



GST NO.: 29AHZPU5620Q1ZZ

An ISO 9001:2015 Certified Company

# ROYAL INDUSTRIAL SUPPLIERS

QUALITY FASTENERS SPECIALIST



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## TECHNICAL DATA SHEET

### SELF CLINCHING NUT (CLS)



**MATERIAL- STAINLESS STEEL**

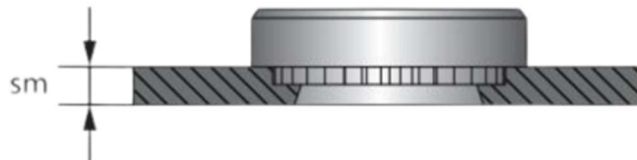
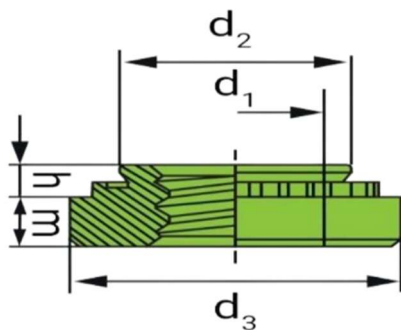
**GRADE-SS304 (A2)**

**AS PER-NON-STANDARD**

**CATALOGUE NO. R4S15v**

### INSTALLATION GUIDE

- VERIFY THE NUT SIZE, THREAD TYPE, AND MATERIAL MATCH THE APPLICATION REQUIREMENT.
- ENSURE THE BASE MATERIAL IS DUCTILE AND SUITABLE FOR SELF CLINCHING INSTALLATION.
- PUNCH OR DRILL THE MOUNTING HOLE TO THE SPECIFIED DIAMETER AND TOLERANCE.
- CONFIRM THE HOLE IS ROUND, CLEAN, AND FREE FROM BURRS OR CONTAMINATION.
- INSERT THE SELF CLINCHING NUT INTO THE HOLE FROM THE CORRECT INSTALLATION SIDE.
- ENSURE THE NUT HEAD OR FLANGE IS FLUSH AGAINST THE BASE MATERIAL SURFACE.
- USE A FLAT, PARALLEL PRESS TOOL OR HYDRAULIC PRESS FOR INSTALLATION.
- APPLY STEADY, AXIAL PRESS FORCE WITHOUT ROTATION.
- ALLOW THE BASE MATERIAL TO FLOW INTO THE NUT'S UNDERCUT GROOVE.
- DO NOT HAMMER OR APPLY IMPACT FORCE DURING INSTALLATION.
- VERIFY THE NUT IS FULLY SEATED AND FLUSH WITH THE MATERIAL SURFACE.
- CHECK THAT THE NUT DOES NOT SPIN OR PULL OUT AFTER INSTALLATION.
- AVOID OVER-PRESSING TO PREVENT PANEL DISTORTION OR THREAD DAMAGE.
- ENSURE THREADS ARE CLEAR AND UNDAMAGED AFTER INSTALLATION.
- INSPECT THE FINAL ASSEMBLY FOR ALIGNMENT, HOLDING STRENGTH, AND SURFACE FLATNESS.



## UNF SERIES

| Size→<br>Dimension↓                     |        | #10-32 | 1/4"-28 | 5/16"-24 | 3/8"-24 |
|-----------------------------------------|--------|--------|---------|----------|---------|
| Collar dia d2                           | max    | 0.249  | 0.343   | 0.412    | 0.499   |
| Nut dia d3                              | ±0.01  | 0.340  | 0.440   | 0.500    | 0.560   |
| Nut thickness m                         | ±0.01  | 0.090  | 0.17    | 0.23     | 0.27    |
| Hole Size in Sheet                      | +0.003 | 0.250  | 0.344   | 0.413    | 0.500   |
| Minimum edge distance to<br>hole centre |        | 0.28   | 0.34    | 0.38     | 0.44    |

Quote the PART NUMBER given below with your order/ inquiries:

All Dimensions in Inches

| Size     | Shank<br>Code | PART NUMBER | h<br>(Shank)<br>Max. | Min Sheet<br>Thickness<br>sm | Press In<br>(Installation) lbs |                | Push out lbs |       | Torque out lbs |       |
|----------|---------------|-------------|----------------------|------------------------------|--------------------------------|----------------|--------------|-------|----------------|-------|
|          |               |             |                      |                              | Aluminium                      | Steel          | Aluminium    | Steel | Aluminium      | Steel |
| #10-32   | 0             | R4S15v13200 | 0.030                | 0.030                        | 2500-<br>3500                  | 4000-<br>6000  | 68           | 120   | 26             | 32    |
|          | 1             | R4S15v13201 | 0.038                | 0.040                        |                                |                | 110          | 180   | 32             | 40    |
|          | 2             | R4S15v13202 | 0.054                | 0.056                        |                                |                | 190          | 320   | 50             | 60    |
| 1/4"-28  | 1             | R4S15v62001 | 0.056                | 0.054                        | 4000-<br>7000                  | 6000-<br>8000  | 360          | 400   | 90             | 150   |
|          | 2             | R4S15v62002 | 0.090                | 0.087                        |                                |                |              |       | 125            |       |
| 5/16"-24 | 1             | R4S15v79001 | 0.056                | 0.054                        | 4000-<br>7000                  | 6000-<br>8000  | 380          | 420   | 160            | 180   |
|          | 2             | R4S15v79002 | 0.090                | 0.087                        |                                |                |              |       |                |       |
| 3/8"-24  | 1             | R4S15v91001 | 0.090                | 0.087                        | 5000-<br>8000                  | 7000-<br>10000 | 400          | 460   | 270            | 320   |
|          | 2             | R4S15v91002 | 0.125                | 0.120                        |                                |                |              |       |                |       |

Sizes in BLUE are non-preferred. Availability is limited and MOQ is applied

Data is strictly informative

Note: All Austenitic Stainless-Steel Fasteners may exhibit some Magnetic Properties due to the Manufacturing Process.  
Refer: ISO 3506-2 Annex F