

## Application-oriented solutions:

Customised features



Different materials and coatings



Specific anti-rotation head



Special thread requirements



- In-house R&D and technical support for specific applications



Dejond has more than 60 years of experience in developing and manufacturing **Tubtara**® blind rivet nuts. **Tubtara**® has become synonymous with high quality performance, innovation, in-house R&D and technical support. Always one step ahead of industry demand.

**Tubtara**® blind rivet nuts can be tailor-made in accordance with your specifications and to suit the demands of almost every application. Our in-house R&D engineers always strive to manufacture the best possible blind rivet nut fit. These customised solutions offer additional features to the standard **Tubtara**® such as increased torque-to-turn, sealing, controlled deformation, integration into parent material, centering, pressure spread, compatibility with other fasteners or tools, special thread requirements etc. The Tubtara's designed for the latest aerospace programmes for instance are used in composite material and aluminium structures on wing parts and seats.

Besides blind rivet nuts, Dejond also concentrates on cold forming selected parts according to customers' drawings for very specific applications.

For a detailed summary, visit [www.tubtara.com](http://www.tubtara.com) and click on 'customised solutions'.



Our brochure on customised solutions  
available in different languages



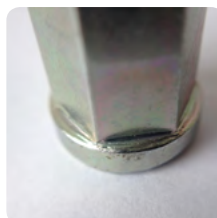
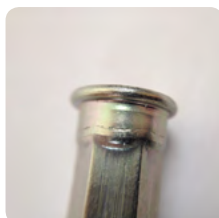
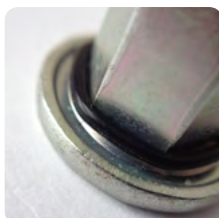
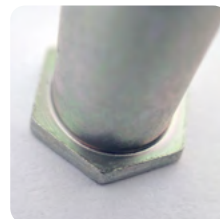
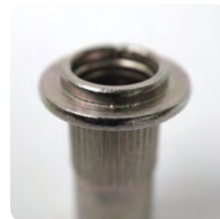
Please take the following into consideration when ordering custom-made rivet nuts:

- Give us an accurate description of the application.
- If possible, include a drawing with indication of sizes, tolerances, material type and exact sheet thickness (incl. tolerances).
- Tell us about other special features or important remarks we need to know.
- If possible, provide us with a sample of the application and/or existing fastener solution.
- Indicate any special technical requirements such as torque value, mount load, tensile or thread strength, etc..
- Specify which type of setting equipment will be used.

Our R&D people will evaluate your request and our Sales Department will provide you with information.

Some examples of additional features providing innovative solutions for your problems:

- Increased torque-to-turn / spin-out resistance
- Spacer function
- Controlled deformation
- (Full) integration into parent material (e.g. composites)
- Flush installation
- Seal function
- Visual identification
- Centering
- Search function (for automatic installation)
- Pressure spread
- Facilitate field repair (increased torque-to-turn resistance)
- Compatibility with available fasteners
- Compatibility with available tools
- Drip / dry function (paint, oil, ...)
- Blind installation / limited space
- Special thread requirements
- (Electrical) conductivity
- Increased push-out force
- Increased pull-out force (thread strength)
- Anti-vibration
- Customised grip (range)





## Stainless Steel A5 & A6

Standard shank versions  
Standard head types  
Open or closed end  
1st and 2nd grips

superior corrosion  
protection

## Cold formed Tubtara® in high alloy austenitic stainless steel A5 and A6



### ● Material

Stainless steel A5 : 316 Ti – WNr 1.4571  
Stainless steel A6 : 904L – WNr 1.4539

### ● Applications

- extremely demanding, chloride bearing applications where even A4 fasteners in stainless 316 offer insufficient corrosion protection
- A6 grade is also armoured against strong acid bearing environments
- civil engineering, tunnel infrastructures, ceiling panels in swimming pools etc.

### ● Important advantages

- Superior corrosion protection, mainly thanks to considerable nickel and molybdenum content
- A6 guarantees increased protection against pitting and crevice corrosion, reaching a PRE (pitting resistance equivalent) value of 35 (compared to PRE 25 for stainless 316)

### ● Samples

Following samples available from stock: stainless A6 M6 UPO 30 – stainless A5 M8 UPO30 / M8 UPO 65 / M8 UFO 45 / M8 UFO 65 / M8 UFX 45 / M8 UKO 30 / M8 HUKO 30

Development of other dimensions upon request





## Seal Inox® topcoat on stainless steel

Semi-hexagonal or knurled shank  
Standard head types  
Open or closed end  
Different grips

## Seal Inox® topcoat on stainless Tubtara® prevents galling

### ● What is Seal Inox®?

Seal Inox® is a topcoat that makes it easier to assemble stainless steel threaded parts. The integrated lubricant additive in this topcoat prevents gripping during assembly, also called 'galling'.

Galling is caused by adhesion of two sliding surfaces under increased friction and often occurs between stainless steel threaded connections.

Characteristics :

- thin dry layer
- can be applied in single or two layers [to avoid any assembly problem, we recommend to use a (hex) hole tolerance of 0.05 - 0.15 mm instead of 0 - 0.1 mm]
- visually distinguishable grey treatment, other colours on request
- friction coefficient 0.09 – 0.14 (according to DIN EN ISO 16047)
- temperature resistance 180°C
- conforms to ELV and RoHS, Cr<sup>6+</sup> free

### ● Benefits of a Seal Inox® topcoat on stainless Tubtara® blind rivet nuts

- reduces friction and prevents galling
- provides a higher clamping force
- reduces assembly time
- slows down contact corrosion
- protects against various chemicals e.g. chlorides, acids and oils
- can be applied on our different stainless steel qualities: 304, 316, 316Ti, 904L
- is preferentially applied on hexagonal or knurled Tubtara's since Seal Inox® will be present on both inside and outside surfaces, thus potentially reducing torque-to-turn for round Tubtara's

Galling between a stainless bolt or screw and a stainless Tubtara® can occur when the assembly is done with a power tool (often at high speeds), but also when the bolt or screw is assembled and tightened by hand.

### ● Availability

Seal Inox® is only applied to order (non-standard).  
Prices and lead times available on request.



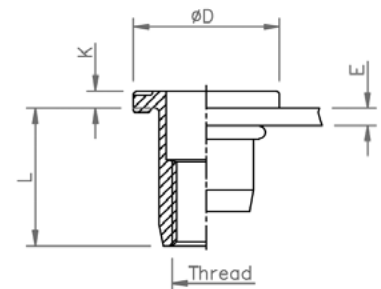
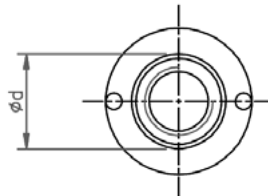
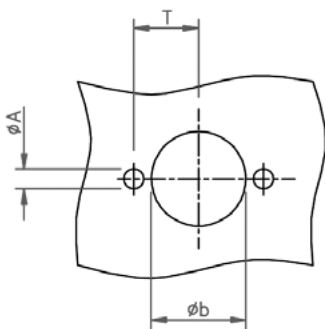


## Stainless Steel 304

Round shank  
Anti-turn head  
Open end

ATO

easy repair solution:  
extra high  
torque-to-turn values



THREAD	TYPE	E = grip	L	b <sup>+0,1</sup> = drill dia	d = shank dia	D	K	A	T	kg/1000	ORDER CODE	BOX Small	BOX Large
M6	ATO30	0,5-3,0	14,5	9,0	9,0	14,0	1,5	1,8	6,25	-	-	-	-
M8	ATO30	0,5-3,0	16,0	11,0	11,0	17,0	2,0	2,3	7,50	7,4	548 1010*	-	1200
	ATO55	3,0-5,5	18,5							7,8	548 1020*	-	1000
M10	ATO35	0,8-3,5	21,0	13,0	13,0	19,0	2,0	3,0	8,75	11,3	540 1600*	-	750

Tool to position Ø A:

M6	AT 206*
M8	AT 208*
M10	AT 210*



Small box: only for DFS customers, not export - (xxx) handling cost can be charged

Samples available from stock

\* **Non-stock item:** minimum order quantity required after depletion of stock

All dimensions in mm - Technical data subject to modification  
Tolerances and characteristics see chapter 'Technical Information'





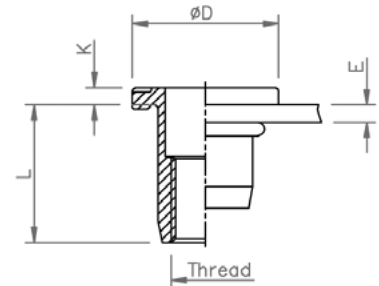
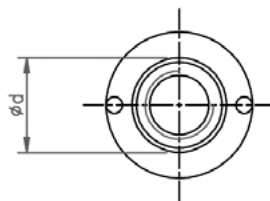
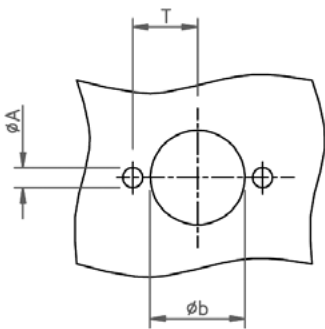
## Steel

Round shank  
Anti-turn head  
Open end

Zinktop 480h, Cr<sup>VI</sup> - free

ATO

easy repair solution:  
extra high  
torque-to-turn values



THREAD	TYPE	E = grip	L	b <sup>+0,1</sup> = drill dia	d = shank dia	D	K	A	T	kg/1000	ORDER CODE	BOX Small	BOX Large
M6	ATO30	0,5-3,0	14,5	9,0	9,0	14,0	1,5	1,8	6,25	4,6	526 1029*	-	1750
M8	ATO30	0,5-3,0	16,0	11,0	11,0	17,0	2,0	2,3	7,5	7,4	528 1022*	-	1200
M10	ATO35	0,8-3,5	21,0	13,0	13,0	19,0	2,0	3,0	8,75	11,4	520 1609*	-	750

Tool to position Ø A:

M6	AT 206*
M8	AT 208*
M10	AT 210*



Small box: only for DFS customers, not export - (xxx) handling cost can be charged

Samples available from stock

\* **Non-stock item:** minimum order quantity required after depletion of stock

All dimensions in mm - Technical data subject to modification  
Tolerances and characteristics see chapter 'Technical Information'

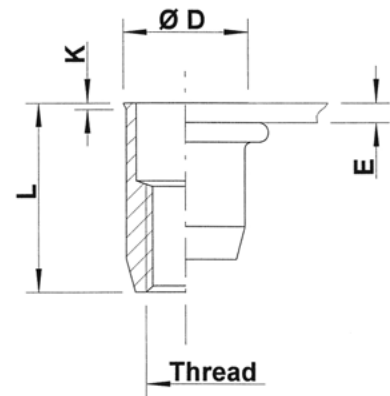
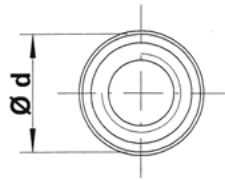
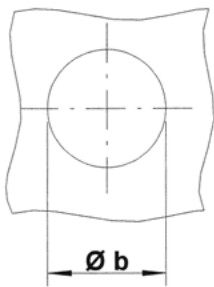




## Stainless Steel 304

Round shank  
Low profile head  
Open end

UKO  
UNIFIED THREAD



THREAD	TYPE	E = grip	L	b <sup>+0,1</sup> = drill dia	d = shank dia	D	K	kg/1000	ORDER CODE	BOX Large
10-32 UNF	UKO30	0,5-3,0	12,0	7,0	7,0	7,5	0,5	1,5	549 500	5000
1/4-20 UNC	UKO30	0,5-3,0	14,5	9,0	9,0	9,5	0,5	3,4	547 660	3000
5/16-18 UNC	UKO30	0,5-3,0	16,0	11,0	11,0	11,5	0,5	5,0	547 830	2000

All dimensions in mm

THREAD	TYPE	E = grip	L	b <sup>+0.004</sup> = drill dia	d = shank dia	D	K	lbs/1000	ORDER CODE	BOX Large
10-32 UNF	UKO30	.020-.118	0.472	0.276	0.276	0.295	.020	3.30	549 500	5000
1/4-20 UNC	UKO30	.020-.118	0.571	0.354	0.354	0.374	.020	7.49	547 660	3000
5/16-18 UNC	UKO30	.020-.118	0.630	0.433	0.433	0.453	.020	11.00	547 830	2000

All dimensions in inches - Technical data subject to modification  
Tolerances and characteristics see chapter 'Technical Information'



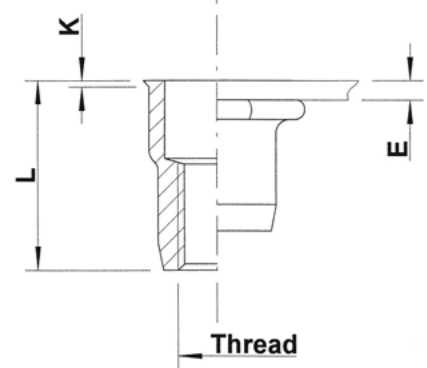
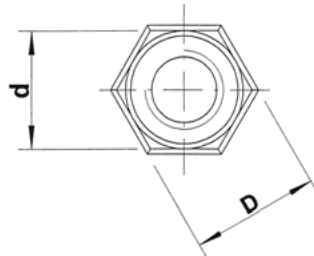
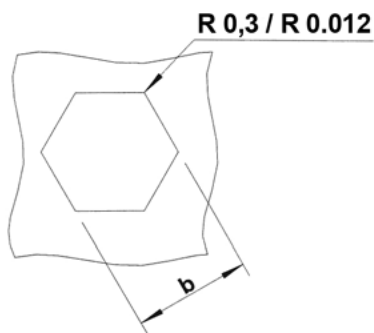




## Stainless Steel 304

Semi-hexagonal shank  
Low profile head  
Open end

**HUKO  
UNIFIED THREAD**



THREAD	TYPE	E = grip	L	b <sup>+0,1</sup> = hex hole	d = hex shank	D = hex head	K	kg/1000	ORDER CODE	BOX Large
10-32 UNF	HUKO30	0,5-3,0	12,0	7,0	7,0	7,5	0,5	1,5	549 530	5000
1/4-20 UNC	HUKO30	0,5-3,0	14,5	9,0	9,0	9,7	0,5	3,3	547 690	3000
5/16-18 UNC	HUKO30	0,5-3,0	16,0	11,0	11,0	11,8	0,5	4,9	547 850	2000

All dimensions in mm

THREAD	TYPE	E = grip	L	b <sup>+0,004</sup> = hex hole	d = hex shank	D = hex head	K	lbs/1000	ORDER CODE	BOX Large
10-32 UNF	HUKO30	.020-.118	0.472	0.276	0.276	0.295	.020	3.30	549 530	5000
1/4-20 UNC	HUKO30	.020-.118	0.571	0.354	0.354	0.382	.020	7.27	547 690	3000
5/16-18 UNC	HUKO30	.020-.118	0.630	0.433	0.433	0.465	.020	10.79	547 850	2000

All dimensions in inches - Technical data subject to modification  
Tolerances and characteristics see chapter 'Technical Information'

