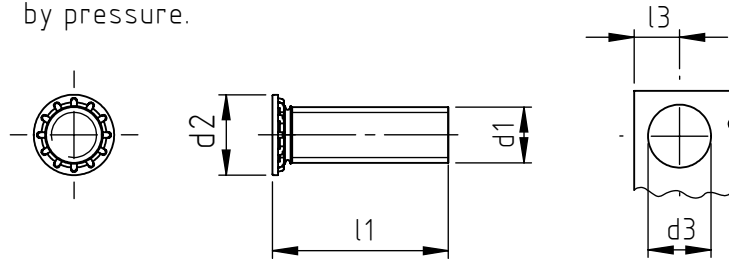


Applications: sheet metal, stainless steel, light alloy, non-ferrous sheet metal.
Assembly: by pressure.



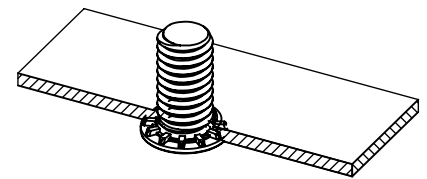
code	stud length l1 ±0,4	available					
		M2,5	M3	M4	M5	M6	M8
506	6,0	X	X	X	X		
508	8,0	X	X	X	X	X	
510	10,0	X	X	X	X	X	X
515	15,0	X	X	X	X	X	X
520	20,0	X	X	X	X	X	X
525	25,0	X	X	X	X	X	X
530	30,0			X	X	X	X
534	34,0			X	X	X	X

code	metric thread d1	sheet thickness ≥ *	d2	hole diameter d3 0/+0,05	distance from the edge (min.) ≥L3
___ 0 025. ___	M2,5	1,0	4,0	2,5	5,0
___ 0 030. ___	M3	1,0	4,6	3,0	5,5
___ 0 040. ___	M4	1,0	5,9	4,0	7,0
___ 0 050. ___	M5	1,0	6,5	5,0	7,5
___ 0 060. ___	M6	1,5	8,5	6,0	8,0
___ 0 080. ___	M8	1,5	10,0	8,0	10,0

* When sheet thicknesses is lower than 1,0 mm, use press studs for thin sheets, the code is: ___2___. (special part on demand)

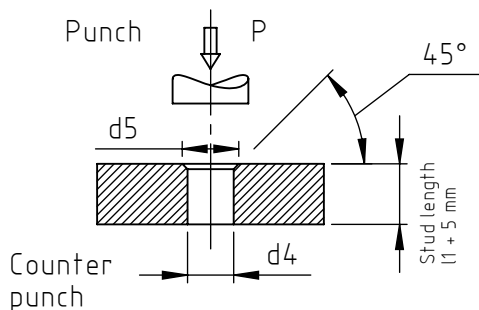
Non binding dimensions, expressed in mm.

Standard On demand



Material: steel, stainless steel
 Finishing: steel: zinc-plated (on 80 HRB max)
 stainless steel: natural (on 70 HRB max) (on demand)
 Tolerance: where not specified, degree of accuracy (coarse)
 according to ISO 2768 - m
 Thread d1: metric ISO 6g
 Example: Clifa® self clinching stud, M 5 thread,
 stud length L=15 mm, zinc-plated steel: 515 0 050.12

___ .12
 ___ .50



clifa®	counter punch hole diameter d4	flare diameter d5	approx. pressure required on sheets P(KN)
M2,5	2,6	3,4	8,9 ÷ 12
M3	3,1	4,0	10,5 ÷ 19
M4	4,1	5,2	16 ÷ 25
M5	5,1	6,4	29 ÷ 35
M6	6,1	7,6	30 ÷ 50
M8	8,1	10,2	30 ÷ 60

Note: pressure value depends on Clifa® size, teeth type, and application.
 Clifa stud must be inserted flush 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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