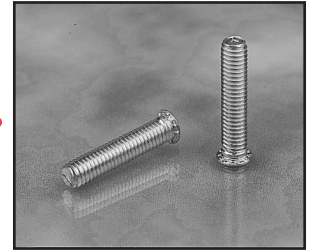


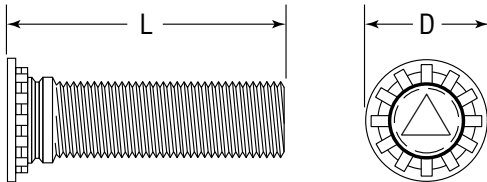


Self-Clinching Studs

Series CH, CHS & CHA

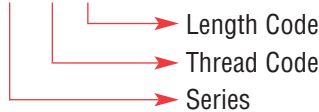


CH studs provide a strong flush-head assembly in material as thin as .040 in. (1.0 mm) with high torque-out and pushout performance.



Part Number Structure:

CH 256-4



Series	Material	Finish
CH	Heat-treated Carbon Steel	Zinc* Clear
CHS	300 Series Stainless Steel	Passivated ASTM A380
CHA	2024-T4 Aluminum	None

*Spec. ASTM B633-85

Thread: Class 2A, MIL-S-7742; (6g ISO Metric).

Use in: CH- Materials with HRB-80 or less.
 CHS- Materials with HRB-70 or less.
 CHA- Materials with HRB-50 or less.

Dimensions & Specifications

INCH (in.)	Thread Size	Thread Code	L Length ±.015 in.										D ± .015	+ .003 - .000	Max.* Rec. Nut Tight. Torque in.-lbs	Min.	Min.
			.250	.3125	.375	.500	.625	.750	.875	1.00	1.25	1.50					
	#2-56	256	-4	-5	-6	-8	-10	-12 [†]					.144	.085	2.5	.187	.040
	#4-40	440	-4	-5	-6	-8	-10	-12	-14	-16 [†]			.176	.111	5	.219	.040
	#6-32	632	-4	-5	-6	-8	-10	-12	-14	-16	-20	-24 [†]	.206	.137	10	.250	.040
	#8-32	832	-4	-5	-6	-8	-10	-12	-14	-16	-20	-24 [†]	.237	.163	15	.281	.040
	#10-24	1024		-5*	-6	-8	-10	-12	-14	-16	-20	-24 [†]	.256	.189	25	.281	.040
	#10-32	1032		-5*	-6	-8	-10	-12	-14	-16	-20	-24	.256	.189	30	.281	.040
	1/4-20	420			-6*	-8	-10	-12	-14	-16	-20	-24	.337	.249	55	.312	.062
	5/16-18	518				-8*	-10	-12	-14	-16	-20	-24	.376	.311	115	.375	.093

† Not stocked, available on special order.

* For aluminum studs, values are 60% of those listed.

Dimensions & Specifications

METRIC (mm)	Thread Size	Thread Code	L Length ± 0.4 mm													D ± 0.4	+0.08 -0.00	Max.* Rec. Nut Tight. Torque N.m	Min.	Min.
			6	8	10	12	15	18	20	22	25	28	30	35	38					
	M2.5X0.45	M2.5	-6 [†]	-8 [†]	-10 [†]	-12 [†]	-15 [†]	-18 [†]								4.1	2.5	.40	5.4	1.0
	M3X0.5	M3	-6 [†]	-8	-10	-12	-15	-18	-20	-22	-25					4.6	3.0	.72	5.6	1.0
	M3.5X0.6	M3.5	-6	-8	-10	-12	-15	-18	-20	-22	-25	-28	-30			5.3	3.5	1.10	6.4	1.0
	M4X0.7	M4	-6 [†]	-8	-10	-12	-15	-18	-20	-22	-25	-28	-30	-35	-38	5.9	4.0	1.6	7.2	1.0
	M5X0.8	M5		-8 [†]	-10	-12	-15	-18	-20	-22	-25	-28	-30	-35	-38	6.5	5.0	3.4	7.2	1.0
	M6X1.0	M6			-10	-12	-15	-18	-20	-22	-25	-28	-30	-35	-38	8.2	6.0	5.7	7.9	1.6
	M8X1.25	M8				-12 [†]	-15	-18	-20	-22	-25	-28	-30	-35	-38	9.6	8.0	14.0	9.6	2.4

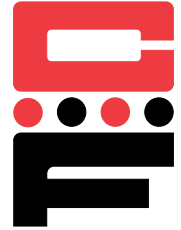
Note: Studs are available in lengths up to 3 in. (76.2 mm) upon special order for 1/4-20/M6 and larger.

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Self-Clinching Studs

Series CH, CHS & CHA

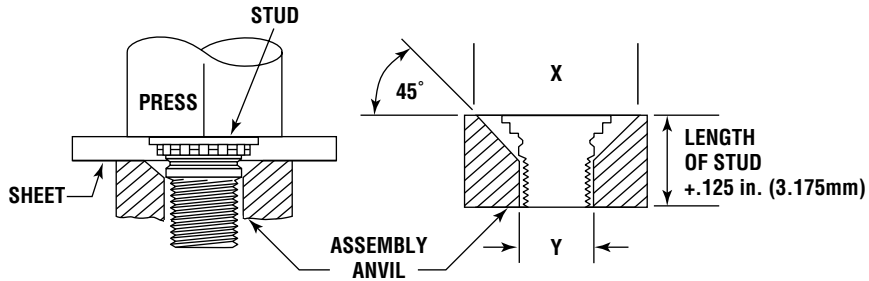


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TOOLING

Note 1.

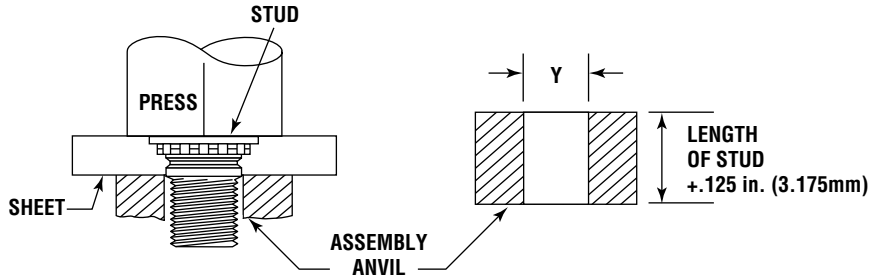
For material thickness of .059 in. or less, a countersunk hole is needed in the anvil.



Tooling for sheet thickness .059 in. (1.51mm) and less with #2 (M2.5) thru #10 (M5) thread sizes and less than .093 in. (2.3mm) for 1/4 in. (M6) threads.

Note 2.

For material thickness of .060 in. or more, a through-hole is needed in the anvil.



Tooling for sheet thickness .060 in. (1.51mm) minimum and greater with #2 (M2.5) thru #10 (M5) thread sizes and .092 in. (2.3mm) minimum and greater for 1/4 in. (M6) and 5/16 in. (M8) threads.

Thread Code	Anvil Dimensions (in.)	
	X +.004	Y +.003
256	.110	.087
	.114	.090
440	.136	.113
	.140	.116
632	.162	.139
	.166	.142
832	.188	.165
	.192	.168
1024	.216	.191
	.220	.194
1032	.216	.191
	.220	.194
420	.295	.250
	.300	.253
518	—	.3125
	—	.3155

Thread Code	Anvil Dimensions (mm)	
	X +0.1	Y +0.08
M2.5	3.1	2.50
M3	3.6	3.00
M3.5	4.1	3.50
M4	4.6	4.00
M5	5.6	5.00
M6	6.6	6.00
M8	—	8.00

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Self-Clinching Studs


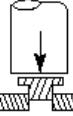
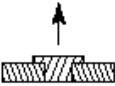
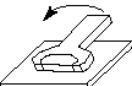



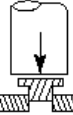
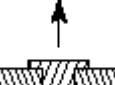
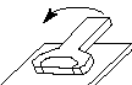
Series CH, CHS &CHA

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Note: Values based on Stainless (steel studs values may be higher)

Installation & Performance Data

INCH (in.)	Thread Code	 Sheet Material & Thickness	 Installation Force (lbs.)	 Pushout (lbs.)	 Torque-out (lbs.)
	256		.062 Aluminum	2000	95
		.062 Steel	2500	175	5
440		.064 Aluminum	3800	165	10
		.062 Steel	4300	270	10
632		.064 Aluminum	3800	175	19
		.062 Steel	4700	295	19
832		.064 Aluminum	4800	215	29
		.062 Steel	6800	370	39
#10-24 #10-32		.064 Aluminum	5500	265	37
		.062 Steel	6800	445	59
420		.093 Aluminum	6500	305	64
		.088 Steel	9500	570	95
518		.093 Aluminum	6500	425	105
		.088 Steel	10000	645	170

METRIC (mm.)	Thread Code	 Sheet Material & Thickness	 Installation Force (kN)	 Pushout (N)	 Torque-out (Nm)
	M2.5		1.6 Aluminum	8.9	625
		1.5 Steel	11.1	1025	0.9
M3		1.6 Aluminum	12.9	890	1.6
		1.5 Steel	14.7	1240	1.6
M3.5		1.6 Aluminum	15.6	980	1.6
		1.5 Steel	22.3	1550	2.7
M4		1.6 Aluminum	22.3	1290	2.8
		1.5 Steel	28.9	1780	4.1
M5		1.6 Aluminum	24.5	1470	3.4
		1.5 Steel	33.4	1980	6.4
M6		2.4 Aluminum	28.9	2000	7.2
		2.2 Steel	29.8	3110	11.2
M8		2.4 Aluminum	29	2440	11.2
		2.2 Steel	44.5	3780	19.1