	22	25	5.4	5.38	6.4	3.2	7.0	1.0
M3.5x0.6	356	3	4	6	8	10	12	14	16	18	20	22	25	5.4	5.38	6.4	4.0	7.0	1.0
M4x0.7	470	3	4	6	8	10	12	14	16	18	20	22	25	7.2	7.11	7.9	4.8	8.0	1.3
M5x0.8	580	3	4	6	8	10	12	14	16	18	20	22	25	7.2	7.11	7.9	5.2	8.0	1.3
S DIM. MIN.		3.2	4.0	5.0	6.5	9.5													
T ± 0.40	NONE	4.0			8.0			11.0											

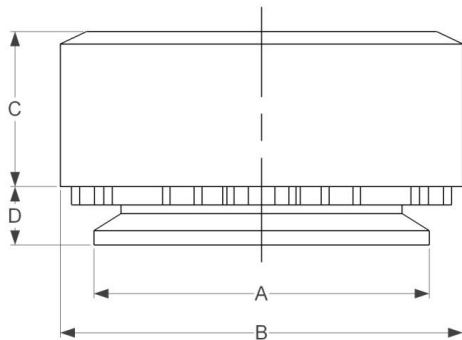
DIMENSIONS & SPECIFICATIONS																	(INCH)						
THREAD SIZE	PART NO.	L LENGTH + 0.002/ -0.005													D DIM + .003 - .000	C DIM + .000 - .005	H HEX DIM (NOM.)	D counter. BORE ±0.05					
		0.125	0.1875	0.250	0.3125	0.375	0.4375	0.500	0.5625	0.625	0.6875	0.750	0.8125	0.875							0.9375	1.0	1.0625
#4-40	440	0.125	0.1875	0.250	0.3125	0.375	0.4375	0.500	0.5625	0.625	0.6875	0.750	0.8125	0.875	0.9375	1.0	1.0625	0.166	0.165	0.1875	0.125	0.23	0.040
	440B	0.125	0.1875	0.250	0.3125	0.375	0.4375	0.500	0.5625	0.625	0.6875	0.750	0.8125	0.875	0.9375	1.0	1.0625	0.213	0.212	0.25	0.125	0.27	0.040
#6-32	632	0.125	0.1875	0.250	0.3125	0.375	0.4375	0.500	0.5625	0.625	0.6875	0.750	0.8125	0.875	0.9375	1.0	1.0625	0.213	0.212	0.25	0.156	0.27	0.04
	632B	0.125	0.1875	0.250	0.3125	0.375	0.4375	0.500	0.5625	0.625	0.6875	0.750	0.8125	0.875	0.9375	1.0	1.0625	0.281	0.280	0.3125	0.156	0.31	0.05
#8-32	832	0.125	0.1875	0.250	0.3125	0.375	0.4375	0.500	0.5625	0.625	0.6875	0.750	0.8125	0.875	0.9375	1.0	1.0625	0.281	0.280	0.3125	0.188	0.31	0.05
#10-30	1032	0.125	0.1875	0.250	0.3125	0.375	0.4375	0.500	0.5625	0.625	0.6875	0.750	0.8125	0.875	0.9375	1.0	1.0625	0.281	0.280	0.3125	0.203	0.31	0.05
S DIM. MIN.	FULL THREAD	0.1563	0.1875	0.25	0.375																		
T ± 0.0156	FULL THREAD	0.1875			0.3125			0.4375															




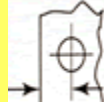
# Self-Clinching Lock Nuts




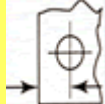


DIMENSIONS & SPECIFICATIONS											(MILLIMETERS)			
THREAD SIZE	L LENGTH ± 0.20									A ± 0.20	H ± 0.10	D +0.00 -0.08	T ± 0.10	P ± 0.10
	4	6	8	10	12	14	16	18	20					
M3x0.5	4	6	8	10	12	14	16	18	20	7.20	0.55	6.18	5.60	0.50
M4x0.7		6	8	10	12	14	16	18	20	8.20	0.55	7.18	6.60	0.50
M5x0.8			8	10	12	14	16	18	20	8.20	0.55	7.18	6.60	0.50
S	2	3	4	6	8	8	8	8	8					

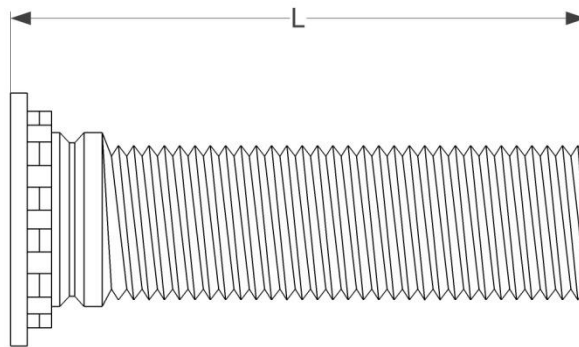
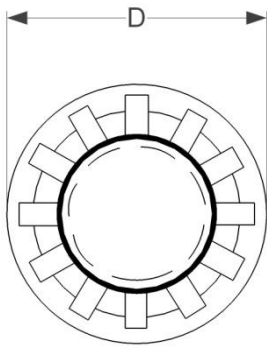
# Self-Clinching Nuts











DIMENSION & SPECIFICATION								(MILLMETERS)
 THREAD SIZE	PART NO.	D MAX.	 MIN.	+0.080 -0.000	 A MAX	B ± 0.25	C ± 0.25	 MIN.
M2x0.4	2401	0.76	0.8	4.25	4.22	6.3	1.5	4.8
	2402	0.97	1.0					
	2403	1.37	1.4					
	2404	2.21	2.3					
M2.5x0.45	2501	0.76	0.8	4.25	4.22	6.3	1.5	4.8
	2502	0.97	1.0					
	2503	1.37	1.4					
	2504	2.21	2.3					
M3x0.5	3501	0.76	0.8	4.25	4.22	6.3	1.5	4.8
	3502	0.97	1.0					
	3503	1.37	1.4					
	3504	2.21	2.3					
M3.5x0.6	3561	0.76	0.8	4.75	4.73	7.1	1.5	5.6
	3562	0.97	1.0					
	3563	1.37	1.4					
	3564	2.21	2.3					
M4x0.7	4701	0.76	0.8	5.4	5.38	7.9	2.0	6.9
	4702	0.97	1.0					
	4703	1.37	1.4					
	4704	2.21	2.3					
M5x0.8	5801	0.76	0.8	6.4	6.38	8.7	2.0	7.1
	5802	0.97	1.0					
	5803	1.37	1.4					
	5804	2.21	2.3					
M6x1.0	6101	1.37	1.4	8.75	8.72	11.05	4.08	8.6
	6102	2.21	2.3					
	6103	3.05	3.2					
M8x1.25	81251	1.37	1.4	10.5	10.44	12.65	5.47	9.7
	81252	2.21	2.3					
	81253	3.05	3.2					
M10x1.5	10151	2.21	2.3	14.0	13.94	17.35	7.48	13.5
	10152	3.05	3.2					
	10153	6.00	6.4					

DIMENSIONS & SPECIFICATIONS								(INCH)
 THREAD SIZE	PART NO.	D MAX.	 MIN.	+0.003 -0.000	 A MAX	B ±0.01	C ±0.01	 MIN.
#2-56	256-1	0.030	0.030	0.166	0.165	0.250	0.070	0.19
	256-2	0.038	0.040					
	256-3	0.054	0.056					
	256-4	0.087	0.091					
#3-48	348-1	0.030	0.030	0.166	0.165	0.250	0.070	0.19
	348-2	0.038	0.040					
	348-3	0.054	0.056					
	348-4	0.087	0.091					
#4-40	440-1	0.030	0.030	0.166	0.165	0.250	0.070	0.19
	440-2	0.038	0.040					
	440-3	0.054	0.056					
	440-4	0.087	0.091					
#6-32	632-1	0.030	0.030	0.1875	0.187	0.281	0.070	0.22
	632-2	0.038	0.040					
	632-3	0.054	0.056					
	632-4	0.087	0.091					
#8-32	832-1	0.030	0.030	0.213	0.212	0.312	0.090	0.27
	832-2	0.038	0.040					
	832-3	0.054	0.056					
	832-4	0.087	0.091					
#10-24	1024-1	0.030	0.030	0.250	0.249	0.344	0.090	0.28
	1024-2	0.038	0.040					
	1024-3	0.054	0.056					
	1024-4	0.087	0.091					
#10-32	1032-1	0.030	0.030	0.250	0.249	0.344	0.090	0.28
	1032-2	0.038	0.040					
	1032-3	0.054	0.056					
	1032-4	0.087	0.091					
#12-24	1224-1	0.038	0.040	0.277	0.276	0.380	0.130	0.31
	1224-2	0.054	0.056					
	1224-3	0.027	0.091					
#1/4-20	420-1	0.054	0.056	0.344	0.343	0.437	0.170	0.34
	420-2	0.087	0.091					
	420-3	0.120	0.125					
#1/4-28	428-1	0.054	0.056	0.344	0.343	0.437	0.170	0.34
	428-2	0.087	0.091					
	428-3	0.120	0.125					
#5/16-18	518-1	0.054	0.056	0.413	0.412	0.500	0.230	0.38
	518-2	0.087	0.091					
	518-3	0.120	0.125					
#5/16-24	524-1	0.054	0.056	0.413	0.412	0.500	0.230	0.38
	524-2	0.087	0.091					
	524-3	0.120	0.125					
#3/8-16	316-1	0.087	0.091	0.500	0.499	0.562	0.270	0.44
	316-2	0.120	0.125					
	316-3	0.235	0.250					
#3/8-24	324-1	0.087	0.091	0.500	0.499	0.562	0.270	0.44
	324-2	0.120	0.125					
	324-3	0.235	0.250					

# Self-Clinching Studs



DIMENSIONS & SPECIFICATIONS															(MILLIMETERS)				
 THREAD SIZE	PART NO.	L LENGTH ± 0.4												D ± 0.4 +0.08 -0.00	 MAX REC.NUT TIGHT.TORQUE N.m	 MIN	 MIN		
		6	8	10	12	15	18												
M2.5x0.45	2545	6	8	10	12	15	18							4.1	2.5	0.40	5.4	1.0	
M3x0.5	350	6	8	10	12	15	18	20	22	25				4.6	3.0	0.72	5.6	1.0	
M3.5x0.6	356	6	8	10	12	15	18	20	22	25	28	30		5.3	3.5	1.10	6.4	1.0	
M4x0.7	470	6	8	10	12	15	18	20	22	25	28	30	35	38	5.9	4.0	1.60	7.2	1.0
M5x0.8	580		8	10	12	15	18	20	22	25	28	30	35	38	6.5	5.0	3.40	7.2	1.0
M6x1.0	610			10	12	15	18	20	22	25	28	30	35	38	8.2	6.0	5.70	7.9	1.6
M8x1.25	8125				12	15	18	20	22	25	28	30	35	38	9.6	8.0	14.0	9.6	2.4

DIMENSIONS & SPECIFICATIONS															(INCH)			
 THREAD SIZE	PART NO.	L LENGTH ± 0.015												D ±0.015 +0.003 -0.000	 MAX. REC.NUT TIGHT.TORQUE IN.-LBS	 MIN	 MIN	
		0.250	0.3125	0.375	0.500	0.625	0.750	0.875	1.00	1.125	1.25	1.50						
#2-56	256	0.250	0.3125	0.375	0.500	0.625	0.750							0.144	0.085	2.5	0.187	0.040
#4-40	440	0.250	0.3125	0.375	0.500	0.625	0.750	0.875	1.00					0.176	0.111	5	0.219	0.040
#6-32	632	0.250	0.3125	0.375	0.500	0.625	0.750	0.875	1.00	1.25	1.50			0.206	0.137	10	0.250	0.040
#8-32	832	0.250	0.3125	0.375	0.500	0.625	0.750	0.875	1.00	1.25	1.50			0.237	0.163	15	0.281	0.040
#10-24	1024		0.3125	0.375	0.500	0.625	0.750	0.875	1.00	1.25	1.50			0.256	0.189	25	0.281	0.040
#10-32	1032		0.3125	0.375	0.500	0.625	0.750	0.875	1.00	1.25	1.50			0.256	0.189	30	0.281	0.040
1/4-20	420			0.375	0.500	0.625	0.750	0.875	1.00	1.25	1.50			0.337	0.249	55	0.312	0.062
5/16-18	518			0.375	0.500	0.625	0.750	0.875	1.00	1.25	1.50			0.376	0.311	115	0.375	0.093

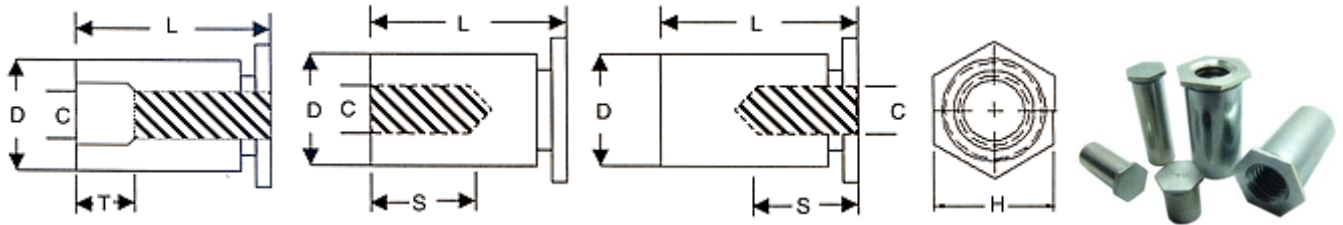
\_MATERIAL: STEEL

\_FINISH: ZINC PLATED

\_OTHER MATERIALS ARE AVAILABLE UPON REQUEST.

# Self-Clinching Standoffs

(for thin sheet metal)

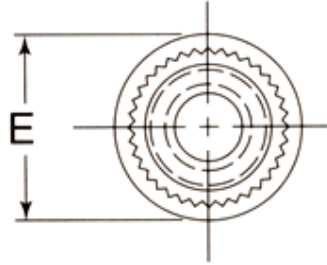
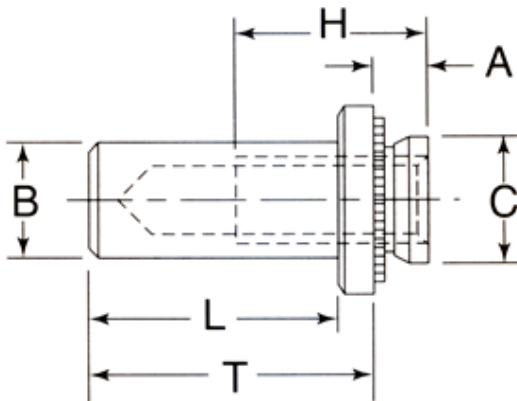


DIMENSIONS & SPECIFICATIONS															(MILLIMETERS)			
THREAD SIZE	PART NO.	L LENGTH $\pm 0.08$											D DIM. $+0.08$ $-0.00$	S MIN. THREAD DEPTH	H NOM.	MIN.	MIN.	
		TYPE S			TYPE ST			TYPE SC										
M2.5x0.45	2545	2	3	4	6	8	10	12	14	16	18	19	4.2	4.19	5.2	4.8	0.63	5.8
	2545B												5.4	5.38		6.4	0.63	7.1
M3.0x0.50	350	2	3	4	6	8	10	12	14	16	18	19	4.2	4.19	6.2	4.8	0.63	5.8
	350B												5.4	5.38		6.4	0.63	7.1
M3.5x0.60	356	2	3	4	6	8	10	12	14	16	18	5.4	5.38	7.0	6.4	0.63	7.1	

DIMENSIONS & SPECIFICATIONS															(INCH)				
THREAD SIZE	PART NO.	L LENGTH $\pm 0.08$											D DIM. $+0.003$ $-0.000$	S MIN. THREAD DEPTH	H NOM.	MIN.	MIN.		
		TYPE S			TYPE ST			TYPE SC											
#2-56	256	0.09	0.125	0.187	0.250	0.312	0.375	0.437	0.500	0.562	0.625	0.687	0.750	0.166	0.165	0.200	0.187	0.025	0.23
	256B													0.213	0.212		0.250	0.025	0.27
#4-40	440	0.09	0.125	0.187	0.250	0.312	0.375	0.437	0.500	0.562	0.625	0.687	0.750	0.166	0.165	0.220	0.187	0.025	0.23
	440B													0.213	0.212		0.250	0.025	0.27
#6-32	632	0.09	0.125	0.187	0.250	0.312	0.375	0.437	0.500	0.562	0.625	0.687	0.213	0.212	0.270	0.250	0.025	0.27	

INSTALLATION AND PERFORMANCE DATA\*\*\*

# Blind Pressed Nuts



DIMENSIONS & SPECIFICATIONS											(MILLIMETERS)
THREAD SIZE	PART NO.	BARREL DIA. B MAX.	MIN.	+0.08 -0.00	SHANK DIA. C MAX.	L MAX.	A MAX.	E ±0.25	T ±0.25	MIN.	H DEPTH FULL THREAD MIN.
M3x0.5	3501	3.8	1.0	4.25	4.22	8.5	0.97	6.35	9.6	4.8	5.3
	3502		1.4				1.37				
M4x0.7	4701	5.2	1.0	5.40	5.38	9.8	0.97	7.95	11.2	6.9	7.1
	4702		1.4				1.37				
M5x0.8	5801	6.0	1.0	6.40	6.38	9.8	0.97	8.75	11.2	7.1	7.1
	5802		1.4				1.37				
M6x1.0	6101	7.8	1.4	8.75	8.72	12.7	1.37	11.10	14.3	8.6	7.8
	6102		2.3				2.21				

DIMENSIONS & SPECIFICATIONS											(INCH)
THREAD SIZE	PART NO.	BARREL DIA. B MAX.	MIN.	+0.003 -0.000	SHANK DIA. C MAX.	L MAX.	A MAX.	E MAX.	T MAX.	MIN.	H DEPTH FULL THREAD MIN.
#4-40	4401	0.149	0.040	0.166	0.165	0.335	0.038	0.25	0.38	0.19	0.21
	4402		0.056				0.054				
#6-32	6321	0.169	0.040	0.187	0.186	0.335	0.038	0.28	0.38	0.22	0.23
	6322		0.056				0.054				
#8-32	8321	0.204	0.040	0.213	0.212	0.385	0.038	0.31	0.44	0.27	0.28
	8322		0.056				0.054				
#10-32	10321	0.235	0.040	0.250	0.249	0.385	0.038	0.34	0.44	0.28	0.28
	10322		0.056				0.054				
1/4-20	4201	0.305	0.056	0.344	0.343	0.500	0.054	0.43	0.56	0.34	0.31
	4202		0.090				0.087				

INSTALLATION AND PERFORMANCE DATA\*\*