

	THREA D SIZE	TYPE	THREAD CODE	LENGTH CODE "L" $\pm .015$										SHEET THICK- NESS	HOLE SIZE IN SHEET $+.003$ $-.000$	H $\pm .015$	S MAX
				.250	.312	.375	.500	.625	.750	.875	1.00	1.25	1.50				
UNIFIED (INCH)	.112-40	CHTS	440	4	5	6	8	10	12	14	16	-	-	.040- .095	.111	.176	.085
	.138-32	CHTS	632	4	5	6	8	10	12	14	16	20	24	.040- .095	.137	.206	.090
	.164-32	CHTS	832	4	5	6	8	10	12	14	16	20	24	.040- .095	.163	.237	.090
	.190-32	CHTS	1032	-	5	6	8	10	12	14	16	20	24	.040- .095	.189	.256	.100

	THREAD SIZE	TYPE	THREAD CODE	LENGTH CODE "L" $\pm .015$										SHEET THICK- NESS	HOLE SIZE IN SHEET $+.08$ $-.00$	H $\pm 0.4$	S MAX
				6	8	10	12	15	18	20	25	30	35				
METRIC (MM)	M3 X 0.5	CHTS	M3	6	8	10	12	15	18	20	25	-	-	1-2.4	3	4.6	2.1
	M4 X 0.7	CHTS	M4	6	8	10	12	15	18	20	25	30	35	1-2.4	4	5.9	2.4
	M5 X 0.8	CHTS	M5	-	8	10	12	15	18	20	25	30	35	1-2.4	5	6.5	2.7

### MATERIAL & FINISH SPECIFICATIONS

TYPE	Threads	Materials	Standard Finish	Sheet Hardness Requirement
CKT	Internal ANSI B1.1 2B/ANSI/ASME B1.13M 6H	400 Series Stainless Steel	Passivated per ASTM A380	92 or less on the Rockwell "B" scale

\*ALL ITEMS SUBJECT TO MINIMUM ORDER

**ABOVE BOARD ELECTRONICS**

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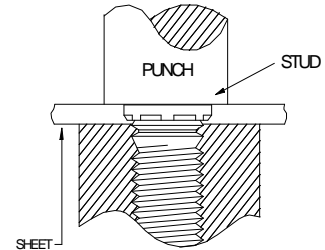
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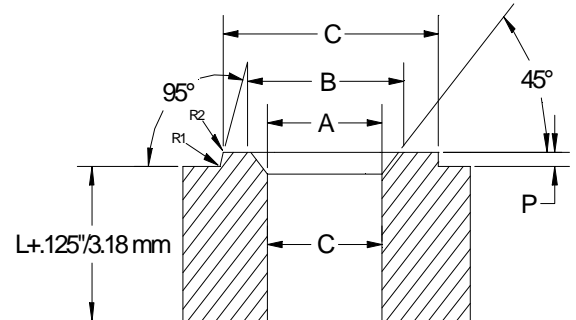
## INSTALLATION

Captive self clinching studs are installed by placing them in punched or drilled holes in the sheet material and squeezing them into place with any standard press. A flat punch with a minimum hardness of Rc55 is necessary for installation. A special anvil with a raised ring is also required to create proper installation. The raised ring acts as a second displacer of the stainless sheet material, thereby ensuring that the annular groove is filled. We do not recommend the use of CHT studs in sheet thickness greater than .095 (2.41mm). The hardness of Rc55 minimum is required to provide long anvil life. We recommend measuring the P dimension every 5000 installations to ensure that the anvil remains within specification. (see note 1 below)



UNIFIED (inch)	Thread Code	Anvil Dimensions (in)					
		A	B	C	P	R1	R2
	440	.113	.144	.174	.010	.003	.005
	632	.140	.170	.200	.010	.003	.005
	832	.166	.202	.236	.010	.003	.005
	1032	.191	.235	.275	.010	.003	.005

METRIC (mm)	Thread Code	Anvil Dimensions (mm)					
		A	B	C	P	R1	R2
	M3	3.05	3.81	4.57	0.25	0.08	0.13
	M4	4.04	4.95	5.82	0.25	0.08	0.13
	M5	5.08	6.15	7.16	0.25	0.08	0.13



## PERFORMANCE DATA (1)

UNIFIED (inch)	Thread Code	Max. Nut Tightening Torque (in. lbs.)	Sheet Thickness And Material	Sheet Hardness HRB Max	Installation (lbs.)	Pushout (lbs.)	Torque-out (in. lbs.)	Pull thru (lbs.)
	440	6	.060" SS	92	9000	750	16	800
	632	11	.060" SS	92	9500	900	27	1350
	832	21	.060" SS	92	11200	1000	58	1800
	1032	33	.060" SS	92	12000	1100	95	2250

METRIC (mm)	Thread Code	Max. Nut Tightening Torque (N.m)	Sheet Thickness And Material	Sheet Hardness HRB Max	Installation (kN)	Pushout (N)	Torque-out (N.m)	Pull thru (N)
	M3	9	1.5mm SS	92	40	3300	1.8	3500
	M4	2.1	1.5mm SS	92	50	4400	6.5	8000
	M5	4.3	1.5mm SS	92	53	4900	10.7	10000

(1) Performance values shown are typical for fasteners properly installed using tooling in good condition. We recommend replacing installation tooling when the height of the "P" dimension is reduced to .005" (0.13mm) due to wear. Reductions in performance may occur as the height of the protrusion wears. Variations in hole proportion, installation force, and sheet material type, thickness, and hardness will affect both performance and tooling life.

Specifications subject to change without notice.

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