Clifa®
press-in nut/stud ...

Clifa®-press-in nuts and Clifa® studs are threaded inserts made of steel with a specially formed shank or head.

Clifa®-press-in nuts and Clifa® studs can also be supplied in rust-proof material, and the nuts additionally in light alloy.

Clifa®-threaded inserts are pressed into moulded components with prepunched receiving holes. During this process, the material flows out of the area of the hole wall into the gear ring / the annular grooves of the Clifa® threaded inserts. A permanent connection is formed.

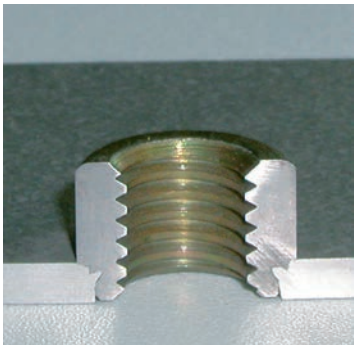
Several Clifa® inserts can be installed in a single work process. The fastening screw is always screwed in from the opposite side.

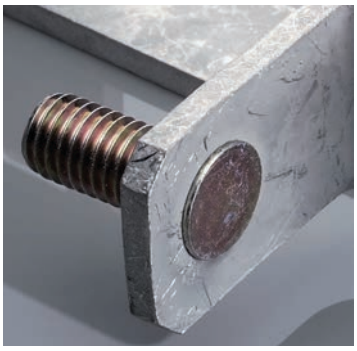
Fields of application

Clifa® press-in elements serve as a screw point mainly on moulded parts of steel or light metal. They may also be used as spacers.

Product features

- Clifa® is torque-proof, capable of withstanding high loads.
- It has minimal outside dimensions for space and weight-saving
- The thread is wear-resistant, clean and true to gauge
- Mounting in drilled, punched or lasered receiving holes
- Do not countersink drill holes in the component
- Can be used in surface-treated, galvanized or unweldable materials
- Clifa® is not pressed out during the screwing process.
- The component material must be softer than the Clifa® element





Specifications

Works Standard sheets Clifa®
Pages 11 to 20

High-performance installation equip ment for short cycle times in largescale production on request.

Clifa® installation ...

Installation

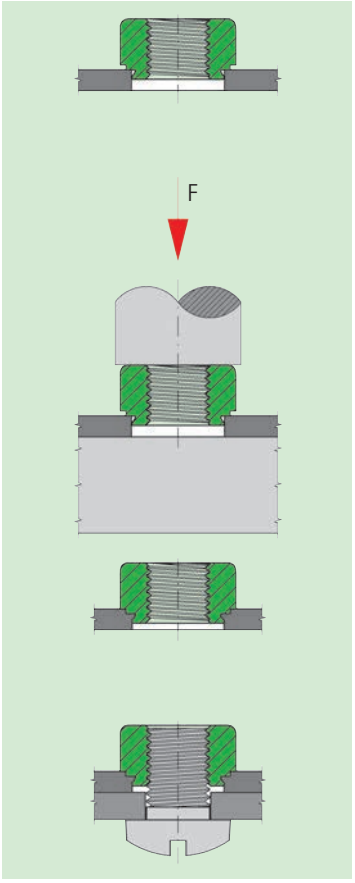
The receiving hole is punched, lasered or drilled **but not deburred or countersunk.**

With punched holes, Clifa® is pressed in from the punching burr side. The press-in process takes place on a plane parallel basis using a customary press with adjustable pressure level, until the surface of the shoulder in the Clifa® pressin nut comes to rest flat against the surface of the sheet metal.

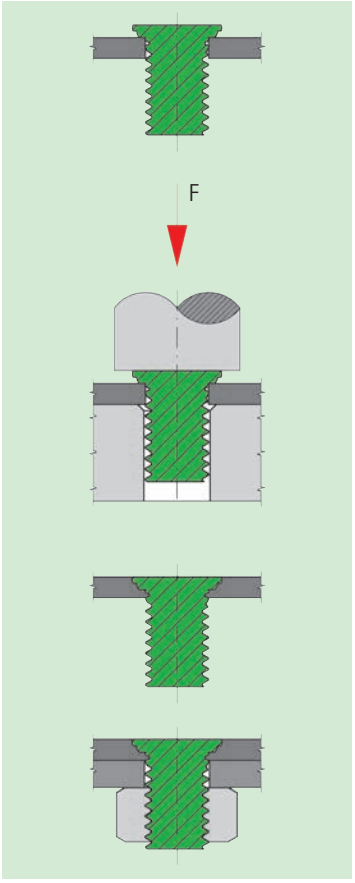
In the case of the Clifa®-SP/SPD/SPS stud, the head must be fully pressed in and come to rest flush with the surface of the sheet metal.

Pressure which is too high or applied only on one side as well as inclined support surfaces must be avoided wherever possible.

Examples for mounting



Press-in nut Clifa® Fig. 7



Press-in stud Clifa®-SP Fig. 8

Special request

short length
standoff bushings for metals
standoff bushings for plastics threaded press-in stud
Flush surface on the press-in side of the nut element (/- thread closed on one side)
Grub screw for thin sheet thicknesses
Grub screw for high load values
threaded press-in stud for lower press-in force

We recommend

Clifa®-M	(Works Standard 500 0 to 503 0)
Clifa®-AM	(Works Standard 503 8 to 525 8)
Clifa®-AL	(Works Standard 503 6 to 525 6)
Clifa®-ABO/-ABG	(Works Standard 570 0 to 571 0)
Clifa®-SPD	(Works Standard 5.. 2)
Clifa®-SA	(Works Standard 515 4 to 534 4)
Clifa®-SAD	(Works Standard 515 9 to 534 9)

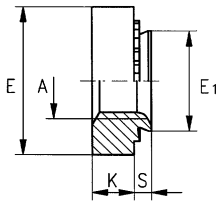
Kerb Konus

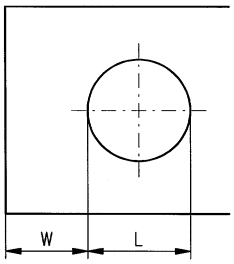
Press-in nut
self-clinching

Clifa®-P
Works Standard
500 5 to 502 5

Application

Clifa®-press-in nuts are used to create wear-free screw connections in thin-walled moulded components from 0,8 mm in thickness.





Dimensions in mm

	Article no. of the first group of digits	for sheet metal thickness M	Shank height max. S
M4 to M5	500 5..	0,8	0,76
	501 5..	1,0	0,97
	502 5..	1,4	1,37
M6	500 5..	1,2	1,15
	501 5..	1,4	1,37
	502 5..	2,3	2,21
M8	501 5..	1,4	1,38
	502 5..	2,3	2,21
M10	501 5..	1,5	1,48
	502 5..	2,3	2,21

Article no. of the second and third group of digits	Internal thread A	External diameter E	Nut height K	Collar max. E_1	Hole diameter L +0,08	Minimum spacing W
... 500 040 ...	M 4	7,9	2,0	5,38	5,4	3,8
... 500 050 ...	M 5	8,7	2,0	6,38	6,4	3,9
... 500 060 ...	M 6	11,05	4,08	8,72	8,75	4,2
... 500 080 ...	M 8	12,65	5,47	10,47	10,5	4,4
... 500 100 ...	M 10	16,50	7,9	12,67	12,7	5,6

Example for finding the article number
Press-in nut Clifa®-P with internal thread M4 made of tempered FK10, zinc plated and blue passivated steel for sheet metal thickness 1,4 mm: Clifa®-P 502 500 040.110

Materials
Steel tempered FK10, zinc plated, blue passivated — Article no. (**fourth** group of digits) 110
Steel tempered FK10, zinc-nickel plated, transparent passivated — Article no. (**fourth** group of digits) 143

Other finishes or special shapes on request.

Tolerances
ISO 2768-m

Thread
Internal thread A: as per ISO 6H

Press-in force
Guideline values for press-in force, see page 12