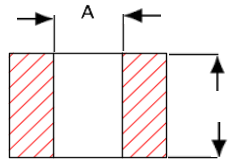
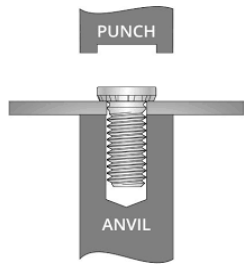
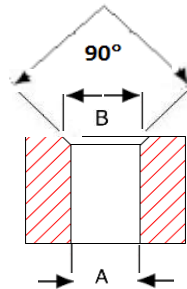
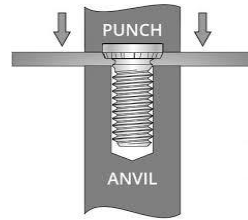


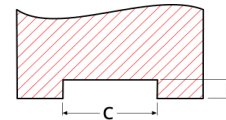
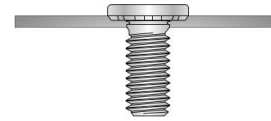
Self Clinch Thin Panel High Strength Stud Installation Guide



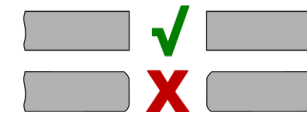
Straight Through Hole Style
 Anvil For 1.51mm Miminum
 Panel Thickness For Thread Sizes
 M5 And M6 And 1.90mm Miminum
 Panel Thickness For Thread Size M8



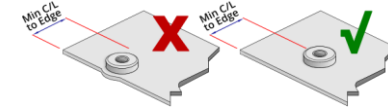
Countersunk Hole Style
 Anvil For 1.50mm Or Less Panel
 Thickness For M5 And M6 And
 1.90mm Or Less Panel Thickness
 For Thread Size M8



Pocket Punch Detail
 Pocket Provides Clearance
 For Head Protrusion Minimising
 Risk Of Over Installation



Do Not Remove Any Extra Materoa; OR Chamfer
 The Hole As This Could Result In Improper
 Installation Or Reduce Performance.



Ensure Attention Is Paid To Minimum Hole Centreline
 To Edge Dimension For Each Fastener.
 Installing To Close Could Result In Imptoper
 Installtion Or Reduced Performance.
 Minimum Centreline To Edge Dimension Shown
 For Eaxh Fastener Apply To One Edge Only.
 If This Distance Is Applied On Multiple Sides
 Significant Panel Distortion Will Occur Unless
 The Panel Edges Are Supported During Installation

Firsty Punch OR Drill The Correct Hole Size Do NOT Deburr Or Chamfer The Hole Prior
 To Installation As This Will Remove Material Required During The Clinching Process
 It Is Preferable To Install The Fastener From The Punch Side Of The Panel.
 Place The Fastener In The Prepared Hole In The Panel And Locate The Fastener In The
 Anvil Like In The Above Diagram. With The Panel Held Level Apply Squezzing Force Until
 The Castellations Are Fully Embedded In The Panel. This Fatener Is Not Designed To Install
 Flush. Correct Installation Should Leave The Head Protruding Slightly (Refer To 'S' Dimension)
 Do NOT Over Install The Fatener In The Panel As This Will Result In Panel Deformation.
 Please Pay Attention To The Minimum Hole Centreline To Edge And Parent Material
 Hardness Limitations.

Anvil Dimensions				
Thread Size	A	B	C	D
M5	+0.08	+0.1	+0.2	+0.03
M6	5.03	5.60	10.00	1.17
M6	6.00	6.60	11.75	1.39
M8	8.03	8.60	15.75	2.00

HRB (Rockwell Hardness B Scale)

Ensure That You Are Installing Into A Panel That Is
 Ductile And At OR Below The Published Maximum
 Recommended Hardness For The Fastener