

CLINCH NUT SERIES



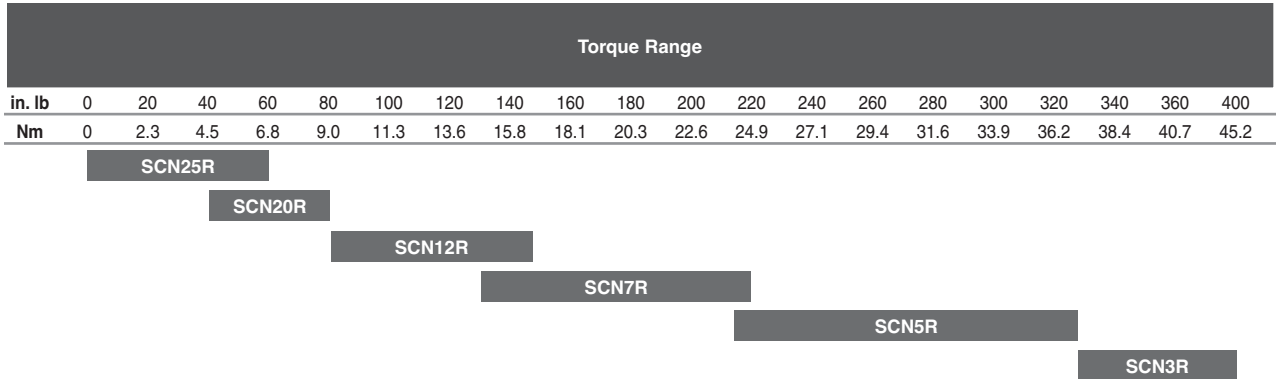
Tool Selection / Order Guide

Selecting the proper tool for your clinch nut application is simple, just follow the steps outlined below:

Step 1: Determine the torque required to properly install the clinch nut/stud. The installation torque can be determined by consulting the clinch nut manufacturer or manufacturers' guide, or through testing of your application.

Step 2: Noting the torque requirement for your fastener, refer to the Power Unit Selection Guide below to determine the appropriate power unit for your application. The guide illustrates the approximate torque output. The torque ranges shown for each power unit can be achieved by adjusting the air inlet pressure between 60 PSI (4.1 bar) and 90 PSI (6.2 bar) using an appropriate air pressure regulator. For additional performance and feature specifications, refer to the power unit specifications found on the back of this brochure.

Power Unit Selection Guide



Step 3: After selecting the appropriate power unit, refer to the Head Assembly Selection Chart below. Determine the correct head assembly suffix by locating the thread size in the chart. Select the suffix based on whether your fastener is a clinch nut (female threads) or clinch stud (male threads). You will also need to determine if your application requires a serrated or smooth head. A serrated style head will better grip the clinch nut/stud during the installation process, preventing the fastener from rotating, and reducing the torque reaction on the operator. A smooth style head reduces the risk of damaging smaller fasteners, and is preferable in cosmetic applications where visible serrations left on the fastener would be undesirable.



Serrated Nose



Smooth Nose

Clinch Nut (Female)



Thread Size	Order Number Suffix	
	Serrated Nose	Smooth Nose
#4-40	440	440S
M3 x 0.5	M305	M305S
#6-32	632	632S
#8-32	832	832S
M4 x 0.7	M407	M407S
#10-24	1024	1024S
#10-32	1032	1032S
M5 x 0.8	M508	M508S
1/4-20	420	420S
M6 x 1.0	M610	M610S
5/16-18	518	518S
M8 x 1.25	M8125	M8125S
3/8-16	616	616S
M10 x 1.5	M1015	M1015S

Clinch Stud (Male)



Thread Size	Order Number Suffix	
	Serrated Nose	Smooth Nose
#4-40	440F	440SF
M3 x 0.5	M305F	M305SF
#6-32	632F	632SF
#8-32	832F	832SF
M4 x 0.7	M407F	M407SF
#10-24	1024F	1024SF
#10-32	1032F	1032SF
M5 x 0.8	M508F	M508SF
1/4-20	420F	420SF
M6 x 1.0	M610F	M610SF
5/16-18	518F	518SF
M8 x 1.25	M8125F	M8125SF
3/8-16	616F	616SF
M10 x 1.5	M1015F	M1015SF

Head assemblies can be ordered separately by adding the prefix SCN to the above part number, (example SCN-420).

Step 4: After selecting the power unit and head assembly, combine their part numbers as shown in the following example, to determine the complete tool ordering number:

Tool Order Number Example: SCN3R420

Quality You Count On... Performance You Depend On!

Sioux Tool's new Signature Series Rapid Reverse Clinch Nut tools are meeting the demand of today's manufacturing marketplace with versatility and simplicity. Clinch nuts, also known as captive nuts, or rivet nuts, provide a reliable means of securing assembly components in thin wall applications. These unique fasteners are inserted into pre-drilled holes in thin materials such as sheet metal, and with the aid of a Sioux clinch nut tool, compress and expand to clamp the material. This process creates a strong, secure base with either a female or male thread for assembling additional components.

When installing clinch nut fasteners, the key to achieving high productivity with accurate, repeatable results is matching the tool and fastener to your application. The right combination of rundown speed and stall torque in conjunction with a quick reverse method for disengaging the tool, will provide the best results. The new Sioux Signature Series tools offer higher torque in a wide range of speeds so you can match the right tool to your application. With an additional 25% increase in power, you can use a faster speed and still get the same torque from the tool, plus our exclusive Rapid Reverse feature makes short work of direction changes ensuring fast disengagement from the fastener.

The wide selection of speeds and threads in both English and Metric sizes, make Sioux Tools your choice for all your clinch nut applications.



Clinch Nut Installation Procedure

Step 1:
Pre-drill hole for fastener.



Step 2:
Insert fastener.



Step 3:
Thread tool into fastener.



Step 4:
Run tool to collapse fastener. Reverse tool to release.



Step 5:
Assemble.



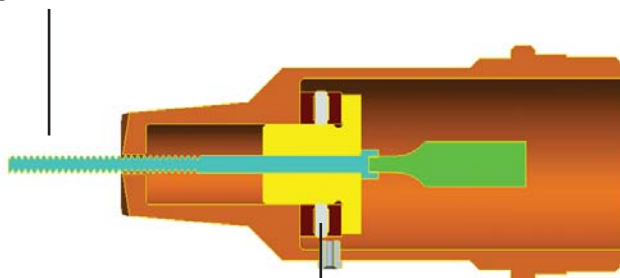
Features



Features

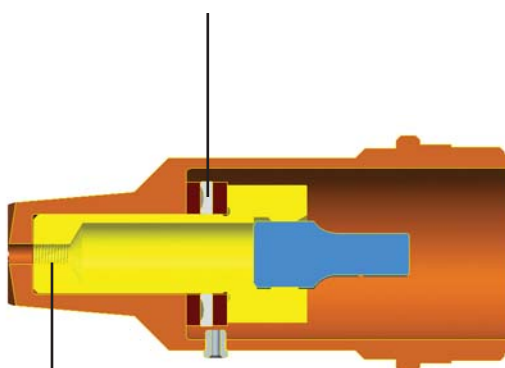
Male Threaded Output Spindle

For installing clinch nuts



Large Thrust Bearing

Increases load carrying capacity for longer life



Female Threaded Output Spindle

For installing clinch studs

The SCN series clinch nut tools offers some great features:

- A wrenchless head assembly making it easy to change the size or style without the use of tools.
- A grease fitting on the nose assembly allows lubrication to the thrust bearing for reduced wear and longer life.
- Large thrust bearing for improved bearing life.
- 3/4" (20 mm) nose diameter allows easy access into tight spaces.
- Available with either a smooth or serrated nose and can be ordered for either clinch nut or clinch stud applications.



Clinch Nut Power Unit

Model Number	Free Speed	Maximum Torque		Weight		"A" Dimension		Side To Center		Maximum Air Consumption		Sound Level
	rpm	in. lb	Nm	lb	kg	in.	mm	in.	mm	cfm	l/s	dB(A)
Pistol Grip - Rapid Reverse - Power Units Specifications												
SCN3R	300	400	45.2	3.2	1.5	11.0	279	0.8	20	30	14.2	80
SCN5R	500	325	36.7	3.2	1.5	11.0	279	0.8	20	30	14.2	80
SCN7R	700	220	24.8	3.2	1.5	11.0	279	0.8	20	30	14.2	80
SCN12R	1200	145	16.4	3.2	1.5	11.0	279	0.8	20	30	14.2	80
SCN20R	2000	80	9.0	2.8	1.3	10.0	254	0.8	20	30	14.2	80
SCN25R	2500	60	6.5	2.8	1.3	10.0	254	0.8	20	30	14.2	80

Power units can be ordered separately using part number above. See the tool Selection/Order Guide for instructions on ordering complete tools.

General:

Air Inlet Size: 1/4" NPT • Recommended Hose Size: 3/8" (10 mm)

Standard Equipment:

Parts list • Safety and Instruction manual

siouxtools.com



250 Snap-on Drive
 P.O. Box 1596
 Murphy, North Carolina USA 28906
 PH: 828.835.9765
 FAX: 828.835.9685
 TOLL FREE: 866.259.7291
 TOLL FREE FAX: 800.722.7236

Benelux
 Tel.: (N) 31 (0) 20 568 26 63
 (B) 32 (0) 14 23 19 67
 Fax: (N) 31 (0) 20 568 26 60
 (B) 31 (0) 14 23 26 27
 e-mail: snap@snap-on.nl

Latin America
 Tel.: 305-271-0944
 Fax: 305-271-7152
 e-mail: latinamerica.caribbean@snapon.com

Germany
 Tel.: 49 2104 9509-0
 Fax: 49 2104 9509-99
 e-mail: snapon.industrial@snapon.com

Italy
 Tel.: 00 39 02 66 04 53 70
 Fax: 00 39 02 61 29 78 15
 e-mail: indus.italia@snapon.com

United Kingdom
 Tel.: 44 (0) 1536-413904
 Fax: 44 (0) 1536-413874
 e-mail: industrialuk@snapon.com

Asia
 Tel.: 65-6451-5570
 Fax: 65-6451-5574
 email: esales.sg@snapon.com

Australia
 Tel.: 61 2 9837 9100
 Fax: 61 2 9624 2578
 e-mail: SOTA.customerservice@snapon.com

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