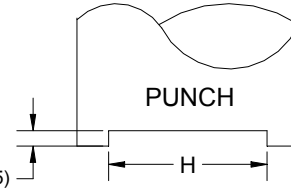
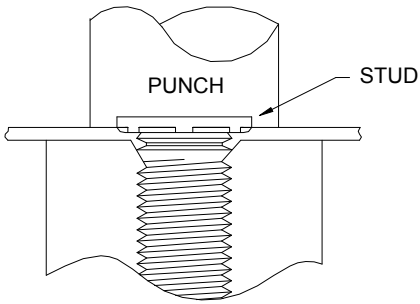


INSTALLATION OF CAPTIVE FASTENER HCW STUDS

Using the punch against the head of the stud, apply an adequate steady squeezing force that results in only setting the lobes of the head into the sheet material.



.035"-.036"(032)/0.94mm-0.96mm(M5)
 .045"-.046" (420)/1.14mm-1.16mm(M6)
 .063"-.064"(0518)/1.62mm-1.64mm (M8)
 .077"-.078"(0616)/2.1mm-2.12mm(M10)

+ .015"/+0.4mm
 + .025"/+0.6mm

PERFORMANCE DATA OF CAPTIVE FASTENER HCH, HCHS STUDS

INCH (in.)	Thread Code	Sheet Material & Thickness	Sheet Hardness HRB	Installation Force (lbs.)	Pushout (lbs.)	Torque Out (lbs.)	Pull thru (lbs.)
	1024	1032	.060 Aluminum	27	7500	175	58
.060 Steel			67	9500	350	58	2200
420	518	.065 Aluminum	27	8000	340	118	3200
		.059 Steel	67	13500	600	128	3600
518		.091 Aluminum	22	9000	400	238	6000
		.090 Steel	65	15500	650	288	6400

METRIC (mm)	Thread Code	Sheet Material & Thickness	Sheet Hardness HRB	Installation Force (kN)	Pushout (N)	Torque Out (N•m)	Pull thru (kN)
	M5		1.5 Aluminum	27	37.7	685	8.0
1.5 Steel			67	51.1	1345	8.0	10.6
M6		1.5 Aluminum	27	39	745	11.7	14.2
		1.5 Steel	67	60	1395	14.3	15.5
M8		2.3 Aluminum	22	42	1225	23.4	25
		2.3 Steel	65	71.1	2395	33.8	27.5