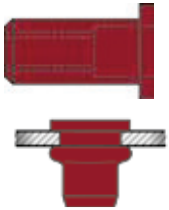







BLIND RIVET NUTS MONEL®



Material: Monel 400 NiCu30Fe 2.4360

Standard Dome head



D	D x L mm	 mm	No.	
M 5  7.1 mm	7 x 11.5	0.25 - 3.0	146 4292	A 500
M 6  9.1 mm	9 x 15.5	0.25 - 3.5	145 5489	A 250
M 8  11.1 mm	11 x 17.0	0.25 - 3.5	146 4291	A 100

Material surcharge will be added at a daily rate

SHAFT GEOMETRY ROUND AND SPLINED; ALL MATERIALS

Size mm	Dome head		Countersunk		Small head	
	Head diameter mm	Height of head mm	Head diameter mm	Height of head mm	Head diameter mm	Height of head mm
M 4	9	0.80	9	1.5 - 1.6	7.1	0.70
M 5	10	1.00	10	1.5 - 1.6	8.1	0.70
M 6	12	1.50	12	1.5 - 1.6	10.1	0.70
M 8	14	1.50	14	1.5 - 1.6	12.1	0.70
M 10	15	1.50	15	1.5 - 1.6	13.1	0.70

SHAFT GEOMETRY HALF HEXAGONAL; ALL MATERIALS

Size mm	Dome head		Small head	
	Head diameter mm	Height of head mm	Head diameter mm	Height of head mm
M 4	9	0.80	7.4	0.60
M 5	10	1.00	8.4	0.70
M 6	13	1.50	10.4	0.70
M 8	16	1.50	12.4	0.70

TECHNICAL DATA

SCHEMATIC LAYOUT FOR THE TORQUE TEST

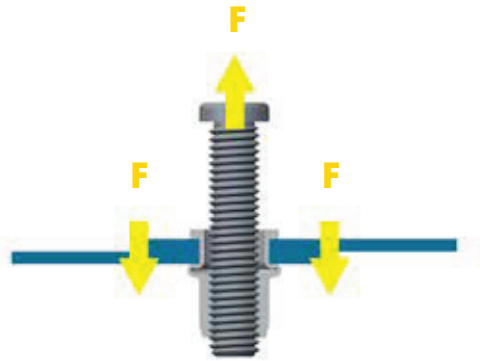
The tightening torque [(Nm) or (lb-ft)] specifies the maximum torque with which the screw can be tightened.

For testing, GESIPA® uses screws of the strength class 10.9 or higher that are free of all lubricants. A hardened washer is used as the clamping part. The test is carried out in the lower and the upper clamping range, where the blind rivet nuts are loaded with the specified torque. Then the screw is screwed out again.



SCHEMATIC LAYOUT FOR THE THREAD TEAR-OUT TEST

The maximum bearable axial load on the thread is the thread breaking force [(N) and (kp)]. GESIPA® uses screws of the strength class 10.9 or higher that are free of all lubricants for the test. The test takes place in the lower and upper clamping range.



The thread must still turn smoothly in order to pass the test. Then the blind rivet nut is loaded again up to the overtorque.

THE TIGHTENING TORQUE (NM) AND (LB-FT)

	Alu		Steel		Stainless steel A2 / A4 / Monel®	
	Nm	(lb-ft)	Nm	(lb-ft)	Nm	(lb-ft)
M4	2.5	1.8	3.0	2.2	5.5	4.1
M5	5.0	3.7	8.0	5.9	14.0	10.3
M6	9.5	7.0	12.0	8.9	27.0	19.9
M8	17.5	12.9	30.0	22.1	40.0	29.5
M10	28.0	20.7	38.0	28.0	-	-

THREAD BREAKING FORCE (N) AND (KP)

	Alu		Steel		Stainless steel A2 / A4 / Monel®	
	N	(kp)	N	(kp)	N	(kp)
M4	4,800	489	8,000	815	10,000	1,019
M5	5,700	581	11,500	1,172	15,000	1,529
M6	9,500	968	18,000	1,836	> 25,000	2,548
M8	13,000	1,325	28,000	2,853	> 30,000	3,057
M10	14,000	1,427	30,000	3,057	-	-