

Self-Clinching Studs

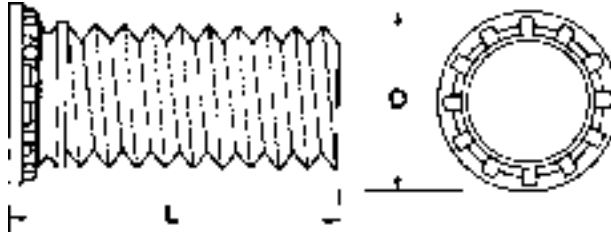
Inch

Goujons autoriveurs

Pouce

B

Steel  
Stainless Steel  
Aluminum



PKG QTY. 100

Inch Sizes

DIMENSIONS & SPECIFICATIONS:

THREAD SIZE	D. Head Dia. ±1/64	Hole in Sheet +.003 -.000	Min. Edge Distance to center of Hole in Panel	Kind of Metal	(L) Length in inches										
					1/4	5/16	3/8	1/2	5/8	3/4	7/8	1	1-1/4	1-1/2	
					ORDER BY SPAENAUR No's LISTED BELOW										
2-56	9/64	.085	.19	STEEL			614-003	614-004	614-005						
				S.S.	614-808	614-809	614-810	614-811	614-812						
4-40	3/16	.111	.22	STEEL	614-006	614-007	614-008	614-009	614-010	614-011					
				S.S.	614-813	614-814	614-800	614-801	614-815	614-816					
6-32	13/64	.137	.25	STEEL	614-057	614-012	614-013	614-014	614-015	614-016	614-017	614-018	614-019		
				S.S.		614-817	614-802	614-803	614-818	614-819	614-820	614-821	614-822	614-823	614-824
8-32	15/64	.163	.28	STEEL			614-020	614-021	614-022	614-023	614-024	614-025	614-026	614-027	
				S.S.			614-822	614-804	614-805	614-823	614-824	614-825			
10-24	1/4	.189	.28	STEEL			614-028	614-029	614-030	614-031	614-032	614-033	614-034	614-C01-1T	
				S.S.			614-826	614-827	614-828	614-829	614-830	614-831	614-832	614-833	614-834
10-32	1/4	.189	.28	STEEL			614-036	614-037	614-038	614-039	614-040	614-041	614-042	614-043	
				S.S.			614-832	614-806	614-807	614-833	614-834	614-835	614-841	614-836	614-837
1/4"-20	21/64	.249	.31	STEEL				614-044	614-045	614-046	614-047	614-048	614-049	614-050	
				S.S.				614-835	614-841	614-836	614-837	614-838	614-839	614-840	
5/16"-18	25/64	.311	.38	STEEL	THREAD Class 2A (MIL-S-7742)				614-051	614-052	614-053	614-054	614-055	614-056	
				S.S.					614-838						
				ALUM.											

STEEL

Carbon Steel, Heat Treated, Zinc or Cadmium Plated, QQ-P-416, Type 1, Class 3, Plus Clear Chromate Dip

MATERIAL AND FINISHES

STAINLESS STEEL (S.S.)  
300 Series Stainless Steel (Passivated, QQ-P-35, Type I)

ALUMINUM (ALUM.)  
2024-T4 Aluminum

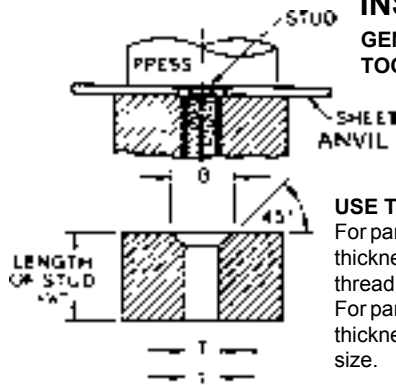
ANVIL DIMENSIONS

THREAD SIZE	ANVIL	
	B	T
2-56	.110	.087
	.114	.090
4-40	.136	.113
	.140	.116
6-32	.162	.139
	.166	.142
8-32	.188	.165
	.192	.168
10-24	.216	.191
	.220	.194
1/4-20	.295	.250
	.300	.253
5/16-18		.3125
		.3155

INSTALLATION

GENERAL TOOLING SETUP

Note: These values are for general reference only.  
\*Maximum nut tightening values



**USE THIS ANVIL**  
For panels less than .060" in thickness, with #2 thru #10 thread sizes.  
For panels less than .093" in thickness, with 1/4" thread size.

USE THIS ANVIL

For panels .060" and more in thickness, with #2 thru #10 thread sizes.  
For panels .093" and more in thickness, with 1/4" and 5/16" thread sizes.

THREAD SIZE	*Torque (IN-LB)	Installation (LB)	
		STEEL	ALUM
2-56	2-1/2	3000	2000
4-40	5	4000	3000
6-32	10	4500	3500
8-32	20	5000	4000
10-24	25	6000	4500
10-32	35	6000	4500
1/4-20	80	7000	5000
5/16-18	140	8000	6000

**INSTALLATION NOTE:** Apply only sufficient squeezing pressure to embed head of stud flush with panel. Do not use more pressure than necessary. Amount of pressure varies with panel metal and size of stud. Studs install flush in sheets .040" or thicker, but will project up to .020" in thinner sheets.