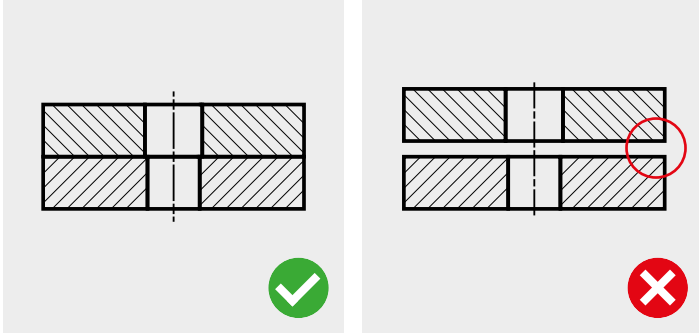


# nonut<sup>®</sup>

## 1. Component Positioning



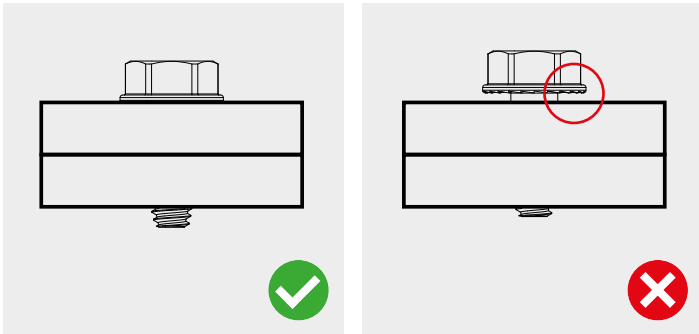
All parts to be joined should be in direct contact

## 2. Installation Process



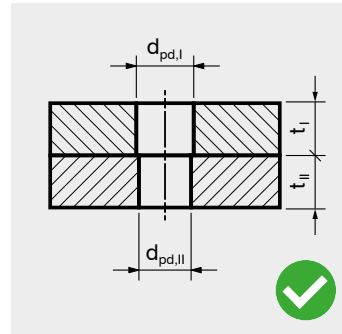
Fasteners must be installed perpendicular to the surface of the component

## 3. Completing the Installation Process



To ensure the fastener is fully engaged the fastener head must be in complete contact with component I and will not rotate any further

## 4. Pre-drilling



The pre-drill diameter must comply with the manufacturer's specifications

Tolerance for pre-drill diameter:  
 component thickness  $t < 3 \text{ mm}$  →  $d_{pd}$  tolerance range  $+0 / -0.2 \text{ mm}$   
 component thickness  $t \geq 3 \text{ mm}$  →  $d_{pd}$  tolerance range  $+0.1 / -0.1 \text{ mm}$

## 5. Installation Device

Tangential impact wrench with adjustable power levels is recommended. Required output depends on the respective application. (component thickness, steel grade, predrill diameter, fastener diameter)

## 6. Boundary conditions

nonut <sup>®</sup> fastener-Ø [mm]	Field of application $\Sigma t = t_I + t_{II}$ [mm]	Reference *) nominal output impact wrench [Nm]	Reference *) tightening torque [Nm]
8.6	up to 4	> 50	25
	4 up to 7	> 100	40
	> 7	> 200	50
10.6	up to 4	> 100	25
	4 up to 7	> 150	40
	> 7	> 250	50
13.4	up to 4	> 150	25
	4 up to 7	> 200	45
	> 7	> 250	65

\*) dependent on the particular application (component thickness, steel grade, predrill diameter, fastener diameter)