

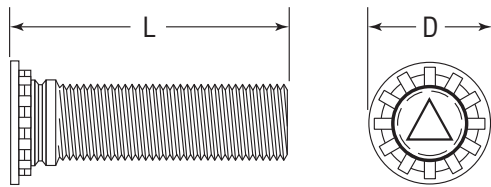
Studs For Stainless Steel Sheets

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 mm) with high torque-out and pushout performance.

Series	Material	Finish
CHTS	400 Series Stainless Steel	Passivated ASTM A380



Thread: External 2A, ANSI B1.1 (6g ANSI/ASME B1.13M).
Use in: CHTS - Materials with HRB-92 or less.

Part Number Structure:

CHTS 440-48



Dimensions & Specifications

INCH (in.)	Thread Size	Series	Thread Code	L Length $\pm .015$ in.										Sheet Thickness	Hole Size In Sheet +.003 -.000	D $\pm .015$	U Max.	Min.
				.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	.219
	#6-32	CHTS	632	-4	-5	-6	-8	-10	-12	-14	-16	-20	-24	.040 - .095	.137	.206	.090	.250
	#8-32	CHTS	832	-4	-5	-6	-8	-10	-12	-14	-16	-20	-24	.040 - .095	.163	.237	.090	.281
	#10-32	CHTS	1032		-5	-6	-8	-10	-12	-14	-16	-20	-24	.040 - .095	.189	.256	.100	.281
	1/4-20	CHTS	420			-6	-8	-10	-12	-14	-16	-20	-24	.062 - .117	.249	.337	.135	.312
	5/16-18	CHTS	518				-8	-10	-12	-14	-16	-20	-24	.093 - .148	.311	.376	.160	.375

Dimensions & Specifications

METRIC (mm)	Thread Size	Series	Thread Code	L Length $\pm .4$ mm										Sheet Thickness	Hole Size In Sheet +.08 -.00	D $\pm .4$	U Max.	Min.
				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	5.6
	M4 x 0.7	CHTS	M4	-6	-8	-10	-12	-15	-18	-20	-25	-30	-35	1 - 2.4	4	5.9	2.4	7.2
	M5 x 0.8	CHTS	M5		-8	-10	-12	-15	-18	-20	-25	-30	-35	1 - 2.4	5	6.5	2.7	7.2
	M6 x 1.0	CHTS	M6			-10	-12	-15	-18	-20	-25	-30	-35	1.6 - 3	6	8.2	3.0	7.9
	M8 x 1.25	CHTS	M8				-12	-15	-18	-20	-25	-30	-35	2.4 - 3.8	8	9.6	3.7	9.6

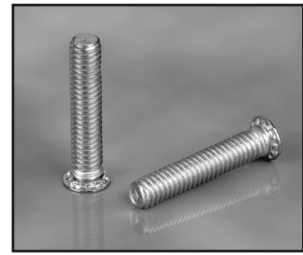
Note: All items subject to minimum order.

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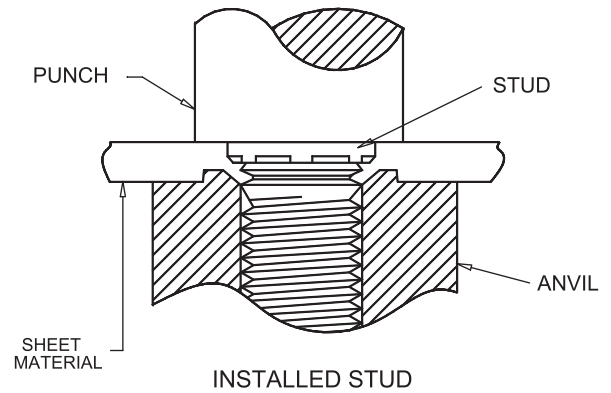


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Installation Procedure

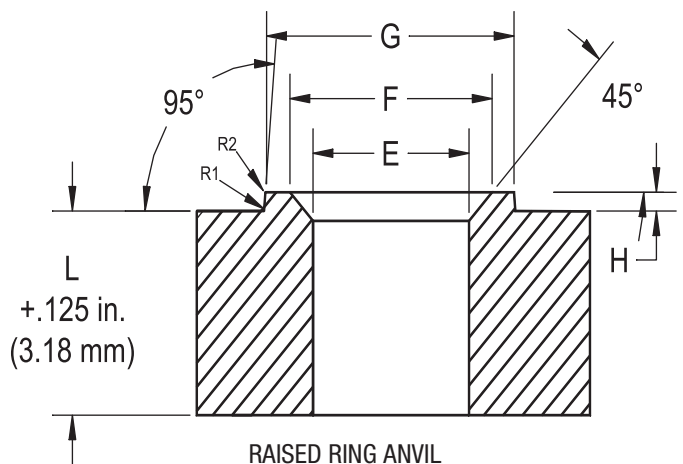
Drill or punch the proper size hole in the parent material and apply the recommended force, with a standard shop press, to fully seat the fastener. For best results, a flat punch with a minimum hardness of Rockwell C55 should be used along with a special anvil that has a raised ring. This will assure 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. (.13 mm) 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
	420	.251	.310	.363	.010	.003	.005
	518	.313	.385	.474	.010	.003	.005

METRIC (mm)	Thread Code	Anvil Dimensions (mm)					
		E	F	G	H	R1	R2
	M3	3.05	3.81	4.57	.25	.08	.13
	M4	4.04	4.95	5.82	.25	.08	.13
	M5	5.08	6.15	7.16	.25	.08	.13
	M6	6.05	7.87	8.79	.25	.08	.13
	M8	7.95	9.78	10.27	.25	.08	.13






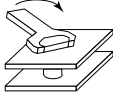
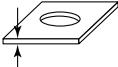
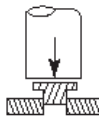
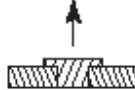

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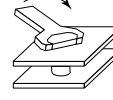

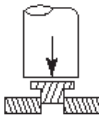


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Dimensions & Specifications

INCH (in.)				Sheet Hardness HRB Max.				Pull thru (lbs.)
	Thread Code	Max. Nut Tightening Torque (in.-lbs.)	Sheet Thickness & Material		Installation (lbs.)	Pushout (lbs.)	Torque-out (in.-lbs.)	
	440	6	.060 SS	92	9000	440	15	795
	632	11	.060 SS	92	9500	530	25	1340
	832	21	.060 SS	92	11200	775	57	1790
	1032	33	.060 SS	92	12000	1045	93	2245
	420	70	.060 SS	92	13000	1590	154	3850
	518	80	.090 SS	92	16000	1775	295	7375

METRIC (mm)				Sheet Hardness HRB Max.				Pull thru (N)
	Thread Code	Max. Nut Tightening Torque (N•m)	Sheet Thickness & Material		Installation (kN)	Pushout (N)	Torque-out (N•m)	
	M3	.9	1.5mm SS	92	40	2210	1.7	3510
	M4	2.1	1.5mm SS	92	50	3200	6.4	7960
	M5	4.3	1.5mm SS	92	53	3570	10.5	9980
	M6	7.2	1.5mm SS	92	58	4195	15.7	14880
	M8	9.0	2.3mm SS	92	71	7895	33.3	32804