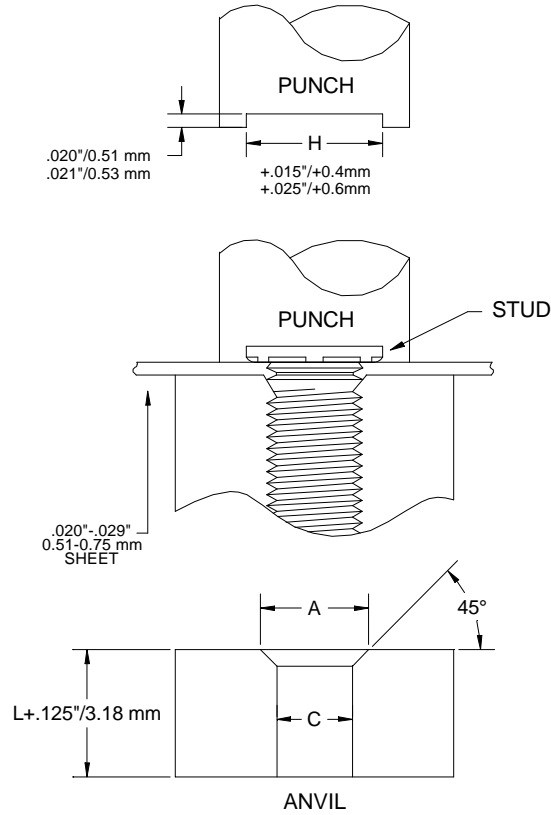


INSTALLATION OF CAPTIVE FASTENER TCH, TCHS STUDS

TOOLING FOR SHEET THICKNESS .020"/0.51 mm TO .029"/0.75 mm.

The diagram below indicates suggested tooling for type TCH Studs. Note that for .030" (0.76 mm) and thicker sheets, the anvil requires only a straight thru hole to accommodate the stud. For .020" (0.51 mm) to .029" (0.75 mm) sheets, the hole requires a countersink with dimension A at the top to provide for metal flow around the shank of the stud. The standard punch design below provides clearance for the stud head and reduces chances of over squeezing the head of the stud into the sheet metal. When installed, the stud head is not flush, but will protrude approximately .025" (0.64 mm).



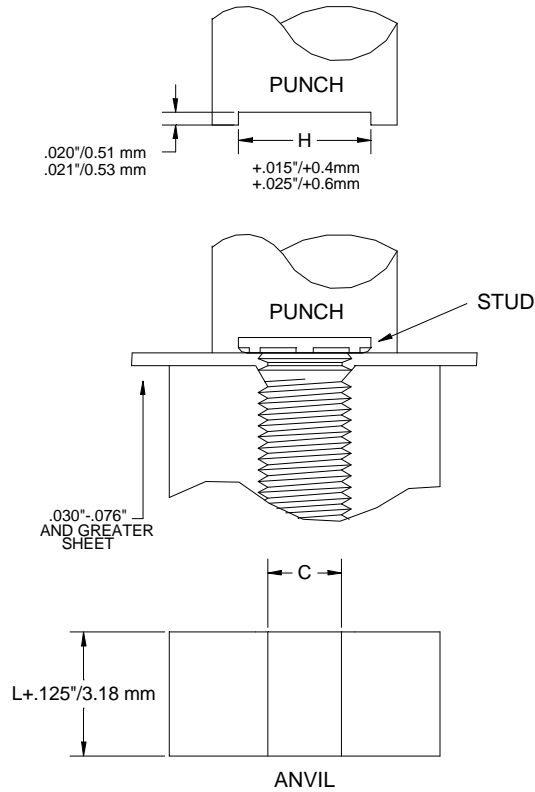
	THREAD CODE	ANVIL DIMENSIONS	
		A	C
UNIFIED	256	.110-.114	.087-.090
	440	.136-.140	.113-.116
	632	.162-.166	.139-.142
	832	.188-.192	.165-.168
	1024 & 1032	.216-.220	.191-.194
	420	.295-.300	.250-.253
	518	-	.3125-.3155
	616	-	.375-.378

	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 TCH, TCHS STUDS

TOOLING FOR SHEET THICKNESS .030"/0.76 mm AND GREATER.

The sketch below indicates suggested tooling for type TCH Studs. Note that for .030"/0.76 mm and thicker sheets, the anvil requires only a straight thru hole to accommodate the stud. For .020"/0.51 mm to .029"/0.75 mm sheets, the hole requires a countersink with dimension A at the top to provide for metal flow around the shank of the stud. The standard punch design below provides clearance for the stud head and reduces chances of over squeezing the head of the stud into the sheet metal. When installed, the stud head is not flush but will protrude approximately .025"/0.64 mm.



	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

