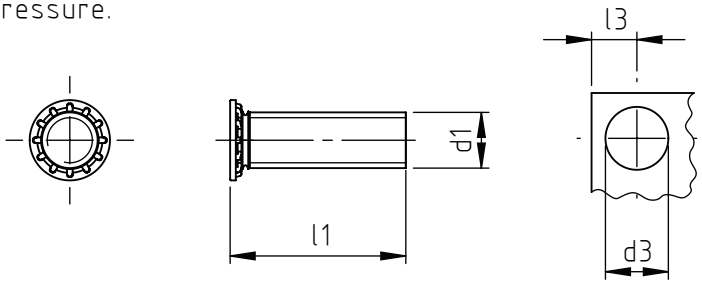
specialinsert	SELF CLINCHING STUDS	Clifa series 506-534

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



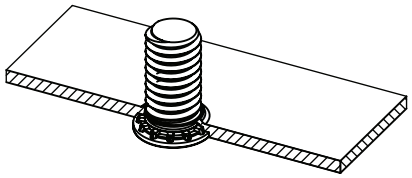
code	stud length l 1±0,4	available					
		M2,5	M3	M4	M5	M6	M8
506__ ___.___	6,0	X	X	X	X		
508__ ___.___	8,0	X	X	X	X	X	
510__ ___.___	10,0	X	X	X	X	X	-
512__ ___.___	12,0	X	X	X	X	X	X
514__ ___.___	14,0	X	X	X	X	X	X
516__ ___.___	16,0	X	X	X	X	X	X
518__ ___.___	18,0	X	X	X	X	X	X
520__ ___.___	20,0	X	X	X	X	X	X
___ __ ___:___							
___ __ ___:___							
___ __ ___:___							
534__ ___.___	34,0			X	X	X	X

code	metric thread d1	sheet thickness ≥	hole diameter d3 0/+0,05	distance from the edge (min.) ≥L3	screwing torsion (max) ≤Nm
___0 025.___	M2,5	*1,0	2,5	5,0	0,4
___0 030.___	M3	*1,0	3,0	5,5	0,8
___0 040.___	M4	*1,0	4,0	7,0	1,9
___0 050.___	M5	*1,0	5,0	7,5	3,8
___0 060.___	M6	1,5	6,0	8,0	8,0
___0 080.___	M8	1,5	8,0	10,0	12,0

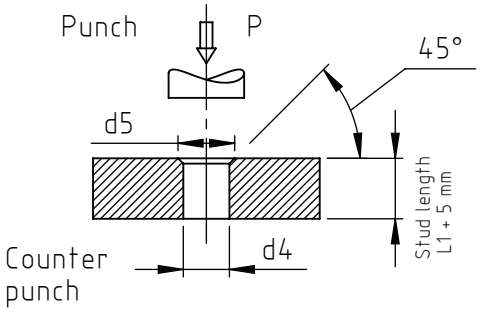
*For sheet thicknesses lower than 1,0 mm, use press studs for thin sheets, the code is: ___2___.__.

Non binding dimensions, expressed in mm.

___ __ ___.___ Standard ___ __ ___:___ On demand



Material: steel, stainless steel
Finishing: steel: zinc-plated (su 80 HRB max) ___ __ _____.12
stainless steel: natural (su 70 HRB max) (on demand) ___ __ _____.50
Tolerance: where not specified, degree of accuracy (coarse) according to ISO 2768 - m
Thread d1: metric ISO 6 g
Example: clifa self clinching stud, M 5 thread, styd length L=16 mm, zinc plated steel: 516 0 050.12



clifa	counter punch hole diameter d4	flare diameter d5	approx. pressure required on sheets P(t)	
			steel,light alloy	brass
M2,5	2,6	3,4	0,5 ÷ 1,5	0,7 ÷ 1,7
M3	3,1	4,0	0,5 ÷ 1,5	0,7 ÷ 1,7
M4	4,1	5,2	0,5 ÷ 1,5	1,5 ÷ 2,5
M5	5,1	6,4	0,5 ÷ 1,5	1,5 ÷ 2,5
M6	6,1	7,6	1,0 ÷ 3,0	2,5 ÷ 4,0
M8	8,1	10,2	1,0 ÷ 3,0	2,5 ÷ 4,0

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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