

NUTSERTS



The A-T Series Insert is unique in that it can be installed into most any material above .030/.76 mm in thickness. As the A-T Series is installed, the threaded portion is completely swaged 360° into the sleeve portion and the hole. This permits the A-T Series to be used with Grade 8/metric 12.9 mating screws. The A-T Series Insert is installed using lightweight, hand held pneumatic tools that can be located at any position in your product's assembly sequence. The A-T Series Insert can be installed either prior to or after finish.

360° SWAGING HOW IT WORKS FOR YOU

As the A-T Series Insert is installed, the threaded nut portion is drawn into the upper sleeve portion.



As this occurs, a 360° swaging action takes place anchoring the A-T Series in the parent material.

NUTSERT HOLE SIZE / MATERIAL THICKNESS CHART

Installation hole size for the A-T Series Insert is determined by the parent material's thickness and density. The thicker the material the larger the hole required to allow full 360° installation swaging. The application should be tested before hole size is specified.

| THREAD SIZE | .030-.090 MAT. THICKNESS | | .091-.124 MAT THICKNESS | | .125-.186 MAT. THICKNESS | | .187-OVER MAT. THICKNESS | |
|-------------|--------------------------|---------|-------------------------|---------|--------------------------|---------|--------------------------|---------|
| | DRILL SIZE | DECIMAL | DRILL SIZE | DECIMAL | DRILL SIZE | DECIMAL | DRILL SIZE | DECIMAL |
| 4-40 UNC | 3/16 | .1875 | #10 | .1935 | #10 | .1935 | #9 | .1960 |
| 6-32 UNC | 7/32 | .2188 | #2 | .2210 | #1 | .2280 | #1 | .2280 |
| 8-32 UNC | 1/4 | .2500 | "F" | .2570 | 17/64 | .2656 | 17/64 | .2656 |
| 10-24 UNC | 9/32 | .2812 | "L" | .2900 | "L" | .2900 | 19/64 | .2969 |
| 10-32 UNF | 9/32 | .2812 | "L" | .2900 | "L" | .2900 | 19/64 | .2969 |
| 1/4-20 UNC | 3/8 | .3750 | 3/8 | .3750 | "V" | .3860 | 25/64 | .3906 |
| 1/4-28 UNC | 3/8 | .3750 | 3/8 | .3750 | "V" | .3860 | 25/64 | .3906 |
| 5/16-18 UNC | 1/2 | .5000 | 1/2 | .5000 | 33/64 | .5156 | 33/64 | .5156 |
| 5/16-24 UNC | 1/2 | .5000 | 1/2 | .5000 | 33/64 | .5156 | 33/64 | .5156 |
| 3/8-16 UNC | 9/16 | .5625 | 9/16 | .5625 | 37/64 | .5781 | 37/64 | .5781 |
| 1/2-13 UNC | 3/4 | .7500 | 49/64 | .7656 | 25/32 | .7810 | 51/64 | .7970 |



| Thread Size | Thread Call Out | HD ±.005 | L ±.015 | D MAX. | IL MAX. | LB ±.015 | ILB MAX. | IATD** MAX. | Hole Depth Min. | Part No. | Price Each |
|-------------|-----------------|----------|---------|--------|---------|----------|----------|-------------|-----------------|-----------|------------|
| 4-40 UNC | 440 | .211 | .370 | .1875 | .205 | .660 | .495 | .395 | .400 | ATS2-440 | --- |
| 6-32 UNC | 632 | .240 | .370 | .2185 | .205 | .675 | .505 | .410 | .400 | ATS2-632 | --- |
| 8-32 UNC | 832 | .269 | .370 | .2495 | .205 | .675 | .505 | .410 | .400 | ATS2-832 | --- |
| 10-24 UNC | 1024 | .306 | .370 | .2805 | .205 | .685 | .520 | .385 | .400 | ATS2-1024 | --- |
| 10-32 UNF | 1032 | .306 | .370 | .2805 | .205 | .685 | .520 | .385 | .400 | ATS2-1032 | --- |
| 1/4-20 UNC | 420 | .400 | .515 | .3745 | .275 | 1.005 | .760 | .615 | .540 | ATS2-420 | --- |
| 1/4-28 UNC | 420 | .400 | .515 | .3745 | .275 | 1.005 | .760 | .615 | .540 | ATS2-428 | --- |
| 5/16-18 UNC | 518 | .528 | .615 | .4995 | .325 | 1.065 | .770 | .630 | .640 | ATS2-518 | --- |
| 5/16-24 UNC | 518 | .528 | .615 | .4995 | .325 | 1.065 | .770 | .630 | .640 | ATS2-524 | --- |
| 3/8-16 UNC | 616 | .588 | .745 | .5615 | .390 | 1.450 | 1.095 | .890 | .770 | ATS2-616 | --- |
| 1/2-13 UNC | 813 | .800 | .935 | .7485 | .485 | NA | NA | NA | .960 | ATS2-813 | --- |

**Dimensions in minimum grip condition. Additional UNF thread sizes available.

AA-112 HI-TORQUE NUTSERT TOOL



The hi-torquer tool is ideal for field and maintenance applications. It features a patented Quick Change thread size nose assembly.

Order one base tool plus appropriate conversion kit. No warranty on these tools.

| Thread Size | Conv. Kit Part No. | Price Each |
|--------------------------------------|--------------------|------------|
| 4-40 UNC | AAT-202-440 | --- |
| 6-32 UNC | AAT-202-632 | --- |
| 8-32 UNC | AAT-202-832 | --- |
| 10-24 UNC | AAT-202-1024 | --- |
| 10-32 UNF | AAT-202-1032 | --- |
| 1/4-20 UNC | AAT-202-420 | --- |
| 1/4-28 UNC | AAT-202-428 | --- |
| 5/16-18 UNC | AAT-202-518 | --- |
| 5/16-24 UNC | AAT-202-524 | --- |
| 3/8-16 UNC | AAT-202-616 | --- |
| Base tool, P/N AA-112.....--- | | |

AAT916 EXPENDABLE NUTSERT TOOLS



These expendable tools are ideal for applications such as field repair. They

can also be packaged with instructions for use along with quantity of inserts for consumer assembly. Sizes 6-32, 8-32 include a hex key. Sizes 10-32, and larger require a wrench (not included). No warranty on these tools.

| THREAD SIZE | TOOL PART NUMBER | Price Each |
|-------------|------------------|------------|
| 4-40 UNC | AAT-916-440 | --- |
| 6-32 UNC | AAT-916-632 | --- |
| 8-32 UNC | AAT-916-832 | --- |
| 10-24 UNC | AAT-916-1024 | --- |
| 10-32 UNF | AAT-916-1032 | --- |
| 1/4-20 UNC | AAT-916-420 | --- |
| 1/4-28 UNC | AAT-916-428 | --- |
| 5/16-18 UNC | AAT-916-518 | --- |
| 5/16-24 UNC | AAT-916-524 | --- |
| 1/2-13 UNC | AAT-916-813 | --- |
| 3/8-16 UNC | AAT-916-616 | --- |

AAT312A MASTER NUTSERT ASSORTMENT KIT



The A-T Series master assortment kit is ideal for prototype and maintenance repair applications. The rugged hard shell plastic kit contains quantities of the A-T Series Inserts and the AA 112 Hi-torquer tool. It also contains a full compliment of thread size conversion kits and instruction label.

No warranty on these tools.

KIT CONTAINS:

| Thread Size | Qty. | Nutsert Part No. | Conv. Kit |
|---------------------------------|------|------------------|--------------|
| 4-40 UNC | 50 | ATS2-440 | AAT-202-440 |
| 6-32 UNC | 50 | ATS2-632 | AAT-202-632 |
| 8-32 UNC | 50 | ATS2-832 | AAT-202-832 |
| 10-32 UNF | 50 | ATS2-1032 | AAT-202-1032 |
| 1/4-20 UNC | 50 | ATS2-420 | AAT-202-420 |
| 5/16-18 UNC | 50 | ATS2-518 | AAT-202-518 |
| Kit, P/N AAT312A.....--- | | | |

Nutsert available. Sold Each.