

# TUBTARA®

## Blind rivet nuts

Available from **MARYLAND METRICS**

P.O. Box 261 Owings Mills, MD 21117 USA

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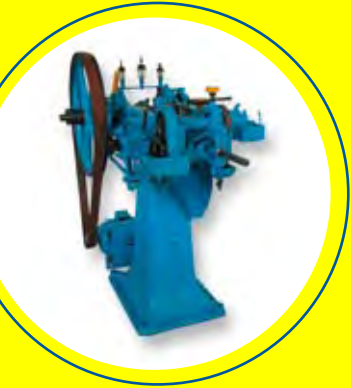


TUBTARA® - your reliable connection



**1901** Foundation of the company by the family Dejong

**1938** Dejong starts to manufacture solid rivets



**1954** Launch of the TUBTARA® blind rivet nut

**1966** Dejong becomes one of the first European manufacturers producing cold formed blind rivet nuts

**1989** The first stainless steel blind rivet nuts are coldformed

**1996** ISO 9002 accreditation by BVQI (Bureau Veritas)

**2000** Opening of an extension to the production facility

**2002** ISO 9001/2000 accreditation by BVQI (Bureau Veritas)

**2004** TUBTARA® celebrates its 50th birthday!

**2005** Launch of the Tubtara® range in stainless steel 316  
Zinktop : Dejong's new Cr<sup>VI</sup>-free surface treatment

**2007** Important investments in the production unit e.g.  
new degreasing and tapping machines

**2008** New heading machine for production of more difficult parts  
First cold formed stainless M10 extends the Tubtara® product range

**2009** Year dedicated to R&D despite the tough  
economical situation worldwide

**2010** Development of the Anti-turn Tubtara®



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## Stainless Steel 304 and 316 High corrosion resistance

**304 316**

Round, flat head, open/closed end	UPO / SPO / UPX / SPX	9-10	20-21
Round, countersunk head, open end	UFO / SFO	11	
Round, low profile head, open/closed end	UKO / SKO / UKX	12-13	22-23
Semi-hexagonal, flat head, open/closed end	HUPO / HUPX	14-15	24-25
Semi-hexagonal, low profile head, open/closed end	HUKO / HUKX	16-17	26-27
Unified thread: round, low profile head, open end	UKO	18	
Unified thread: semi-hexagonal, low profile head, open end	HUKO	19	

## Steel

Round, flat head, open/closed end	UPO / SPO / UPX	28-29	
Round, countersunk head, open/closed end	UFO / UFX	30-31	
Round, low profile head, open/closed end	UKO / UKX	32-33	
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Hexagonal, low profile head, open/closed end	HUKO / HSKO / HUKX	37-38	
Hexagonal, flat head, closed end , with seal under the head	HX	39	
Splined, flat head, open end	UPO RS	40	
Splined, countersunk head, open end	UFO RS	41	

## Aluminium

Round, flat head, open/closed end	UPO / UPX	42-43	
Round, countersunk head, open/closed end	UFO / UFX	44-45	
Round, low profile head, open end	UKO	46	

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## Setting equipment

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## Technical information

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# TUBTARA®

## Dejond: an overview

Started as a small metal stockist in 1901, Dejond turned into a leading and reputed supplier to the industry over the years. Located in Wilrijk (Antwerp), about 100 employees, spread over 4 business units, are dedicated to maintain the long term partnerships with their customers and suppliers around the globe and find new business opportunities.

Core business :

- stockkeeping wholesaler of non-ferrous metals with service center,
- distributor of exclusive architectural and building systems,
- industrial supplier of high quality, value-added mechanical fasteners and fastening systems,
- R&D, production, marketing and sales of Tubtara® blind rivet nuts (Cold Forming Division)

Dejond continuously aims to increase service and customer satisfaction. Considerable investments in all 4 business units over the years should help Dejond to strengthen its position of trendsetter and specialist in new technical developments.

The stylishly renovated building in Antwerp reflects Dejond's clear view for the future: professionalism. Dejond's name stands for high quality products, a multi-industry supply, prompt orderprocessing, on time deliveries and a reliable (aftersales-) service.

Dejond does not only deliver products, it primarily offers a strong customer support.



### ● Dejond: the industrial specialist in fastening technology

On its home market Dejond has become a major player in fastening technology by offering a full range of high quality mechanical fasteners manufactured by different internationally recognized suppliers, including its own Tubtara® blind rivet nut range. It serves the general, automotive and aerospace industries.

Thanks to the regular product trainings at the suppliers, its in house expertise and the continuous search for new products, Dejond's people are able to keep pace with the latest market requirements & trends. In strong partnership with its suppliers, Dejond tries to solve its customers' problems and offer the appropriate product for their specific applications.

**In other words : offer a total quality solution.**

## ● Cold Forming Division

In 1954 Dejong launched its first Tubtara® blind rivet nuts, machined on a lathe. Only 10 years later the production started specializing in cold forming technology. Today Dejong offers one of the widest, cold formed ranges of high quality blind rivet nuts in the world, all manufactured in its ISO 9001/2000 certified production facility in Wilrijk (Belgium).

The Tubtara® programme includes standard and special products in stainless steel 304 & 316, steel and aluminium.

The entire cold forming team is more than ever committed to meet the challenges that lie ahead. By manufacturing in an environmentally friendly way, it tries to minimize the influence of its activities on the environment and create a balance between economical, social and environmental aspects. Together with its focus on R&D, Dejong wants to reach the highest quality ever.

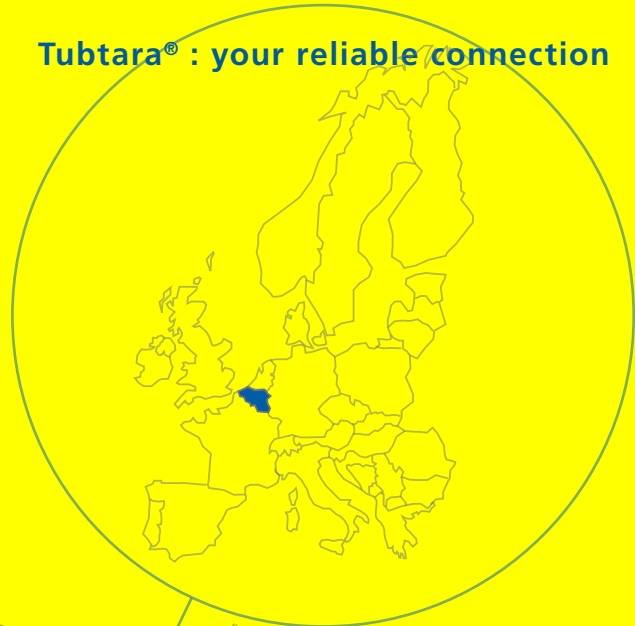
In that respect Dejong's management decided to further uplevel the Tubtara® range by investing in a new, advanced machine-unit. New developments and more difficult parts will gradually be introduced as from 2010.

**Dejong has the ambition to stay at the forefront of the design and manufacture of blind rivet nuts.**

Through short delivery times and a strong technical & commercial support Dejong tries to give its partners-distributors the opportunity to gain new applications worldwide. Thanks to its flexible stock availability and central location near the port of Antwerp and Brussels airport, customers of all continents receive their Tubtara® blind rivet nuts at short notice.



**Tubtara® : your reliable connection**



# TUBTARA®

## ● Blind rivet nuts

A Tubtara® blind rivet nut is a mechanical fastener that ensures a strong thread in a thin sheet and is used in applications where there is little or no access at the rear. It can be used to clinch separate sheets together (acting as a rivet) and allows you to assemble another component with a bolt or screw.

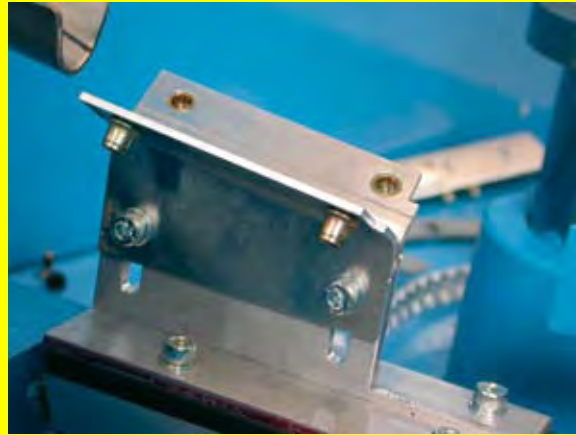
## ● Benefits

- Provides a strong thread in a thin sheet
- Simple blind (one sided) installation
- Fast assembly time
- Low assembly costs : easy installation with 1 single operation of the hand
- Avoids damaging the (pre-coated or - painted) surface of the workpiece
- No deformation of the workpiece
- Low installation cost : no expensive setting tools needed
- Works in close-to-edge applications
- Unloseable after setting
- Appropriate for repeated (re-)assembly

## ● Installation

Installing a Tubtara® blind rivet nut is very simple : screw the Tubtara® on the mandrel of the setting tool, bring it into the hole of the workpiece, pull lengthwise to set the Tubtara® and unscrew the mandrel. For more detailed information on the setting method see pg 50 .

A Tubtara® can be set with a hand- or pneumatic tool, a press or an automatic installation unit.



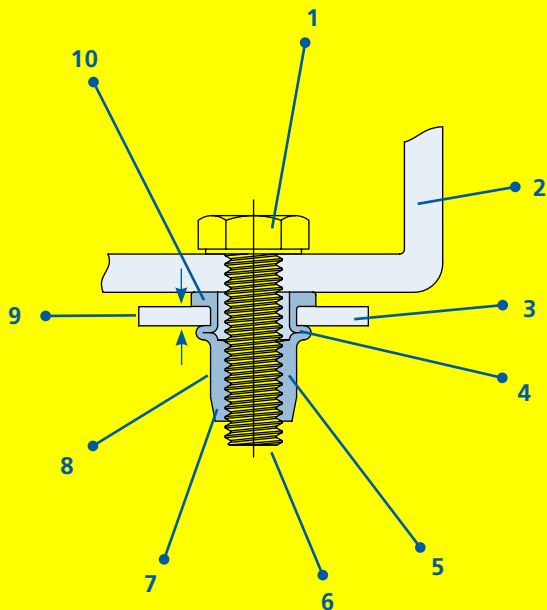
## ● Applications

A Tubtara® is used in all kinds of sheet metal applications. It avoids tapping, welding and working with a bolt and nut. It's a very good solution for enclosed applications that can only be accessed from one side.

Some marketsegments :

- Aerospace
- Automotive
- White Goods
- Electronics
- Metal furniture
- Railways
- Telecom
- Food
- Chemicals
- Lighting
- Marine
- Offshore
- Medical
- Pulp & paper
- etc...

e.g. cabinets, pipes, cable trays, leg levelling, window & door profiles, rails, benches, fences, metal enclosures, heating installations, airconditioning, swimming pools, solar panels etc.



## ● Terminology

1. Screw or bolt inserted for assembly
2. Assembled part
3. Workpiece: can be 1 sheet or several sheets which have to be clinched
4. Bulb or counterhead: the chamber (un-threaded part) of the Tubtara® deformed during setting
5. Strong, secured internal thread of the Tubtara®
6. Open or closed end: closed version minimalizes the ingress of dirt & fluids especially in combination with an underhead seal (see HX-version pg 39)
7. Chamfer: leads the Tubtara® into the hole
8. Shank: round, (semi-)hexagonal or splined version
9. Grip: the exact material thickness of the workpiece
10. Head: flat, countersunk, low profile or watertight head - NEW : anti-turn head

## ● Product Description

Steel	M5	RS	UFO	40
Stainless	M6	H	UKX	30
Aluminium	M8	-	UPO	80
↓	↓	↓	↓	↓
<b>material</b>	<b>thread</b>	<b>shank</b>	<b>head &amp; shank</b>	<b>max grip</b>
		RS: splined	F: countersunk head	
		H: hexagonal	P: flat head	
		- : round	K: low profile head	
			O: open end	
			X: closed end	

## ● How to choose the appropriate Tubtara® ?

- What kind of material and surface treatment do you need?
- What is the required thread size?
- Choose the correct grip range for the required material thickness of the application.
- Choose the required head and shank style.
- Do you need an open or closed version?
- Check the technical characteristics of the chosen Tubtara®.

We advise you to do some tests on the suitable product in the specific application on beforehand. **Samples are available on request.**



# TUBTARA®

## ● Specials

Don't you find the appropriate Tubtara® in this catalogue?

**Do you need a special Tubtara®, tailor-made for your specific application?**

Always take the following into consideration:

- Give us an accurate description of the application.
- Do you have a drawing with indication of sizes, tolerances and exact sheet thickness?
- Are there other special features and important remarks we need to know?
- Can you give us a sample of the application and/or present fastener?
- Do you have special technical requirements like torque value, upset load, tensile or thread strength etc.?
- What type of setting equipment will be used?

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

## ● Anti-rotation solutions

There are different solutions to avoid the risk on rotation and increase the torque-to-turn resistance:

- A Tubtara® with hexagonal shank is a very effective solution against rotation.
- If you have applications in soft material such as plastics or soft aluminium, use our splined Tubtara® versions. When the splines protrude into the sheet during setting, your Tubtara® won't turn into the hole.
- Can you only use or drill round holes? Do you have an application in very hard or slippery material? Use our new Anti-Turn Tubtara® with special anti-turn head and reach the highest torque-to-turn values possible with a round shank (see info pg. 7).



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# TUBTARA®

## ANTI-TURN Tubtara®

Round shank  
Anti-turn flat head  
Open / closed end  
Steel, stainless, aluminium

High torque values  
Easy to prepare  
Easy to install



New Development

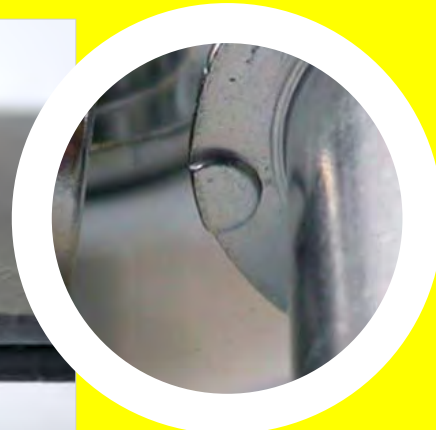
**Torque-to-turn value at least twice as high  
as that of the equivalent round blind rivet nut**

### ● Applications

All applications where hexagonal holes are not allowed or difficult to make

### ● Important advantages

- very effective on slippery surfaces
- no damage of the surface ( ↔ splined blind rivet nuts)
- very effective in hard material ( ↔ splined blind rivet nuts)
- use of standard round holes, so no risk of cracks on the corners ( ↔ hexagonal blind rivet nuts)
- easy to install with a standard setting tool
- no problem to set automatically
- possible to combine different material of nut and sheet ( ↔ welding nuts)



# TUBTARA®

## Blind rivet nuts

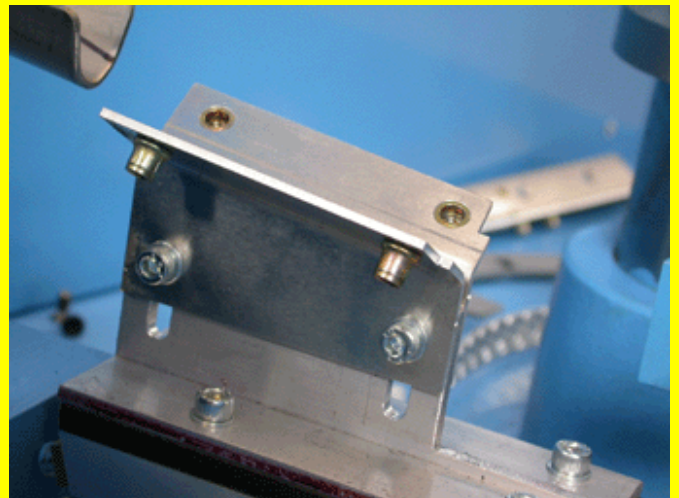
The **TUBTARA®** blind rivet nut ensures a strong thread in a thin sheet and can be used in applications where there is no or little access at the rear.

Not only does the blind rivet nut allow a bolt to be inserted into it, it can also be used to clench separate sheets together therefore acting as a rivet as well.

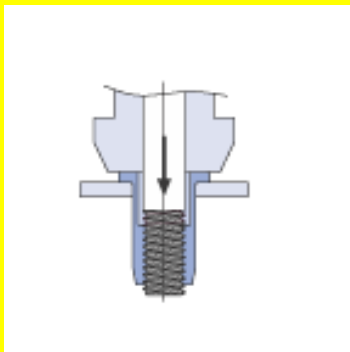


## Benefits

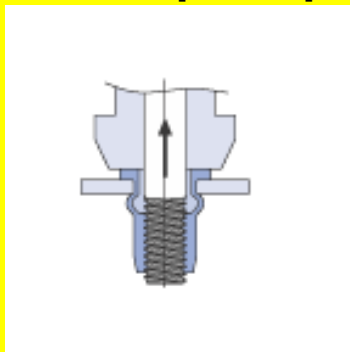
- Simple blind (one sided) installation
- Provides a strong secured thread in a thin sheet
- Fast assembly time
- Avoids damaging the surface
- No deformation of the workpiece



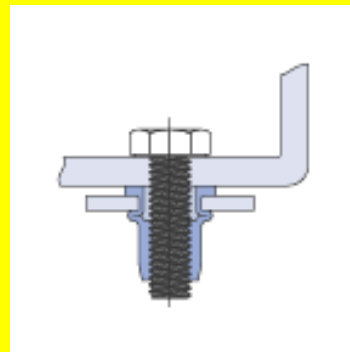
## Installation principle



The TUBTARA® mounted on the setting tool, is brought into the hole of a workpiece from one side.



Then pulled lengthwise, which causes an expansion on the underside of the workpiece to clench the workpiece tightly.



Possibility of subsequent bolt or screw assembly.

## Applications: industries

- Aerospace
- Automotive
- White goods
- Electronics
- Metal furniture
- Railways
- Marine
- Offshore
- Telecom
- Food
- Chemical
- Lighting
- Medical
- Paper
- etc....

### Dejond: Cold Forming Division

**TUBTARA®** blind rivet nuts are produced in house at our ISO 9001 certified production facility located in Antwerp, Belgium.

**Dejond** continues to be at the forefront of the design and manufacture of high quality blind rivet nuts.

**Dejond** is committed to total customer satisfaction and strives to strengthen our partnership with our customers around the world by offering a total quality solution.

