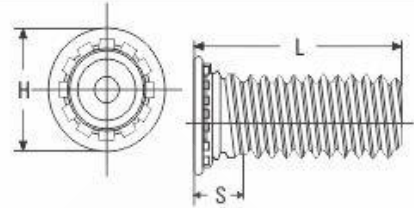


SELF CLINCHING STUDS

Flush-Head For Sheet Thickness of .040" / 1mm & Greater
 TYPE SE-FH/ SE-FHS/ SE-FHA



Thread Size x Pitch	Type Fastener Material			Thread Code	Length code "L" + 0.4 (In M.M.)										Min. sheet Thickness	Hole size in Sheet +0.08	Max Hole in attach Parts	H +0.4	S Max.	Min Dis. Hole C/L to Edge
	Steel	Stainless Steel	Aluminium		6	8	10	12	15	18	20	25	30	35						
M2.5x0.45	SE-FH	SE-FHS	SE-FHA	M2.05	6	8	10	12	15	18	NA	NA	NA	NA	1	2.5	3.1	4.1	1.95	5.4
M3x0.5	SE-FH	SE-FHS	SE-FHA	M3	6	8	10	12	15	18	20	25	NA	NA	1	3	3.6	4.6	2.1	5.6
M3.5x0.6	SE-FH	SE-FHS	SE-FHA	M3.5	6	8	10	12	15	18	20	25	30	35	1	3.5	4.1	5.3	2.25	6.4
M4x0.7	SE-FH	SE-FHS	SE-FHA	M4	6	8	10	12	15	18	20	25	30	NA	1	4	4.6	5.9	2.4	7.2
M5x0.8	SE-FH	SE-FHS	SE-FHA	M5	NA	8	10	12	15	18	20	25	30	35	1	5	5.6	6.5	2.7	7.2
M6x1	SE-FH	SE-FHS	SE-FHA	M6	NA	NA	10	12	15	18	20	25	30	35	1.6	6	6.6	8.2	03	7.9
M8x1.25	SE-FH	SE-FHS	SE-FHA	M8	NA	NA	NA	12	15	18	20	25	30	35	2.4	08	8.6	9.6	3.7	9.6

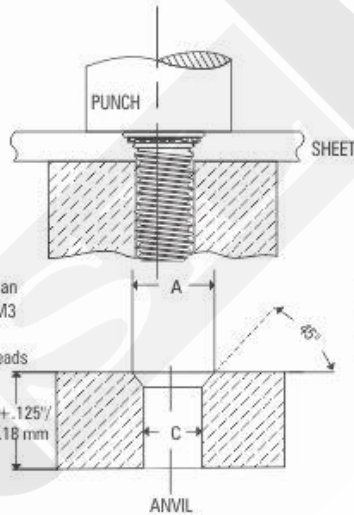
INSTALLATION

For Types SE- FH, SE- FHS, SE- FHA

Self Clinching studs are installed by placing them in punched or drilled hole in the steel material and squeezing them into place with any standard press. All that is required is a flat or recessed punch and a plain anvil having a hole to clear the thread diameter so that force is applied between the top of the stud head and underside of the steel material. The squeezing action forces the ribs of the stud into the sheet displacing sheet material causing it to fill the annular groove under the lead of the stud.

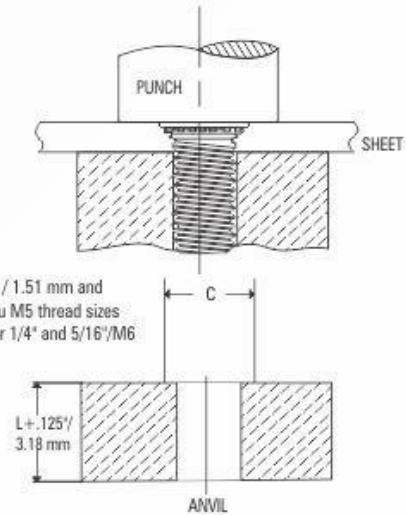
The illustrations below indicate suggested tooling for applying installation force. Note that for sheet .060"/1.51 mm and thicker the anvil requires only a straight thru hole to accommodate the stud. For sheets less than .060"/1.51 mm the hole requires a countersink with dimension A at the top to provide for metal flow around the shank of the stud.

Thread code	Anvil Dimensions	
	A +0.1	C +0.08
M2.5	3.1	2.53
M3	3.6	3.03
M3.5	4.1	3.53
M4	4.6	4.03
M5	5.6	5.03
M6	6.6	6.03
M8	8.6	8.03
M10	-	10.03



Tooling for sheet thicknesses less than .060" / 1.51 mm with #2 thru #10 / M3 thru M5 thread sizes and less than .093" / 2.4 mm for 1/4" / M6 threads

Tooling for sheet thicknesses .060" / 1.51 mm and greater with #2 thru #10 / M3 thru M5 thread sizes and .093" / 2.41 mm and greater for 1/4" and 5/16" / M6 and M8 threads



TYPE SE-FH 4

- Permanent installation into stainless steel sheets as thin as .040" / 1 mm.
- For use in sheet hardness of 92 or less on the Rockwell "B" scale.

Thread Size x Pitch	Type	Thread Code	Length Code "L" + 0.4 (Length Code in millimeters)										Sheet Thickness	Hole Size in Sheet +0.08	Max. Hole in Attach Parts	H +0.4	S Max.	Min. Dist. Hole C/L to Edge
			6	8	10	12	15	18	20	25	30	35						
M3 x 0.5	SE-FH4	M3	6	8	10	12	15	18	20	NA	NA	1-2.4	3	3.6	4.6	2.1	5.6	
M4 x 0.7	SE-FH4	M4	6	8	10	12	15	18	20	25	30	1-2.4	4	4.6	5.9	2.4	7.2	
M5 x 0.8	SE-FH4	M5	NA	8	10	12	15	18	20	25	30	1-2.4	5	5.6	6.5	2.7	7.2	
M6 x 1	SE-FH4	M6	NA	NA	10	12	15	18	20	25	30	1-2.4	6	6.6	8.2	3	7.9	