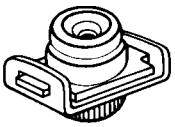
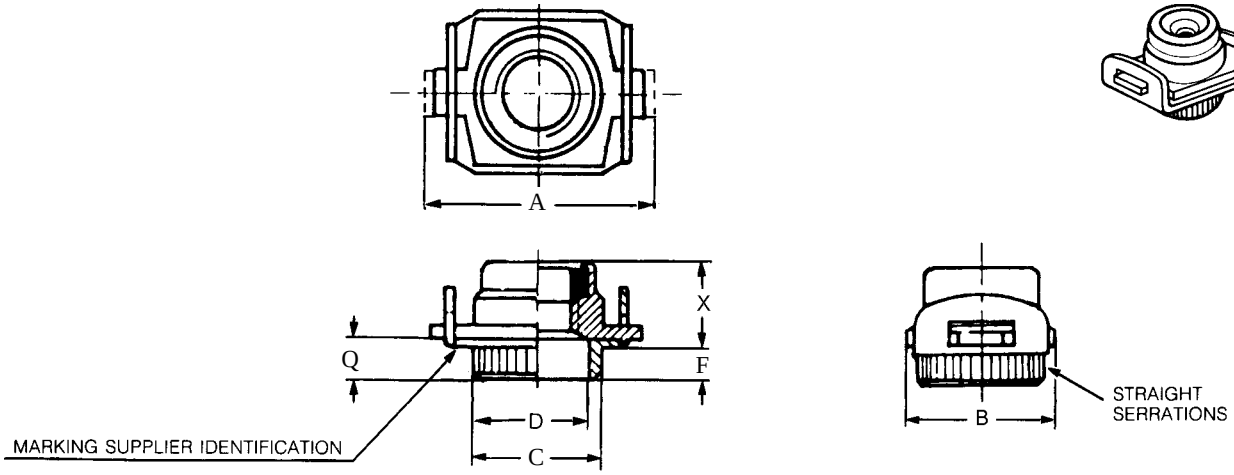
Howmet Fastening Systems
Howmet Fixations Simmonds SAS
9, rue des Cressonnières
72110 Saint-Cosme-en-Vairais – France - F0224
Tél : 33 (0)2-43-31-41-00
Fax : 33 (0)2-43-33-18-02





PART NUMBER	THREAD	A MAX.	B	C +.003 -.002	D +.005 -.000	F ±.003	Q REF.	X MAX.	APPROX WEIGHT LB/100
NSF8804-1	.1120-40 UNJC-3B	.446	.300	.224	.180	.040	.062	.134	.18
NSF8804-2						.060	.082		.19
(See Note 1)									
NSF8806-1	.1380-32 UNJC-3B	.446	.300	.224	.180	.040	.062	.174	.23
NSF8806-2						.060	.082		.24
(See Note 1)									
NSF8808-1	.1640-32 UNJC-3B	.498	.350	.275	.232	.040	.062	.202	.29
NSF8808-2						.060	.082		.30
NSF8808-3						.090	.112		.31
NSF883-1	.1900-32 UNJF-3B	.498	.350	.275	.232	.040	.062	.221	.31
NSF883-2						.060	.082		.32
NSF883-3						.090	.112		.33

Contact Howmet Fastening Systems for the diameter/type in manufacturing.

■ Dimensions in Inch.

MATERIAL: Alloy steel heat treated.

FINISH: Nut & Basket - Cadmium Plate, AMS-QQ-P-416, Type II, Class 3.

LOCKING INSERT: Nylon.

PERFORMANCE: NASM25027 except: torque out 40 inch. Lbs for ∅ .1900-32 UNJF-3B.

THREADS: In accordance with AS8879.

FLOATABILITY: Minimum radial .020 within limits of « A » dimension.

APPLICATION: Type NSF 88 Clinch Nuts are particularly suited for use in applications where limited mounting or wrenching areas make use of miniature fixed nut desirable since the spline on the nut shank must broach into the work.
Installations are usually limited to use in thin Aluminum or soft Steel Sheets or plates, the floating nut component adds advantage to the use of NSF 88 since it relaxes the usual requirements for close bolt hole alignments in making assembly stack-ups.

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SHANK LENGTH SELECTION

NOTE 1:

NSF88..-1: Parts are recommended for installations involving sheet thicknesses up to approximately .050 inch practical flushness can be achieved in thicknesses as low as **.**030 inch.

NSF88..-2: Parts are recommended for use in sheet thicknesses of **.**050 minimum.

NSF8803-3 & NSF 883-3: Parts are recommended for use in sheet thicknesses of **.**080 minimum.

For optimum installation it is recommended that the proper tools be used, and that the maximum tabulated clinching pressures not be exceeded.

Exceeding these values can, depending upon the material into which the nut is installed cause distortion of the work and/or the nut itself.

The most satisfactory installations are obtained when the nut is pressed into the work until its shoulder rests against the surface of the work. The shank should then be flared.

It is recommended that the acting surface of the punch face be maintained. Both the Punch and the Dolly should be regularly inspected and cleaned of any plating « Build-up » in order to assure proper seating of the nut.

Thread sizes -04 and -06, are not available with the -3 (**.**090) shank length as of printing of this catalog consult SIMMONDS for availability.

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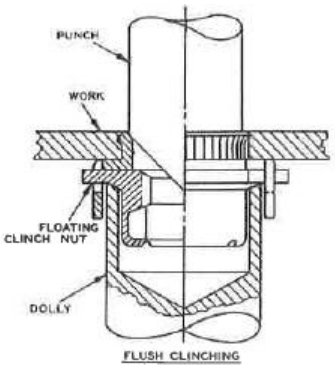
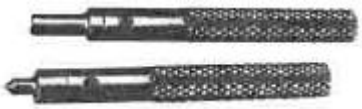
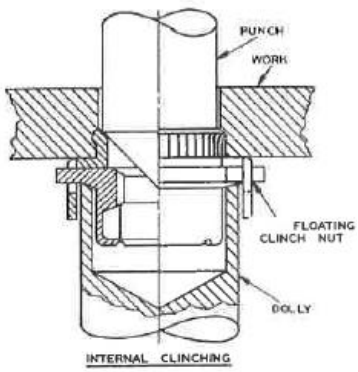
MOUNTING RECOMMENDATION

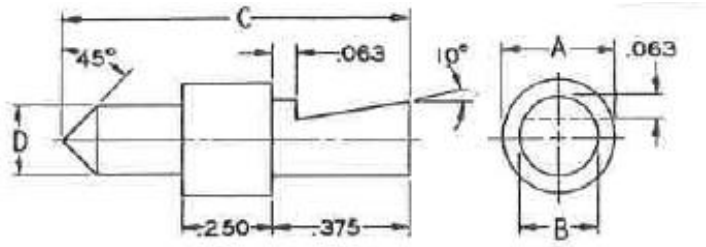




Thread	Installation			Maximum Recommended Clinching Pressure (LB)	Installation Hole Diameters	
	Punch (PCH)	Handle (HDL)	Dolly (DLY)		Min.	Max.
.1120-40 UNJC-3B	PCH1	HDL1	DLY1	1,500	.217	.219
.1380-32 UNJC-3B			DLY2			
.1640-32 UNJC-3B	PCH2	HDL2	DLY3	2,500	.268	.271
.1900-32 UNJF-3B			DLY4			



PUNCH

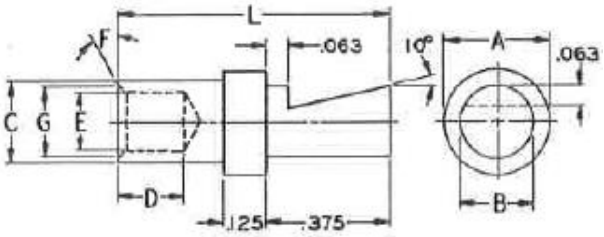


Punch (PCH)	A	B +.000 -.002	C	D +.000 -.002
PCH1	.307	.200	.919	.213
PCH2	.419	.300	.954	.264

Material: Alloy Steel Heat Treated

Finish: Unplated

DOLLY

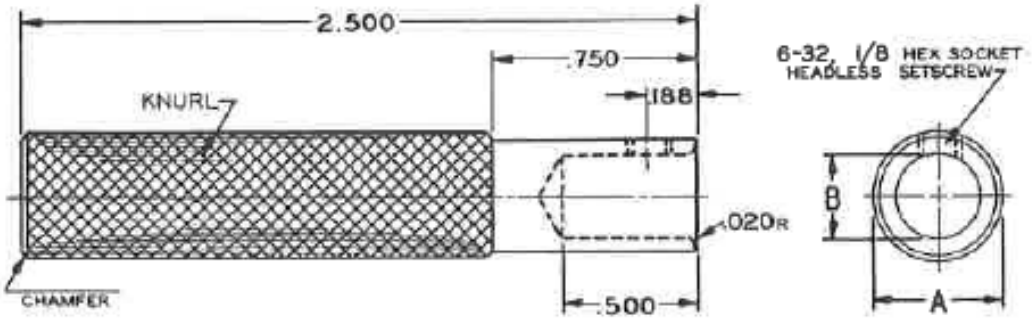


Dolly (DLY)	A	B +.000 -.002	C ± .002	D	E +.003 -.000	F ± 1°	G ± .003	L
DLY1	.299	.200	.299	.166	.183	35°	.209	.791
DLY2	.299	.200	.299	.166	.243	21°	.287	.791
DLY3	.419	.300	.351	.200	.269	21°	.318	.825
DLY4	.419	.300	.351	.200	.288	21°	------	.825

Material: Alloy Steel Heat Treated

Finish: Unplated

HANDLE



Handle (HDL)	A	B + .002 - .000
HDL1	.312	.201
HDL2	.437	.301

Material: Alloy Steel.

Finish: Unplated

DIMENSIONS IN INCH.

TOLERANCES: Unless otherwise specified: Decimals, ± .015, Angles, ± 2°.

RECOMMENDED TOOLING : Not provided by AFS.

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