THE NUTTY COMPANY INC
FASTENER SPECIALISTS SINCE 1977

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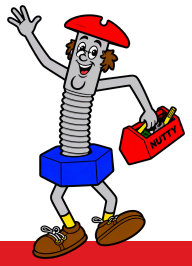
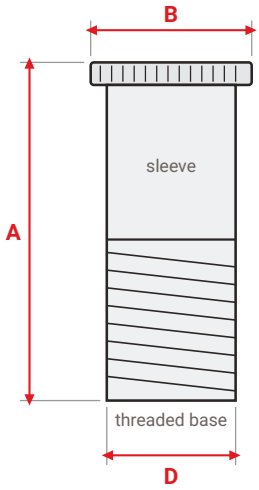


PRODUCT DATA SHEET

Steel Thread-Serts®

1.0 Dimensions & Hole Sizes (inches)





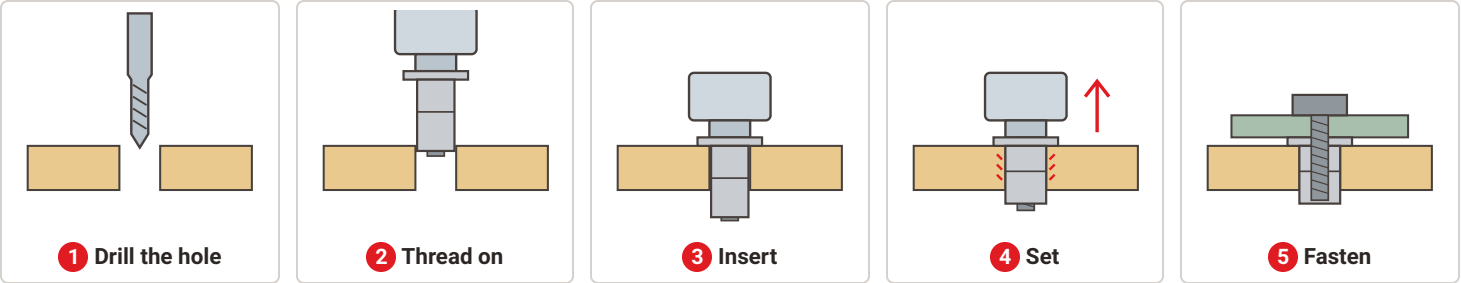
- **Two-piece insert** – a threaded base inside a sleeve, small flange, open end.
- As it sets, the base swages the sleeve **360° against the hole** for high torque-out resistance.
- Works in any material **.094" (3/32") and thicker** – no maximum grip, blind holes OK.
- Minimal back-side protrusion.
- No tapping, welding or brazing – a drilled or punched hole is all you need.
- Sets with any manual or pneumatic rivet nut tool.

A body length (±.005) **B** head diameter (±.005) **D** body diameter (±.002). A and D are before setting.

					Material .094"–.156"		Material over .156"	
Stock No.	Thread Size	A Body Length	B Head Dia.	D Body Dia.	Hole Size	Drill Size	Hole Size	Drill Size
TSS632	**6-32**	.375	.250	.215	.221	**#2**	.234	**A**
TSS832	**8-32**	.375	.282	.246	.250	**1/4"**	.261	**G**
TSS1024	**10-24**	.375	.314	.277	.281	**9/32"**	.290	**L**
TSS1032	**10-32**	.375	.314	.277	.281	**9/32"**	.290	**L**
TSS1420	**1/4-20**	.510	.408	.372	.391	**25/64"**	.391	**25/64"**
TSS51618	**5/16-18**	.615	.537	.496	.500	**1/2"**	.516	**33/64"**
TSS3816	**3/8-16**	.740	.600	.559	.562	**9/16"**	.578	**37/64"**

Dimensions in inches. Inch threads are Class 2B. Thread-Sert® is a registered trademark of its owner. We also stock aluminum Thread-Serts®. Contact us for other thread sizes.

2.0 Installation



1. **Drill the hole.** Drill or punch the hole to the size in the table – the smaller hole for material .094"–.156", the larger hole over .156". Deburr.
2. **Thread on.** Thread the insert onto the tool mandrel until the flange sits against the nosepiece.
3. **Insert.** Push the insert into the hole until the flange is flat on the work. Hold the tool square.
4. **Set.** Operate the tool. The threaded base is pulled up into the sleeve and swages it 360° tight against the wall of the hole.
5. **Fasten.** Unscrew the mandrel and attach your part with a bolt or screw of the same thread. Do not over-tighten.

3.0 Material & Specifications

Property	Specification
Type	Two-piece swaging rivet nut, small flange, open end
Material	Steel
Finish	Zinc plated
Thread	Unified inch, Class 2B
Sizes	6-32, 8-32, 10-24, 10-32, 1/4-20, 5/16-18, 3/8-16
Grip	.094" minimum, no maximum
RoHS	Compliant

4.0 Common Uses

- Thick aluminum or steel plate, extrusions and castings
- Blind holes – no back-side access needed
- Truck bodies, trailers and RVs
- Electrical enclosures, panels and racks
- Machine guards, frames and HVAC equipment
- Rigid plastic and fiberglass

5.0 Tips for a Good Install

- Measure the material: use the **smaller hole** for .094"–.156" and the **larger hole** for anything thicker.
- Hole size matters: too big and the insert can spin, too small and it will not seat. Use the drill size listed.
- Set the tool stroke so the insert is fully set without stretching the threads. Test on scrap first.
- Use the correct mandrel and nosepiece for each thread size.
- Steel Thread-Serts® give higher strength and torque-out resistance. In aluminum parts, use aluminum Thread-Serts® to avoid galvanic corrosion.

Disclaimer: The above is a compilation of data from various industry standards. The Nutty Company, Inc. has made every effort to present the data accurately. However, The Nutty Company, Inc. cannot be held liable for any claim traceable to any errors, typographical or otherwise, contained herein.



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