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 nuthead. The installation torque can be determined by consulting the clinch nut manufacturer or manufacturer's guide, or by testing in your application.

Step 2: Noting the torque requirement for your fastener, refer to the Power Unit Selection Guide below to determine the approximate 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 on-off air pressure regulator. For additional performance and feature specifications, refer to the power unit specifications found on the back of this brochure.

Step 3: After selecting the appropriate power unit, refer to the Head Assembly Selection Chart above. Select the clinch nut assembly that best meets the needs of the application. The chart provides the recommended head styles for both the clinch nut (female threads) and the 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 clinch nut would be undesirable.

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

Example: SCN3R420

- SCN indicates the Clinch Nut Power Unit
- 3R indicates 3/8-16 thread size
- 4F indicates 4F-20 torque range

Note: 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:

Example: SCNR100

- SCNR indicates the Power Unit
- 100 indicates the Model Number

SIOUX TOOLS SIGNATURE SERIES PRODUCT BROCHURE

SIOUX TOOLS SIGNATURE SERIES PRODUCT BROCHURE
### 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 manufacturer’s 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.

**Step 3:** After selecting the appropriate power unit, refer to the Head Assembly Selection Chart below. Determine the clinch nut assemblyuffix by scrolling 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.

**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:

#### Power Unit Selection Guide

<table>
<thead>
<tr>
<th>Thread Size</th>
<th>Power Unit Torque Range</th>
<th>Model Number</th>
<th>Gear Ratio</th>
<th>Speed</th>
<th>Maximum Air Consumption</th>
<th>Free Speed</th>
<th>Sound Level</th>
<th>Center Diameter</th>
<th>A Dimension</th>
<th>B Dimension</th>
<th>F dimension</th>
<th>L Dimension</th>
<th>Notes</th>
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<tbody>
<tr>
<td>M10 x 1.5</td>
<td>3/8-16 616 616S</td>
<td>SCN25R</td>
<td>13</td>
<td>1750</td>
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<td>254</td>
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<td>14.2</td>
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<td>14.2</td>
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<td>SCN7R</td>
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<td>80</td>
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<tr>
<td>M6 x 1.0</td>
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<td>8000</td>
<td>80</td>
<td>254</td>
<td>0.8</td>
<td>20</td>
<td>30</td>
<td>7.2</td>
<td>80</td>
<td>279</td>
<td>14.2</td>
</tr>
<tr>
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<td>SCN3R</td>
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<td>80</td>
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**Clinch Nut Power Unit**

<table>
<thead>
<tr>
<th>Order Number Suffix</th>
<th>Smooth Nose</th>
<th>Serrated Nose</th>
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<tr>
<td>SCN25F</td>
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<tr>
<td>SCN12F</td>
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<td>SCN7SF</td>
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<tr>
<td>SCN5F</td>
<td>SCN5SF</td>
<td></td>
</tr>
<tr>
<td>SCN3F</td>
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**Clinch Stud (Male)**

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<td>M8 x 1.25</td>
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<td>M5 x 0.8</td>
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<tr>
<td>M4 x 0.7</td>
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</tr>
<tr>
<td>#6-32</td>
<td>SCN3F</td>
</tr>
<tr>
<td>#8-32</td>
<td>832S</td>
</tr>
<tr>
<td>#10-24</td>
<td>1024S</td>
</tr>
<tr>
<td>#10-32</td>
<td>1032S</td>
</tr>
<tr>
<td>#12-28</td>
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**Clinch Nut (Female)**

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<th>Order Number Suffix</th>
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</thead>
<tbody>
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</tr>
<tr>
<td>M8 x 1.25</td>
<td>SCN20F</td>
</tr>
<tr>
<td>M6 x 1.0</td>
<td>SCN12F</td>
</tr>
<tr>
<td>M5 x 0.8</td>
<td>SCN7F</td>
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<tr>
<td>M4 x 0.7</td>
<td>SCN5F</td>
</tr>
<tr>
<td>#8-32</td>
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<td>#10-24</td>
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<td>1032S</td>
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<td>1232S</td>
</tr>
<tr>
<td>M3 x 0.5</td>
<td>#10-20</td>
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**For the menu price**

**Distributed by:**

**Sioux Tools Signature Series Product Brochure**

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**Tool Order Number Example:** SCN9R420

---

**Order Number Suffix**

<table>
<thead>
<tr>
<th>Smooth Nose</th>
<th>Serrated Nose</th>
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</thead>
<tbody>
<tr>
<td>SCN25F</td>
<td>SCN25SF</td>
</tr>
<tr>
<td>SCN20F</td>
<td>SCN20SF</td>
</tr>
<tr>
<td>SCN12F</td>
<td>SCN12SF</td>
</tr>
<tr>
<td>SCN7F</td>
<td>SCN7SF</td>
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<tr>
<td>SCN5F</td>
<td>SCN5SF</td>
</tr>
<tr>
<td>SCN3F</td>
<td>SCN3SF</td>
</tr>
</tbody>
</table>

---

**Pistol Grip - Rapid Reverse - Power Units Specifications**

**Order Number:**

- SCN25R
- SCN20R
- SCN12R
- SCN7R
- SCN5R
- SCN3R

**Model Number:**

- 2500
- 2000
- 1200
- 700
- 500
- 300

**Speed:**

- 13 rpm (254 mm/s)
- 22 rpm (254 mm/s)
- 33 rpm (254 mm/s)
- 45 rpm (254 mm/s)
- 65 rpm (254 mm/s)

**Maximum Air Consumption:**

- 80 l/s
- 56 l/s
- 32 l/s
- 23 l/s
- 16 l/s
- 11 l/s

**Sound Level:**

- 14.2 dB(A)
- 19.6 dB(A)
- 23 dB(A)
- 26 dB(A)
- 28.6 dB(A)
- 30.8 dB(A)

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**Parts list • Safety and Instruction manual**

**Standard Equipment:**

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

---

**Contact Information**

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**United Kingdom**

Tel.: 00 44 (0) 1536-413904
Fax: 00 39 02 61 29 78 15
Email: industrialuk@snapon.com
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 the material 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.

**Clutch Nut Installation Procedure**

1. **Step 1:** Drill hole for fastener.
2. **Step 2:** Insert fastener.
3. **Step 3:** Thread tool into fastener.
4. **Step 4:** Run tool to collapse fastener. Reverse tool to release.
5. **Step 5:** Assemble.

**Features**

- **Versatility:** Optional smooth or serrated nose capable of installing clinch nut or stud fasteners.
- **Rapid Reverse:** Allows fast release from fastener.
- **Grease Fittings:** Allow lubrication to the gear train and front thrust bearing for reduced wear and increased life.
- **Innovative Design:** Comfortable trigger with teasing capability for greater control and accuracy.
- **Wrenchless Head:** Makes it easy and quick to change size and style.
- **Low Noise Level:** 80 dB(A) sound level means quieter operation while the down-handle exhaust directs air away from the operator creating a safer working environment.
- **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.

**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 the material 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.

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**Quality You Count On…**

**Performance You Depend On!**

### Features

- **Versatility**
  - Optional smooth or serrated nose capable of installing clinch nut or stud fasteners

- **Wrenchless Head**
  - Makes it easy and quick to change size and style

- **Rapid Reverse**
  - Allows fast release from fastener

- **Grease Fittings**
  - Allow lubrication to the gear train and front thrust bearing for reduced wear and increased life

- **Innovative Design**
  - Comfortable trigger with teasing capability for greater control and accuracy

- **Low Noise Level**
  - 80 dB(A) sound level means quieter operation while the down-handle exhaust directs air away from the operator creating a safer working environment

- **Large Thurst Bearing**
  - Increases load carrying capacity for longer life

- **Rapid Reverse**
  - Allows fast release from fastener

- **Wrenchless Head**
  - Makes it easy and quick to change size and style

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### Clinch Nut Installation Procedure

1. **Step 1:** Pre-drill hole for fastener.
2. **Step 2:** Insert fastener.
3. **Step 3:** Thread tool into fastener.
4. **Step 4:** Run tool to collapse fastener. Reverse tool to release.
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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.

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**Features**

- **Versatility**
  - Optional smooth or serrated nose capable of installing clinch nut or stud fasteners

- **Rapid Reverse**
  - Allows fast release from fastener

- **Wrenchless Head**
  - Makes it easy and quick to change size and style

- **Grease Fittings**
  - Allow lubrication to the gear train and front thrust bearing for reduced wear and increased life

- **Innovative Design**
  - Comfortable trigger with teasing capability for greater control and accuracy

- **Low Noise Level**
  - 80 dB(A) sound level means quieter operation while the down-handle exhaust directs air away from the operator creating a safer working environment

- **Designed for Comfort**
  - Ergonomically designed pistol housing provides extreme comfort, superb balance and precise control

**Clinch Nut Installation Procedure**

1. **Step 1:** Pre-drill hole for fastener.
2. **Step 2:** Insert fastener.
3. **Step 3:** Thread tool into fastener.
4. **Step 4:** Run tool to collapse fastener. Reverse tool to release.
5. **Step 5:** Assemble.

**Soldiers**

- Male Threaded Output Spindle
  - For installing clinch nuts
- Female Threaded Output Spindle
  - For installing clinch studs

**The SCN series clinch nut tools offers some great features:**

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- 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.
Clutch Nut Power Unit

<table>
<thead>
<tr>
<th>Model Number</th>
<th>Free Speed</th>
<th>Maximum Torque</th>
<th>Weight</th>
<th>&quot;A&quot; Dimension</th>
<th>Side To Center</th>
<th>Maximum Air Consumption</th>
<th>Sound Level</th>
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<tr>
<td></td>
<td>mm</td>
<td>in. lb</td>
<td>Nm</td>
<td>lb</td>
<td>in. mm</td>
<td>cfm</td>
<td>l/s</td>
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<td>420</td>
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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

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