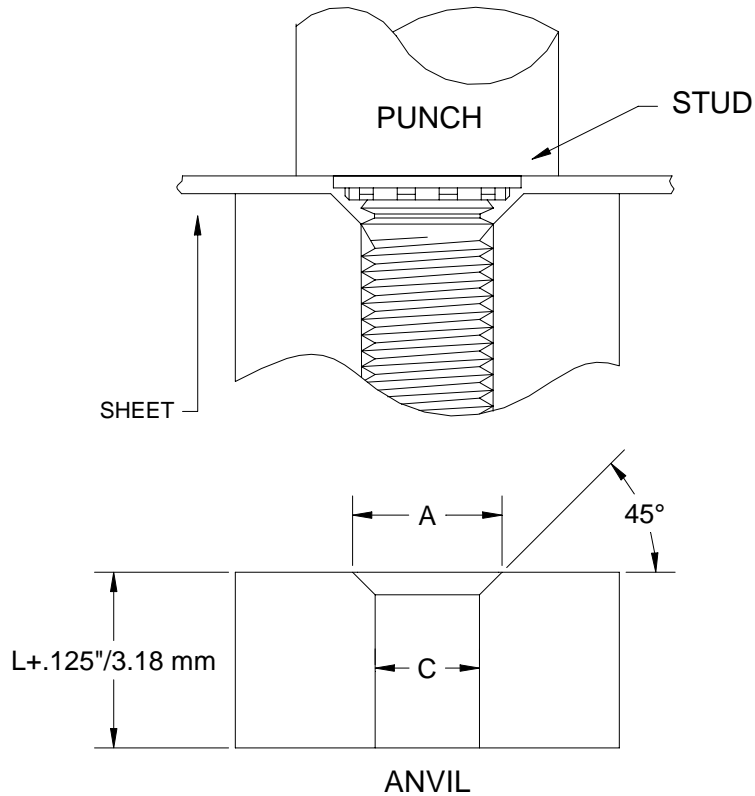


INSTALLATION OF CAPTIVE FASTENER CH, CHS CHA STUDS

TOOLING FOR SHEET THICKNESS .059"/1.5 mm AND LESS.

The diagram below indicates suggested tooling for applying installation forces. Note that for sheets .060"/1.51 mm and thicker, the anvil requires only a straight hole to accommodate stud. For sheets .059"/1.5 mm and less, the installation hole requires a countersink with dimension A at the top to allow metal to flow into the annular ring at the base of the stud.



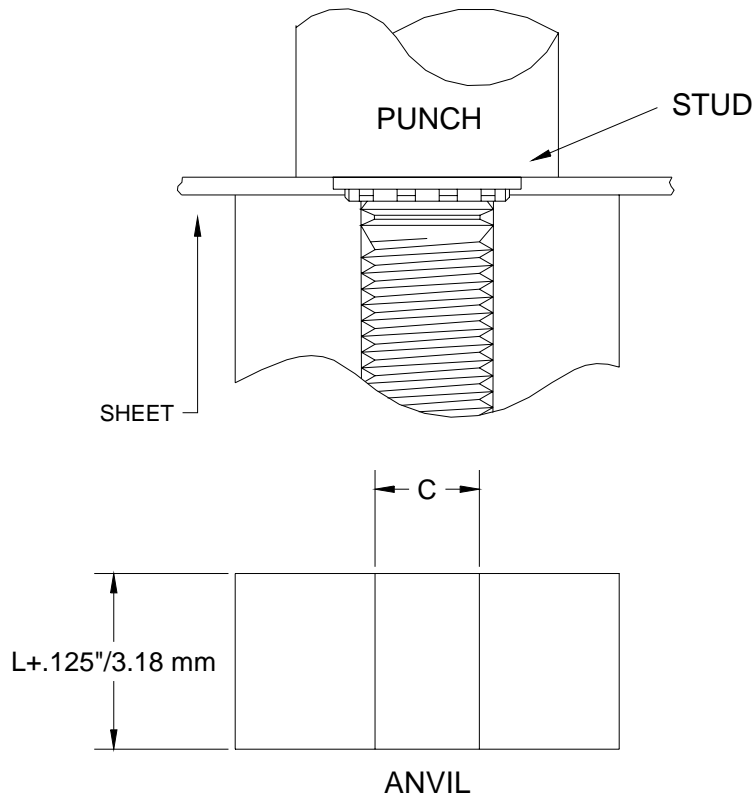
	THREAD CODE	ANVIL DIMENSIONS	
		A	C
UNIFIED	256	.110-.114	.087-.090
	440	.136-.140	.113-.116
	632	.162-.166	.139-.142
	832	.188-.192	.165-.168
	1024 & 1032	.216-.220	.191-.194
	420	.295-.300	.250-.253
	518	-	.3125-.3155
	616	-	.375-.378

	THREAD CODE	ANVIL DIMENSIONS	
		A+0.1	C+0.08
METRIC	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	-	8.03
	M10	-	10.03

INSTALLATION OF CAPTIVE FASTENER CH, CHS/CHA STUDS

TOOLING FOR SHEET THICKNESS .060"/1.51 mm AND GREATER.

The diagram below indicates suggested tooling for applying installation forces. Note that sheets .060"/1.51 mm and thicker, the anvil requires only a straight hole to accommodate stud. For sheets .059"/1.5 mm and less, 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	C
UNIFIED	256	.110-.114	.087-.090
	440	.136-.140	.113-.116
	632	.162-.166	.139-.142
	832	.188-.192	.165-.168
	1024 & 1032	.216-.220	.191-.194
	420	.295-.300	.250-.253
	518	-	.3125-.3155
	616	-	.375-.378

	THREAD CODE	ANVIL DIMENSIONS	
		A+0.1	C+0.08
METRIC	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	-	8.03
	M10	-	10.03