

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 equipment for short cycle times in largescale production on request.



Clifa® installation ...

Installation

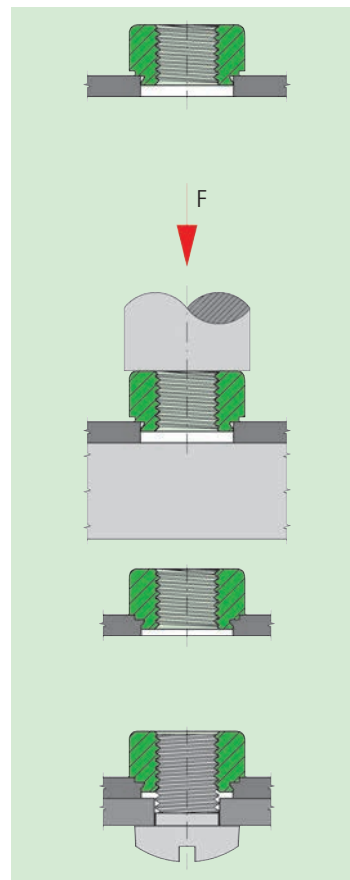
The receiving hole is punched, lasered or drilled **but not deburred or countersunk**.

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.

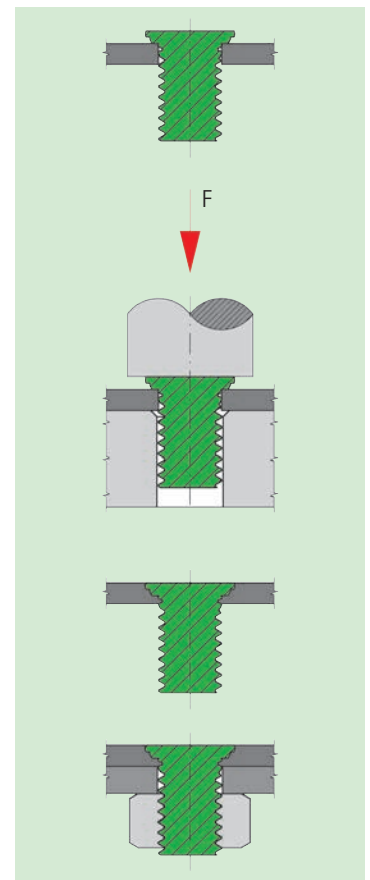
In the case of the Clifa®-SP/SPD/SPS stud, the head must be fully pressed in and come to rest flush with the surface of the sheet metal.

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®



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

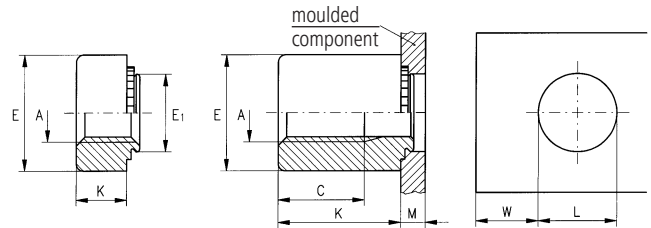
Clifa®-M	(Works Standard 500 0 to 503 0)
Clifa®-AM	(Works Standard 503 8 to 525 8)
Clifa®-AL	(Works Standard 503 6 to 525 6)
Clifa®-ABO/-ABG	(Works Standard 570 0 to 571 0)
Clifa®-SPD	(Works Standard 5.. 2)
Clifa®-SA	(Works Standard 515 4 to 534 4)
Clifa®-SAD	(Works Standard 515 9 to 534 9)

Application

Clifa®-press-in nuts/standoff bushings are used to create wearfree screw connections capable of withstanding high loads in thin-walled moulded components from 0,8 mm in thickness made of

- steel,
- light alloy,
- NF metal (up to hardness HRB 80).

The nut is anchored in the component as a result of the press-in process.



Dimensions in mm

Article number	for sheet metal thickness M	Internal thread A	Internal thread E	Collar diameter E ₁	Hole diameter L +0,05	Minimum spacing W
5.. 800 0.. ...	0,8 to 1,0	M 3	7,0	4,7	4,75	3,6
5.. 800 1.. ...	1,1 to 1,4	M 4	8,0	5,35	5,40	3,8
5.. 800 2.. ...	1,5 to 2,3	M 5	9,0	6,3	6,35	3,8
5.. 800 3.. ...	from 2,4					

Example for finding the article number

Press-in nut Clifa®-AM with internal thread M3, nut height 8,0 mm, made of hardened, zinc plated and blue passivated steel for sheet metal thickness 1,8 mm: Clifa®-AM 508 800 230.110

Nut height K available between 3,0 and 25 mm in 1,0 mm graduations

The **second** and **third** digit of the article number (503 800...; 504 800; 505 800...; ...; 525 800...) are used to identify the nut height K, the **seventh** digit to differentiate the sheet thickness (503 800 130...; 503 800 230...; 503 800 330...).

With nut heights > 8,0 mm, the usable thread length remains C 7,5 mm.

Materials

Steel hardened, zinc plated, blue passivated
 Steel hardened, zinc-nickel plated, transparent passivated
 Stainless steel 1.4305
 Light alloy

Article no. (**fourth** group of digits) 110
 Article no. (**fourth** group of digits) 143
 Article no. (**fourth** group of digits) 500
 Article no. (**fourth** group of digits) 700

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