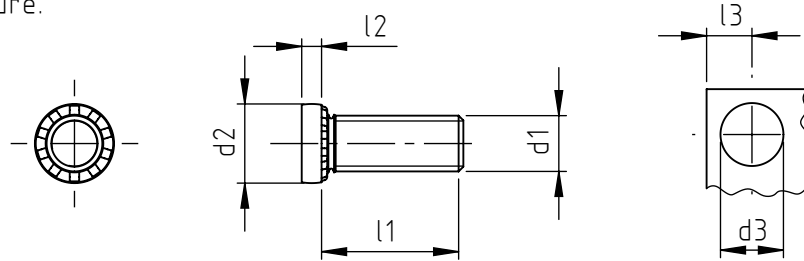


Application: On sheet metal, stainless steel, light alloy, non-ferrous metal sheets.
Assembly: by pressure.



| 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 |

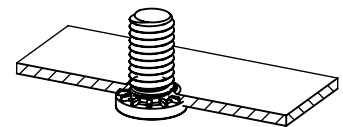
Other lengths on demand.

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

Non binding dimensions, expressed in mm.

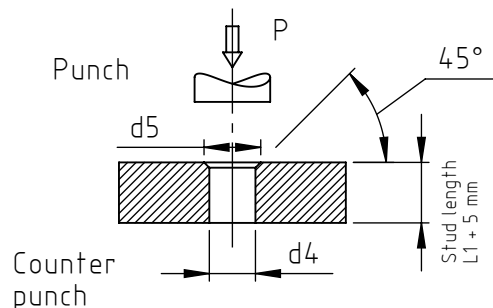


Material: steel, stainless steel



Finishing: Steel stud: zinc-plated (on 80 HRB max) .12
Stainless steel stud: natural state (on 70 HRB max) .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 |

N.B: The pressure value depends on Clifa size, notching type and application. Avoid excessive pressure. It is advisable to carry out assembly tests to determine the best condition for assembly.

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