

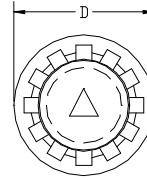
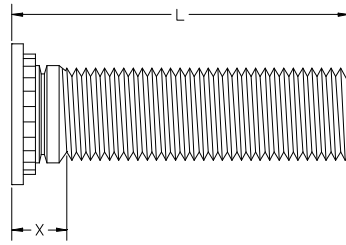


Studs For Stainless Steel Sheets

Series CHTS

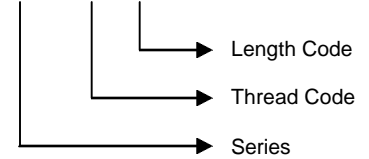


CHTS studs are made of heat treated stainless steel providing a strong, flush-head assembly in stainless steel material as thin as .040 in. (1.0mm) with high torque-out and pushout performance.



Part Number Structure:

CHTS 440 -4



Series	Threads	Material	Finish	Sheet Hardness Requirements
CHTS	External ANSI B1.1 2B/ANSI/ASME B1.13M 6H	400 Series Stainless Steel	Passivate per ASTM A380	92 or less on the Rockwell "B" scale

Dimensions & Specifications

INCH (in.)	THREAD SIZE	TYPE	SERIES	L Length ± 0.015 in.										SHEET THICKNESS	HOLE SIZE IN SHEET +0.003 -0.000	D ± 0.015	X Max
				.250	.312	.375	.500	.625	.750	.875	1.00	1.25	1.50				
	#4-40	CHTS	440	-4	-5	-6	-8	-10	-12	-14	-16			.040-.095	.111	.176	.085
	#6-32	CHTS	632	-4	-5	-6	-8	-10	-12	-14	-16	-20	-24	.040-.095	.137	.206	.090
	#8-32	CHTS	832	-4	-5	-6	-8	-10	-12	-14	-16	-20	-24	.040-.095	.163	.237	.090
	#10-32	CHTS	1032	-4	-5	-6	-8	-10	-12	-14	-16	-20	-24	.040-.095	.189	.256	.100

Dimensions & Specifications

METRIC (mm)	THREAD SIZE	TYPE	SERIES	L Length ± 0.4 mm										SHEET THICKNESS	HOLE SIZE IN SHEET +0.08	D ± 0.4	X Max
				6	8	10	12	15	18	20	25	30	35				
	M3 X 0.5	CHTS	M3	-6	-8	-10	-12	-15	-18	-20	-25			1-2.4	3	4.6	2.1
	M4 X 0.7	CHTS	M4	-6	-8	-10	-12	-15	-18	-20	-25	-30	-35	1-2.4	3	5.9	2.4
	M5 X 0.8	CHTS	M5	-6	-8	-10	-12	-15	-18	-20	-25	-30	-35	1-2.4	3	6.5	2.7

NOTE: ALL ITEMS SUBJECT TO MINIMUM ORDER



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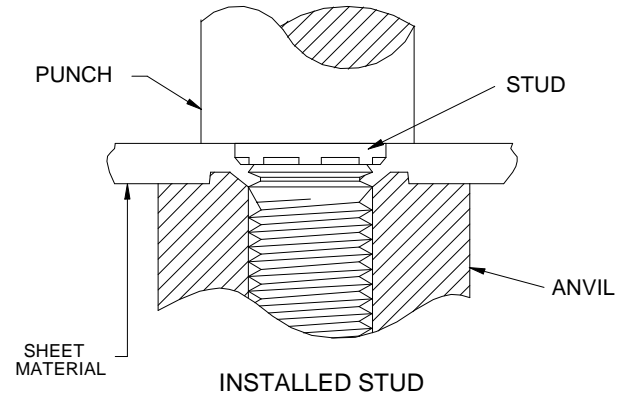


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INSTALLATION DESCRIPTION

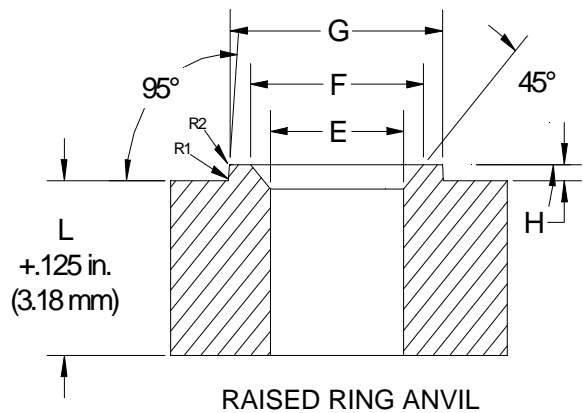
Drill or punch the proper size hole in the parent material and apply the recommended force, with a standard shop press, to fully seat the fastener. For best results, a flat punch with a minimum hardness of Rockwell C55 should be used along with a special anvil that has a raised ring. This will assure full displacement of the stainless sheet material into the clinch ring of the stud.

Be sure to monitor the height of the ring on the anvil periodically and replace anvil when ring height wears down to .005 in. (0.13mm) to assure desired performance.



INCH (in.)	Thread Code	Anvil Dimensions (in.)					
		E	F	G	H	R1	R2
	440	.113	.144	.174	.010	.003	.005
	632	.140	.170	.200	.010	.003	.005
	832	.166	.202	.236	.010	.003	.005
	1032	.191	.235	.275	.010	.003	.005

METRIC (mm)	Thread Code	Anvil Dimensions (mm)					
		E	F	G	H	R1	R2
	M3	3.05	3.81	4.57	0.25	0.08	0.13
	M4	4.04	4.95	5.82	0.25	0.08	0.13
	M5	5.08	6.15	7.16	0.25	0.08	0.13






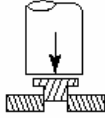
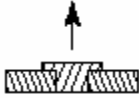
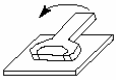
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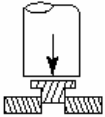
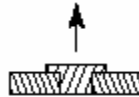
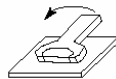
Series CHTS



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Dimensions & Specifications

INCH (in.)		Max. Nut Tightening Torque (in. lbs.)	Sheet Thickness & Material	Sheet Hardness HRB Max				Pull thru (lbs.)
	Thread Code				Installation (lbs.)	Pushout (lbs.)	Torque-out (in.lbs.)	
	440	6	.060" SS	92	9000	740	15	795
	632	11	.060" SS	92	9500	895	25	1340
	832	21	.060" SS	92	11200	995	57	1790
	1032	33	.060" SS	92	12000	1090	93	2245

METRIC (mm.)		Max. Nut Tightening Torque (N.m)	Sheet Thickness & Material	Sheet Hardness HRB Max				Pull thru (N)
	Thread Code				Installation (kN)	Pushout (N)	Torque-out (N.m)	
	M3	9	1.5mm SS	92	40	3290	1.7	3510
	M4	2.1	1.5mm SS	92	50	4400	6.4	7960
	M5	4.3	1.5mm SS	92	53	4850	10.5	9980