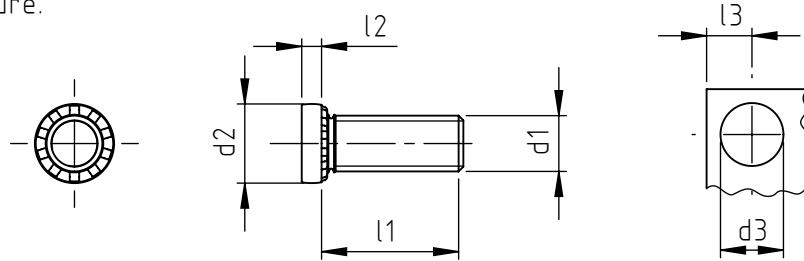


Application: metal sheets, stainless steel, light alloy, non-ferrous metal sheets.  
Assembly: by pressure.



code	stud length l1 ±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

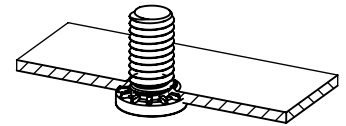
code	metric thread d1	sheet thickness ≥	head diameter d2	head height l2 ±0,1	hole diameter d3 0/+0,1	distance from the edge (min.) ≥L3
4 030	M3	1,0	6,0	0,8	3,0	8,5
4 040	M4	1,0	7,5	1,2	4,0	9,5
4 050	M5	1,2	8,5	1,5	5,0	10,5
4 060	M6	1,2	10,0	1,5	6,0	11,5
4 080	M8	1,5	12,5	1,75	8,0	12,5
4 100	M10	2,0	15,7	2,2	10,0	13,5

Other lengths on demands.

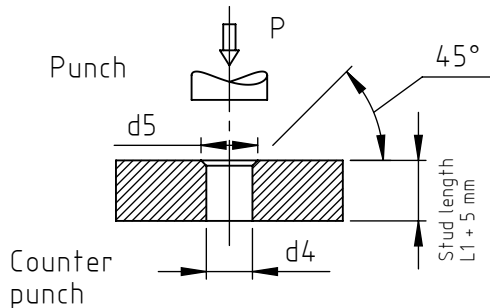
For sheet thicknesses ≥ 0,8 mm, use press stud for thin sheets, the code is: 9

Non binding dimensions, expressed in mm.

Standard      On demand



Material: steel  
stainless steel  
Finishing: zinc-plated (on 80 HRB max)      .12  
natural      .50  
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 countersink d5	approx pressure required on sheets 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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