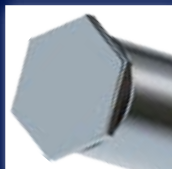


**PRODUCT PROFILE No. 9**

**FASTENERS**  
— FOR —  
**SHEET METAL**



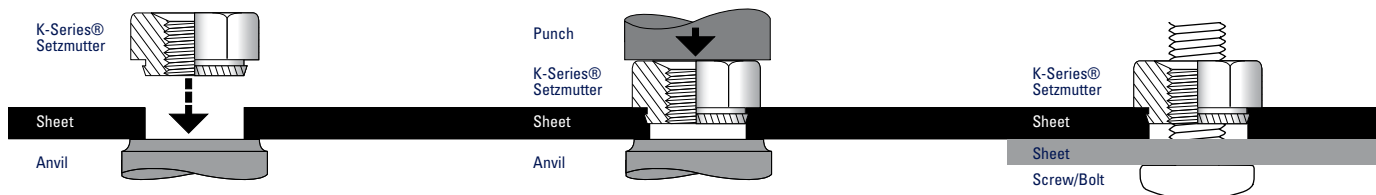
**Lancaster Fastener Co Ltd**  
Threadforming Screw Specialists





## K-Series® Setzmutter (Press Nuts)

K-Series® Setzmutter offer a permanent female thread in sheet steel and in some plastic applications that are too thin to be tapped by conventional methods. Designed specifically for use in applications with a minimum sheet thickness of 1mm, K-Series® Setzmutter, when installed, offer a female thread for attaching equivalent metric externally threaded fasteners. K-Series® Setzmutter can be easily installed into the parent material without the need for specialist tooling. When inserted the underhead shank serrations provide a permanent thread with a high prevailing torque and a resistance to turning.



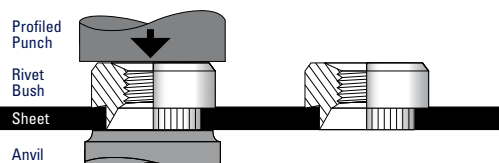
Prior to installation the K-Series® Setzmutter must be aligned squarely with the pre-drilled or pre-pressed hole in the host material.

Ideally using a punch the K-Series® Setzmutter is pressed into the host material. As the nut rotates it bites into the wall of the sheet causing the host material to flow around the spigot of the nut. The slanted serrations provide a secure fit with a strong resistance to rotation.

When the K-Series® Setzmutter has been installed an externally threaded fastener can be used to join the two materials together. The K-Series® Setzmutter is secured from the serrated side.

## Rivet Bushes

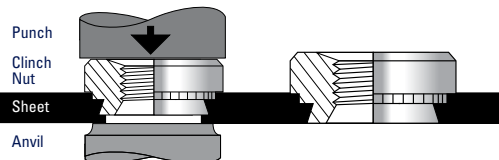
Rivet Bushes offer a permanent thread in sheet steel and plastics that are too thin to be tapped by conventional methods; they can be installed into panels as thin as 0.5mm. They may also be suitable for installation in stainless steel applications.



Rivet Bushes can be installed using a variety of methods, ideally a press incorporating a profile punch. However, they can be installed using a simple hammer and ball bearing.

## Self-Clinching Fasteners

Self-Clinching Fasteners are used when good pull out and torque loads are required in sheet metal that is too thin to be tapped by conventional methods. When correctly installed, Self-Clinching Fasteners are prevented from rotating in the host material and become a permanent part of the application. Whilst taking up less space and requiring fewer assembly operations, they also have greater reusability and more holding power than sheet metal screws.



Self Clinching fasteners must be squeezed into place by applying a constant squeezing action and not a blow (or trauma) type force. In short, an automated press of some type must be used for installation.

## CD Weld Studs

Capacitor Discharge (CD) stud welding is used to weld small diameter studs to thin base materials such as mild steel, stainless steel or aluminium.

The capacitor discharge welding process operates on the principle that the energy stored in a capacitor battery is discharged within between 1 and 3 milliseconds through the ignition pip of the part being welded. In view of the fact that the welding process is completed instantaneously, welds can be made without evident distortion, burn-through or reverse side discolouration. CD stud welding eliminates secondary operations by removing the need for pre-drilled or pre-tapped holes and can also reduce costs through offering savings to labour and material expenditure.

K-Series® & CASTLE® are registered trade marks of Lancaster Fastener Co Ltd.



## K-Series® Setzmuttern (Press Nuts)



Popular sizes of K-Series® Setzmuttern are offered in 20kg bulk carton quantities at reduced prices as part of Lancaster's **CASTLE®** range.

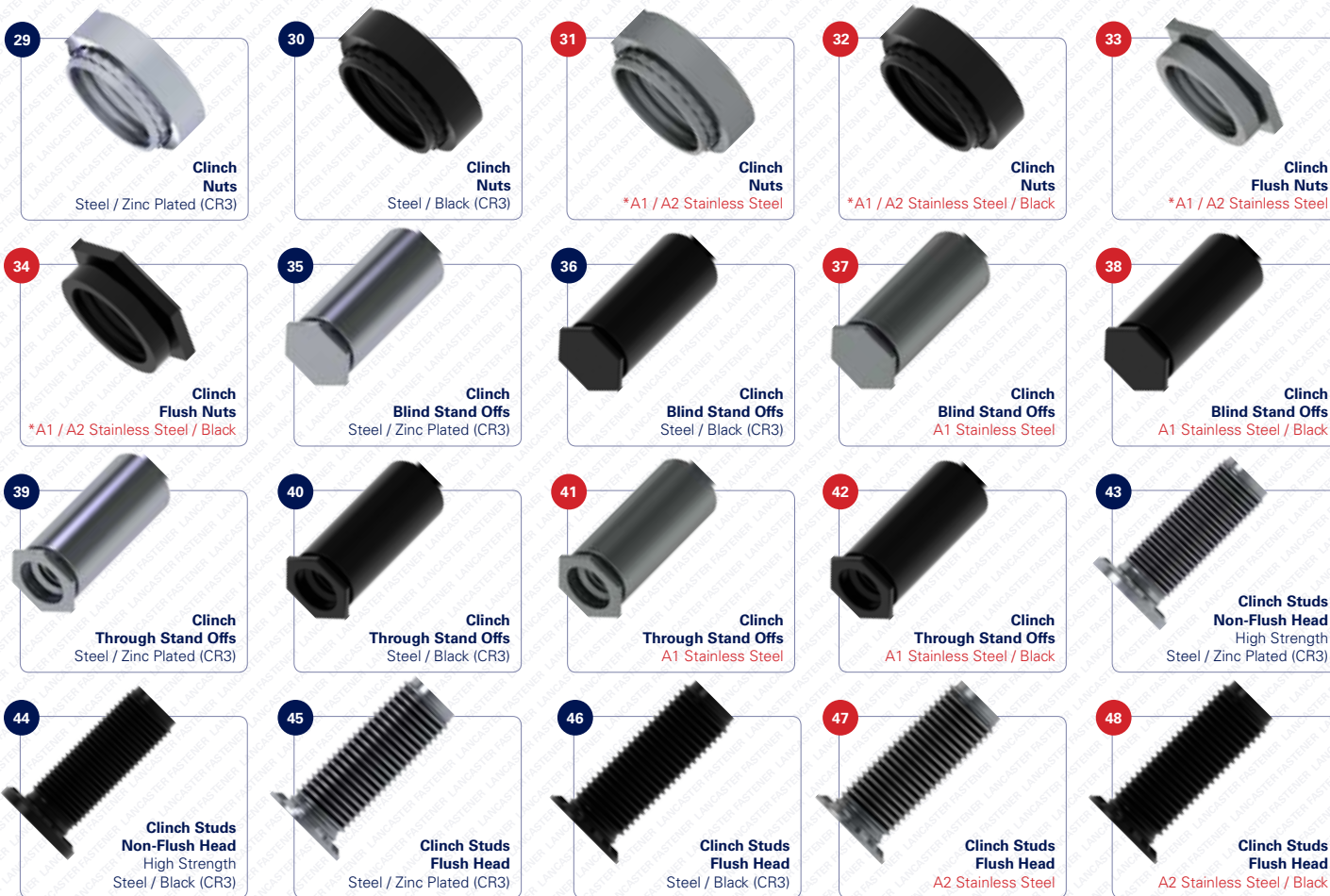


## Rivet Bushes



\* Grade depends on method of manufacture.

## Self-Clinching Fasteners



## CD Weld Studs



[www.lancasterfastener.com](http://www.lancasterfastener.com)

"Visit Lancaster's website for more detailed product information including size ranges, weights per 1000, bulk & small box quantities and comprehensive technical data."

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\* Grade depends on method of manufacture.



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A  
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