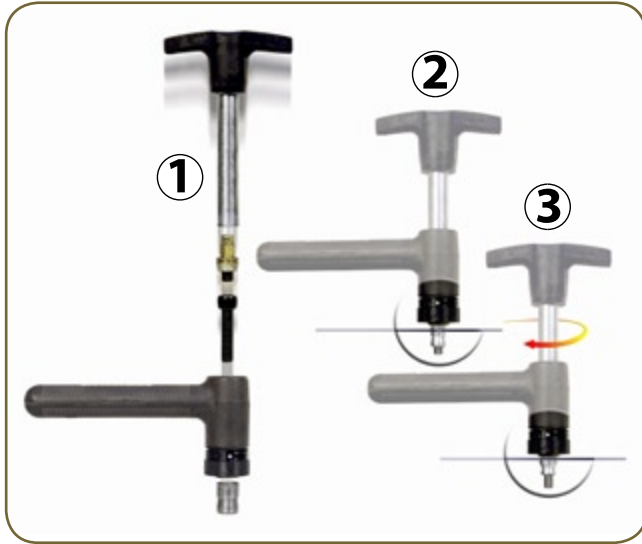


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Nut Insert Drill Chart

Part	Thread	Drill Size
HD-NS1	10-24	9/32"
HD-NS2	1/4-20	3/8"
HD-NS3	5/16-18	1/2"
HD-NTOOL	Must specify insert size when ordering (Additional insert sizes available)	

(1) Pre-drill sheetmetals or thin plastics to the size recommended in the chart below. Drill straight and do not ream the hole with the drill bit. The effectiveness of Nut Inserts is dependent on a snug fit. Assemble the parts as shown here. It helps assembly if you light oil the threads on the hex screw but do not get oil on the outside of the aluminum nut insert.

(2) Fully insert the nut into the hole in #2. Make sure it is inserted all the way to the serrated groove near the top of the nut as this is what grips your material.

(3) Turn the T-Handle clockwise to crush the nut on the backside of your material. NOTE: Make sure you fully crush the Nut Insert with the tool. You can use a 1/4" ratchet in the top of the T-Handle if you need additional torque to crush the nut. Unscrew the hex screw and remove the tool. The Nut Insert should be tight and straight in the hole and you're ready to install your StandOff Systems™ Parts.