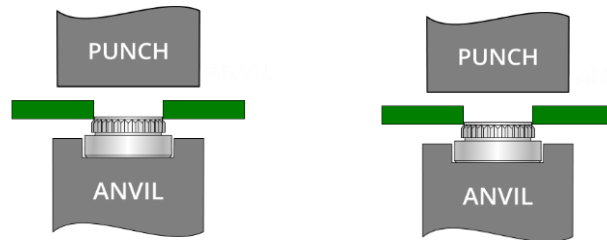


Broaching Nut Installation Guide



Prepare The Specified Hole In Panel

Place The Fastener In The Anvil With The Shank Facing Upwards

Locate The Panel Mounting Hole Over The Shank Of The Nut

Ensure The Panel Is Held Level And Apply Parallel Squeezing Force

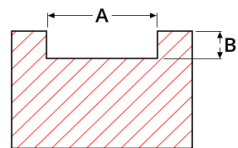
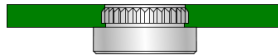
Until The Shoulder Of The Nut Is Seated Against The Panel

Do Not Over Squeeze The Nut Into The Panel As This Could Result

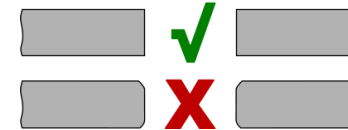
In Panel And Thread Deformation

Please Pay Attention To Minimum Hole Centreline To The Edge Of Panel

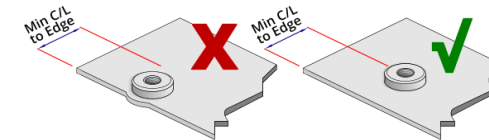
And Parent Material Hardness Limitations



Anvil Dimensions		
Thread Sizes	A +/- 0.05	B + / - 0.03
M2 - M2.5 - M3	5.79	1.20
M3.5 - M4	8.97	1.70
M5	9.76	2.70



Do Not Remove Any Extra Material
OR Chamfer The Hole As This Could Result
In Improper Installation Or Reduce Performance



Ensure Attention Is Paid To The Minimum Hole
Centreline To Edge Dimension For Each Fastener
Installing Too Close To The Edge Or Bend Could
Result In Improper Installation Or Reduced
Performance. Minimum Centreline To Edge
Dimensions Shown For Each Fastener Apply
To One Edge Only. If This Distance Is Applied
On Multiple Sides There Will Be Significant
Panel Distortion Unless The Panel Edges
Are Supported During Installation.

HRB (Rockwell Hardness B Scale)
Ensure That You Are Installing Into A
Panel That Is Or Below Published
Maximum Recommended Hardness For
The Fastener.