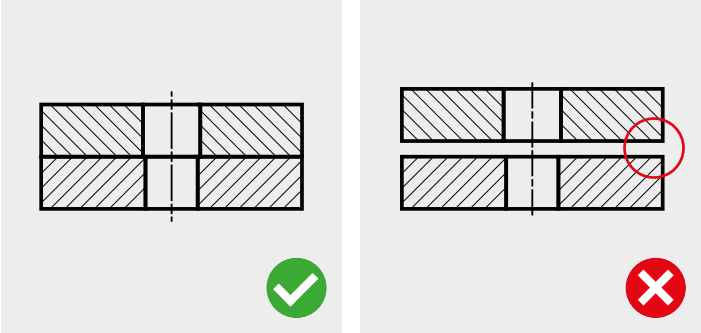
# nonut®

## 1. Component Positioning

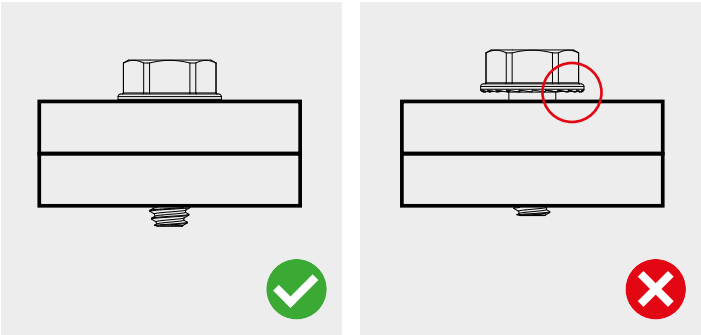


All parts to be joined should be in direct contact

## 2. Installation Process

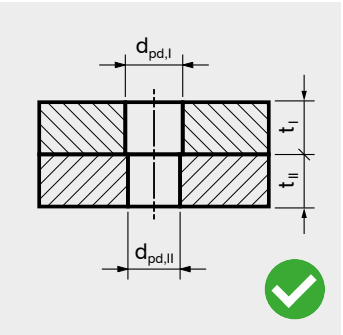
Fasteners must be installed perpendicular to the surface of the component

## 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 mm ➔ $d_{pd}$ tolerance range +0 / –0.2 mm
component thickness t ≥ 3 mm ➔ $d_{pd}$ tolerance range +0.1 / –0.1 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®** 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)

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