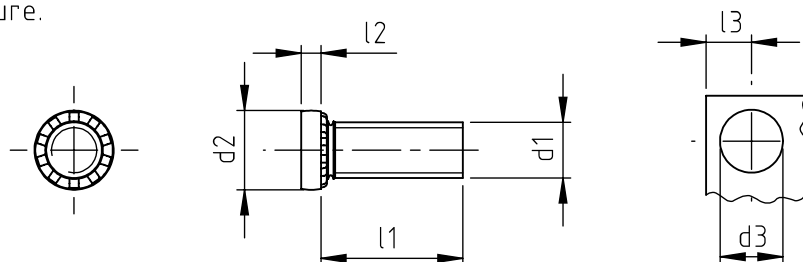


Application: metal sheets, stainless steel, light alloy, non-ferrous metal sheets.
Assembly: by pressure.



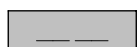
code	stud length $l \pm 0,2$	available					
		M3	M4	M5	M6	M8	M10
510_._._.	10	X	X	X	X		
515_._._.	15	X	X	X	X	X	X
520_._._.	20	X	X	X	X	X	X
525_._._.	25	X	X	X	X	X	X
530_._._.	30	X	X	X	X	X	X
534_._._.	34	X	X	X	X	X	X

Other lengths on demands.

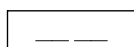
code	metric thread d1	sheet thickness \geq	head diameter d2	head height $l2 \pm 0,1$	hole diameter $d3 \text{ } 0/+0,1$	distance from the edge (min.) $\geq L3$
4 030_._.	M3	1,0	6,0	0,8	3,0	10,0
4 040_._.	M4	1,0	7,5	1,2	4,0	11,5
4 050_._.	M5	1,2	8,5	1,5	5,0	13,0
4 060_._.	M6	1,2	10,0	1,5	6,0	14,5
4 080_._.	M8	1,5	12,5	1,75	8,0	16,5
4 100_._.	M10	2,0	15,7	2,2	10,0	18,5

For sheet thicknesses $\geq 0,8$ mm, use press stud for thin sheets, the code is: 9_._._.

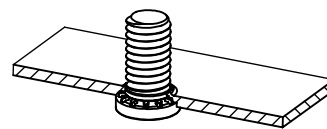
Non binding dimensions, expressed in mm.



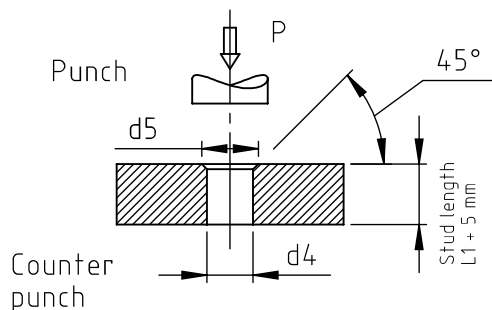
Standard



On demand



Material: steel
Finishing: zinc-plated (on 80 HRB max) _._._.12
Tolerance: ISO 2768 - m
Thread d 1: metric ISO 6 g
Example: clifa self clinching stud, M 5 thread,
stud length L=15 mm, zinc plated steel: 515 4 050.12



clifa	counter punch hole diameter d4	flare diameter d5	approx pressure required on sheets KN
M3	3,1	4,0	$9,0 \div 15$
M4	4,1	5,2	$14,5 \div 38$
M5	5,1	6,4	$21 \div 42$
M6	6,1	7,6	$21 \div 50$
M8	8,1	10,2	$21 \div 60$
M10	10,1	12,2	$32 \div 84$

Note: pressure value depends on Clifa size, teeth type, and application.
Clifa stud must be inserted flat to the sheet metal surface. Avoid any over-pressure.
It is advisable to carry out some preliminary tests in order to determine the best assembly.