TUF-S / TU-S / TUC-S

1. Pre-drill the panel
Pre-drill using a Ø 6 mm blind-hole drill with depth stop

The geometry of the drill hole shall be checked minimum on 1% of all drillings. Nominal measure: Ø 5,9 – 6,0 mm

1.1 Use a blind-hole drill bit
1.2 Do not use a drill bit with a point angle
1.3 Do not use a worn-out drill bit

1.4 Panel must lie on a hard surface

1.5 Keep a right angle during the drill process

1.6 Remove debris from drilled hole

The life expectancy for SFS drill bits:

<table>
<thead>
<tr>
<th>Drill bit</th>
<th>in HPL</th>
<th>in fiber cement</th>
</tr>
</thead>
<tbody>
<tr>
<td>HSS</td>
<td>100–150 drills</td>
<td>25–100 drills</td>
</tr>
<tr>
<td>VHM</td>
<td>500+ drills</td>
<td>250–500 drills</td>
</tr>
</tbody>
</table>

Example: TUF-S-6x9-A4 – 3,5 mm = 5,5 mm Drill depth
TU-S-6x9-A4 – 3,5 mm + 0,5 mm = 6,0 mm Drill depth

TUF-S Length – Bracket thickness = TUF-S Drill depth
TU-S Length – Bracket thickness + 0,5 mm = TU-S Drill depth
TUC-S Length – Bracket thickness – 1,0 mm = TUC-S Drill depth

Drill depth tolerance: +0,5 / 0
2. Position the bracket

Position the pre-drilled bracket over the hole in the panel and push through the TU-fastener

![Diagram of bracket positioning](image)

Dimension must be kept

2.2

There can be a gap between the TU-fastener head and the bracket

2.3

Giving heavy force to the TU-fastener while not removing the mandrel can cause damage to the panel

3. Remove mandrel

Remove the mandrel using the GESIPA® PowerBird® Pro riveting tool

![Diagram of mandrel removal](image)

Use nose piece 17/36 or 17/40

3.1

Panel must lie on a hard surface

3.2

Keep a right angle during the setting process

Push the GESIPA® PowerBird® Pro slightly towards the panel

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All calculations therefore have to be checked and approved by the responsible planner ahead of execution. The user is responsible to assure compliance with all applicable laws and regulations.

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