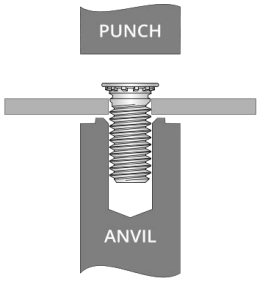
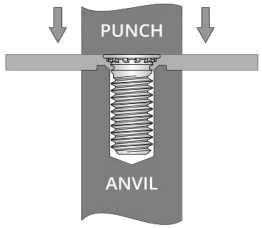
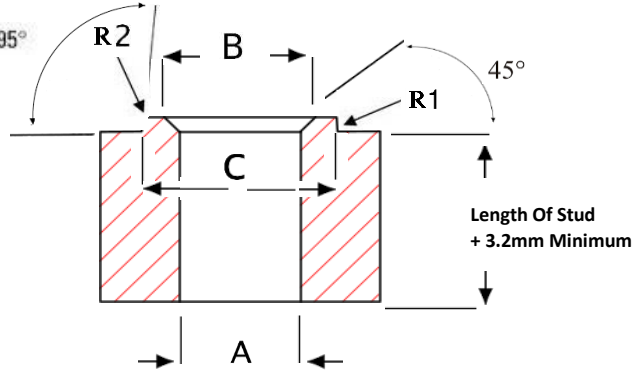
Self Clinch Flush Head Studs For Stainless Steel Installation Guide



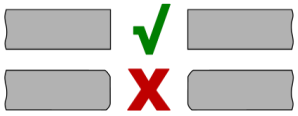


Anvil Dimensions						
Thread Size	A + 0.08	B + 0.10	C + 0.10	S +/- 0.025	R1 Max.	R2 Max
M3	3.05	3.76	4.52	0.25	0.08	0.13
M4	4.04	4.9	5.77	0.25	0.08	0.13
M5	5.08	6.1	7.11	0.25	0.08	0.13
M6	6.05	7.82	8.74	0.51	0.08	0.13

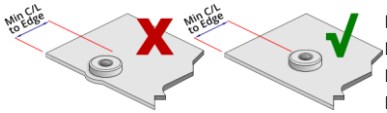


HRB (Rockwell Hardness B Scale)
Ensure That you Are InstallingInto A Panel That Is Ductile And Or Below The Published Maximum Recommended Hardness For The Fastener

Flush Head Studs For Stainless Steel Require A Special Stakin Ring Anvil For Correct Installation
The Staking Ring Aids Displacement Of Panel Material To Ensure That The Annular Clinch Feature Is Fully Filled. For Longevity It is Recommended That Anvils Should Be A Minimum Of 55HRC



Ensure That The Panel Is Within The Recommended Range (1.0 - 2.4mm For M3-M4 & M5 And 1.6 - 3.0mm For M6 parts)
Punch OR Drill Correct Hole Size AND Do Not Deburr OR Chamfer The Hole Prior To Installation As This Will Remove Material Required During The Clinching Process. It Is Prefferable To Install The Fastener From Punch Side Of Panel.
Place The Fastener In The Prepared Hole In The Panel, Locate The Fastener In The Anvil, With The Panel Held Level Apply Parallel Squezzing Force Until The Head Is Installed Flush To The Panel Surface. Do NOT Over Squezze The Fastener Into The Panle As This Will Result In Panel Deformation.



Ensure That Attention Is Paid To The Minimum Hole Centreline To Edge Dimensions For Each Fastener Installing To Close To An Edge OR Bend Could Result In Improper Installation Or Reduced Performance Minimum Centreline Dimension Shown For Each Fastener Apply To One Edge Only. If This Distance Is Applied On Multiple Sides There Will Be Significant Panel Distortion Unless The Panel Edges Are Supported During Installation