

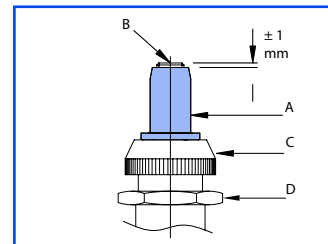
Technical information

● Setting method

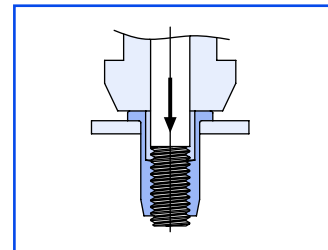
Select one of the Tubtara® blind rivet nuts out of our product range and a setting tool adequate for the application. Take a test workpiece and drill an appropriate hole

Screw the Tubtara® (A) on the mandrel (B) of the setting tool. For an open version the mandrel should protrude about 1 mm, for a closed one until you feel resistance.

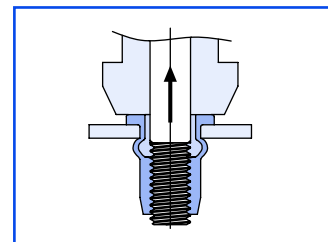
Screw the anvil (C) against the head of the Tubtara® and block it with the locking nut (D).



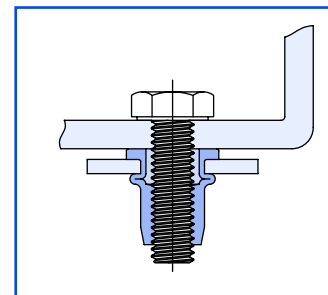
Introduce the Tubtara® mounted on the setting tool, into the hole of the workpiece.



Set the Tubtara®. The deformation chamber of the Tubtara® is now forming the counterhead on the underside of the workpiece (bulb). Unscrew the mandrel from the Tubtara®.

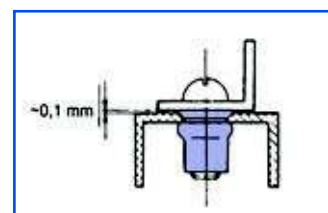


The Tubtara® is set. Now you can easily insert your bolt or screw to assemble a component.



● Countersunk heads

When you use a Tubtara® with a countersunk head, always countersink at 90° so that the head of the installed Tubtara® protrudes about 0,1 mm above your workpiece. This ensures direct contact with the assembled component.



Don't you have the possibility to countersink?
Use a low profile head!

● **General tolerances**

	Head form	Dimensions in mm	Dimensions in inches
D (head diameter)	Flat head Countersunk head Low profile head	± 0,35 0 -0,5 -0,15 +0,3	±.014 0 -.020 -.006 +.012
K (head thickness)	Flat head Countersunk head Low profile head	±0,15 0 +0,3 -0,05 +0,3	±.006 0 +.012 -.002 +.012
L (length)	General Stainless M10 shank 13 mm	±0,35 ±0,5	±.014 ±.020
Metric thread= 6H			
Shank size	General Splined shank M10 shank 12,4 mm	-0,02 -0,15 ±0,08 ±0,08	-.001 -.006 ±.003 ±.003

● **Material specification**

(subject to modification)

Aluminium: ALMG 2,5
 Steel: QST 34-3
 Stainless steel 304: 304 Cu
 Stainless steel 316: 316 Cu
 ...or equivalent.

● **Surface treatment**

on Tubtara® blind rivet nuts in steel

Zinktop

High-quality Cr^{VI}-free plating
 WEEE / ROHS compliant
 96 h white rust - 480 h red rust
 10µ±2µ

Zinc plated, yellow passivated

96 h white rust - 240 h red rust
 10µ±2µ

other surface treatments on request

● **Reach**

Please contact our Sales Department for all information.

Don't hesitate to contact us, if you need additional info.

● Mechanical characteristics

Can be used as a guidance for other versions

TYPE	Grip mm	ALUMINIUM			STEEL			STAINLESS STEEL 304 + 316		
		LOAD N	STROKE mm	THREAD N	LOAD N	STROKE mm	THREAD N	LOAD N	STROKE mm	THREAD N
M3 UPO 20	1	2000	2	3750	4000	2,5	> 5000			
	2	2600	1,5	3280	4750	2	> 5000			
M3 UPO 30	2	1850	1,5	3900	3700	2,5	> 5000			
	3	2050	1	3968	4750	2	> 5000			
M4 UPO 20	1							4900	2	> 9000
	2							5500	1,5	> 9000
M4 UPO 30	1	2100	3	5170	4300	2,5	> 8000			
	3	2430	1	4330	5650	1,5	> 8000			
M4 UPO 35	2							5500	2,6	> 9000
	3,5							6000	1,7	> 9000
M4 UPO 45	3	2050	2,75	4838	4200	2,5	> 8000			
	4,5	2875	1,5	4421	5000	1,5	> 8000			
M5 UPO 30	1	3050	3,5	5500	6150	3,5	12240	7500	3	> 15000
	3	3650	2	5000	7200	2,5	9600	8500	1,7	> 15000
M5 UPO 50	3							7500	4	> 15000
	5							8500	2	> 15000
M5 UPO 55	3	3000	3,5	6450	5750	4	11800			
	5,5	4300	1,5	5525	9650	2	10300			
M6 UPO 30	1	4500	3	11000	9400	4	21200	11850	4	> 24000
	3	5750	2	10000	12000	3	18500	14460	3	> 24000
M6 UPO 50	3							13500	4,5	> 24000
	5							15000	2,75	> 24000
M6 UPO 55	3	4500	3,5	11000	9000	3,5	22700			
	5,5	6100	1,75	10000	11000	2	19700			

Upset Load: Force (in Newton) necessary to deform the Tubtara® referred to in an adequate way.

Upset Stroke: Stroke (in mm) that should be set on the setting tool to give the Tubtara® referred to, the adequate deformation.

Ultimate Thread Strength: Surpassing this ultimate force (in Newton), the thread of the set Tubtara® will be pulled out.

Can be used as a guidance for other versions

TYPE	Grip mm	ALUMINIUM			STEEL			STAINLESS STEEL 304 + 316		
		LOAD N	STROKE mm	THREAD N	LOAD N	STROKE mm	THREAD N	LOAD N	STROKE mm	THREAD N
M6 UPO 80	5,5	4950	4,7	9160	8700	4	19900			
	8	5400	2	8200	11750	2,5	17200			
M8 UPO 30	1	5000	3	14900	11500	4	30400	14500	4,2	> 41000
	3	6600	2	14000	13750	2,5	26100	18000	2,8	> 41000
M8 UPO 55	3	5400	4	15500	11500	4	32500	14500	5,5	> 41000
	5,5	7400	2	11200	15500	2,5	31900	18500	3	> 41000
M8 UPO 80	5,5	5900	4	16100	10700	4	32400			
	8	7850	2	13600	14700	2,5	26500			
M10 UPO 30	1							14500	3,5	> 45000
	3							18500	2,5	> 45000
M10 UPO 35	1	6750	4	22100	13600	4,5	39600			
	3,5	9000	2,5	17700	17000	2,5	32400			
M10 UPO 50	3							14500	3,5	> 39500
	5							18500	2,5	> 37000
M10 UPO 60	3,5	9000	5	25250	14900	4	42300			
	6	13000	3	23000	17900	2,5	31700			
M10 SPO 35	1				13500	4,5	40500	19500	4,5	> 45000
	3,5				16100	2,5	36100	26500	3,5	> 45000
M10 SPO 60	3,5				15900	5,5	48000			
	6				20400	3	37500			
M12 UPO 40	1				19500	5,5	> 50000			
	4				25000	4	> 50000			
M12 UPO 70	4				19500	5,5	> 50000			
	7				25000	4	> 50000			

The mentioned values are average reference values only.

We strongly advise the customer to do his own tests in the proper material thickness and specific application.

● **TUBTARA® with seal under the head** (for productinfo see page 39)

Information about NBR O-Ring & compatibility with other products					
Shore Hardness	70 - 95	Aromatic Hydrocarbons	x	Lye	x
Hydraulic fluids	xxxx	Aliphatic Hydrocarbons	xxx	Chlorinated Hydrocarbons	x
Fuel Oils	xx	Water under 80°C	xxx	Ozone & Sunlight	x
Animal Oils	xxxx	Water over 80°C	x	Temperature range °C	-35 +120
Brake Fluid	-	Alcohols	xx	Electr. properties	-
Silicone & Grease	xx	Ketone	-	Compression sets	xxx
Gasoline	xxx	Acid (concentrated)	-	Flame resistance	No
Aromatic fluids up to 50 %	xx	Acid (diluted)	x		
Kerosene	xxx				

Key: xxxx very good --> x satisfactory - not suitable.

Storage: protect against UV-light; store in a dry and dark place (all boxes are marked)

Seals in other materials on request.

● **Conversion table**

Multiply	by	To get
millimeter (mm)	.03937	inch (in)
inch (in)	25,4	millimeter (mm)
kilogram (kg)	2,2046	pound (lb)
pound (lb)	0,4536	kilogram (kg)
Newton (N)	0,2248	pound-force (lbf)

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General conditions available on our website www.dejond.com

Any dispute will fall within the exclusive jurisdiction of the courts of Antwerp