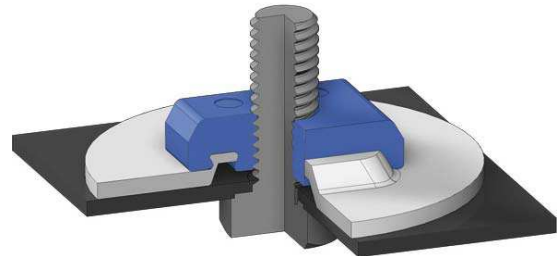
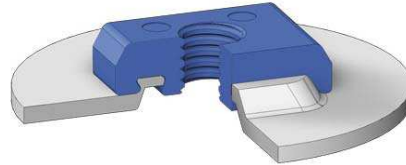
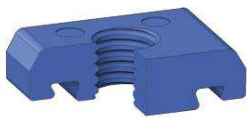
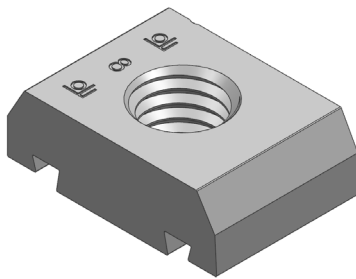


## Rectangular nut, „high integrated“

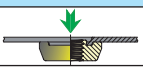
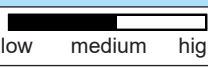
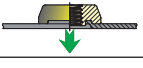
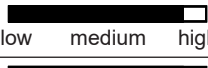




- For single-stage processing and moderate loading cases.



### Technical features

- Thread sizes M6 - M8.
- Pierce nut can be universally used for various sheet metal thicknesses up to 1.75 mm.
- High clamping forces.
- High resistance to twist forces, even for thin sheet metal.

Mechanical properties		
Push out force		
Pull through force		
Torque*		
Tensile strength of the base material to be processed		Class 8 up to 900 MPa Class 10 up to 1200 MPa
Suitable for alternative materials		Yes
Suitable for repair work		Yes

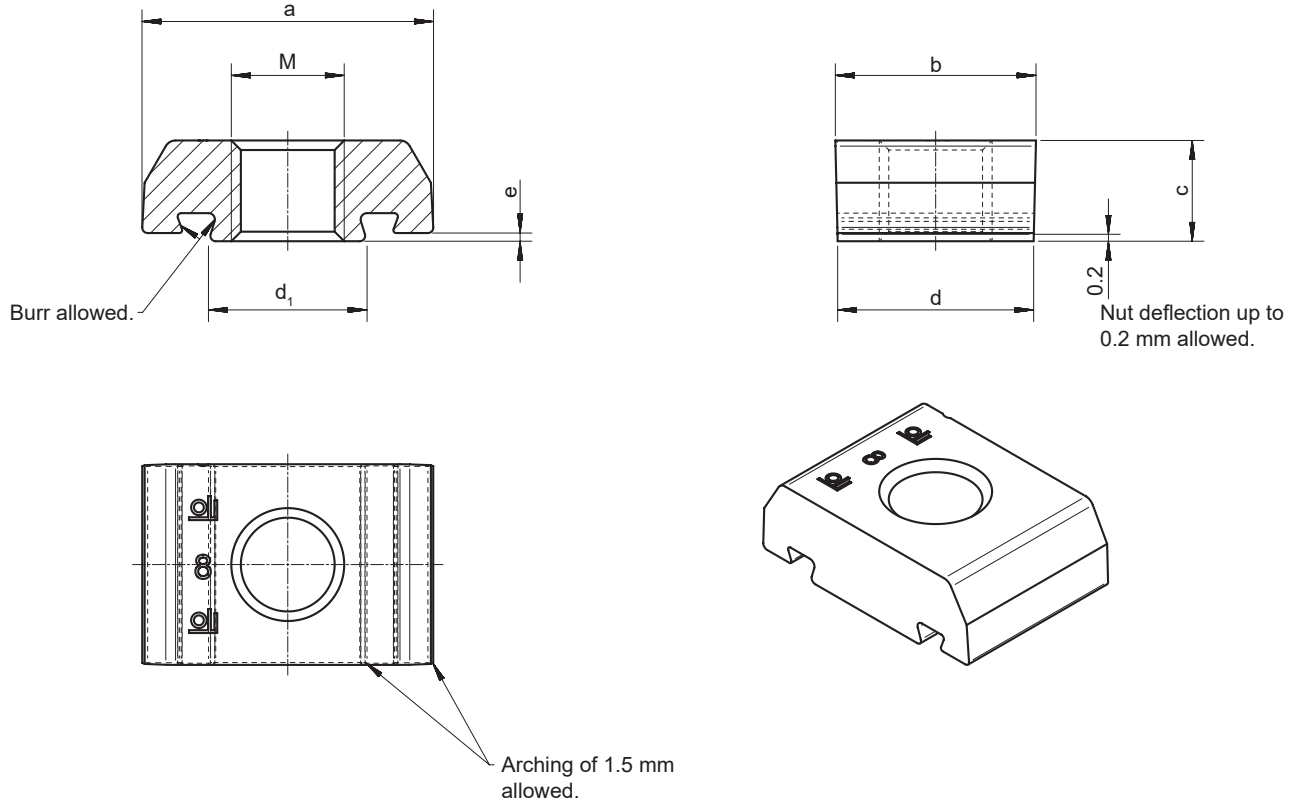
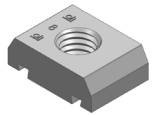
Nut size		Smallest sheet thickness	Largest sheet thickness
M6	HIP-12	0.80 mm	1.75 mm
M8	HIP-22	0.80 mm	1.75 mm

It may be possible to use HIP pierce nut for sheet-metal thicknesses lying outside the thickness range specified above. Please contact PROFIL to clarify the usage possibilities.

\*See PN-HIP 01.2 for information on recommended tightening torques

Information on processing	Processing direction	From above	Yes
		From below	Yes
		Angular position possible via wedge slide**	Yes
	Sheet preparation	Pre-form	No
		Pre-pierce	No
	Processing	Self piercing	Yes
Clinching		Yes	
Riveting		No	

\*\*Not included in PROFIL's scope of delivery. No designing of the wedge slide by PROFIL.



Thread DIN 13 M	Nut size	Sheet thickness [mm]	Nut			Guiding width		height e ±0.05 [mm]	Distance i [mm]
			length a ±0.13 [mm]	width b -0.25 [mm]	height c ±0.08 [mm]	d ±0.13 [mm]	d <sub>1</sub> ±0.13 [mm]		
M6	HIP-12	0.80 - 1.75	18.03	11.61	5.21	11.35	9.35	0.64	>0.10
M8	HIP-22		20.62	14.22	7.14	13.89	10.97		

The fixed dimensions and requirements are valid for nut processing in cold-rolled steel. The steel must be corresponding with technical delivery terms and quality in EN 10 130. Should the characteristics of the sheet quality like strength (e.g. high-strength panel) or material (e.g. Aluminium, Sandwich-panels) differ from these specifications and standards, the form of the hole or its diameter possibly need to be adjusted in order to create an optimum joint between the nut and the sheet. In this case please contact PROFIL.

Standard condition at delivery:

- Property class 8 acc. DIN EN ISO 898-2
- Uncoated (bare) surface
- Thread tolerance 6G

Other specifications as agreed.

Inspection characteristics for series production must be agreed with PROFIL and established by a drawing exchanged and confirmed by both.

The processing establishment is responsible for the monitoring and the qualitative assessment of this riveting process.

## PROFIL Verbindungstechnik

GmbH & Co. KG

Otto-Hahn-Straße 22 - 24

D-61381 Friedrichsdorf

Tel.: +49 (0) 61 75 / 79 90

Fax: +49 (0) 61 75 / 77 94

E-Mail: [info@PROFIL.eu](mailto:info@PROFIL.eu)

Internet: [www.PROFIL.eu](http://www.PROFIL.eu)



## PROFIL (UK) Ltd.

Unit 11 Melchett Road

Kings Norton

Birmingham B30 3HG

Phone: +44 (0) 121 389 8332

E-mail: [profil-uk@profil.eu](mailto:profil-uk@profil.eu)

Internet: [www.PROFIL.eu](http://www.PROFIL.eu)



## PROFIL System Inc.

24415 Halsted Road

Farmington Hills, MI 48335

USA

Phone: +1 248 53 62 130

E-mail: [info@profil.us](mailto:info@profil.us)

Internet: [www.PROFIL.eu](http://www.PROFIL.eu)

