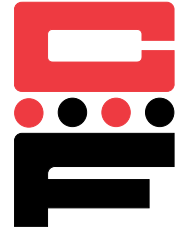




Self-Clinching Studs For Stainless Steel

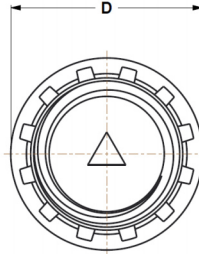
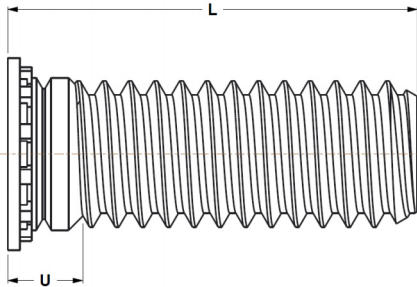
Series CHTS



CHTS studs are made of heat treated stainless steel providing a strong, flush-head assembly in stainless steel material as thin as .040 in. (1 mm) with high torque-out and pushout performance.

Series	Material	Finish
CHTS	400 Series Stainless Steel	Passivated ASTM A967

Thread: External 2A, ANSI B1.1 (6g ANSI/ASME B1.13M).
Use in: CHTS - Materials with HRB-92 or less.



Part Number Structure:

CHTS 440-8



Dimensions & Specifications

INCH (in.)	Thread Size	Series	Thread Code	L Length ± 0.015 in.										Sheet Thickness	Hole Size In Sheet +.003 -.000	D ± 0.015	U Max.	Min.
				.250	.312	.375	.500	.625	.750	.875	1.00	1.25	1.50					
	#4-40	CHTS	440	-4	-5	-6	-8	-10	-12	-14	-16			.040-.095	.111	.176	.085	.219
	#6-32	CHTS	632	-4	-5	-6	-8	-10	-12	-14	-16	-20	-24	.040-.095	.137	.206	.090	.250
	#8-32	CHTS	832	-4	-5	-6	-8	-10	-12	-14	-16	-20	-24	.040-.095	.163	.237	.090	.281
	#10-32	CHTS	1032		-5	-6	-8	-10	-12	-14	-16	-20	-24	.040-.095	.189	.256	.100	.281
	1/4-20	CHTS	420			-6	-8	-10	-12	-14	-16	-20	-24	.062-.117	.249	.337	.135	.312
	5/16-18	CHTS	518				-8	-10	-12	-14	-16	-20	-24	.093-.148	.311	.376	.160	.375

Dimensions & Specifications

METRIC (mm.)	Thread Size	Series	Thread Code	L Length ± 0.4 mm.										Sheet Thickness	Hole Size In Sheet +.08 -.00	D ± 0.4	U Max.	Min.
				6	8	10	12	15	18	20	25	30	35					
	M3 x 0.5	CHTS	M3	-6	-8	-10	-12	-15	-18	-20	-25			1 - 2.4	3	4.6	2.1	5.6
	M4 x 0.7	CHTS	M4	-6	-8	-10	-12	-15	-18	-20	-25	-30	-35	1 - 2.4	4	5.9	2.4	7.2
	M5 x 0.8	CHTS	M5		-8	-10	-12	-15	-18	-20	-25	-30	-35	1 - 2.4	5	6.5	2.7	7.2
	M6 x 1.0	CHTS	M6			-10	-12	-15	-18	-20	-25	-30	-35	1.6 - 3	6	8.2	3.0	7.9
	M8 x 1.25	CHTS	M8				-12	-15	-18	-20	-25	-30	-35	2.4 - 3.8	8	9.6	3.7	9.6

Note: All items subject to minimum order.

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Self-Clinching Studs For Stainless Steel

Series CHTS

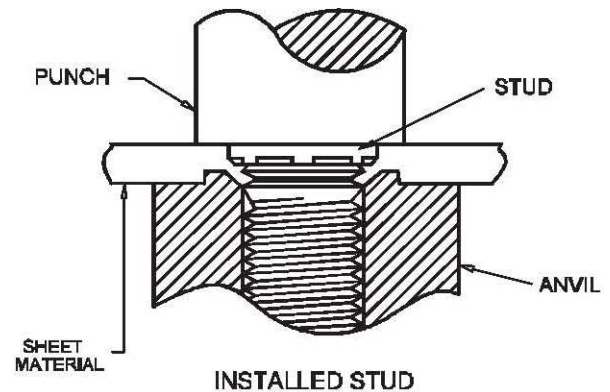


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Installation Procedure

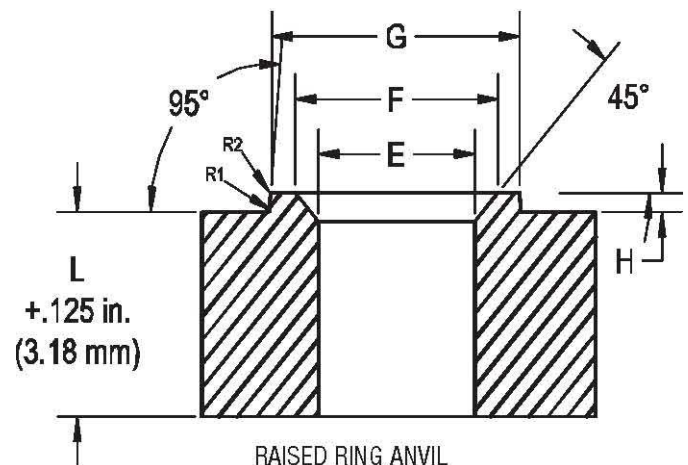
Drill or punch the proper size hole in the parent material and apply the recommended force, with a standard shop press, to fully seat the fastener. For best results, a flat punch with a minimum hardness of Rockwell C55 should be used along with a special anvil that has a raised ring. This will assure full displacement of the stainless steel material into the clinch ring of the stud.

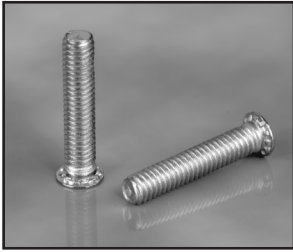
Be sure to monitor the height of the ring on the anvil periodically and replace anvil when ring height wears down to .005 in. (.13 mm) to assure desired performance



INCH (in.)	Thread Code	Anvil Dimensions (in.)					
		E	F	G	H	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
	420	.251	.310	.363	.020	.003	.005
	518	.313	.385	.474	.020	.003	.005

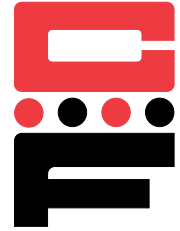
METRIC (mm.)	Thread Code	Anvil Dimensions (mm.)					
		E	F	G	H	R1	R2
	M3	3.05	3.81	4.57	.25	.08	.13
	M4	4.04	4.95	5.82	.25	.08	.13
	M5	5.08	6.15	7.16	.25	.08	.13
	M6	6.05	7.87	8.79	.51	.08	.13
	M8	7.95	9.78	10.27	.51	.08	.13






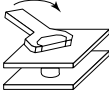
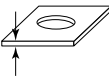


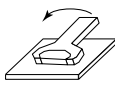

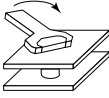
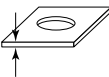


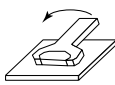
Self-Clinching Studs For Stainless Steel

Series CHTS



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Installation & Performance Data

	INCH (in.)							
	 Thread Code	 Max. Nut Tight. Torque (in.-lbs.)	 Sheet Thickness & Material	Sheet Hardness HRB Max.	 Installation (lbs.)	 Pushout (lbs.)	 Torque-out (in.-lbs.)	Pull thru (lbs.)
	440	6	.060 SS	87	9000	450	16	800
	632	11	.060 SS	87	9500	540	27	1350
	832	21	.060 SS	86	11200	780	58	1800
	1032	33	.060 SS	86	12000	800	95	2250
	420	70	.060 SS	88	13000	1600	156	3900
	518	80	.090 SS	92	16000	1775	295	7375
	METRIC (mm)							
	 Thread Code	 Max. Nut Tight. Torque (N•m)	 Sheet Thickness & Material	Sheet Hardness HRB Max.	 Installation (kN)	 Pushout (N)	 Torque-out (N•m)	Pull thru (N)
	M3	.9	1.5mm SS	87	40	2200	1.8	3500
	M4	2.1	1.5mm SS	86	50	3210	6.5	8000
	M5	4.3	1.5mm SS	86	53	3560	10.7	10000
	M6	7.2	1.5mm SS	88	58	4200	15.9	14900
	M8	9.0	2.3mm SS	92	71	7895	33.3	32804