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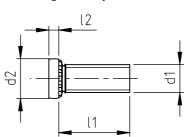
SELF CLINCHING STUDS

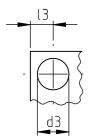
Clifa series 510-4/534-4

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

Assembly: by pressure.







code	stud length	available					
	l 1 ±0,2	МЗ	Μ4	M5	M6	M8	M10
510	10	Χ	Χ	Χ	Χ		
515	15	Χ	Χ	Χ	Χ	Χ	Χ
520	20	Χ	Χ	Χ	Χ	Χ	Χ
525	25	Χ	Χ	Χ	Χ	Χ	Χ
530	30	Χ	Χ	Χ	Χ	Χ	Χ
534	34	Χ	Χ	Χ	Χ	Χ	Χ

Other lengths on demands.

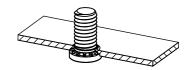
code	metric thread d1	sheet thickness ≥	head diameter d2	head height l2 ±0,1	hole diameter d3 0/+0,1	distance from the edge (min.) ≥L3
 4 030	M3	1,0	6,0	0,8	3,0	10,0
 4 040	M4	1,0	7,5	1,2	4,0	11,5
 4 050	M5	1,2	8,5	1,5	5,0	13,0
 4 060	M6	1,2	10,0	1,5	6,0	14,5
 4 080	M8	1,5	12,5	1,75	8,0	16,5
 4 100	M10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

For sheet thicknesses ≥ 0,8 mm,use press stud for thin sheets, the code is: 9

Non binding dimensions, expressed in mm.

Standard





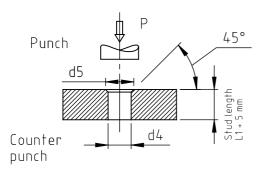
Material: steel

zinc-plated (on 80 HRB max) Finishing:

Tolerance: ISO 2768 - m Thread d 1: metric ISO 6 q

Example: clifa self clinching stud, M 5 thread,

styd length L=15 mm, zinc plated steel: 515 4 050.12



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



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