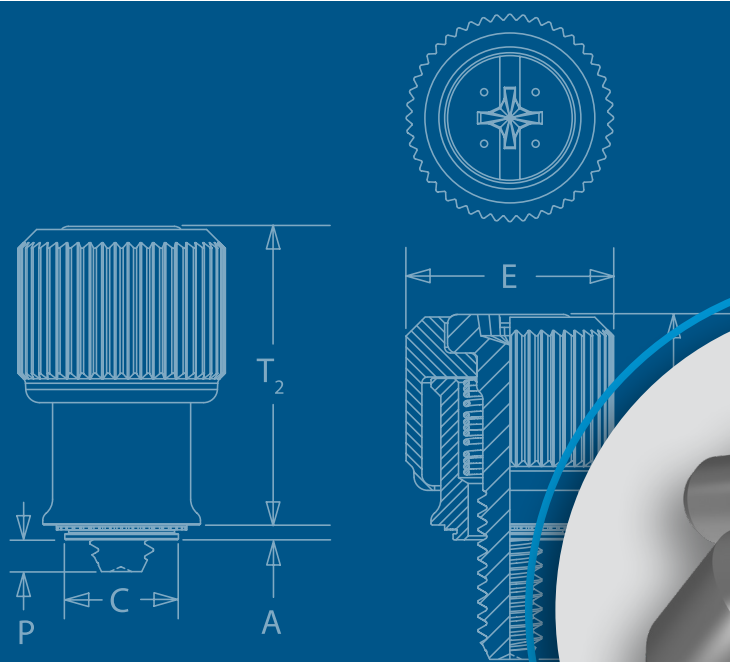




PF™

PEM® CAPTIVE PANEL SCREWS



PEM® captive hardware for
easy service access without
loose components.



PEM® brand captive panel screws are designed to help keep parts to a minimum and eliminate risks associated with loose hardware that could fall out and damage internal components. These panel fastener assemblies are ideal to attach metal panels or other thin material components in applications where subsequent access will be necessary.

Fastener drawings and models are available at www.pemnet.com.

Custom sizes are available on special order.
[Contact us](#) for more information.

PF11™/PF12™/PF11M™/PF12M™/PF15™/PF15M™ large knob, spring-loaded self-clinching panel screws — [PAGE 5](#)



PF11MF™ large knob, spring-loaded flare-mounted captive panel screws — [PAGE 6](#)



PF11MW™ large knob, spring-loaded flare-mounted, floating captive panel screws — [PAGE 7](#)



PF11PM™ large knob, spring-loaded plastic PEM® C.A.P.S.® captive panel screws — [PAGE 8](#)



PFHV™ screw, non-spring captive panel screw — [PAGE 9](#)



PF7M™ captive panel screw, spring-loaded self-clinching captive panel screws — [PAGE 10](#)



PF7MF™ spring-loaded, flare-mounted captive panel screw — [PAGE 11](#)



PF30™ low-profile knob, spring-loaded captive panel screws — [PAGE 12](#)



PF50™ and **PF60™** low-profile knob, spring-loaded captive panel screws — [PAGE 13](#)



PFC4™ recessed-head captive panel screws for installing into stainless steel — [PAGE 14](#)



PFC2P™ tool only, non-flush, spring-loaded captive panel screws — [PAGE 15](#)



PFC2™/PFS2™ screw head, spring-loaded captive panel screws — [PAGE 16](#)



PTL2™/PSL2™ locating pin, spring-loaded plunger assemblies — [PAGE 17](#)



SCBR™ tool only, spinning clinch bolt with spring — [PAGE 18](#)



SCB™/SCBJ™ tool only, spinning clinch bolts, no spring — [PAGE 19](#)



HSCB™, HSR™, and HSL™ heat sink mounting fastener system — [PAGE 20-21](#)



PF10™ tool only, flush-mounted captive panel screws, no spring — [PAGE 22-23](#)



REELFAST® SMTPFLSM™ surface mount spring-loaded captive panel screws — [PAGE 24](#)



REELFAST® SMTPF™ surface mount, panel screw components — [PAGE 25](#)



PFK™ screw head, spring-loaded broaching captive panel screws — [PAGE 26](#)



Value-added capabilities — [PAGE 27](#)

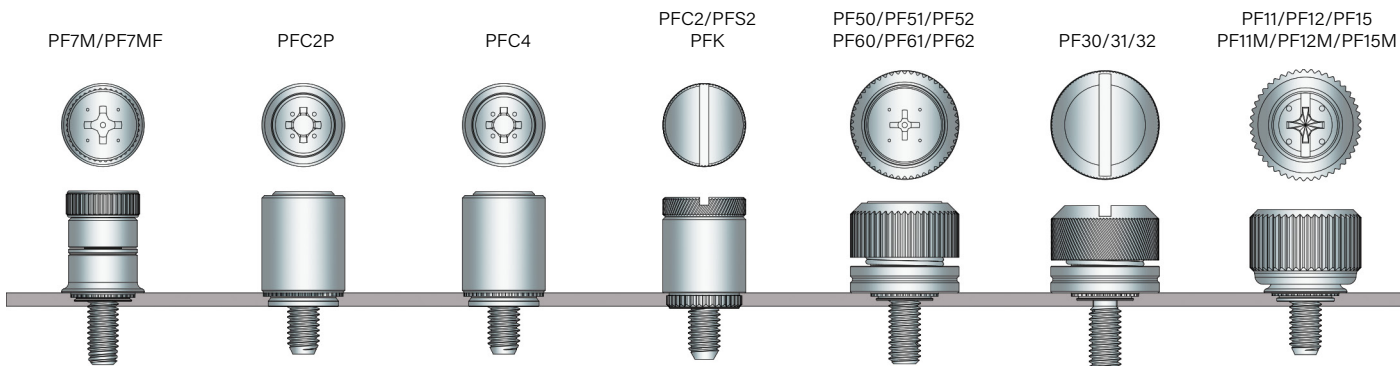
Captive panel screw installation — [PAGE 28-37](#)

Captive panel screw performance data — [PAGE 38-42](#)

Captive panel screw capabilities — [PAGE 43](#)

Height Comparison Guide And Standard Driver Recess

Installed and fastened height above sheet for M3 Thread size.

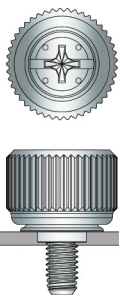


Captive Panel Screw Selector Guide

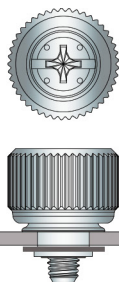
PEM® Panel Fastener Type	Page No.	Application Requires:														
		UL Approved	High corrosion resistance	Spring loaded	Actuation		Installs into				Multiple screw lengths	Flush mounted top side	Available in black	Available in custom colors	Includes anti cross-threading feature	Mating hole misalignment
					Tool	Hand	Thinner sheets	Printed circuit boards	Stainless steel sheet	Painted panels and/or any hardness						
PF11/PF15	5			•	•	•					•		•			
PF11M/PF15M	5			•	•	•					•		•		•	
PF12	5			•	•						•		•			
PF12M	5			•	•						•		•		•	
PF11MF	6			•	•	•	•		•	•	•		•		•	
PF12MF	6			•	•		•		•	•	•		•		•	
PF11MW	7			•	•	•	•	•	•	•	•		•		•	•
PF12MW	7			•	•		•	•	•	•	•		•		•	•
PEM C.A.P.S.	8			•	•	•					•		•(1)	•	•	
PFHV	9				•						•		•			
PF7M	10			•	•	•					•				•	
PF7MF	11			•	•	•	•		•	•	•				•	
PF30 PF31 PF32	12			•	•	•							•			
PF50 PF51 PF52	13			•	•	•					•		•			
PF60 PF61 PF62	13			•	•						•		•			
PFC4	14	•		•	•				•		•					
PFC2P	15	•		•	•						•		•			
PFC2	16		•	•	•	•					•		•			
PFS2	16			•	•	•					•		•			
SCBR	18			•	•											
SCB/SCBJ	19				•						•					
HSCB	20-21			•	•											
PF10	22-23	•	•		•							•				
SMTPLSM	24			•	•	•		•			•				•	
SMTPF	25				•	•		•			•		•(1)	•		
PFK	26		•	•	•	•		•			•		•			

(1) Standard color is black.

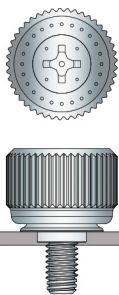
PF11MF



PF11MW



PEM C.A.P.S.®



HSCB



PFHV



SCBR



SCB/SCBJ

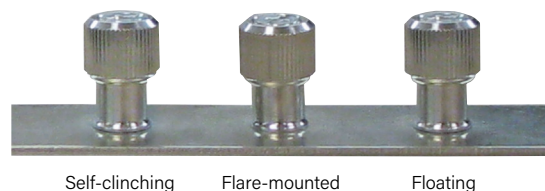


PF10



PEM® PF11™, PF12™, PF15™, PF11MF™, PF11MW™, And PEM® C.A.P.S.® Captive Panel Screws

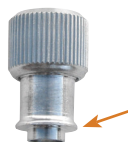
- Available in three installation types; self-clinching, flare-mounted and floating
- All have the same profile or look above the sheet or panel
- Standard selection of knobs include knurled, semi-smooth or smooth metal caps and plastic PEM C.A.P.S.® (Colored Access Panel Screws)



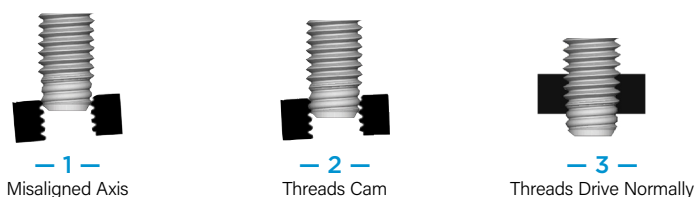
Key Features Include:

- Shoulder on retainer to provide positive stop during installation.
- Anti cross-threading feature (designated with an "M" in the part number). Eases assembly, aligns components, improves assembly line productivity, prevents jamming, and slides through clogged internal threads.
- We offer a solution that is compliant with ATCA® specifications. Contact [Tech Support](#) for more information.

Shoulder on Retainer



Anti Cross-thread Technology - How it works



PennEngineering is a licensee for MATHread® technology, a registered trademark of MATHread Inc.

Standard Mounting Styles:

Self-clinching

- Installs flush on back side of panel.
- Available in three screw lengths.



Flare-mounted

- Appropriate for close centerline-to-edge applications.
- Doesn't require high installation force.
- Installs into any panel hardness.
- Installs flush on back side of panel.
- Can be installed into most any thin material.
- Appropriate for painted panels.



Flare-mounted, Floating

- Compensates for mating hole misalignment.
- Installs into any panel hardness.



Standard Cap Selection:



Knurled Metal Cap
All metal cap available with knurls.



Smooth Metal Cap
All metal cap available without knurls.



Semi-smooth Metal Cap
All metal cap available with partial knurls.



Black Metal Cap
DuraBlack™ finish is scratch resistant. Finish is on both metal cap and screw. (finish code "BL")



Plastic Cap
Available with custom color plastic cap. (See [page 8](#) for colors)

Available Drive Configurations:

PF11



Phillips/slot
(Standard -
except for plastic cap)

PF11P



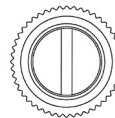
Phillips
(Optional)

PF11LS



Torx®/Slot
Combination
(Optional)

PF11S



Slotted
(Optional)

PF11L



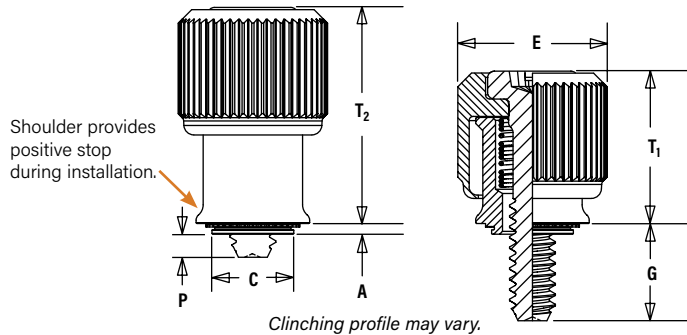
Torx®
(Optional)

PennEngineering is a licensee for Acument Global Technologies (Torx®).

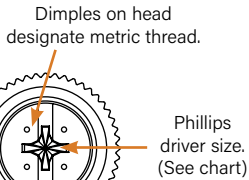
PF11™/PF12™/PF15™ Captive Panel Screws



New semi-smooth cap design reduces scratches



Float .010"/.25mm minimum, in all directions from center, .020"/.5mm total.
Installation Data [page 28](#), Performance Data [page 36](#).



Threads:

External, ASME B1.1, 2A / ASME B1.13M, 6g

Material:

Knob: Aluminum
Retainer: Hardened Carbon Steel
Screw (PF11/PF12/PF15): 400 Series Stainless Steel
Screw (PF11M/PF12M/PF15M): Hardened Carbon Steel ⁽¹⁾
Spring: 300 Series Stainless Steel

Finish:

Knob: Natural Finish
Retainer: Bright nickel over copper flash,
per ASTM B689, Type II
Screw (PF11/PF12/PF15): Passivated and/or tested per ASTM A380
Screw (PF11M/PF12M/PF15M): Zinc plated per ASTM B633, SC1 (5µm),
Type III, colorless ⁽³⁾
Spring: Natural Finish

Optional Finish (BL):

Knob: Black anodize ⁽²⁾
Screw: Black nitride, AMS2753, Section 3 ⁽²⁾

For use in sheet hardness:

HRB 80 or less (Hardness Rockwell "B" Scale) / HB 150 or less (Hardness Brinell)

Part Number Designation

PF11 M - 632 - 1 BL

↓ ↓ ↓ ↓ ↓

Type Optional Thread Screw Optional
Anti-cross Code Length DuraBlack
thread feature Code Code finish

All dimensions are in inches.

	Thread Size	Type			Thread Code	Screw Length Code	A Max.	Min. Sheet Thickness	Hole Size In Sheet + .003 - .000	C Max.	E ± .010	G ± .025	P ± .025	T ₁ Nom.	T ₂ Nom.	Driver Size	Min. Dist. Hole C/L to Edge (4)
		Knurled Cap	Smooth Cap	Semi-smooth Cap													
Unified	#12-40 (#4-40)	PF11	PF12	PF15	440	0	.036	.036	.219	.218	.417	.170	.000	.310	.450	#1	.28
		PF11M	PF12M	PF15M		1						.230	.060				
						2						.290	.120				
	#18-32 (#6-32)	PF11	PF12	PF15	632	0	.036	.036	.250	.249	.450	.230	.000	.450	.640	#2	.29
		PF11M	PF12M	PF15M		1						.290	.060				
						2						.350	.120				
	#16-32 (#8-32)	PF11	PF12	PF15	832	0	.036	.036	.312	.311	.514	.230	.000	.450	.640	#2	.33
		PF11M	PF12M	PF15M		1						.290	.060				
						2						.350	.120				
	#19-32 (#10-32)	PF11	PF12	PF15	032	0	.036	.036	.312	.311	.514	.230	.000	.450	.640	#2	.33
		PF11M	PF12M	PF15M		1						.290	.060				
						2						.350	.120				
	#250-20 (1/4-20)	PF11	PF12	PF15	0420	0	.036	.036	.375	.374	.575	.290	.000	.530	.790	#3	.46
		PF11M	PF12M	PF15M		1						.350	.060				
						2						.410	.120				

All dimensions are in millimeters.

	Thread Size x Pitch	Type			Thread Code	Screw Length Code	A Max.	Min. Sheet Thickness	Hole Size In Sheet + 0.08	C Max.	E ± 0.25	G ± 0.64	P ± 0.64	T ₁ Nom.	T ₂ Nom.	Driver Size	Min. Dist. Hole C/L to Edge (4)
		Knurled Cap	Smooth Cap	Semi-smooth Cap													
Metric	M3 x 0.5	PF11	PF12	PF15	M3	0	0.92	0.92	5.56	5.54	10.59	4.32	0	7.87	11.43	#1	7.11
		PF11M	PF12M	PF15M		1						5.84	1.52				
						2						7.37	3.05				
	M3.5 x 0.6	PF11	PF12	PF15	M3.5	0	0.92	0.92	6.35	6.33	11.43	5.84	0	11.43	16.26	#2	7.37
		PF11M	PF12M	PF15M		1						7.37	1.52				
						2						8.89	3.05				
	M4 x 0.7	PF11	PF12	PF15	M4	0	0.92	0.92	7.92	7.9	13.06	5.84	0	11.43	16.26	#2	8.38
		PF11M	PF12M	PF15M		1						7.37	1.52				
						2						8.89	3.05				
	M5 x 0.8	PF11	PF12	PF15	M5	0	0.92	0.92	7.92	7.9	13.06	5.84	0	11.43	16.26	#2	8.38
		PF11M	PF12M	PF15M		1						7.37	1.52				
						2						8.89	3.05				
	M6 x 1	PF11	PF12	PF15	M6	0	0.92	0.92	9.53	9.5	14.61	7.37	0	13.46	20.07	#3	11.68
		PF11M	PF12M	PF15M		1						8.89	1.52				
						2						10.41	3.05				

(1) As with all Class 2A/6g external threads with an additive finish, the maximum major and pitch, after plating, may equal basic sizes and be gauged to Class 3A/4h, per ANSI B1.1, Section 8, Table 3A and ANSI B1.13M, Section 8, Paragraph 8.2.

(2) "BL" suffix will be added to part number to designate DuraBlack™ finish.

(3) See PEM Technical Support section of our website (www.pemnet.com) for related plating standards and specifications.

(4) For more information on proximity to bends and distance to other clinch hardware, see [PEM® Tech Sheet C/L To Edge](#).

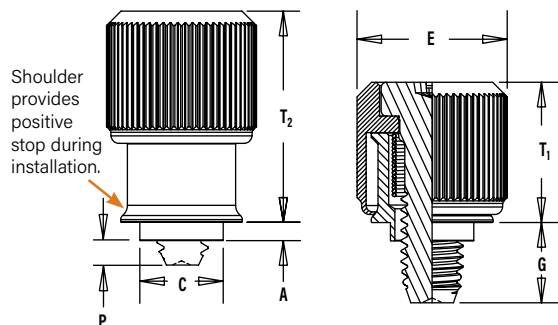
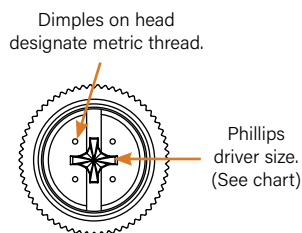
PFMF™ Flare-Mounted Captive Panel Screws



PF11MF
Knurled Cap



PF12MF
Smooth Cap



Float .010"/0.25mm minimum, in all directions from center, .020"/0.5mm total.
Installation Data [page 28](#). Performance Data [page 36](#).

Threads:

External, ASME B1.1, 2A / ASME B1.13M, 6g ⁽¹⁾

Material:

Knob: Aluminum
Retainer: Aluminum
Screw: Hardened Carbon Steel
Spring: 300 Series Stainless Steel

Finish:

Knob: Natural Finish
Retainer: Natural Finish
Screw: Zinc plated per ASTM B633, SC1 (5µm), Type III, colorless ⁽³⁾
Spring: Natural Finish

Optional Finish (BL):

Knob: Black anodize ⁽²⁾
Screw: Black nitride AMS2753, Section 3 ⁽²⁾

Part Number Designation

PF11 PF12	M M	F F	- 632 - 1 - 632 - 1		BL
Type	Anti-cross Thread Feature	Flare- mounted Style	Thread Code	Screw Length Code	Optional DuraBlack finish

All dimensions are in inches.

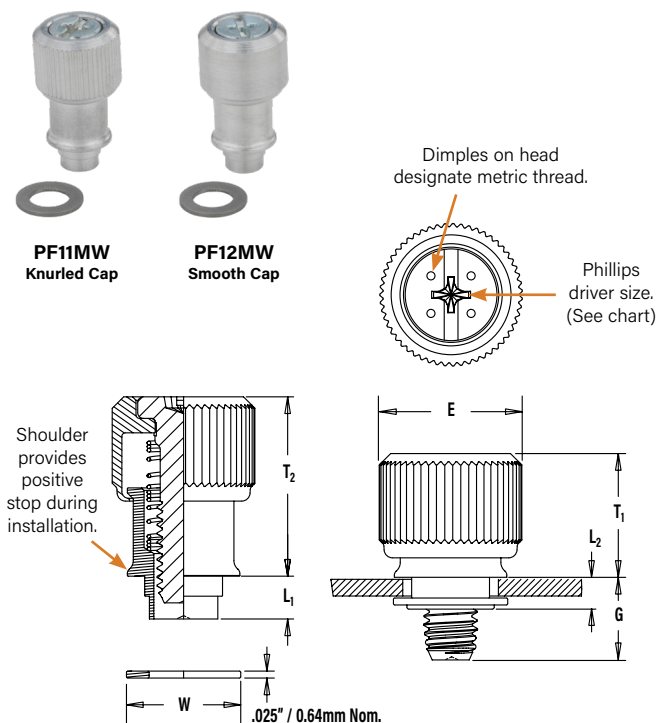
	Thread Size	Type		Thread Code	Screw Length Code	A Max.	Min. Sheet Thickness	Countersunk Hole Size In Sheet ⁽⁴⁾ +.005 - .000	C Max.	E ± .010	G ± .025	P ± .025	T ₁ Nom.	T ₂ Nom.	Driver Size
		Knurled Cap	Smooth Cap												
Unified	.112-40 (#4-40)	PF11MF	PF12MF	440	0	.041	.031	.187	.186	.417	.170	.000	.310	.450	#1
					1						.230	.055			
					2						.290	.115			
	.138-32 (#6-32)	PF11MF	PF12MF	632	0	.072	.060	.213	.212	.450	.230	.000	.450	.640	#2
					1						.290	.024			
					2						.350	.084			
	.164-32 (#8-32)	PF11MF	PF12MF	832	0	.072	.060	.266	.265	.514	.230	.000	.450	.640	#2
					1						.290	.024			
					2						.350	.084			
	.190-32 (#10-32)	PF11MF	PF12MF	032	0	.072	.060	.266	.265	.514	.230	.000	.450	.640	#2
					1						.290	.024			
					2						.350	.084			
	.250-20 (1/4-20)	PF11MF	PF12MF	0420	0	.072	.060	.323	.322	.575	.290	.000	.530	.790	#3
					1						.350	.024			
					2						.410	.084			

All dimensions are in millimeters.

	Thread Size x Pitch	Type		Thread Code	Screw Length Code	A Max.	Min. Sheet Thickness	Countersunk Hole Size In Sheet ⁽⁴⁾ +0.1	C Max.	E ± 0.25	G ± 0.64	P ± 0.64	T ₁ Nom.	T ₂ Nom.	Driver Size
		Knurled Cap	Smooth Cap												
Metric	M3 x 0.5	PF11MF	PF12MF	M3	0	1.05	0.79	4.75	4.73	10.59	4.32	0	7.87	11.43	#1
					1						5.84	1.4			
					2						7.37	2.92			
	M4 x 0.7	PF11MF	PF12MF	M4	0	1.83	1.52	6.76	6.74	13.06	5.84	0	11.43	16.26	#2
					1						7.37	0.61			
					2						8.89	2.13			
	M5 x 0.8	PF11MF	PF12MF	M5	0	1.83	1.52	6.76	6.74	13.06	5.84	0	11.43	16.26	#2
					1						7.37	0.61			
					2						8.89	2.13			
	M6 x 1	PF11MF	PF12MF	M6	0	1.83	1.52	8.2	8.18	14.61	7.37	0	13.46	20.07	#3
					1						8.89	0.61			
					2						10.41	2.13			

- (1) As with all Class 2A/6g external threads with an additive finish, the maximum major and pitch, after plating, may equal basic sizes and be gauged to Class 3A/4h, per ANSI B1.1, Section 8, Table 3A and ANSI B1.13M, Section 8, Paragraph 8.2.
- (2) "BL" suffix will be added to part number to designate DuraBlack™ finish.
- (3) See PEM Technical Support section of our website (www.pemnet.com) for related plating standards and specifications.
- (4) See [page 28](#) for countersunk hole size detail.

PFMW™ Flare-Mounted, Floating Captive Panel Screws



Installation Data [page 29](#). Performance Data [page 36](#).

Threads:

External, ASME B1.1, 2A / ASME B1.13M, 6g ⁽¹⁾

Material:

Knob: Aluminum
Retainer: Aluminum
Screw: Hardened Carbon Steel
Spring: 300 Series Stainless Steel
Washer: 300 Series Stainless Steel

Finish:

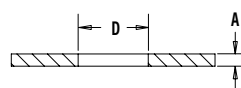
Knob: Natural Finish
Retainer: Natural Finish
Screw: Zinc plated per ASTM B633, SC1 (5µm), Type III, colorless ⁽³⁾
Spring: Natural Finish
Washer: Natural Finish

Optional Finish (BL):

Knob: Black anodize ⁽²⁾
Screw: Black nitride,
AMS2753,
Section 3 ⁽²⁾

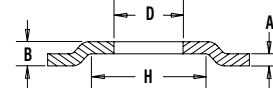
Panel Configuration 1

For applications where a space between mating panels is acceptable.



Panel Configuration 2

For applications where a space between mating panels is not acceptable.



Part Number Designation

PF11	M	W - 632 - 1	1	BL
PF12	M	W - 632 - 1	1	
Type	Anti-cross Thread Feature	Floating style	Thread Code	Shank Code ⁽⁴⁾
			Screw Length Code ⁽⁴⁾	Optional DuraBlack finish

PF11MW panel fasteners are shipped with mating washers.

All dimensions are in inches.

Unified	Thread Size	Type		Thread Code	Shank Code (4)	Screw Length Code (4)	A Max. Sheet Thickness	B Min.	D Hole Size In Sheet +.003 -.001	E ±.010	G Nom.	H Min.	L1 Nom.	L2 Max.	T1 Nom.	T2 Nom.	Driver Size	Min. Total Float	W Nom.
		Knurled Cap	Smooth Cap																
	.112-40 (#4-40)	PF11MW	PF12MW	440	1	1	.063	.111	.250	.417	.230	.375	.137	.127	.310	.450	#1	.073	.312
						2													
	.138-32 (#6-32)	PF11MW	PF12MW	632	1	1	.063	.115	.283	.450	.290	.413	.149	.127	.450	.640	#2	.076	.344
						2													
	.164-32 (#8-32)	PF11MW	PF12MW	832	1	1	.063	.121	.346	.514	.290	.469	.157	.140	.450	.640	#2	.076	.407
						2													
	.190-32 (#10-32)	PF11MW	PF12MW	032	1	1	.063	.121	.346	.514	.290	.469	.157	.140	.450	.640	#2	.076	.407
						2													
	.250-20 (1/4-20)	PF11MW	PF12MW	0420	1	1	.063	.128	.413	.575	.350	.531	.157	.140	.530	.790	#3	.081	.468
						2													

All dimensions are in millimeters.

Metric	Thread Size x Pitch	Type		Thread Code	Shank Code (4)	Screw Length Code (4)	A Max. Sheet Thickness	B Min.	D Hole Size In Sheet +0.08 -0.03	E ±0.25	G Nom.	H Min.	L1 Nom.	L2 Max.	T1 Nom.	T2 Nom.	Driver Size	Min. Total Float	W Nom.
		Knurled Cap	Smooth Cap																
	M3 x 0.5	PF11MW	PF12MW	M3	1	1	1.6	2.82	6.35	10.59	5.84	9.52	3.48	3.23	7.87	11.43	#1	1.85	7.92
						2													
	M3.5 x 0.6	PF11MW	PF12MW	M3.5	1	1	1.6	2.92	7.19	11.43	7.37	10.49	3.78	3.23	11.43	16.26	#2	1.93	8.74
						2													
	M4 x 0.7	PF11MW	PF12MW	M4	1	1	1.6	3.07	8.79	13.06	7.37	11.91	3.99	3.56	11.43	16.26	#2	1.93	10.34
						2													
	M5 x 0.8	PF11MW	PF12MW	M5	1	1	1.6	3.07	8.79	13.06	8.89	11.91	3.99	3.56	11.43	16.26	#2	1.93	10.34
						2													
	M6 x 1	PF11MW	PF12MW	M6	1	1	1.6	3.25	10.49	14.61	8.89	13.48	3.99	3.56	13.46	20.07	#3	2.06	11.89
						2													

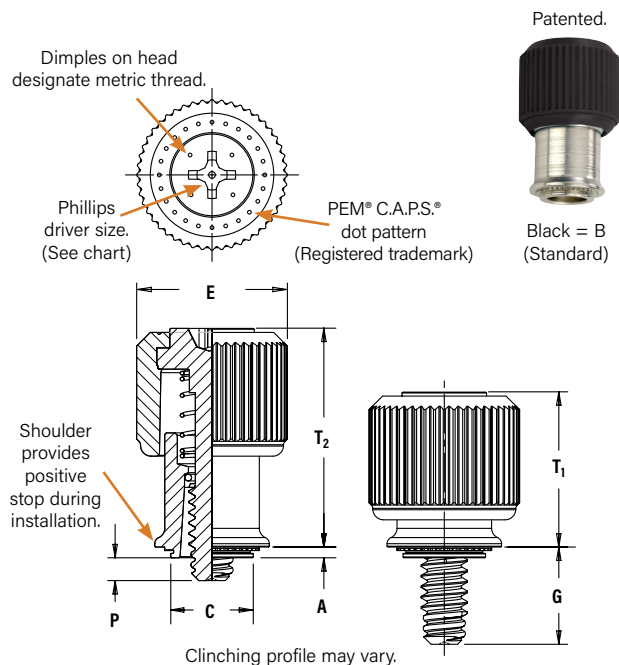
(1) As with all Class 2A/6g external threads with an additive finish, the maximum major and pitch, after plating, may equal basic sizes and be gauged to Class 3A/4h, per ANSI B1.1, Section 8, Table 3A and ANSI B1.13M, Section 8, Paragraph 8.2.

(2) "BL" suffix will be added to part number to designate DuraBlack™ finish.

(3) See PEM Technical Support section of our website (www.pemnet.com) for related plating standards and specifications.

(4) Other shank and screw lengths available.

PEM® C.A.P.S.® Captive Panel Screws



Float .010"/0.25mm minimum, in all directions from center, .020"/0.5mm total.

Installation Data [page 28](#). Performance Data [page 37](#).

Color Capabilities ⁽¹⁾

Choose a knob color code and add it to the end of the base part number.



Threads:

External, ASME B1.1, 2A / ASME B1.13M, 6g ⁽²⁾

Material:

Knob: PC/ABS (UL 94V-0, halogen-free) ⁽³⁾

Retainer: Hardened Carbon Steel

Screw: Hardened Carbon Steel

Spring: 300 Series Stainless Steel

Retaining Clip: 300 Series Stainless Steel

Finish:

Retainer: CN - Bright nickel over copper flash per ASTM B689, Type II

Screw: Zinc plated per ASTM B633, SC1 (5µm), Type III, colorless

Spring: Natural Finish

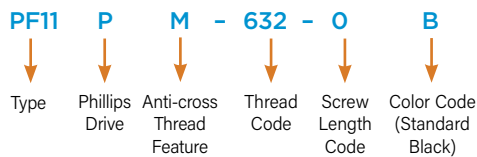
Retaining Clip: Natural Finish

For use in sheet hardness:

HRB 80 or less (Hardness Rockwell "B" Scale)

HB 150 or less (Hardness Brinell)

Part Number Designation



Also available with flare-mounted retainer as PF11PMF or with floating style retainer as PF11PMW.

All dimensions are in inches.

Unified	Thread Size	Type	Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet +.003 - .000	C Max.	E ± .010	G ± .025	P ± .025	T ₁ Nom.	T ₂ Nom.	Driver Size	Min. Dist. Hole C/L to Edge (4)
		Knurled Cap													
	.112-40 (#4-40)	PF11PM	440	0	.036	.036	.219	.218	.417	.170	.000	.310	.450	#2	.28
				1						.230	.060				
				2						.290	.120				
	.138-32 (#6-32)	PF11PM	632	0	.036	.036	.250	.249	.450	.230	.000	.450	.640	#2	.29
				1						.290	.060				
				2						.350	.120				
	.164-32 (#8-32)	PF11PM	832	0	.036	.036	.312	.311	.514	.230	.000	.450	.640	#2	.33
				1						.290	.060				
				2						.350	.120				
	.190-32 (#10-32)	PF11PM	032	0	.036	.036	.312	.311	.514	.230	.000	.450	.640	#2	.33
				1						.290	.060				
				2						.350	.120				

All dimensions are in millimeters.

Metric	Thread Size x Pitch	Type	Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet + 0.08	C Max.	E ± 0.25	G ± 0.64	P ± 0.64	T ₁ Nom.	T ₂ Nom.	Driver Size	Min. Dist. Hole C/L to Edge (4)
		Knurled Cap													
	M3 x 0.5	PF11PM	M3	0	0.92	0.92	5.56	5.54	10.59	4.32	0	7.87	11.43	#2	7.11
				1						5.84	1.52				
				2						7.37	3.05				
	M4 x 0.7	PF11PM	M4	0	0.92	0.92	7.92	7.9	13.06	5.84	0	11.43	16.26	#2	8.38
				1						7.37	1.52				
				2						8.89	3.05				
	M5 x 0.8	PF11PM	M5	0	0.92	0.92	7.92	7.9	13.06	5.84	0	11.43	16.26	#2	8.38
				1						7.37	1.52				
				2						8.89	3.05				

(1) The colors shown (except for black) are non-stocked standards and available on special order. Since actual color knob may vary slightly from those represented, we recommend that you request samples for color verification. If you require a custom color or you need a "color matched" knob, please contact us.

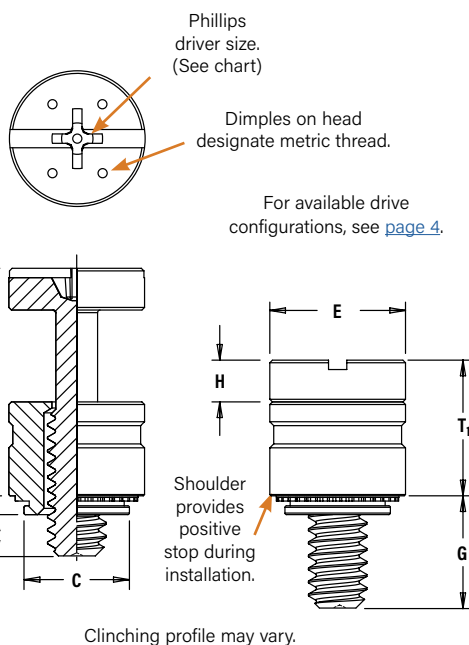
(2) As with all Class 2A/6g external threads with an additive finish, the maximum major and pitch, after plating, may equal basic sizes and be gauged to Class 3A/4h, per ANSI B1.1, Section 8, Table 3A and ANSI B1.13M, Section 8, Paragraph 8.2.

(3) Temperature limit is 210° F / 99° C.

(4) For more information on proximity to bends and distance to other clinch hardware, see [PEM® Tech Sheet C/L To Edge](#).

PEM® PFHV™ Captive Panel Screws

- Compact, low profile design for limited access applications
- Low cost captive screw design to replace loose hardware
- Two screw lengths
- Universal slot/Phillips recess standard with available Torx® recess
- Available with MATHread® anti cross-thread technology. (See [page 4](#) for more information)



Installation Data [page 29](#). Performance Data [page 37](#).

Threads:

External, ASME B1.1, 2A / ASME B1.13M, 6g ⁽¹⁾

Material:

Retainer: Carbon Steel

Screw: Hardened Carbon Steel

Finish:

Retainer: CN - Bright nickel over copper flash per ASTM B689, Type II

Screw: CN - Bright nickel over copper flash ⁽¹⁾

For use in sheet hardness:

HRB 60 or less (Hardness Rockwell "B" Scale)

HB 107 or less (Hardness Brinell)

Part Number Designation

PFHV - 632 - 0 CN

↓ ↓ ↓ ↓

Type Thread Size Screw Finish

Code Length Code Code

All dimensions are in inches.

Unified	Thread Size	Type	Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet + .003 - .000	C Max.	E ± .010	G ± .025	H ± .005	P ±.025	T ₁ Nom.	T ₂ Nom.	Driver Size	Min. Dist. Hole C/L to Edge (2)
	.112-40 (#4-40)	PFHV	440	0	.036	.036	.203	.202	.260	.216	.080	.000	.260	.436	#1	.21
				1						.316		.095				
	.138-32 (#6-32)	PFHV	632	0	.036	.036	.219	.218	.276	.234	.092	.000	.290	.484	#2	.23
				1						.359		.120				
	.164-32 (#8-32)	PFHV	832	0	.036	.036	.252	.251	.309	.259	.111	.000	.335	.555	#2	.26
				1						.371		.106				

All dimensions are in millimeters.

Metric	Thread Size x Pitch	Type	Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet + 0.08	C Max.	E ± 0.25	G ± 0.64	H ± 0.13	P ±0.64	T ₁ Nom.	T ₂ Nom.	Driver Size	Min. Dist. Hole C/L to Edge (2)
	M3 x 0.5	PFHV	M3	0	0.92	0.92	5.5	5.49	6.95	5.55	2.03	0	6.69	11.25	#1	5.8
				1						756		1.9				
	M3.5 x 0.6	PFHV	M3.5	0	0.92	0.92	6	5.98	745	6.01	2.34	0	745	12.47	#2	6.3
				1						842		2.3				
	M4 x 0.7	PFHV	M4	0	0.92	0.92	6.4	6.38	785	6.59	2.79	0	8.5	14.1	#2	6.7
				1						939		2.7				

- (1) As with all Class 2A/6g external threads with an additive finish, the maximum major and pitch, after plating, may equal basic sizes and be gauged to Class 3A/4h, per ANSI B1.1, Section 8, Table 3A and ANSI B1.13M, Section 8, Paragraph 8.2.
- (2) For more information on proximity to bends and distance to other clinch hardware, see [PEM® Tech Sheet C/L To Edge](#).

PEM® PF7M™ And PF7MF™ Captive Panel Screws

- Smallest footprint, spring-loaded panel fastener for limited access applications
- MATHread® anti cross-thread technology (See [page 4](#) for more information)
- Installs flush on back side of panel
- Available with Torx® recess
- PF7M Self-clinching style provides high pushout resistance
- PF7M does not require special hole preparation
- PF7MF is appropriate for close centerline-to-edge applications
- PF7MF does not require high installation force
- PF7MF installs into any panel hardness



PF7M

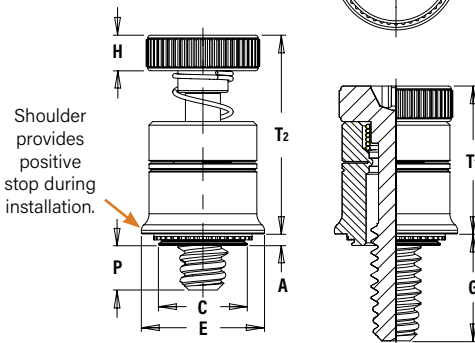


PF7MF

PF7M™ Self-Clinching Captive Panel Screws



Patented.
#D656,392S



Dimples on head designate metric thread.

Phillips driver size.
(See chart)

Shoulder provides positive stop during installation.

Clinching profile may vary.

Installation Data [page 30](#). Performance Data [page 37](#).

Threads:

External, ASME B1.1, 2A / ASME B1.13M, 6g ⁽¹⁾

Material:

Retainer: Carbon Steel
Screw: Hardened Carbon Steel
Spring: 300 Series Stainless Steel

Finish:

Retainer: CN - Bright nickel over copper flash per ASTM B689, Type II
Screw: CN - Bright nickel over copper flash
Spring: Natural Finish

For use in sheet hardness:

HRB 60 or less (Hardness Rockwell "B" Scale)
HB 107 or less (Hardness Brinell)

Part Number Designation

PF7 M - 632 - O CN

↓ ↓ ↓ ↓ ↓

Type Anti Cross-thread Feature Thread Size Code Length Code Finish

All dimensions are in inches.

Unified	Thread Size	Type	Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet +.003 -.000	C Max.	E ±.010	H ±.010	G ±.025	P ±.025	T1 Nom.	T2 Nom.	Driver Size	Min. Dist. Hole C/L to Edge (2)
		Fastener Material Steel														
	.112-40 (#4-40)	PF7M	440	0	.036	.036	.219	.218	.310	.100	.210	.000	.380	.550	#2	.28
				1												
Metric	.138-32 (#6-32)	PF7M	632	0	.036	.036	.250	.249	.342	.100	.240	.000	.410	.610	#2	.29
				1												
	.164-32 (#8-32)	PF7M	832	0	.036	.036	.312	.311	.405	.120	.240	.000	.430	.630	#2	.33
				1												

All dimensions are in millimeters.

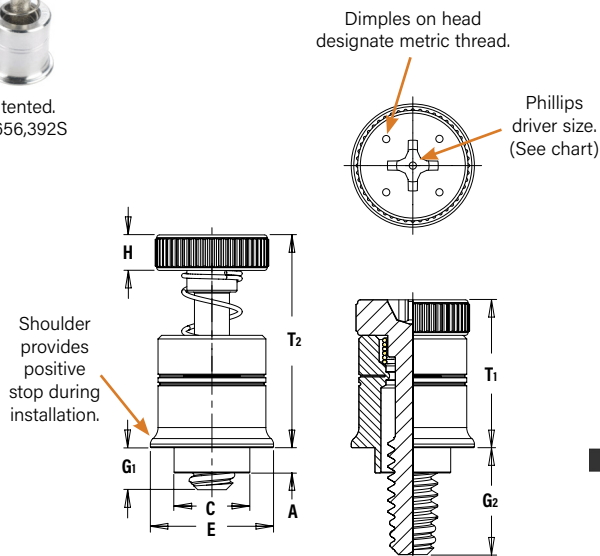
Metric	Thread Size x Pitch	Type	Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet +.08	C Max.	E ±.025	H ±.025	G ±.064	P ±.064	T1 Nom.	T2 Nom.	Driver Size	Min. Dist. Hole C/L to Edge (2)
		Fastener Material Steel														
	M3 x 0.5	PF7M	M3	0	0.92	0.92	5.56	5.54	7.87	2.5	5.33	0	9.65	13.97	#2	7.11
				1												
Metric	M4 x 0.7	PF7M	M4	0	0.92	0.92	7.92	7.9	10.29	3	6.1	0	10.92	16	#2	8.38
				1												
	M4 x 0.7	PF7M	M4	0	0.92	0.92	7.92	7.9	10.29	3	6.1	0	10.92	16	#2	8.38
				1												

- (1) As with all Class 2A/6g external threads with an additive finish, the maximum major and pitch, after plating, may equal basic sizes and be gauged to Class 3A/4h, per ANSI B1.1, Section 8, Table 3A and ANSI B1.13M, Section 8, Paragraph 8.2.
- (2) For more information on proximity to bends and distance to other clinch hardware, see [PEM® Tech Sheet C/L To Edge](#).

PF7MF™ Flare-Mounted Captive Panel Screws



Patented.
#D656,392S



Threads:

External, ASME B1.1, 2A / ASME B1.13M, 6g ⁽¹⁾

Material:

Retainer: Aluminum
Screw: Hardened Carbon Steel
Spring: 300 Series Stainless Steel
Spring: Natural Finish

Finish:

Retainer: Natural finish
Screw: CN - Bright nickel over copper flash

Part Number Designation

PF7 M F - 632 - 0

Type Anti Cross-thread Feature Flaring Thread Size Code Length Code

Installation Data [page 30](#). Performance Data [page 37](#).

All dimensions are in inches.

Unified	Thread Size	Type	Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet +.005 -.000	C Max.	E ±.010	H ±.010	G1 ±.025	G2 ±.025	T1 Nom.	T2 Nom.	Driver Size
		Fastener Material													
		Steel													
	.112-40 (#4-40)	PF7MF	440	0	.041	.031	.187	.186	.310	.100	.040	.210	.380	.550	#2
				1							.100	.270			
	.138-32 (#6-32)	PF7MF	632	0	.072	.060	.213	.212	.342	.100	.040	.240	.410	.610	#2
				1							.100	.300			
	.164-32 (#8-32)	PF7MF	832	0	.072	.060	.266	.265	.405	.120	.040	.240	.430	.630	#2
				1							.100	.300			

All dimensions are in millimeters.

Metric	Thread Size x Pitch	Type	Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet +0.13	C Max.	E ±0.25	H ±0.25	G1 ±0.64	G2 ±0.64	T1 Nom.	T2 Nom.	Driver Size
		Fastener Material													
		Steel													
	M3 x 0.5	PF7MF	M3	0	1.05	0.79	4.75	4.73	7.87	2.5	1.02	5.33	9.65	13.97	#2
				1							2.54	6.86			
	M4 x 0.7	PF7MF	M4	0	1.83	1.52	6.76	6.74	10.29	3	1.02	6.1	10.92	16	#2
				1							2.54	7.62			

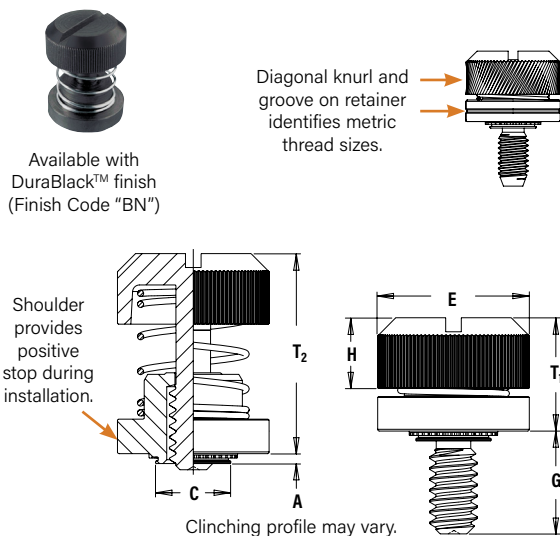
(1) As with all Class 2A/6g external threads with an additive finish, the maximum major and pitch, after plating, may equal basic sizes and be gauged to Class 3A/4h, per ANSI B1.1, Section 8, Table 3A and ANSI B1.13M, Section 8, Paragraph 8.2.

PEM® PF30™, PF50™ And PF60™ Captive Panel Screws

- Low-profile design satisfies many functional and cosmetic requirements
- Convenient large head for tool or hand operation
- PF50/PF60 are available with Torx® recess
- PF50/PF60 are available with MATHread® anti cross-thread technology. (See [page 4](#) for more information)



PF30™ Low-Profile Captive Panel Screws



Installation Data [page 31](#). Performance Data [page 38](#).

Threads:

External, ASME B11, 2A / ASME B113M, 6g ⁽¹⁾

Material:

Retainer: Carbon Steel
Screw: Hardened Carbon Steel (#4-40 and M3 sizes only)
Carbon Steel (all other sizes)
Spring: 300 Series Stainless Steel

Finish:

Retainer: CN - Bright nickel over copper flash per ASTM B689, Type II
Screw: CN - Bright nickel over copper flash per ASTM B689, Type II
Spring: Natural Finish

Optional Finish:

Retainer: BN - Black nitride, AMS2753, Section 3
Screw: BN - Black nitride, AMS2753, Section 3

For use in sheet hardness:

HRB 60 or less (Hardness Rockwell "B" Scale)
HB 107 or less (Hardness Brinell)

Part Number Designation

PF30 - 832 - 30 CN
↓ ↓ ↓ ↓
Type and Thread Size Screw Finish
Shank Code Code Length Code Code

All dimensions are in inches.

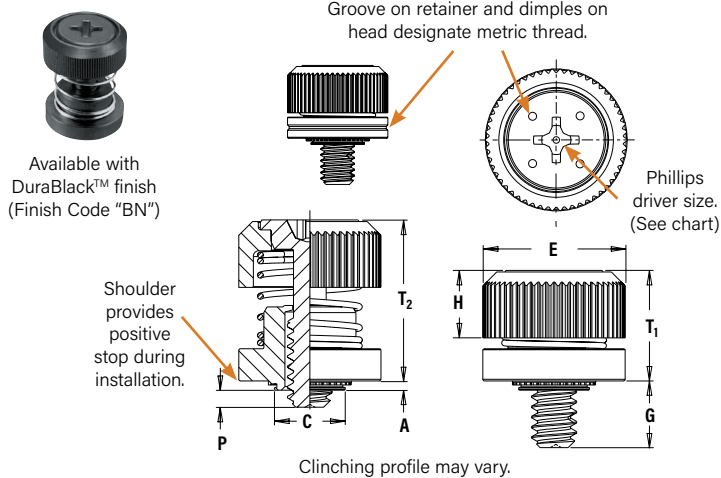
Unified	Thread Size	Type	Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet + .003 - .000	C Max.	E ±.010	G ± .015	H ± .005	T ₁ Max.	T ₂ Nom.	Min. Dist. Hole C/L to Edge (2)
	.112-40 (#4-40)	PF30	440	30	.030	.030	.203	.202	.406	.300	.202	.325	.595	.26
		PF31			.038	.040								
		PF32			.058	.060								
	.138-32 (#6-32)	PF30	632	30	.030	.030	.219	.218	.438	.300	.202	.325	.595	.28
		PF31			.038	.040								
		PF32			.058	.060								
	.164-32 (#8-32)	PF30	832	30	.030	.030	.250	.249	.468	.300	.207	.330	.600	.29
		PF31			.038	.040								
		PF32			.058	.060								
	.190-32 (#10-32)	PF30	032	30	.030	.030	.312	.311	.530	.300	.220	.335	.605	.33
		PF31			.038	.040								
		PF32			.058	.060								
	.250-20 (1/4-20)	PF32	0420	35	.058	.060	.375	.374	.625	.350	.242	.385	.675	.38

All dimensions are in millimeters.

Metric	Thread Size x Pitch	Type	Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet + 0.08	C Max.	E ±0.25	G ± 0.4	H ± 0.13	T ₁ Max.	T ₂ Nom.	Min. Dist. Hole C/L to Edge (2)
	M3 x 0.5	PF31	M3	30	0.97	1	5.5	5.48	10.31	7.62	5.13	8.26	15.11	6.6
		PF32			1.48	1.5								
	M4 x 0.7	PF31	M4	30	0.97	1	6.4	6.38	11.89	7.62	5.26	8.38	15.24	7.37
		PF32			1.48	1.5								
	M5 x 0.8	PF31	M5	30	0.97	1	8	7.98	13.46	7.62	5.59	8.51	15.37	8.38
		PF32			1.48	1.5								
	M6 x 1	PF32	M6	35	1.48	1.5	9.5	9.48	15.88	8.89	6.12	9.78	17.15	9.65

- (1) As with all Class 2A/6g external threads with an additive finish, the maximum major and pitch, after plating, may equal basic sizes and be gauged to Class 3A/4h, per ANSI B1.1, Section 8, Table 3A and ANSI B1.13M, Section 8, Paragraph 8.2.
- (2) For more information on proximity to bends and distance to other clinch hardware, see [PEM® Tech Sheet C/L To Edge](#).

PF50™/PF60™ Low-Profile Captive Panel Screws



Installation Data [page 31](#). Performance Data [page 39](#).

Threads:

External, ASME B1.1, 2A / ASME B1.13M, 6g ⁽¹⁾

Material:

Knob: Carbon Steel Retainer: Carbon Steel
Screw: Hardened Carbon Steel Spring: 300 Series Stainless Steel

Finish:

Knob: CN - Bright nickel over copper flash per ASTM B689, Type II
Retainer: CN - Bright nickel over copper flash per ASTM B689, Type II
Screw: CN - Bright nickel over copper flash
Spring: Natural Finish

Optional Finish:

Knob: BN - Black Nitride, AMS2753, Section 3
Retainer: BN - Black Nitride, AMS2753, Section 3
Screw: BN - Black Nitride, AMS2753, Section 3

For use in sheet hardness:

HRB 60 or less (Hardness Rockwell "B" Scale)
HB 107 or less (Hardness Brinell)

Part Number Designation

PF50 - 440 - 1 CN
PF60 - 440 - 1 CN

Type and Shank Code Thread Size Code Screw Length Code Finish Code

All dimensions are in inches.

Unified	Thread Size	Type		Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet + .003 -.000	C Max.	E ±.010	G ±.025	H ±.008	P ±.025	T ₁ Max.	T ₂ Nom.	Driver Size	Min. Dist Hole C/L to Edge (2)
		Knurled Cap	Smooth Cap														
	.112-.40 (#4-.40)	PF50	PF60	440	0	.030	.030	.203	.202	.406	.230	.207	.000	.340	.520	#1	.26
					1						.290		.060				
		PF51	PF61	440	0	.038	.040	.203	.202	.406	.230	.207	.000	.340	.520	#1	.26
					1						.290		.052				
		PF52	PF62	440	0	.058	.060	.203	.202	.406	.230	.207	.000	.340	.520	#1	.26
					1						.290		.032				
	.138-.32 (#6-.32)	PF50	PF60	632	0	.030	.030	.219	.218	.438	.230	.207	.000	.340	.520	#2	.28
					1						.290		.060				
		PF51	PF61	632	0	.038	.040	.219	.218	.438	.230	.207	.000	.340	.520	#2	.28
					1						.290		.052				
		PF52	PF62	632	0	.058	.060	.219	.218	.438	.230	.207	.000	.340	.520	#2	.28
					1						.290		.032				
	.164-.32 (#8-.32)	PF50	PF60	832	0	.030	.030	.250	.249	.468	.230	.217	.000	.340	.520	#2	.29
					1						.290		.060				
		PF51	PF61	832	0	.038	.040	.250	.249	.468	.230	.217	.000	.340	.520	#2	.29
					1						.290		.052				
		PF52	PF62	832	0	.058	.060	.250	.249	.468	.230	.217	.000	.340	.520	#2	.29
					1						.290		.032				
	.190-.32 (#10-.32)	PF50	PF60	032	0	.030	.030	.312	.311	.530	.230	.225	.000	.340	.530	#2	.33
					1						.290		.060				
		PF51	PF61	032	0	.038	.040	.312	.311	.530	.230	.225	.000	.340	.530	#2	.33
					1						.290		.052				
		PF52	PF62	032	0	.058	.060	.312	.311	.530	.230	.225	.000	.340	.530	#2	.33
					1						.290		.032				
	.250-.20 (1/4-.20)	PF52	PF62	0420	0	.058	.060	.375	.374	.625	.280	.246	.000	.395	.600	#2	.38
					1						.340		.060				

All dimensions are in millimeters.

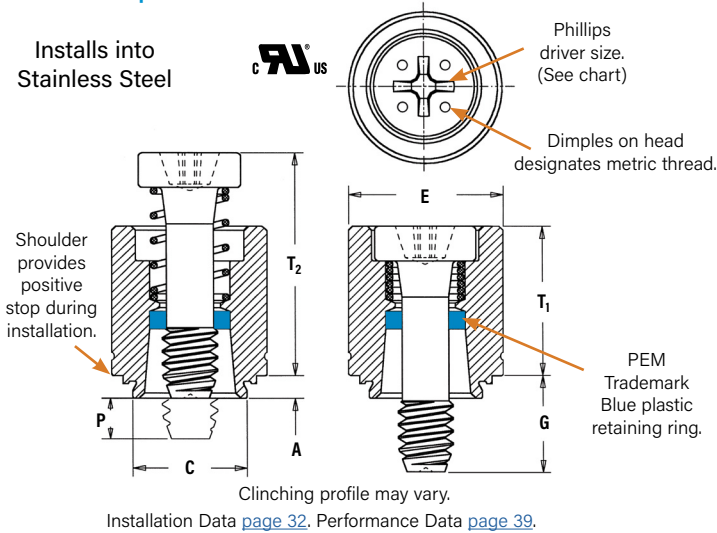
Metric	Thread Size x Pitch	Type		Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet + 0.08	C Max.	E ±0.25	G ±0.64	H ±0.2	P ±0.64	T ₁ Max.	T ₂ Nom.	Driver Size	Min. Dist Hole C/L to Edge (2)
		Knurled Cap	Smooth Cap														
	M3 x 0.5	PF50	PF60	M3	0	0.77	0.8	5.5	5.48	10.3	5.84	5.26	0	8.64	13.21	#1	6.6
					1						7.37		1.52				
		PF51	PF61	M3	0	0.97	1	5.5	5.48	10.3	5.84	5.26	0	8.64	13.21	#1	6.6
					1						7.37		1.32				
		PF52	PF62	M3	0	1.48	1.5	5.5	5.48	10.3	5.84	5.26	0	8.64	13.21	#1	6.6
					1						7.37		0.81				
	M3.5 x 0.6	PF50	PF60	M3.5	0	0.77	0.8	5.56	5.54	11.1	5.84	5.26	0	8.64	13.21	#2	7.1
					1						7.37		1.52				
PF51		PF61	M3.5	0	0.97	1	5.56	5.54	11.1	5.84	5.26	0	8.64	13.21	#2	7.1	
				1						7.37		1.32					
PF52		PF62	M3.5	0	1.48	1.5	5.56	5.54	11.1	5.84	5.26	0	8.64	13.21	#2	7.1	
				1						7.37		0.81					
M4 x 0.7	PF50	PF60	M4	0	0.77	0.8	6.4	6.38	11.9	5.84	5.51	0	8.64	13.46	#2	7.4	
				1						7.37		1.52					
	PF51	PF61	M4	0	0.97	1	6.4	6.38	11.9	5.84	5.51	0	8.64	13.46	#2	7.4	
				1						7.37		1.32					
	PF52	PF62	M4	0	1.48	1.5	6.4	6.38	11.9	5.84	5.51	0	8.64	13.46	#2	7.4	
				1						7.37		0.81					
M5 x 0.8	PF50	PF60	M5	0	0.77	0.8	8	7.98	13.5	5.84	5.72	0	8.64	13.46	#2	8.4	
				1						7.37		1.52					
	PF51	PF61	M5	0	0.97	1	8	7.98	13.5	5.84	5.72	0	8.64	13.46	#2	8.4	
				1						7.37		1.32					
	PF52	PF62	M5	0	1.48	1.5	8	7.98	13.5	5.84	5.72	0	8.64	13.46	#2	8.4	
				1						7.37		0.81					
M6 x 1	PF52	PF62	M6	0	1.48	1.5	9.5	9.48	15.9	7.11	6.25	0	10.04	15.24	#2	9.7	
				1						8.64		15.2					

PFC4™ And PFC2P™ Captive Panel Screws

- Fully concealed-head for tool only access
- Comply with UL 60950 standards
- Available with MATHread® anti cross-thread technology (See [page 4](#) for more information)
- Available with Torx® recess
- PFC4 installs into stainless steel sheets HRB 88 or less



PFC4™ Recessed-Head Captive Panel Screws



Threads:

External, ASME B1.1, 2A / ASME B1.13M, 6g

Material:

Retainer: 400 Series Stainless Steel
Screw: 400 Series Stainless Steel
Spring: 300 Series Stainless Steel
Retaining Ring: Nylon, temperature limit 200° F / 93° C

Finish:

Retainer: Passivated and/or tested per ASTM A380
Screw: Passivated and/or tested per ASTM A380
Spring: Natural Finish

For use in sheet hardness:

HRB 88 or less (Hardness Rockwell "B" Scale)
HB 183 or less (Hardness Brinell)

Part Number Designation

PFC4 - 832 - 50

↓ ↓ ↓
Type and Thread Size Screw Length
Material Code Code

All dimensions are in inches.

Unified	Thread Size	Type	Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet +.003 -.000	C Max.	E ± .010	G ± .016	P ±.025	T ₁ Max.	T ₂ Nom.	Driver Size	Min. Dist. Hole C/L to Edge (1)
	.112-.40 (#4-40)	PFC4	440	40	.060	.060	.265	.264	.344	.250	.000	.370	.540	#1	.25
				62						.375	.125				
	.138-.32 (#6-32)	PFC4	632	40	.060	.060	.281	.280	.375	.250	.000	.380	.540	#2	.28
				62						.375	.125				
				84						.500	.250				
	.164-.32 (#8-32)	PFC4	832	50	.060	.060	.312	.311	.406	.312	.000	.480	.705	#2	.31
				72						.437	.125				
				94						.562	.250				
	.190-.32 (#10-32)	PFC4	032	50	.060	.060	.344	.343	.437	.312	.000	.490	.705	#2	.34
				72						.437	.125				
				94						.562	.250				

All dimensions are in millimeters.

Metric	Thread Size x Pitch	Type	Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet + 0.08	C Max.	E ± 0.25	G ± 0.4	P ±0.64	T ₁ Max.	T ₂ Nom.	Driver Size	Min. Dist. Hole C/L to Edge (1)
	M3 x 0.5	PFC4	M3	40	1.53	1.53	6.73	6.71	8.74	6.4	0	9.4	13.72	#1	6.35
				62						9.5	3.2				
	M4 x 0.7	PFC4	M4	50	1.53	1.53	7.92	7.9	10.31	7.9	0	12.19	17.91	#2	7.87
				72						11.1	3.2				
				94						14.3	6.4				
	M5 x 0.8	PFC4	M5	50	1.53	1.53	8.74	8.72	11.1	7.9	0	12.45	17.91	#2	8.63
				72						11.1	3.2				
				94						14.3	6.4				

(1) For more information on proximity to bends and distance to other clinch hardware, see [PEM® Tech Sheet C/L To Edge](#).

A Note About Fasteners For Stainless Steel Panels

In order for self-clinching fasteners to work properly, the fastener must be harder than the sheet into which it is being installed. In the case of stainless steel panels, fasteners made from 300 Series Stainless Steel do not meet this hardness criteria. It is for this reason that 400 series fasteners are offered (PFC4). However, while these 400 Series fasteners install and perform well in 300 Series stainless sheets they should not be used if the end product:

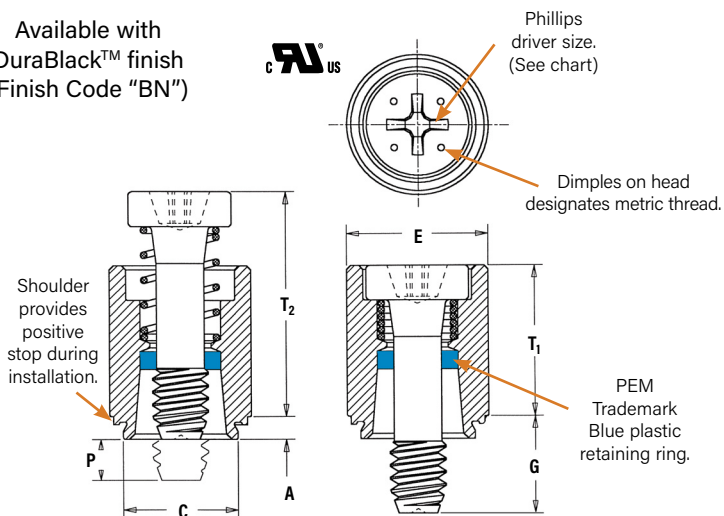
- Will be exposed to any appreciable corrosive presence.
- Requires non-magnetic fasteners.
- Will be exposed to any temperatures above 300° F (149° C)

If any of these are issues, please contact techsupport@pemnet.com for other options.

PFC2P™ Recessed-Head Captive Panel Screws



Available with
DuraBlack™ finish
(Finish Code "BN")



Clinching profile may vary.

Installation Data [page 32](#). Performance Data [page 39](#).

Threads:

External, ASME B1.1, 2A / ASME B1.13M, 6g

Material:

Retainer: 300 Series Stainless Steel

Screw: 400 Series Stainless Steel

Spring: 300 Series Stainless Steel

Retaining Ring: Nylon, temperature limit 200° F / 93° C

Finish:

Retainer: Passivated and/or tested per ASTM A380

Screw: Passivated and/or tested per ASTM A380

Spring: Natural Finish

Optional Finish:

Retainer: BN - Black nitride, AMS2753, Section 3

Screw: BN - Black nitride, AMS2753, Section 3

For use in sheet hardness:

HRB 70 or less (Hardness Rockwell "B" Scale)

HB 125 or less (Hardness Brinell)

Part Number Designation

PFC2P - 832 - 50

↓ ↓ ↓
Type and Thread Size Screw
Material Code Length Code

All dimensions are in inches.

Unified	Thread Size	Type	Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet +.003 -.000	C Max.	E ± .010	G ± .016	P ±.025	T ₁ Max.	T ₂ Nom.	Driver Size	Min. Dist. Hole C/L to Edge (1)
	.112-40 (#4-40)	PFC2P	440	40	.060	.060	.265	.264	.312	.250	.000	.370	.540	#1	.25
				62						.375	.125				
	.138-32 (#6-32)	PFC2P	632	40	.060	.060	.281	.280	.344	.250	.000	.380	.540	#2	.28
				62						.375	.125				
				84						.500	.250				
	.164-32 (#8-32)	PFC2P	832	50	.060	.060	.312	.311	.375	.312	.000	.480	.705	#2	.31
				72						.437	.125				
				94						.562	.250				
	.190-32 (#10-32)	PFC2P	032	50	.060	.060	.344	.343	.406	.312	.000	.490	.705	#2	.34
				72						.437	.125				
				94						.562	.250				
	.250-20 (1/4-20)	PFC2P	0420	60	.060	.060	.413	.412	.468	.375	.000	.620	.905	#3	.38
				82						.500	.125				
				04						.625	.250				

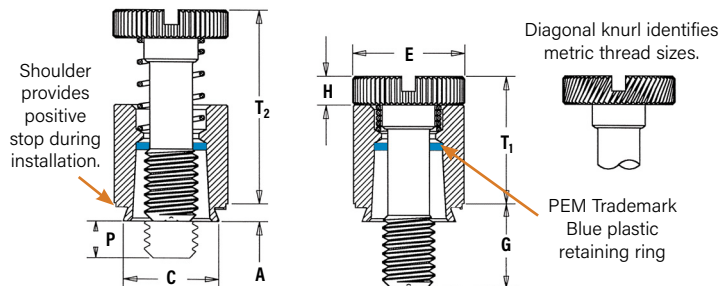
All dimensions are in millimeters.

Metric	Thread Size x Pitch	Type	Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet + 0.08	C Max.	E ± 0.25	G ± 0.4	P ±0.64	T ₁ Max.	T ₂ Nom.	Driver Size	Min. Dist. Hole C/L to Edge (1)
	M3 x 0.5	PFC2P	M3	40	1.53	1.53	6.73	6.71	7.92	6.4	0	9.4	13.72	#1	6.35
				62						9.5	3.2				
	M4 x 0.7	PFC2P	M4	50	1.53	1.53	7.92	7.9	9.53	7.9	0	12.19	17.91	#2	7.87
				72						11.1	3.2				
				94						14.3	6.4				
	M5 x 0.8	PFC2P	M5	50	1.53	1.53	8.74	8.72	10.31	7.9	0	12.45	17.91	#2	8.63
				72						11.1	3.2				
				94						14.3	6.4				
	M6 x 1	PFC2P	M6	60	1.53	1.53	10.49	10.47	11.89	9.5	0	15.75	22.99	#3	9.65
				82						12.7	3.2				
				04						15.9	6.4				

(1) For more information on proximity to bends and distance to other clinch hardware, see [PEM® Tech Sheet C/L To Edge](#).

PFC2™ And PFS2™ Captive Panel Screws

- Spring-loaded panel fastener for tool or hand operation
- Screw assemblies remain captive for easy mounting and removal.



Clinching profile may vary.

Installation Data [page 33](#). Performance Data [page 39](#).

Part Number Designation

PFC2 - 832 - 50
PFS2 - 832 - 50 CN

↓ ↓ ↓ ↓
 Type and Material Thread Size Code Screw Length Code Finish Code



PFC2

Threads:

External, ASME B11, 2A / ASME B113M, 6g

Material:

Retainer: 300 Series Stainless Steel ⁽²⁾
 Screw: 300 Series Stainless Steel
 Spring: 300 Series Stainless Steel
 Retaining Ring: Nylon, temperature limit 200° F / 93° C

Finish:

Retainer: Passivated and/or tested per ASTM A380
 Screw: Passivated and/or tested per ASTM A380
 Spring: Natural Finish

Optional Finish:

Retainer: BN - Black nitride, AMS2753, Section 3
 Screw: BN - Black nitride, AMS2753, Section 3

For use in sheet hardness:

HRB 70 or less (Hardness Rockwell "B" Scale)
 HB 125 or less (Hardness Brinell)

PFS2

Threads:

External, ASME B11, 2A / ASME B113M, 6g ⁽¹⁾

Material:

Retainer: Hardened Carbon Steel ⁽²⁾
 Screw: Carbon Steel
 Spring: 300 Series Stainless Steel
 Retaining Ring: Nylon, temperature limit 200° F / 93° C

Finish:

Retainer: CN - Bright nickel over copper flash per ASTM B689, Type II
 Screw: CN - Bright nickel over copper flash per ASTM B689, Type II
 Spring: Natural Finish

Optional Finish:

Retainer: BN - Black nitride, AMS2753, Section 3
 Screw: BN - Black nitride, AMS2753, Section 3

For use in sheet hardness:

HRB 80 or less (Hardness Rockwell "B" Scale)
 HB 150 or less (Hardness Brinell)

All dimensions are in inches.

Unified	Thread Size	Type		Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet +.003 - .000	C Max.	E ± .010	G ± .016	H ± .005	P ± .025	T ₁ Max.	T ₂ Nom.	Min. Dist. Hole C/L to Edge (3)
		Stainless Steel	Steel													
	.112-40 (#4-40)	PFC2	PFS2	440	40	.060	.060	.265	.264	.312	.250	.072	.000	.360	.540	.25
					62						.375		.125			
	.138-32 (#6-32)	PFC2	PFS2	632	40	.060	.060	.281	.280	.344	.250	.072	.000	.360	.540	.28
					62						.375		.125			
					84						.500		.250			
	.164-32 (#8-32)	PFC2	PFS2	832	50	.060	.060	.312	.311	.375	.312	.082	.000	.450	.690	.31
					72						.437		.125			
					94						.562		.250			
	.190-32 (#10-32)	PFC2	PFS2	032	50	.060	.060	.344	.343	.406	.312	.082	.000	.450	.690	.34
					72						.437		.125			
					94						.562		.250			
	.250-20 (1/4-20)	PFC2	PFS2	0420	60	.060	.060	.413	.412	.468	.375	.097	.000	.580	.880	.38
					82						.500		.125			
					04						.625		.250			

All dimensions are in millimeters.

Metric	Thread Size x Pitch	Type		Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet + 0.08	C Max.	E ± .25	G ± 0.4	H ± 0.13	P ± 0.64	T ₁ Max.	T ₂ Nom.	Min. Dist. Hole C/L to Edge (3)
		Stainless Steel	Steel													
	M3 x 0.5	PFC2	PFS2	M3	40	1.53	1.53	6.73	6.71	7.92	6.4	1.83	0	9.14	13.72	6.35
					62						9.5		3.2			
	M4 x 0.7	PFC2	PFS2	M4	50	1.53	1.53	7.92	7.9	9.53	7.9	2.08	0	11.43	17.53	7.87
					72						11.1		3.2			
					94						14.3		6.4			
	M5 x 0.8	PFC2	PFS2	M5	50	1.53	1.53	8.74	8.72	10.31	7.9	2.08	0	11.47	17.53	8.63
					72						11.1		3.2			
					94						14.3		6.4			
	M6 x 1	PFC2	PFS2	M6	60	1.53	1.53	10.49	10.47	11.89	9.5	2.46	0	14.73	22.35	9.65
					82						12.7		3.2			
					04						15.9		6.4			

(1) As with all Class 2A/6g external threads with an additive finish, the maximum major and pitch, after plating, may equal basic sizes and be gauged to Class 3A/4h, per ANSI B11, Section 8, Table 3A and ANSI B113M, Section 8, Paragraph 8.2.

(2) The blue plastic retaining rings are a PEM trademark. The temperature limit is 200° F / 93° C.

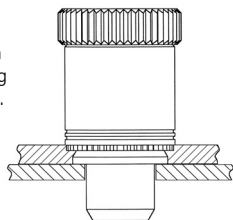
(3) For more information on proximity to bends and distance to other clinch hardware, see [PEM® Tech Sheet C/L To Edge](#).

PTL2™ And PSL2™ Spring-Loaded Plunger Assemblies

- Positioning pins for sliding components such as drawer slides and equipment consoles
- Fast installation and removal of components
- Reverse side of sheet is flush when plunger is retracted
- PTL2 has quick lockout feature to hold plunger in fully retracted position (Available as PSL2 without lockout feature on special order)
- For use in sheets of HRB 80 or less

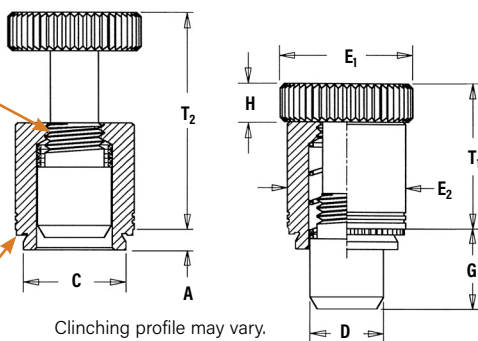


PTL2/PSL2 installed and with mating panel. Minimum mating hole diameter .251" / 6.38 mm.



Lockout feature holds plunger in retracted position. Simply retract and twist to engage lockout feature.

Shoulder provides positive stop during installation.



Clinching profile may vary.

Installation Data [page 33](#). Performance Data [page 39](#).

Material:

Plunger: Hardened Carbon Steel
Retainer: Hardened Carbon Steel
Spring: 300 Series Stainless Steel

Finish:

Plunger: CN - Bright nickel over copper flash per ASTM B689, Type II
Retainer: CN - Bright nickel over copper flash per ASTM B689, Type II
Spring: Natural Finish

For use in sheet hardness:

HRB 80 or less (Hardness Rockwell "B" Scale)
HB 150 or less (Hardness Brinell)

Part Number Designation

PTL2 - 04 - 4 CN
↓ ↓ ↓ ↓
Type Plunger Diameter Code Plunger Length Code Finish Code

All dimensions are in inches.

Unified	Type	Plunger Diameter Code	Plunger Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet +.003 -.000	C Max.	D +.000 -.005	E ₁ ± .010	E ₂ ± .010	G ± .010	H ± .010	T ₁ ± .010	T ₂ Nom.	Min. Dist. Hole C/L to Edge (3)
	PTL2	04	4	.058	.060	.328	.327	.250	.50	.406	.310	.17	.595	.895	.34
	PSL2 ⁽¹⁾	04	4	.058	.060	.328	.327	.250	.50	.406	.310	.17	.510	.780	.34

All dimensions are in millimeters.

Metric	Type	Plunger Diameter Code	Plunger Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet + 0.08	C Max.	D - 0.13	E ₁ ± 0.25	E ₂ ± 0.25	G ± 0.25	H ± 0.25	T ₁ ± 0.25	T ₂ Nom.	Min. Dist. Hole C/L to Edge (3)
	PTL2	04	4	1.47	1.53	8.33	8.31	6.35	12.7	10.3	7.87	4.32	15.11	22.73	8.64
	PSL2 ⁽¹⁾	04	4	1.47	1.53	8.33	8.31	6.35	12.7	10.3	7.87	4.32	12.95	19.81	8.64

(1) Without lockout feature. Available on special order.

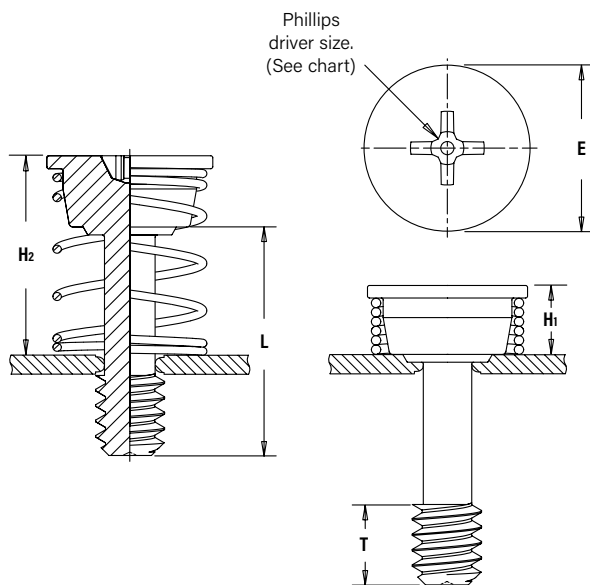
(2) For more information on proximity to bends and distance to other clinch hardware, see [PEM® Tech Sheet C/L To Edge](#).

PEM® SCBR™/SCB™/SCBJ™ Captive Panel Screws

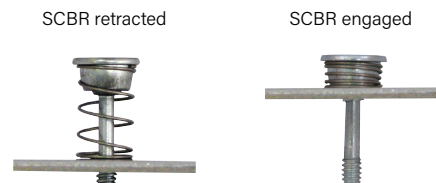
- Permanently captivates into sheets as thin as .040" / 1.02 mm
- Lowest cost captive screw design to replace loose hardware
- Available with self-retracting (SCBR), axial float (SCB), or jacking feature (SCBJ)
- Appropriate for close centerline-to-edge applications



SCBR™ Spinning Clinch Bolt With Self-Retracting Feature



Installation Data [page 34](#). Performance Data [page 40](#).



Threads:

External, ASME B1.1, 2A / ASME B1.13M, 6g ⁽¹⁾

Material:

Screw - Hardened Carbon Steel
Spring - 300 series stainless steel

Finish:

Screw - Zinc plated per ASTM B633, SC1 (5µm), Type III, colorless
Spring: Natural Finish

For use in sheet hardness:

HRB 80 or less (Hardness Rockwell "B" Scale)
HB 150 or less (Hardness Brinell)

Part Number Designation

SCBR - 632 - 8 ZI

↓ ↓ ↓ ↓

Type Thread Size Code Length Code Finish

All dimensions are in inches.

Unified	Thread Size	Type	Thread Code	Length Code "L" ±.015 (Length Code in 16ths of an inch)	Min. Sheet Thickness	Hole Size in Sheet +.003 -.000	E +.005 -.010	H1 ±.005	H2 Ref.	T Nom.	Driver Size	Min. Dist Hole C/L to Edge (2)
				.500								
	.112-40 (#4-40)	SCBR	440	8	.040	.112	.348	.165	.495	.130	#1	.175
	.138-32 (#6-32)	SCBR	632	8	.040	.138	.381	.170	.500	.130	#2	.190
	.164-32 (#8-32)	SCBR	832	8	.040	.164	.410	.175	.505	.130	#2	.205

All dimensions are in millimeters.

Metric	Thread Size x Pitch	Type	Thread Code	Length Code "L" ±0.4 (Length Code in millimeters)	Min. Sheet Thickness	Hole Size in Sheet +0.08	E +0.13 -0.25	H1 ±0.13	H2 Ref.	T Nom.	Driver Size	Min. Dist Hole C/L to Edge (2)
	M3 x 0.5	SCBR	M3	12	1.02	3	9.1	4.2	11.8	3.3	#1	4.5
	M4 x 0.7	SCBR	M4	12	1.02	4	10.7	4.5	12.1	3.3	#2	5.4

(1) As with all Class 2A/6g external threads with an additive finish, the maximum major and pitch, after plating, may equal basic sizes and be gauged to Class 3A/4h, per ANSI B1.1, Section 8, Table 3A and ANSI B1.13M, Section 8, Paragraph 8.2.

(2) For more information on proximity to bends and distance to other clinch hardware, see [PEM® Tech Sheet C/L To Edge](#).

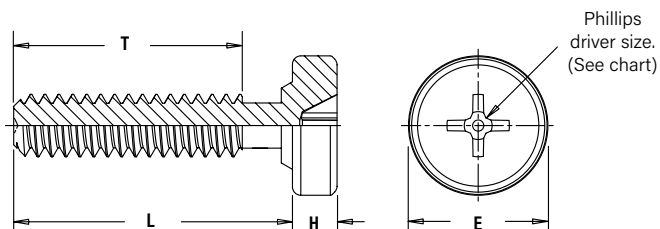
NOTE: SCBR screws are shipped with mating springs.

For designs requiring a specific spring rate, contact our PEM Technical Support group at techsupport@pemnet.com.

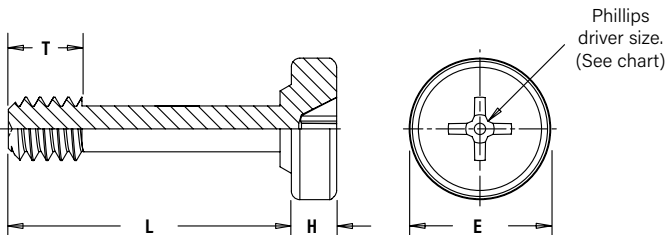
SCB™/SCBJ™ Spinning Clinch Bolts



SCBJ



SCB



Installation Data [page 34](#). Performance Data [page 40](#).

Threads:

External, ASME B1.1, 2A / ASME B1.13M, 6g ⁽¹⁾

Material:

Hardened Carbon Steel

Finish:

Zinc plated per ASTM B633, SC1 (5µm), Type III, colorless

For use in sheet hardness:

HRB 80 or less (Hardness Rockwell "B" Scale)
HB 150 or less (Hardness Brinell)

Part Number Designation

SCB J - 632 - 6 ZI

↓ ↓ ↓ ↓ ↓
Type Jacking Thread Length Finish
(If applicable) Size Code

All dimensions are in inches.

Unified	Thread Size	Type		Thread Code	Length Code "L" ±.015 (Length Code in 16ths of an inch)			Min. Sheet Thickness	Hole Size in Sheet +.003 -.000	E ±.010	H Nom.	T Nom.			Nom. Axial Float	Driver Size	Min. Dist. Hole C/L to Edge (2)
		Jacking	Non-jacking		.250	.375	.500					-4	-6	-8			
	.112-40 (#4-40)	SCBJ	—	440	4	6	8	.040	.112	.250	.080	.160	.285	.410	—	#1	.13
		—	SCB		—	—	8					—	—	.130			
	.138-32 (#6-32)	SCBJ	—	632	4	6	8	.040	.138	.291	.080	.160	.285	.410	—	#2	.15
		—	SCB		—	—	8					—	—	.130			

All dimensions are in millimeters.

Metric	Thread Size x Pitch	Type		Thread Code	Length Code "L" ±0.4 (Length Code in millimeters)				Min. Sheet Thickness	Hole Size in Sheet +0.08	E ±0.25	H Nom.	T Nom.				Nom. Axial Float	Driver Size	Min. Dist. Hole C/L to Edge (2)
		Jacking	Non-jacking										-6	-10	-12	-14			
	M3 x 0.5	SCBJ	—	M3	6	10	12	14	1.02	3	6.6	2.03	3.7	7.7	9.7	11.7	—	#1	3.3
		—	SCB		—	—	12	14					—	—	3.3	5.3			
	M4 x 0.7	SCBJ	—	M4	6	10	12	14	1.02	4	8.28	2.03	3.7	7.7	9.7	11.7	—	#2	5
		—	SCB		—	—	12	14					—	—	3.3	5.3			

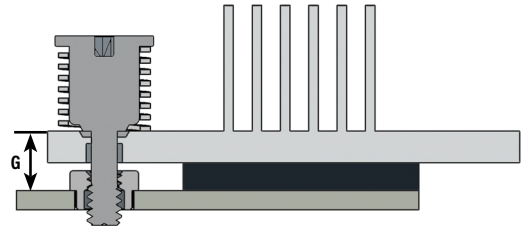
- (1) As with all Class 2A/6g external threads with an additive finish, the maximum major and pitch, after plating, may equal basic sizes and be gauged to Class 3A/4h, per ANSI B1.1, Section 8, Table 3A and ANSI B1.13M, Section 8, Paragraph 8.2.
- (2) For more information on proximity to bends and distance to other clinch hardware, see [PEM® Tech Sheet C/L To Edge](#).

PEM® HSCB™ Heat Sink Mounting System

The HSCB™ engineered mounting system provides secure attachment of a heat sink to the circuit board while providing firm contact to the chip component allowing optimum heat dissipation. The three-piece fastening system, sold individually, includes the screw, spring and receptacle nut. The clamp load created is determined by the spring rate and the amount of deflection that is designed into the joint of the hardware. The system also allows for slight expansion and contraction of the joint components without stress to the delicate circuitry. The unique “click” feature lets the user know when the fastener is completely installed.



- Screw can not be overtightened. Audible “click” when fully engaged.
- Screw and spring mount together permanently into the heat sink.
- Spring determines clamp force.
- Receptacle nut mounts permanently to the PC board.
- Provides even, constant contact of heat sink to chip component.
- Allows removal of heat sink if desired.

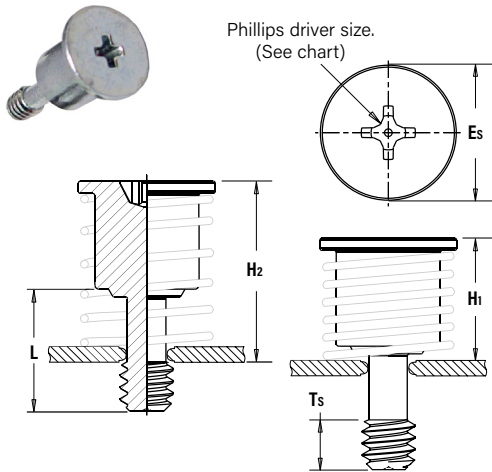


To select proper length code of nut/standoff:

- 1) Determine “G”, the distance from the top surface of the heat sink to the top of the P.C. Board.
- 2) Find the combination of Screw (HSCB) and Nut (HSR) whose sum of Screw Factor (SF) plus Nut Factor (NF) are closest to G.
- 3) Find $D = G - SF - NF$. The D value must be a negative number between zero and 1mm or 1/32” (1 dash length of HSR nut).
- 4) The actual working load is equal to the Spring (HSL) Working Load + (D x spring rate k). Lower D value results in lower force.

If this or any standard product does not meet your application needs, contact our PEM Technical Support group at techsupport@pemnet.com to develop a special product that matches your specific application.

HSCB™ Self-Captivating Screw



Installation Data [page 35](#).
Performance Data [page 40](#).

Threads:

External, ASME B1.1, 2A / ASME B1.13M, 6g ⁽¹⁾

Material:

Hardened carbon steel

Finish:

Screw - Zinc plated per ASTM B633, SC1 (5µm), Type III, colorless

For use in sheet hardness:

HRB 80 / HB150 or less ⁽²⁾

Part Number Designation

HSCB	-	440	-	4	ZI
Type		Thread Size Code		Length Code	Finish

All dimensions are in inches.

Unified	Thread Size	Type	Thread Code	Length Code “L” ±.015	Min. Sheet Thickness	Hole Size in Sheet +.003 -.000	ES ±.010	H1 Ref.	H2 Ref.	TS Min.	Screw Factor (SF)	Driver Size	Min. Dist Hole C/L to Edge (3)
				.320									
	.112-40 (#4-40)	HSCB	440	4	.040	.112	.312	.300	.470	.130	.170	#1	.156
	.138-32 (#6-32)	HSCB	632	4	.040	.138	.352	.300	.470	.130	.170	#2	.178

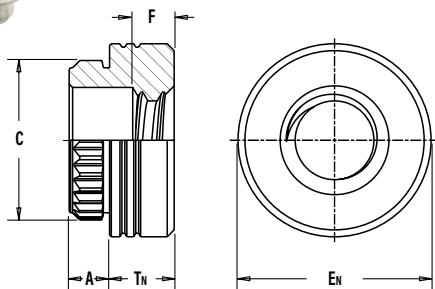
All dimensions are in millimeters.

Metric	Thread Size x Pitch	Type	Thread Code	Length Code “L” ±0.4	Min. Sheet Thickness	Hole Size in Sheet +0.08	ES ±0.25	H1 Ref.	H2 Ref.	TS Min.	Screw Factor (SF)	Driver Size	Min. Dist Hole C/L to Edge (3)
				8.13									
	M3 x 0.5	HSCB	M3	3	1	3	8.18	7.67	12	3.3	4.32	#1	4.13

NOTE: HSCB screws, HSR nuts and HSL springs are sold separately.

- (1) As with all Class 2A/6g external threads with an additive finish, the maximum major and pitch, after plating, may equal basic sizes and be gauged to Class 3A/4h, per ANSI B1.1, Section 8, Table 3A and ANSI B1.13M, Section 8, Paragraph 8.2.
- (2) HRB - Hardness Rockwell “B” Scale. HB - Hardness Brinell.
- (3) For more information on proximity to bends and distance to other clinch hardware, see [PEM® Tech Sheet C/L To Edge](#).

HSR™ Broaching Nut/Standoff



HSR nuts are available for surface mounting. Contact our PEM technical support group at techsupport@pemnet.com.

Installation Data [page 35](#). Performance Data [page 40](#).

Threads:
Internal, ASME B11, 2B / ASME B113M, 6H

Material:
Carbon steel

Finish:
ET - Electro-plated tin ASTM B 545, class B with clear preservative coating, annealed ⁽¹⁾

For use in sheet hardness:
HRB 60 / HB 107 or less ⁽²⁾

Part Number Designation

HSR - 440 - 2 ET
 ↓ ↓ ↓ ↓
 Type Thread Size Code Length Code Finish

All dimensions are in inches.

Unified	Thread Size	Type	Thread Code	Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet +.003 -.000	C ±.003	EN ±.005	F ±.010	TN ±.005	Nut Factor (NF)	Min. Dist. Hole C/L to Edge (3)
	.112-.40 (#4-40)	HSR	440	2	.060	.060	.166	.184	.219	.060	.065	.000	0.17
				3							.093	.031	
	.138-.32 (#6-32)	HSR	632	2	.060	.060	.213	.231	.281	.060	.065	.000	0.22
				3							.093	.031	

All dimensions are in millimeters.

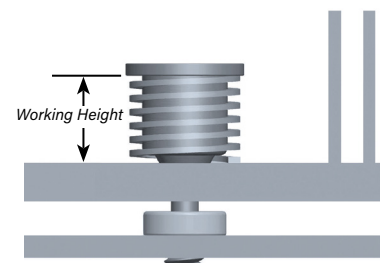
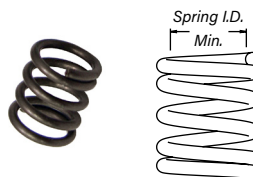
Metric	Thread Size x Pitch	Type	Thread Code	Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet +0.08	C ±0.08	EN ±0.13	F ±0.25	TN ±0.13	Nut Factor (NF)	Min. Dist. Hole C/L to Edge (3)
	M3 x 0.5	HSR	M3	2	1.53	1.53	4.22	4.68	5.56	1.3	2	.75	4.4
				3							3	1.75	

NOTE: HSCB screws, HSR nuts and HSL springs are sold separately.

- (1) See PEM Technical Support section of our website (www.pemnet.com) for related plating standards and specifications.
 (2) HRB - Hardness Rockwell "B" Scale. HB - Hardness Brinell.
 (3) For more information on proximity to bends and distance to other clinch hardware, see [PEM® Tech Sheet C/L To Edge](#).

HSL™ Springs

HSL springs are engineered to provide a reliable and repeatable spring rate when assembled with mating PEM hardware. The spring rate is critical to the successful assembly of your heat sink. Clamp load will be determined by the spring rate and deflection that is designed into the joint.



Part Number	Minimum Inside Dia.		Load at Working Height ±10%		Working Height Ref.		Spring Rate k		Spring Material
	(in.)	(mm)	(lbs.)	(N)	(in.)	(mm)	(lb/in)	(N/mm)	
HSL-574-35	.226	5.74	7.87	35	.270	6.86	74	12.96	17-7 Stainless Steel, Natural Finish
HSL-701-35	.276	7.01	7.87	35	.270	6.86	39	6.84	17-7 Stainless Steel, Natural Finish

NOTE: HSCB screws, HSR nuts and HSL springs are sold separately. HSL-574-35 spring fits screw thread sizes #4-40 and M3 and HSL-701-35 spring fits screw thread size #6-32.

The HSL Inside Diameter Code is expressed in hundredths of millimeters. Example "574" indicates a minimum inside diameter of 5.74mm or .226".

The HSL Load Code is expressed in Newtons developed at the working height of the spring once the joint is assembled. Example "35" indicates working load of 35 Newtons, or approximately 8 lbs.

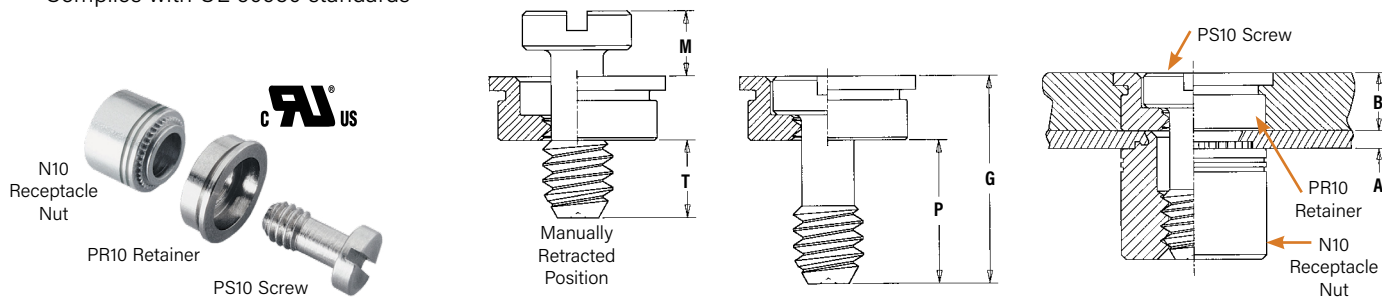
For designs requiring a specific spring rate, contact our PEM Technical Support group at techsupport@pemnet.com

Part Number Designation

HSL - 574 - 35
 ↓ ↓ ↓
 Type Inside Diameter Code Load Code

PEM® PF10™ Flush-Mounted Captive Panel Screws

- PF10 assembly sits flush in sheets as thin as .050" / 1.27 mm or flush on both sides in .125" / 3.2 mm sheets
- PS10 screw remains captive in retainer when disengaged
- PR10 retainer and F10 receptacle nut is for use in sheets of HRB 70 or less
- N10 nut is for use in sheets of HRB 80 or less
- Complies with UL 60950 standards



Installation Data [page 36](#), Performance Data [page 41](#).

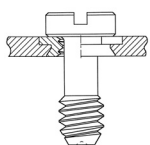
All dimensions are in inches.

Unified	A Min.	B Nom.	G ± .010	M	P	T Nom.
	.04	.125	.40	.16	.28	.13

All dimensions are in millimeters.

Metric	A Min.	B Nom.	G ± 0.25	M	P	T Nom.
	1	3.18	10.16	4.06	7.11	3.3

Flush Fasteners as retainers



For applications where the screw head may project above the sheet surface, PS10 screws may be used with PEMSERT® F fasteners as retainers. For dimensions and engineering data on F fasteners, see PEM Bulletin F.

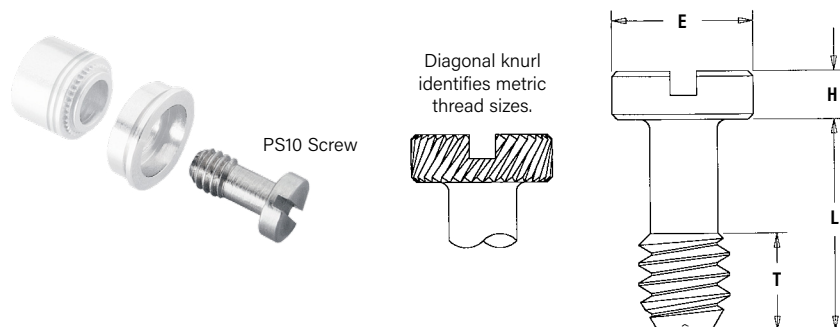


Floating Receptacle Nuts

Available on special order F10 self-clinching floating receptacle nuts permit a minimum of .015"/0.38mm adjustment for mating hole misalignment.



PS10™ Flush Mounted Screws



Threads:

External, ASME B1.1, 2A / ASME B1.13M, 6g

Material:

300 Series Stainless Steel

Finish:

Passivated and/or tested per ASTM A380

Part Number Designation

PS10 - 832 - 40

↓ ↓ ↓

Type and Material Thread Size Code Screw Length Code

All dimensions are in inches.

Unified	Thread Size	Type	Thread Code	Screw Length Code	E Nom.	H +.002 - .006	L ± .010	T Nom.
	.112-40 (#4-40)	PS10	440	40	.18	.075	.33	.13
	.138-32 (#6-32)	PS10	632	40	.21	.075	.33	.13
	.164-32 (#8-32)	PS10	832	40	.25	.075	.33	.13
	.190-32 (#10-32)	PS10	032	40	.28	.075	.33	.13

All dimensions are in millimeters.

Metric	Thread Size x Pitch	Type	Thread Code	Screw Length Code	E Nom.	H + 0.05 - 0.15	L ± 0.25	T Nom.
	M3 x 0.5	PS10	M3	40	4.7	1.91	8.38	3.3
	M4 x 0.7	PS10	M4	40	6.3	1.91	8.38	3.3
	M5 x 0.8	PS10	M5	40	7.1	1.91	8.38	3.3

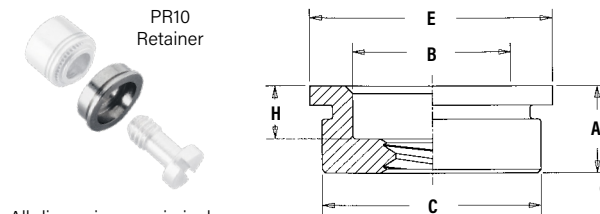
PR10™ Self-Clinching Flush-Mounted Retainers

Threads:
Internal, ASME B11, 2B / ASME B113M, 6H ⁽¹⁾

Material:
300 Series Stainless Steel

Finish:
Passivated and/or tested per ASTM A380

For use in sheet hardness:
HRB 70 or less (Hardness Rockwell "B" Scale)
HB 125 or less (Hardness Brinell)



Part Number Designation

PR10 - 832

Type Thread Size Code

Clinching profile may vary.

All dimensions are in inches.

	Thread Size	Type	Thread Code	A (Shank) Max.	Min. Sheet for Self-Clinching	Min. Sheet for Flush Installation	Hole Size in Sheet +.003 -.000	B Nom.	C Max.	E Nom.	H Nom.	Min. Dist. Hole C/L to Edge (4)
Unified	.112-40 (#4-40)	PR10	440	.125	.050	.125	.281	.195	.280	.31	.075	.31
	.138-32 (#6-32)	PR10	632	.125	.050	.125	.312	.225	.311	.34	.075	.33
	.164-32 (#8-32)	PR10	832	.125	.050	.125	.344	.255	.343	.37	.075	.34
	.190-32 (#10-32)	PR10	032	.125	.050	.125	.375	.290	.374	.41	.075	.36

All dimensions are in millimeters.

	Thread Size x Pitch	Type	Thread Code	A (Shank) Max.	Min. Sheet for Self-Clinching	Min. Sheet for Flush Installation	Hole Size in Sheet + 0.08	B Nom.	C Max.	E Nom.	H Nom.	Min. Dist. Hole C/L to Edge (4)
Metric	M3 x 0.5	PR10	M3	3.18	1.27	3.18	7.14	4.75	7.12	7.87	1.91	7.87
	M4 x 0.7	PR10	M4	3.18	1.27	3.18	8.74	6.48	8.72	9.53	1.91	8.64
	M5 x 0.8	PR10	M5	3.18	1.27	3.18	9.53	7.37	9.5	10.41	1.91	9.14

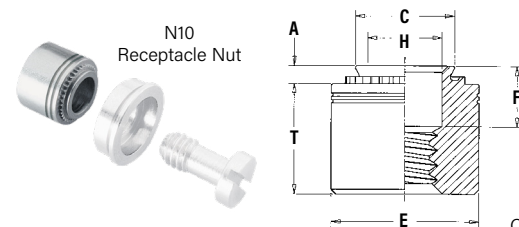
N10™ Self-Clinching Receptacle Nuts⁽³⁾

Threads:
Internal, ASME B11, 2B / ASME B113M, 6H ⁽²⁾

Material:
Hardened Carbon Steel

Finish:
Zinc plated per ASTM B633, SC1 (5µm), Type III, colorless

For use in sheet hardness:
HRB 80 or less (Hardness Rockwell "B" Scale)
HB 150 or less (Hardness Brinell)



Part Number Designation

N10 - 832 - 1 ZI

Type Thread Size Shank Finish Code

Clinching profile may vary.

All dimensions are in inches.

	Thread Size	Type	Thread Code	Shank Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size in Sheet +.003 -.000	C Max.	E Nom.	F ±.010	H Nom.	T ±.005	Min. Dist. Hole C/L to Edge (4)
Unified	.112-40 (#4-40)	N10	440	1	.038	.040	.187	.186	.28	.130	.126	.24	.22
	.138-32 (#6-32)	N10	632	1	.038	.040	.213	.212	.31	.130	.156	.24	.27
	.164-32 (#8-32)	N10	832	1	.038	.040	.250	.249	.34	.130	.187	.24	.28
	.190-32 (#10-32)	N10	032	1	.038	.040	.277	.276	.37	.130	.213	.24	.31

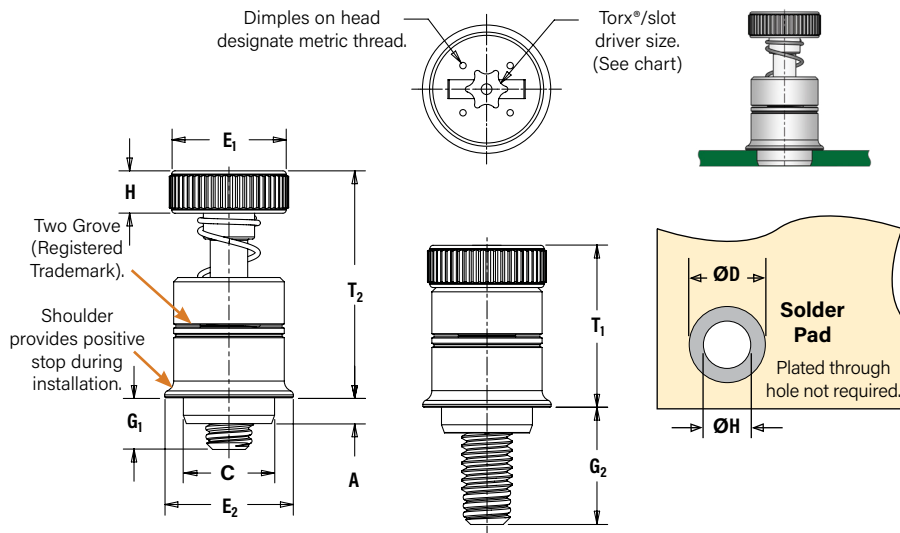
All dimensions are in millimeters.

	Thread Size x Pitch	Type	Thread Code	Shank Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size in Sheet + 0.08	C Max.	E Nom.	F ± 0.25	H Nom.	T ± 0.13	Min. Dist. Hole C/L to Edge (4)
Metric	M3 x 0.5	N10	M3	1	0.97	1	4.75	4.73	7.11	3.3	3.2	6	5.59
	M4 x 0.7	N10	M4	1	0.97	1	6.35	6.33	8.64	3.3	4.75	6	7.11
	M5 x 0.8	N10	M5	1	0.97	1	7.04	7.01	9.53	3.3	5.41	6	7.87

- (1) The purpose of the thread is for component screw retention only, thread may not accept 2B/6H Go threaded plug gage, but class 3A/4h screw must pass with finger torque, may not reject NoGo threaded plug gage and minor diameter may exceed 2B/6H maximum.
- (2) 2B (unified) and 6H (metric) go gauge may stop at pilot end but class 3A (unified) and 4h (metric) screws will pass through with finger torque.
- (3) Also available on special order F10 self-clinching floating receptacle nuts.
- (4) For more information on proximity to bends and distance to other clinch hardware, see [PEM® Tech Sheet C/L To Edge](#).

ReelFast® SMTPFLSM™ Surface Mount Captive Panel Screws

- All metal captive screw assembly installs in one piece utilizing pick and place method
- Combination drive, Torx®/slot
- Solderable finish



Installation Data [page 36](#). Performance Data [page 41](#).

Threads:

External, ASME B11, 2A / ASME B113M, 6g ⁽¹⁾

Material:

Retainer: Carbon Steel
Screw: Hardened Carbon Steel
Spring: 300 Series Stainless Steel

Finish:

Retainer: ET - Electro-plated tin ASTM B545, Class A with preservative coating, annealed ⁽²⁾
Screw: Zinc plated per ASTM B633, SC1 (5µm), Type III, colorless
Spring: Natural Finish

Part Number Designation

SMTPF LS M - 440 - O ET
↓ ↓ ↓ ↓ ↓
Type Driver Anti-cross Thread Feature Thread Code Length Code Finish

All dimensions are in inches.

Unified	Thread Size	Type	Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	C Max.	E ₁ ±.010	E ₂ Nom	G ₁ ±.025	G ₂ ±.025	H ±.010	T ₁ Nom.	T ₂ Nom.	ØK Hole Size in Sheet +.003 -.000	ØD Min. Solder Pad	Driver Size
	.112-.40 (#4-40)	SMTPFLSM	440	0	.063	.063	.215	.280	.300	.040	.210	.100	.38	.55	.220	.340	T15
				1						.100	.270						
	.138-.32 (#6-32)	SMTPFLSM	632	0	.063	.063	.247	.310	.320	.040	.240	.100	.42	.62	.252	.400	T15
				1						.100	.300						

All dimensions are in millimeters.

Metric	Thread Size	Type	Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	C Max.	E ₁ ±0.25	E ₂ Nom	G ₁ ±0.64	G ₂ ±0.64	H ±0.25	T ₁ Nom.	T ₂ Nom.	ØK Hole Size in Sheet +0.08	ØD Min. Solder Pad	Driver Size
	M3 x 0.5	SMTPFLSM	M3	0	1.6	1.6	5.46	7	7.6	1	5.3	2.5	9.6	14	5.6	8.6	T15
				1						2.5	6.8						
	M3.5 x 0.6	SMTPFLSM	M3.5	0	1.6	1.6	6.27	7.9	8.13	1	6.1	2.5	10.7	15.7	6.4	10.2	T15
				1						2.5	7.62						

Number Of Parts Per Reel

Thread Size	Parts Per Reel
440	200
632	150
M3	200
M3.5	150

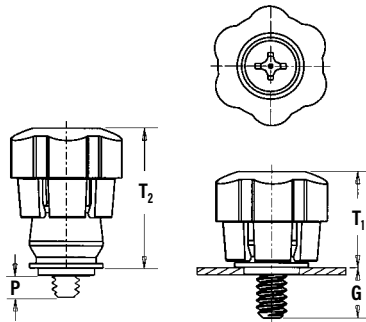
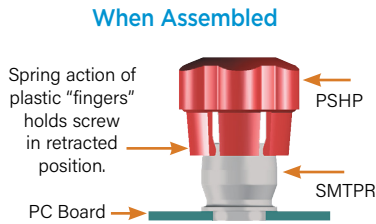


Packaged on 330 mm recyclable reels. Tape width is 24 mm.
Supplied with polyimide patch for vacuum pick up. Reels conform to EIA-481.

- (1) As with all Class 2A/6g external threads with an additive finish, the maximum major and pitch, after plating, may equal basic sizes and be gauged to Class 3A/4h, per ANSI B11, Section 8, Table 3A and ANSI B113M, Section 8, Paragraph 8.2
- (2) Optimal solderability life noted on packaging.

ReelFast® SMTPF™ Surface Mount Captive Panel Screws

- Retainer installed using conventional surface mount techniques
- Simply snap screw into retainer to complete assembly
- Black ABS knob standard
- Optional molded-through colors available
- Available with Torx® recess



Threads:

External, ASME B1.1, 2A / ASME B1.13M, 6g ⁽¹⁾

Material:

Knob: ABS ⁽²⁾

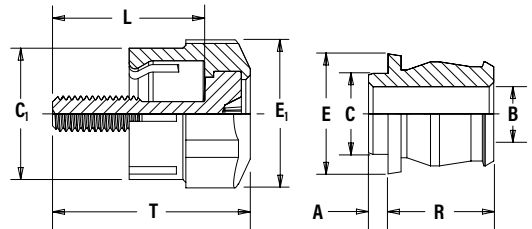
Retainer: Carbon Steel

Screw: Carbon Steel

Finish:

Retainer: ET - Electro-plated tin ASTM B545, Class A with preservative coating, annealed

Screw: CN - Bright nickel over copper flash per ASTM B689, Type II



Installation Data [page 36](#). Performance Data [page 41](#).

All dimensions are in inches.

Unified	Thread Size	Screw Part Number			Retainer Part Number	Assembly Dimensions					Screw Dimensions				Retainer Dimensions					
		Type	Thread Code	Screw Length Code		G ± .025	P ± .025	T ₁ Nom.	T ₂ Nom.	Total Radial Float	C ₁ ±.010	E ₁ ±.010	L ±.015	T Nom.	A (Shank) Max.	Min. Sheet Thick.	B ±.003	C Max.	E Nom.	R ±.005
	.112-40 (#4-40)	PSHP	440	0	SMTPR-6-1	.188	.000	.478	.646	.015	.440	.542	.510	.663	.060	.060	.167	.249	.375	.325
				1		.248	.026						.570	.723						
	.138-32 (#6-32)	PSHP	632	0	SMTPR-6-1	.188	.000	.478	.646	.020	.440	.542	.510	.663	.060	.060	.167	.249	.375	.325
				1		.248	.026						.570	.723						

All dimensions are in millimeters.

Metric	Thread Size x Pitch	Screw Part Number			Retainer Part Number	Assembly Dimensions					Screw Dimensions				Retainer Dimensions					
		Type	Thread Code	Screw Length Code		G ± 0.64	P ± 0.64	T ₁ Nom.	T ₂ Nom.	Total Radial Float	C ₁ ±0.25	E ₁ ±0.25	L ±0.38	T Nom.	A (Shank) Max.	Min. Sheet Thick.	B ±0.08	C Max.	E Nom.	R ±0.13
	M3 x 0.5	PSHP	M3	0	SMTPR-6-1	4.78	0	12.14	16.41	.38	11.18	13.77	12.95	16.84	1.53	1.53	4.24	6.33	9.53	8.26
				1		6.3	.66						14.48	18.36						
M3.5 x 0.6	PSHP	M3.5	0	SMTPR-6-1	4.78	0	12.14	16.41	.51	11.18	13.77	12.95	16.84	1.53	1.53	4.24	6.33	9.53	8.26	
			1		6.3	.66						14.48	18.36							

RETAINER - Packaged on 330 mm recyclable reels of 400 pieces. Tape width is 24 mm. Supplied with Kapton® patch for vacuum pick up. Reels conform to EIA-481.

SCREW - Packaged in bags. Retainers and screws are sold separately.

Part Number Designation For Screw

PSHP - 632 - 0 L 001

↓ ↓ ↓ ↓ ↓

Type Thread Code Length Code Cap Style Color Code (Std. Black)

Part Number Designation For Retainer

SMTPR - 6 - 1 ET

↓ ↓ ↓ ↓

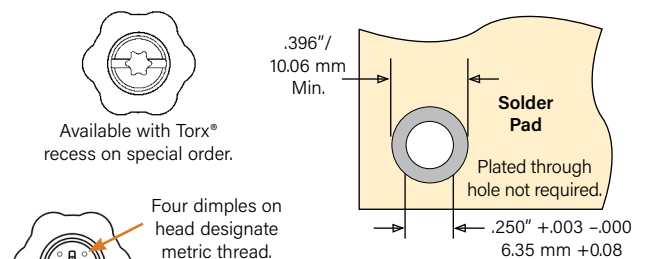
Type Retainer Size Shank Code Finish

Color Capabilities For Type PSHP Screw

The colors shown here (codes #002 thru #007) are non-stocked standards and available on special order. Since actual cap colors may vary slightly from those shown here, we recommend that you request samples for color verification. If you require a custom color or you need a "color matched" cap, please contact us.



Non-flammable UL 94-V0 plastic caps are available on special order.



Stencil Masking Examples

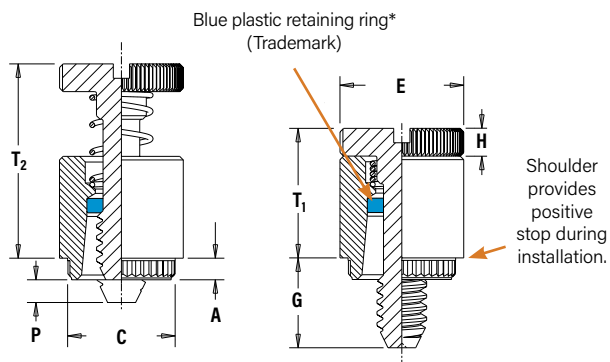
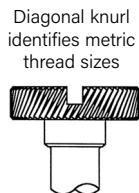


- (1) As with all Class 2A/6g external threads with an additive finish, the maximum major and pitch, after plating, may equal basic sizes and be gauged to Class 3A/4h, per ANSI B1.1, Section 8, Table 3A and ANSI B1.13M, Section 8, Paragraph 8.2.
- (2) See PEM Technical Support section of our website (www.pemnet.com) for related plating standards and specifications.

Metal Phillips Recess
#4-40 & M3 = #1
#6-32 & M3.5 = #2

PFK™ Broaching Captive Panel Screws

- For permanent and reliable installation in PC boards
- Screw assemblies remain captive for easy mounting and removal



Installation Data [page 33](#). Performance Data [page 41](#).

Threads:

External, ASME B1.1, 2A / ASME B1.13M, 6g

Material:

Retainer: 300 Series Stainless Steel

Screw: 300 Series Stainless Steel

Spring: 300 Series Stainless Steel

Retaining Ring: Nylon, temperature limit 200° F / 93° C

Finish:

Retainer: Passivated and/or tested per ASTM A380

Screw: Passivated and/or tested per ASTM A380

Spring: Natural Finish

For use in:

PC Boards

Part Number Designation

PFK - 632 - 40

↓ ↓ ↓

Type Thread Size Code Screw Length Code

All dimensions are in inches.

Unified	Thread Size	Type	Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet +.003 -.000	C ± .003	E ± .010	G ± .016	H ± .005	P ± .025	T ₁ Max.	T ₂ Nom.	Min. Dist. Hole C/L to Edge (1)
	.112-40 (#4-40)	PFK	440	40	.060	.060	.265	.283	.312	.250	.072	.000	.36	.54	.20
				62						.375		.125			
				84						.500		.250			
Metric	.138-32 (#6-32)	PFK	632	40	.060	.060	.281	.299	.344	.250	.072	.000	.36	.54	.26
				62						.375		.125			
				84						.500		.250			

All dimensions are in millimeters.

Metric	Thread Size x Pitch	Type	Thread Code	Screw Length Code	A (Shank) Max.	Min. Sheet Thickness	Hole Size In Sheet +0.08	C ± 0.08	E ± .25	G ± 0.4	H ± 0.13	P ± 0.64	T ₁ Max.	T ₂ Nom.	Min. Dist. Hole C/L to Edge (1)
	M3 x 0.5	PFK	M3	40	1.53	1.53	6.73	7.19	7.92	6.4	1.83	0	9.14	13.72	5.08
				62						9.5		3.2			
				84						12.7		6.4			
Unified															

(1) For more information on proximity to bends and distance to other clinch hardware, see [PEM® Tech Sheet C/L To Edge](#).

Value-Added Capabilities

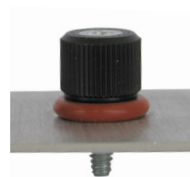
ATCA Solutions

Use PF11PM captive panel screw and TPXS pin in conjunction to satisfy the requirements of the PICMG 3.0 of the Advanced TCA®.



Tight Seal Solutions

Consider adding an o-ring to our PEM C.A.P.S.® captive panel screw. When fastened, it provides a tight seal above the panel.



Nylon Locking Patch

Nylon locking patch is available to be added to any of PEM captive panel screws for applications requiring a locking element.



Thread-forming Opportunity

PennEngineering is official licensee for REMFORM®, TAPTITE®, PT®, and DELTA PT® fastener products.

REMFORM® and TAPTITE® are trademarks of REMINC®. PT® and DELTA PT® are trademarks of EJOT®.

MAThread® Anti Cross-thread Technology

PennEngineering is a licensee of MAThread® Anti Cross-Threading Technology. This unique design allows the threads to self-align and drive easily with reduced effort. This helps speed assembly, reduce or eliminate failures, repairs, scrap, downtime, and warranty service associated with thread damage. This option is available on most types of PEM captive panel screws.



Anti Cross-Thread Feature

MAThread® is a registered trademark of MAThread inc.

Captive Panel Screw Installation

PF11™/PF12™/PF15™/PF11M™/PF12M™/PF15M™/PEM C.A.P.S.® Fasteners

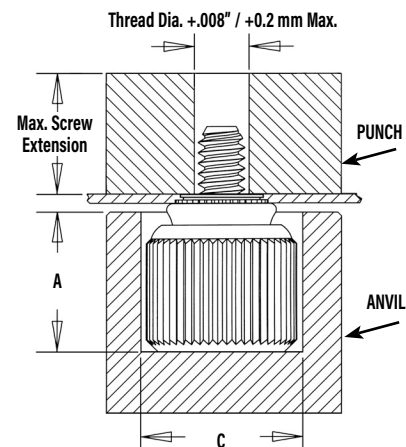
1. Prepare properly sized mounting hole in sheet. Do not perform any secondary operations such as deburring.
2. Place fastener into recessed anvil, and place workpiece (preferably the punch side) over shank of fastener.
3. With installation punch and anvil surfaces parallel, apply squeezing force until the shoulder of the retainer comes in contact with the sheet material.

Installation Tooling⁽¹⁾

Unified	Thread Code	HAEGER® Part Number		PEMSERTER® Part Number		Anvil Dimensions (in.)	
		Anvil	Punch	Anvil	Punch	A ±.002	C ±.002
	440	H-116-4L	H-132-4L	8003521	8003518	.260	.437
	632	H-116-6L	H-132-6L	8003522	8003519	.390	.468
	832	H-116-8/10L	H-132-8L	8003523	8003520	.390	.531
	032	H-116-8/10L	H-132-10L	8003523	8004350	.390	.531
	0420	H-116-04L	H-132-04L	8004351	8004352	.480	.598

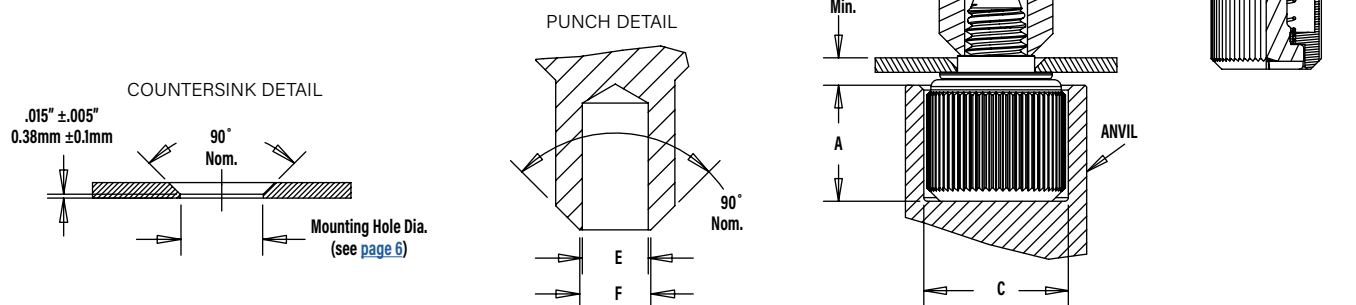
Metric	Thread Code	HAEGER® Part Number		PEMSERTER® Part Number		Anvil Dimensions (mm)	
		Anvil	Punch	Anvil	Punch	A ±0.05	C ±0.05
	M3	H-116-4L	H-132-4L	8003521	8003518	6.6	11.1
	M3.5	H-116-6L	H-132-6L	8003522	8003519	9.91	11.89
	M4	H-116-8/10L	H-132-8L	8003523	8003520	9.91	13.49
	M5	H-116-8/10L	H-132-10L	8003523	8004350	9.91	13.49
	M6	H-116-04L	H-132-04L	8004351	8004352	12.19	15.19

(1) Punches and anvils should be hardened.



PF11MF™/PF12MF™ Fasteners (Flare-Mount Installation)

1. Prepare properly sized mounting hole in sheet with countersink.
2. Place fastener into recessed anvil, and place workpiece over shank of fastener.
3. With installation punch and anvil surfaces parallel, apply squeezing force to flare the retainer of the fastener.



Installation Tooling⁽¹⁾

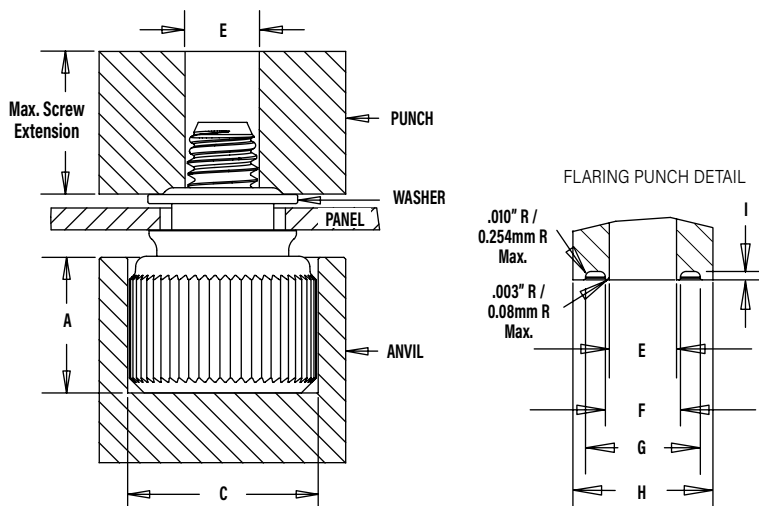
Unified	Thread Code	HAEGER® Part Number		PEMSERTER® Part Number		Anvil Dimensions (in.)		Punch Dimensions (in.)	
		Anvil	Punch	Anvil	Punch	A ±.002	C ±.002	E +.003 -.000	F ±.002
	440	H-116-4L	H-117-4L	8003521	8013670	.260	.437	.123	.133
	632	H-116-6L	H-117-6L	8003522	8013671	.390	.468	.143	.156
	832	H-116-8/10L	H-117-8/10L	8003523	8013672	.390	.531	.202	.210
	032	H-116-8/10L	H-117-8/10L	8003523	8013672	.390	.531	.202	.210
	0420	H-116-04L	H-117-04L	8004351	8013674	.480	.598	.255	.264

Metric	Thread Code	HAEGER® Part Number		PEMSERTER® Part Number		Anvil Dimensions (mm)		Punch Dimensions (mm)	
		Anvil	Punch	Anvil	Punch	A ±0.05	C ±0.05	E +0.08	F ±0.05
	M3	H-116-4L	H-117-4L	8003521	8013670	6.6	11.1	3.12	3.38
	M4	H-116-8/10L	H-117-8/10L	8003523	8013672	9.91	13.49	5.13	5.33
	M5	H-116-8/10L	H-117-8/10L	8003523	8013672	9.91	13.49	5.13	5.33
	M6	H-116-04L	H-117-04L	8004351	8013674	12.19	15.19	6.48	6.71

(1) Punches and anvils should be hardened.

PF11MW™/PF12MW™ Fasteners

1. Prepare properly sized mounting hole in sheet.
2. Place fastener into recessed anvil, place workpiece over shank of fastener, then place the washer over the shank of the fastener.
3. With installation punch and anvil surfaces parallel, apply squeezing force with flaring punch.



Installation Tooling⁽¹⁾

Unified	Thread Code	HAEGER® Part Number		PEMSERTER® Part Number		Anvil Dimensions (in.)		Punch Dimensions (in.)				
		Anvil	Punch	Anvil	Punch	A ±.002	C ±.002	E +.003 -.000	F ±.002	G ±.003	H Min.	I ±.004
	440	H-116-4L	H-119-4L	8003521	8014304	.260	.437	.120	.135	.204	.250	.015
	632	H-116-6L	H-119-6L	8003522	8014305	.390	.468	.140	.159	.249	.300	.015
	832	H-116-8/10L	H-119-8/10L	8003523	8014306	.390	.531	.201	.217	.340	.400	.028
	032	H-116-8/10L	H-119-8/10L	8003523	8014306	.390	.531	.201	.217	.340	.400	.028
	0420	H-116-04L	H-119-04L	8004351	8014307	.480	.598	.252	.271	.430	.500	.028

Metric	Thread Code	HAEGER® Part Number		PEMSERTER® Part Number		Anvil Dimensions (mm)		Punch Dimensions (mm)				
		Anvil	Punch	Anvil	Punch	A ±0.05	C ±0.03	E +0.08	F ±0.03	G ±0.08	H Min.	I ±0.1
	M3	H-116-4L	H-119-4L	8003521	8014304	6.6	11.1	3.05	3.43	5.18	6.35	.381
	M3.5	H-116-6L	H-119-6L	8003522	8014305	9.9	11.9	3.56	4.04	6.32	7.62	.381
	M4	H-116-8/10L	H-119-8/10L	8003523	8014306	9.9	13.5	5.11	5.51	8.64	10.16	.711
	M5	H-116-8/10L	H-119-8/10L	8003523	8014306	9.9	13.5	5.11	5.51	8.64	10.16	.711
	M6	H-116-04L	H-119-04L	8004351	8014307	12.2	15.2	6.4	6.88	10.92	12.7	.711

(1) Punches and anvils should be hardened.

PFHV™ Fasteners

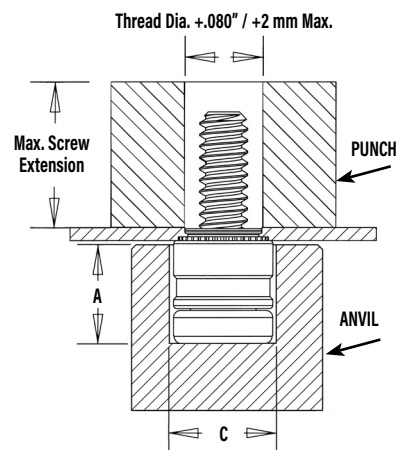
1. Prepare properly sized mounting hole in sheet. Do not perform any secondary operations such as deburring.
2. Place fastener into recessed anvil, and place workpiece (preferably the punch side) over shank of fastener.
3. With installation punch and anvil surfaces parallel, apply squeezing force until the shoulder of the retainer comes in contact with the sheet material.

Installation Tooling⁽¹⁾

Unified	Thread Code	HAEGER® Part Number		PEMSERTER® Part Number		Anvil Dimensions (in.)	
		Anvil	Punch	Anvil	Punch	A ±.002	C ±.002
	440	—	H-132-4L	8004688	970200009400	.220	.285
	632	—	H-132-6L	8004689	8015656	.250	.301
	832	—	H-132-8L	8005439	970200230400	.285	.332

Metric	Thread Code	HAEGER® Part Number		PEMSERTER® Part Number		Anvil Dimensions (mm)	
		Anvil	Punch	Anvil	Punch	A ±0.05	C ±0.05
	M3	—	H-132-4L	8004688	970200009400	5.59	7.24
	M3.5	—	H-132-6L	8004689	8015656	6.35	7.65
	M4	—	H-132-8L	8005439	970200230400	7.24	8.43

(1) Punches and anvils should be hardened.



PF7M™ Fasteners

1. Prepare properly sized mounting hole in sheet. Do not perform any secondary operations such as deburring.
2. Place fastener into recessed anvil, and place workpiece (preferably the punch side) over the shank of fastener.
3. With installation punch and anvil surfaces parallel, apply squeezing force until the shoulder of the retainer comes in contact with the sheet material.

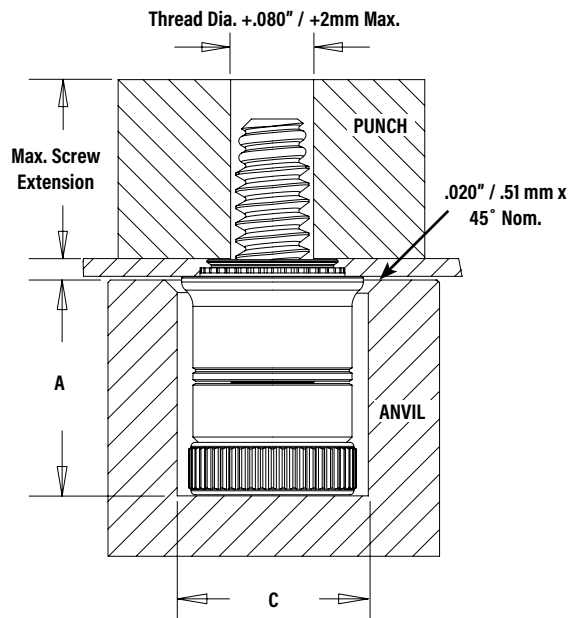
Installation Tooling⁽¹⁾

Unified	Thread Code	HAEGER® Part Number		PEMSERTER® Part Number		Anvil Dimensions (in.)	
		Anvil ⁽²⁾	Punch	Anvil	Punch	A ±.002	C ±.002
	440	—	H-132-4L	8016175	8003518	.319	.290
	632	—	H-132-6L	8016176	8003519	.333	.330
	832	—	H-132-8L	8016177	8003520	.353	.385

Metric	Thread Code	HAEGER® Part Number		PEMSERTER® Part Number		Anvil Dimensions (mm)	
		Anvil ⁽²⁾	Punch	Anvil	Punch	A ±0.05	C ±0.05
	M3	—	H-132-4L	8016175	8003518	8.1	7.34
	M4	—	H-132-8L	8016177	8003520	8.9	9.8

(1) Punches and anvils should be hardened.

(2) [Click here](#) for a quote on Haeger® custom installation tooling.



PF7MF™ Fasteners (Flare-Mount Installation)

1. Prepare properly sized mounting hole in sheet with countersink. Do not perform any secondary operations such as deburring.
2. Place fastener into recessed anvil, and place workpiece over the shank of fastener.
3. With installation punch and anvil surfaces parallel, apply squeezing force to flare the retainer of the fastener.

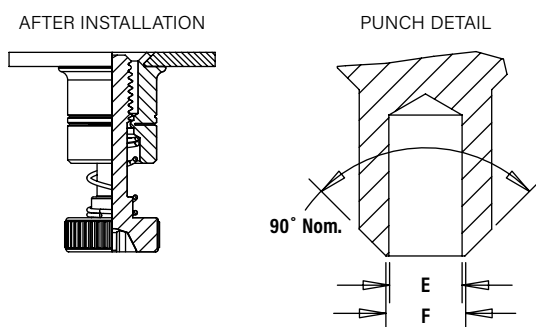
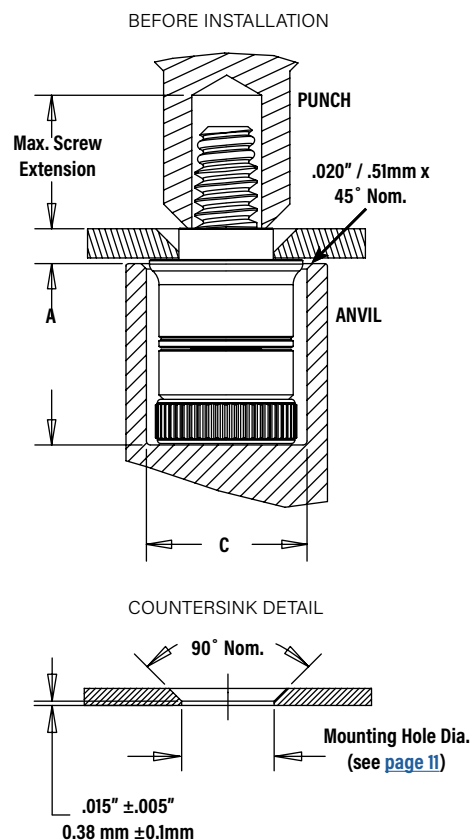
Installation Tooling⁽¹⁾

Unified	Thread Code	HAEGER® Part Number		PEMSERTER® Part Number		Anvil Dimensions (in.)		Punch Dimensions (in.)	
		Anvil ⁽²⁾	Punch	Anvil	Punch	A ±.002	C ±.002	E +.003 -.000	F ±.002
	440	—	H-117-4L	8016175	8013670	.319	.290	.123	.133
	632	—	H-117-6L	8016176	8013671	.333	.330	.143	.156
	832	—	H-117-8L	8016177	8013672	.353	.385	.202	.210

Metric	Thread Code	HAEGER® Part Number		PEMSERTER® Part Number		Anvil Dimensions (mm)		Punch Dimensions (mm)	
		Anvil ⁽²⁾	Punch	Anvil	Punch	A ±0.05	C ±0.05	E +0.08	F ±0.05
	M3	—	H-117-4L	8016175	8013670	8.1	7.34	3.12	3.38
	M4	—	H-117-8L	8016177	8013672	8.9	9.8	5.13	5.33

(1) Punches and anvils should be hardened.

(2) [Click here](#) for a quote on Haeger® custom installation tooling.



PF30™/PF31™/PF32™ Fasteners

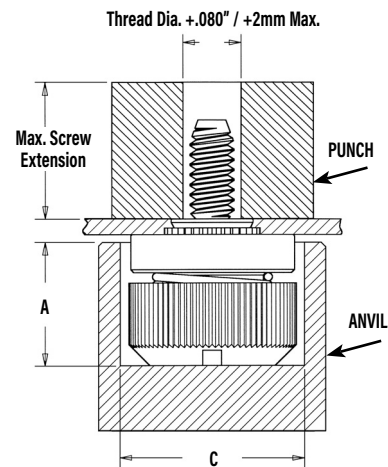
1. Prepare properly sized mounting hole in sheet. Do not perform any secondary operations such as deburring.
2. Place fastener into recessed anvil, and place workpiece (preferably the punch side) over shank of fastener.
3. With installation punch and anvil surfaces parallel, apply squeezing force until the shoulder of the retainer comes in contact with the sheet material.

Installation Tooling⁽¹⁾

Unified	Thread Code	HAEGER® Part Number		PEMSERTER® Part Number		Anvil Dimensions (in.)	
		Anvil	Punch	Anvil	Punch	A ±.002	C ±.002
	440	H-146-4L	H-132-4L	975201060	975200060	.295	.421
	632	H-146-6L	H-132-6L	975201061	975200061	.295	.453
	832	H-146-8L	H-132-8L	975201062	975200062	.310	.484
	032	H-146-10L	H-132-10L	975201063	975200063	.310	.546
	0420	H-146-04L	H-132-04L	975201064	975200064	.365	.640

Metric	Thread Code	HAEGER® Part Number		PEMSERTER® Part Number		Anvil Dimensions (mm)	
		Anvil	Punch	Anvil	Punch	A ±0.05	C ±0.05
	M3	H-146-4L	H-132-4L	975201060	975200060	7.49	10.69
	M4	H-146-6L	H-132-6L	975201062	975200062	7.87	12.29
	M5	H-146-10L	H-132-10L	975201063	975200063	7.87	13.87
	M6	H-146-04L	H-132-04L	975201064	975200064	9.27	16.26

(1) Punches and anvils should be hardened.



PF50™/PF51™/PF52™/PF60™/PF61™/PF62™ Fasteners

1. Prepare properly sized mounting hole in sheet. Do not perform any secondary operations such as deburring.
2. Place fastener into recessed anvil, and place workpiece (preferably the punch side) over shank of fastener.
3. With installation punch and anvil surfaces parallel, apply squeezing force until the shoulder of the retainer comes in contact with the sheet material.

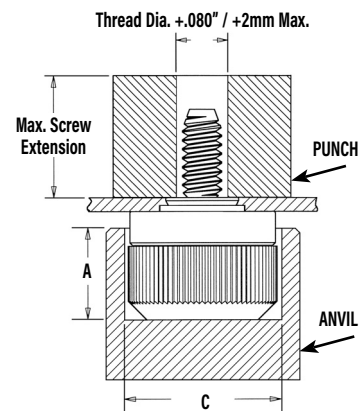
Installation Tooling⁽¹⁾⁽²⁾

Unified	Thread Code	PEMSERTER® Part Number		Anvil Dimensions (in.)	
		Anvil	Punch	A ±.002	C ±.002
	440	975201060	975200060	.295	.421
	632	975201061	975200061	.295	.453
	832	975201062	975200062	.310	.484
	032	975201063	975200063	.310	.546
	0420	975201064	975200064	.365	.640

Metric	Thread Code	PEMSERTER® Part Number		Anvil Dimensions (mm)	
		Anvil	Punch	A ±0.05	C ±0.05
	M3	975201060	975200060	7.49	10.69
	M3.5	975201061	975200061	7.49	11.51
	M4	975201062	975200062	7.87	12.29
	M5	975201063	975200063	7.87	13.87
	M6	975201064	975200064	9.27	16.26

(1) Punches and anvils should be hardened.

(2) [Click here](#) for a quote on Haeger® custom installation tooling.



PFC4™ Fasteners

1. Prepare properly sized mounting hole in sheet. Do not perform any secondary operations such as deburring.
2. Place fastener into recessed anvil, and place workpiece (preferably the punch side) over shank of fastener.
3. With installation punch and anvil surfaces parallel, apply squeezing force until the shoulder of the retainer comes in contact with the sheet material.

Installation Requirements

1. Sheet hardness must be less than 88 on the Rockwell "B" scale.
2. Hole punch should be kept sharp to minimize work hardening around hole.
3. Fastener should be installed in punch side of hole.
4. Fastener should not be installed near bends or other highly cold worked areas where sheet hardness may be greater than 88 on the Rockwell "B" scale.

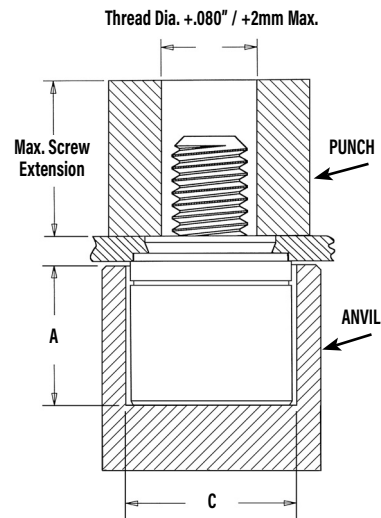
Installation Tooling⁽¹⁾⁽²⁾

Unified	Thread Code	PEMSERTER® Part Number		Anvil Dimensions (in.)	
		Anvil	Punch	A ±.002	C ±.002
	440	975200027	975200060	.345	.358
	632	975201243	975200061	.345	.390
	832	975200029	975200062	.435	.421
	032	975201244	975200063	.435	.452

Metric	Thread Code	PEMSERTER® Part Number		Anvil Dimensions (mm)	
		Anvil	Punch	A ±0.05	C ±0.05
	M3	975200027	975200060	8.76	9.09
	M4	975200029	975200062	11.05	10.69
	M5	975201244	975200063	11.05	11.48

(1) Punches and anvils should be hardened.

(2) [Click here](#) for a quote on Haeger® custom installation tooling.



PFC2P™ Fasteners

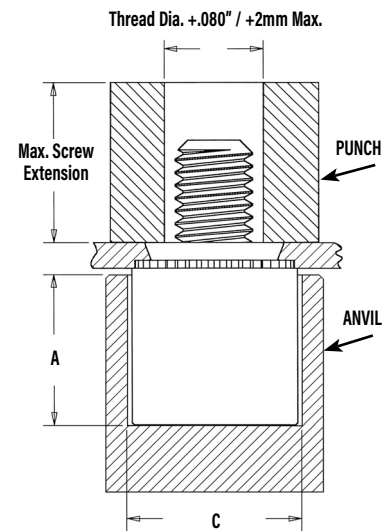
1. Prepare properly sized mounting hole in sheet. Do not perform any secondary operations such as deburring.
2. Place fastener into recessed anvil, and place workpiece (preferably the punch side) over shank of fastener.
3. With installation punch and anvil surfaces parallel, apply squeezing force until the shoulder of the retainer comes in contact with the sheet material.

Installation Tooling⁽¹⁾

Unified	Thread Code	HAEGER® Part Number		PEMSERTER® Part Number		Anvil Dimensions (in.)	
		Anvil	Punch	Anvil	Punch	A ±.002	C ±.002
	440	H-144-4L	H-132-4L	975200026	975200060	.345	.323
	632	H-144-6L	H-132-6L	975200027	975200061	.345	.358
	832	H-144-8L	H-132-8L	975200028	975200062	.435	.386
	032	H-144-10L	H-132-10L	975200029	975200063	.435	.421

Metric	Thread Code	HAEGER® Part Number		PEMSERTER® Part Number		Anvil Dimensions (mm)	
		Anvil	Punch	Anvil	Punch	A ±0.05	C ±0.05
	M3	H-144-4L	H-132-4L	975200026	975200060	8.76	8.2
	M4	H-144-8L	H-132-8L	975200028	975200062	11.05	9.8
	M5	H-144-10L	H-132-10L	975200029	975200063	11.05	10.69

(1)Punches and anvils should be hardened.



PFC2™/PFS2™ Fasteners

1. Prepare properly sized mounting hole in sheet. Do not perform any secondary operations such as deburring.
2. Place fastener into recessed anvil, and place workpiece (preferably the punch side) over shank of fastener.
3. With installation punch and anvil surfaces parallel, apply squeezing force until the shoulder of the retainer comes in contact with the sheet material.

Installation Tooling⁽¹⁾

Unified	Thread Code	HAEGER® Part Number		PEMSERTER® Part Number		Anvil Dimensions (in.)	
		Anvil	Punch	Anvil	Punch	A ±.002	C ±.002
	440	H-144-4L	H-132-4L	975200026	975200060	.345	.323
Metric	632	H-144-6L	H-132-6L	975200027	975200061	.345	.358
	832	H-144-8L	H-132-8L	975200028	975200062	.435	.386
	032	H-144-10L	H-132-10L	975200029	975200063	.435	.421
	0420	H-144-04L	H-132-04L	975200030	975200064	.565	.484

Metric	Thread Code	HAEGER® Part Number		PEMSERTER® Part Number		Anvil Dimensions (mm)	
		Anvil	Punch	Anvil	Punch	A ±0.05	C ±0.05
	M3	H-144-4L	H-132-4L	975200026	975200060	8.76	8.2
Metric	M4	H-144-6L	H-132-6L	975200028	975200062	11.05	9.8
	M5	H-144-10L	H-132-10L	975200029	975200063	11.05	10.69
	M6	H-144-04L	H-132-04L	975200030	975200064	14.35	12.29

(1) Punches and anvils should be hardened.

PTL2™/PSL2™ Fasteners

1. Prepare properly sized mounting hole in sheet. Do not perform any secondary operations such as deburring.
2. Place fastener into recessed anvil, and place workpiece (preferably the punch side) over shank of fastener.
3. With installation punch and anvil surfaces parallel, apply squeezing force until the shoulder of the retainer comes in contact with the sheet material.

Installation Tooling⁽¹⁾⁽²⁾

Unified	Type	PEMSERTER® Part Number		Anvil Dimensions (in.)	
		Anvil	Punch	A ±.002	C ±.002
	PTL2	975201245	970200013300	.580	.520
Metric	PSL2	8021146	970200013300	.490	.520

Metric	Type	PEMSERTER® Part Number		Anvil Dimensions (mm)	
		Anvil	Punch	A ±0.05	C ±0.05
	PTL2	975201245	970200013300	14.86	13.21
Metric	PSL2	8021146	970200013300	12.47	13.21

(1) Punches and anvils should be hardened.

(2) [Click here](#) for a quote on Haeger® custom installation tooling.

PFK™ Fasteners

1. Prepare properly sized mounting hole in board.
2. Place fastener into recessed anvil, and place workpiece over shank of fastener.
3. With installation punch and anvil surfaces parallel, apply squeezing force until the shoulder of the retainer comes in contact with the board.

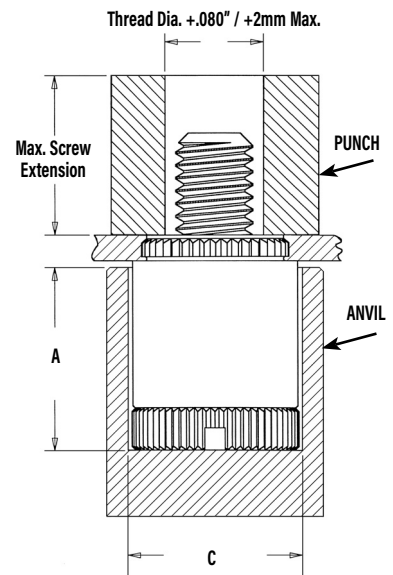
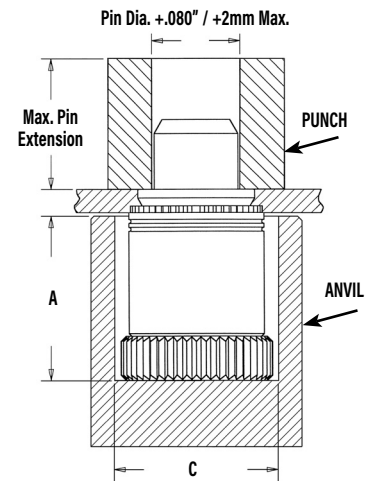
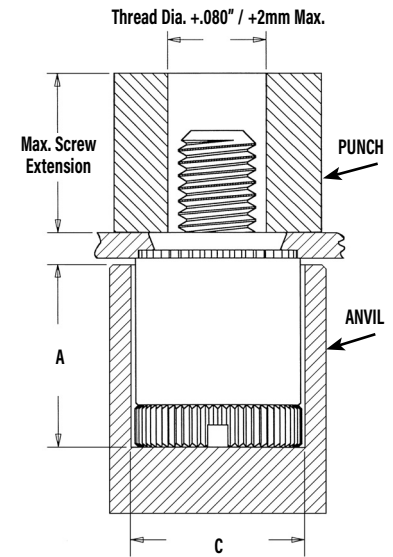
PEMSERTER® Installation Tooling⁽¹⁾⁽²⁾

Unified	Thread Code	PEMSERTER® Part Number		Anvil Dimensions (in.)	
		Anvil	Punch	A ±.002	C ±.002
	440	975200026	975200060	.320	.323
Metric	632	975200027	975200061	.320	.358

Metric	Type	PEMSERTER® Part Number		Anvil Dimensions (mm)	
		Anvil	Punch	A ±0.05	C ±0.05
	M3	975200026	970200060	8.13	8.2

(1) Punches and anvils should be hardened.

(2) [Click here](#) for a quote on Haeger® custom installation tooling.



SCBR™ Fasteners

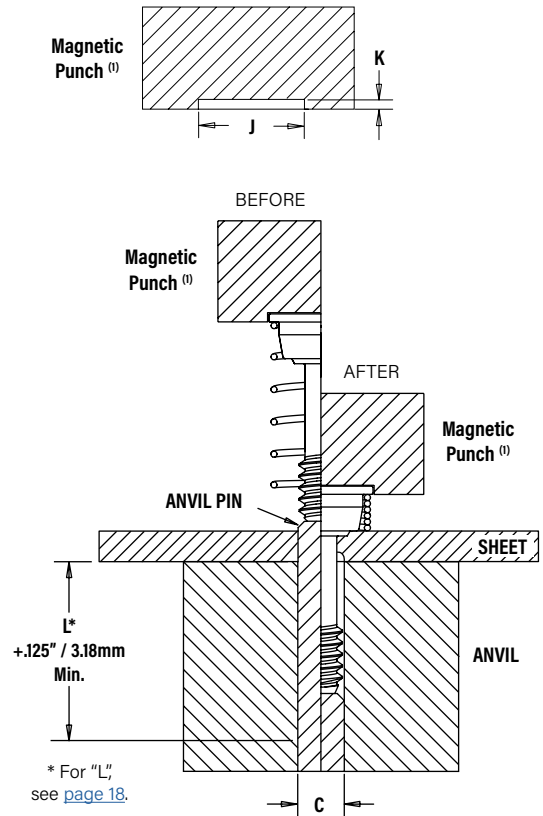
1. Prepare properly sized mounting hole in sheet. Do not perform any secondary operations such as deburring. If the hole is punched, be sure to install fastener into punched side of hole.
2. Assemble spring on screw by rotating spring counter clockwise and position assembly into recessed magnetic punch.
3. Position hole in workpiece over retractable anvil pin.
4. With installation punch and anvil surfaces parallel, apply squeezing force on top of the screw head and the underside of the sheet material. The squeezing action forces the displacer of the screw into the sheet, causing it to reduce the mounting hole diameter and captivate the screw.

Installation Tooling⁽¹⁾⁽³⁾

Unified	Thread Code	PEMSERTER® Part Number		Installation Tooling Dimensions (in.)		
		Anvil	Magnetic Punch (2)	C	J	K
	440	970200048300	8016210	.113 - .116	.354 - .357	.035
	632	970200052300	8016211	.139 - .142	.387 - .390	.035
	832	970200054300	8016212	.165 - .168	.416 - .419	.035

Metric	Thread Code	PEMSERTER® Part Number		Installation Tooling Dimensions (mm)		
		Anvil	Magnetic Punch (2)	C	J	K
	M3	970200049300	8016213	3.03 - 3.11	9.25 - 9.32	0.89
	M4	970200053300	8016214	4.03 - 4.11	10.8 - 10.9	0.89

- (1) Punches and anvils should be hardened.
 (2) Pneumatic punch may also be used. Please [contact us](#) for punch part numbers.
 (3) [Click here](#) for a quote on Haeger® custom installation tooling.



SCB™/SCBJ™ Fasteners

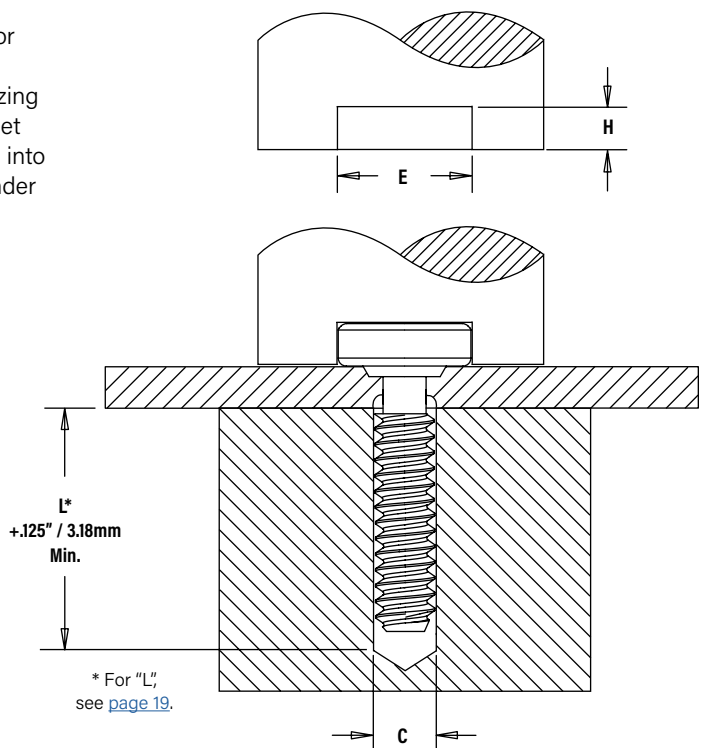
1. Prepare properly sized mounting hole in sheet.
2. Place the fastener through mounting hole and into anvil. A flat or recessed punch can be used.
3. With installation punch and anvil surfaces parallel, apply squeezing force to the top of the screw head and the underside of the sheet material. The squeezing action forces the shoulder of the screw into the sheet, displacing sheet material, causing it to fill the void under the head and shoulder of the screw.

Installation Tooling⁽¹⁾⁽²⁾

Unified	Thread Code	Installation Tooling Dimensions (in.)		
		C	E	H
	440	.113 - .116	.270 - .280	.073 - .074
	632	.139 - .142	.308 - .318	.073 - .074

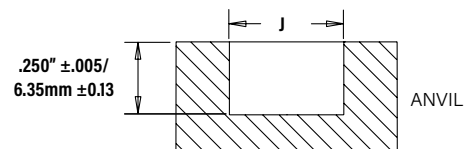
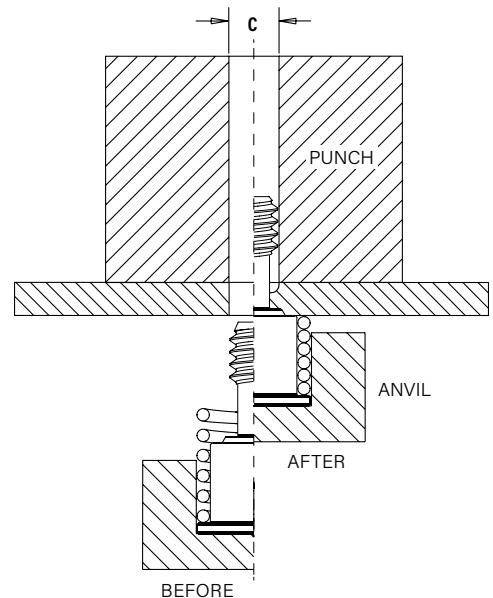
Metric	Thread Code	Installation Tooling Dimensions (mm)		
		C	E	H
	M3	3.03 - 3.11	6.86 - 7.11	1.85 - 1.88
	M4	4.03 - 4.11	8.53 - 8.79	1.85 - 1.88

- (1) Punches and anvils should be hardened.
 (2) [Click here](#) for a quote on Haeger® custom installation tooling.



HSCB™ Fastener Into Heat Sink

1. Prepare properly sized mounting hole in heat sink. Do not perform any secondary operations such as deburring. If the hole is punched, be sure to install the fastener into the punch side of the hole.
2. Place the head of the screw into the recess of the installation anvil and position assembly into recessed magnetic punch.
3. Place the spring over the shoulder of the screw, maintaining concentricity.
4. Position the heat sink mounting hole over the screw.
5. Bring the heat sink down over the screw and onto the shoulder of the screw.
6. With installation punch and anvil surfaces parallel, apply a squeezing force to the heat sink and the head of the screw. The squeezing action forces the displacer of the screw into the heat sink, causing it to reduce the mounting hole diameter and captivate the screw and spring.



Installation Tooling⁽¹⁾⁽²⁾

Unified	Thread Code	PEMSERTER® Part Number		Installation Tooling Dimensions (in.)	
		Anvil	Punch	C	J
	440	8018043	970200006300	.113 - .116	.322 - .324
	632	8018044	970200007300	.139 - .142	.362 - .364

Metric	Thread Code	PEMSERTER® Part Number		Installation Tooling Dimensions (mm)	
		Anvil	Punch	C	J
	M3	8018045	970200229300	3.03 - 3.11	8.43 - 8.48

- (1) Punches and anvils should be hardened.
 (2) [Click here](#) for a quote on Haeger® custom installation tooling.

HSR™ Nut/Standoff

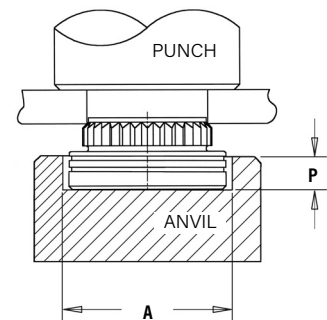
1. Prepare properly sized mounting hole in board.
2. Place fastener into the anvil hole and place the mounting hole over the shank of the fastener as shown in drawing.
3. With installation punch and anvil surfaces parallel, apply squeezing force until shoulder contacts the board.

Installation Tooling⁽¹⁾⁽²⁾

Unified	Thread Code	PEMSERTER® Part Number		Installation Tooling Dimensions (in.)	
		Anvil	Punch	A	P ±.005
	HSR-440	8023699	975200048	.228 - .231	.115
	HSR-632	8023701	975200048	.290 - .293	.115

Metric	Thread Code	PEMSERTER® Part Number		Installation Tooling Dimensions (mm)	
		Anvil	Punch	A	P ±0.13
	HSR-M3	80223700	975200048	5.8 - 5.86	2.92

- (1) Punches and anvils should be hardened.
 (2) [Click here](#) for a quote on Haeger® custom installation tooling.

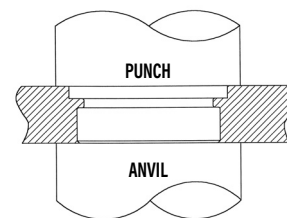


Final Assembly

Once the screw and spring are captivated, assemble the heat sink to the circuit board by tightening the screw into the receptacle nut or standoff until the audible "click" is heard. The screw will continue to rotate, but will no longer be engaged in the threads or continue to actively tighten.

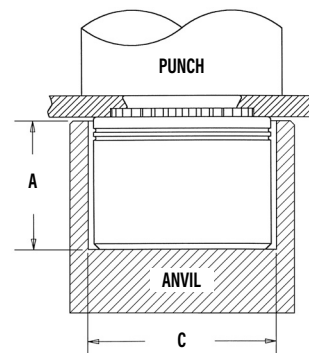
PR10™ Fasteners

1. Prepare properly sized mounting hole in sheet. Do not perform any secondary operations such as deburring.
2. Place fastener into the mounting hole.
3. With installation punch and anvil surfaces parallel, apply squeezing force until the retainer is flush in the sheet.



N10™ Fasteners

1. Prepare properly sized mounting hole in sheet. Do not perform any secondary operations such as deburring.
2. Place fastener into recessed anvil, and place workpiece (preferably the punch side) over shank of fastener.
3. With installation punch and anvil surfaces parallel, apply squeezing force until the shoulder of the nut comes in contact with the sheet material.



Installation Tooling⁽¹⁾⁽²⁾

Unified	Thread Code	PEMSERTER® Part Number		Anvil Dimensions (in.)	
		Anvil	Punch	A ±.002	C ±.002
	440	8006124	975200048	.225	.298
	632	8006735	975200048	.225	.329
	832	8006736	975200048	.225	.361
	032	8006174	975200048	.225	.392

Metric	Thread Code	PEMSERTER® Part Number		Anvil Dimensions (mm)	
		Anvil	Punch	A ±0.05	C ±0.05
	M3	8006124	975200048	5.72	7.57
	M4	8006736	975200048	5.72	9.17
	M5	8006174	975200048	5.72	9.6

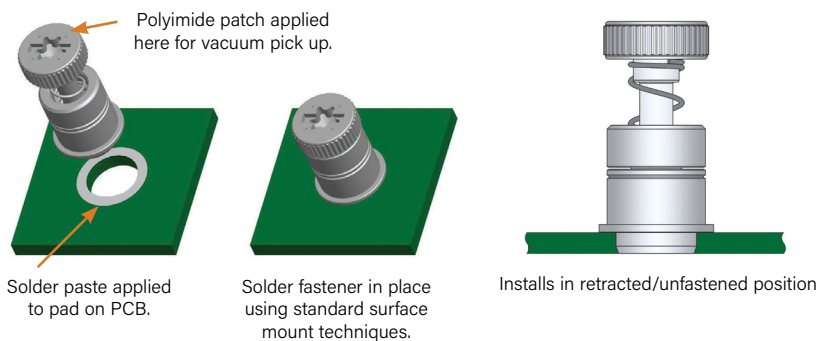
(1) Punches and anvils should be hardened.

(2) [Click here](#) for a quote on Haeger® custom installation tooling.

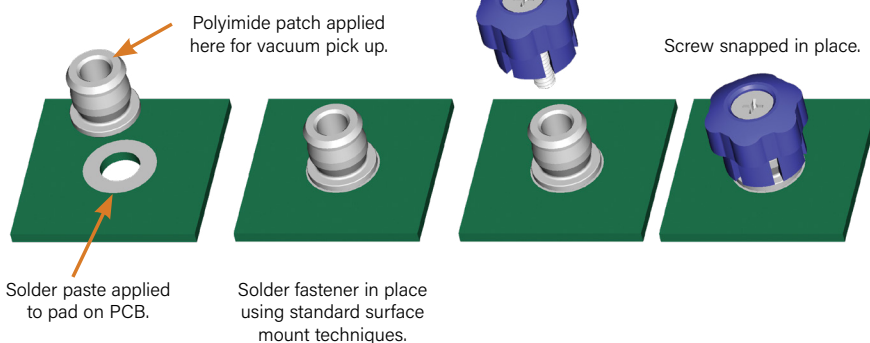
Installation Notes

- For best results we recommend using a HAEGER® or PEMSERTER® machine for installation of PEM® self-clinching fasteners. Please check our website for more information.
- Visit the Animation Library on our website to view the installation process [for select products](#).

SMTFSLM™ Captive Panel Screws



SMTPF™ Retainer

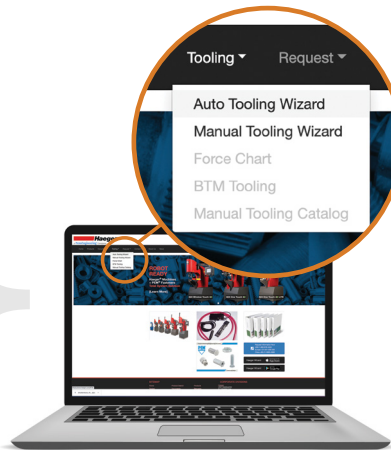


For Additional HAEGER® and PEMSERTER® Tooling Information / Part Numbers

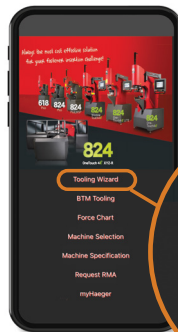


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Captive Panel Screw Performance Data⁽¹⁾

PF11™/PF12™/PF15™/PF11M™/PF12M™/PF15M™/PEM C.A.P.S.® Fasteners

Unified	Type	Thread Code	Test Sheet Material			
			Aluminum		Cold-Rolled Steel	
			Installation (lbs.)	Retainer Pushout (lbs.)	Installation (lbs.)	Retainer Pushout (lbs.)
	PF11	440	1500	80	2500	145
		632	2000	95	3500	150
	PF12	832	3000	100	4500	160
	PF15	032	3000	100	4500	160
		0420	3500	105	5000	195

Metric	Type	Thread Code	Test Sheet Material			
			Aluminum		Cold-Rolled Steel	
			Installation (kN)	Retainer Pushout (N)	Installation (kN)	Retainer Pushout (N)
	PF11	M3	6.7	355	11.1	645
		M4	13.3	445	20	710
	PF15	M5	13.3	445	20	710
		M6	15.6	465	22.2	865

PF11MF™ Fasteners

Unified	Type	Thread Code	Installation (lbs.)	Retainer Pullout (lbs.)
	PF11MF	440	250	81
		632	300	175
		832	350	180
		032	350	180
		0420	400	200

Metric	Type	Thread Code	Installation (kN)	Retainer Pullout (N)
	PF11MF	M3	1.1	360
		M4	1.5	800
		M5	1.5	800
		M6	2	890

PF11MW™ Fasteners

Unified	Type	Thread Code	Test Sheet Material	
			.060" Cold-rolled Steel	
			Swaging Force (lbs.)	Retainer Pullout (lbs.)
	PF11MW	440	350	112
		632	400	138
		832	700	202
		032	700	202
		0420	900	212

Metric	Type	Thread Code	Test Sheet Material	
			1.52mm Cold-rolled Steel	
			Swaging Force (N)	Retainer Pullout (N)
	PF11MW	M3	1557	499
		M3.5	1779	612
		M4	3114	897
		M5	3114	897
		M6	4003	945

PFHV™ Fasteners

Unified	Type	Thread Code	Test Sheet Material			
			Aluminum		Cold-Rolled Steel	
			Installation (lbs.)	Retainer Pushout (lbs.)	Installation (lbs.)	Retainer Pushout (lbs.)
	PFHV	440	1700	108	2200	118
		632	1850	117	2400	128
		832	2100	134	2700	147

Metric	Type	Thread Code	Test Sheet Material			
			Aluminum		Cold-Rolled Steel	
			Installation (kN)	Retainer Pushout (N)	Installation (kN)	Retainer Pushout (N)
	PFHV	M3	8.1	516	10.5	564
		M3.5	8.8	561	11.4	614
		M4	9.4	599	12.1	656

(1) Published installation forces are for general reference. Actual set-up and confirmation of complete installation should be made by observing proper seating of fastener as described in the installation steps. Other performance values reported are averages when all proper installation parameters and procedures are followed. Variations in mounting hole size, sheet material, and installation procedure may affect performance. Performance testing this product in your application is recommended. We will be happy to provide technical assistance and/or samples for this purpose.

Captive Panel Screw Performance Data⁽¹⁾

PF7M™ Fasteners

Unified	Type	Thread Code	Rec. Tightening Torque (in. lbs.) (2)	Min. Screw Tensile (lbs.)	Test Sheet Material			
					Aluminum		Cold-rolled Steel	
					Installation (lbs.)	Retainer Pushout (lbs.)	Installation (lbs.)	Retainer Pushout (lbs.)
	PF7M	440	4.5	580	1500	80	2500	145
	PF7M	632	8.6	855	2000	95	3500	150
	PF7M	832	15.6	1300	3000	100	4500	160

Metric	Type	Thread Code	Rec. Tightening Torque (N · m) (2)	Min. Screw Tensile (N)	Test Sheet Material			
					5052-H34 Aluminum		Cold-rolled Steel	
					Installation (kN)	Retainer Pushout (N)	Installation (kN)	Retainer Pushout (N)
	PF7M	M3	0.66	2900	6.7	355	11.1	645
	PF7M	M4	1.57	5010	13.3	445	20	710

PF7MF™ Fasteners

Unified	Type	Thread Code	Rec. Tightening Torque (in. lbs.) (2)	Min. Screw Tensile (lbs.)	Installation (lbs.)	Retainer Pullout (lbs.)
	PF7MF	440	4.5	580	250	81
	PF7MF	632	8.6	855	300	175
	PF7MF	832	15.6	1300	350	180

Metric	Type	Thread Code	Rec. Tightening Torque (N-m) (2)	Min. Screw Tensile (N)	Installation (kN)	Retainer Pullout (N)
	PF7MF	M3	0.66	2900	1.1	360
	PF7MF	M4	1.57	5010	1.5	800

PF30™/PF31™/PF32™ Fasteners

Unified	Type	Thread Code	Test Sheet Material			
			Aluminum		Cold-Rolled Steel	
			Installation (lbs.)	Retainer Pushout (lbs.)	Installation (lbs.)	Retainer Pushout (lbs.)
	PF30	440	2200	64	5000	90
	PF31	440	2200	105	5000	110
	PF32	440	2200	185	5000	300
	PF30	632	2400	66	5500	90
	PF31	632	2400	105	5500	130
	PF32	632	2400	190	5500	300
	PF30	832	2800	68	6000	90
	PF31	832	2800	110	6000	130
	PF32	832	2800	200	6000	300
	PF30	032	3500	72	8000	95
	PF31	032	3500	150	8000	160
	PF32	032	3500	260	8000	425
	PF32	0420	4300	320	12000	450

Metric	Type	Thread Code	Test Sheet Material			
			Aluminum		Cold-Rolled Steel	
			Installation (kN)	Retainer Pushout (N)	Installation (kN)	Retainer Pushout (N)
	PF30	M3	9.8	285	22.2	400
	PF31	M3	9.8	465	22.2	489
	PF32	M3	9.8	823	22.2	1334
	PF30	M4	12.5	302	26.7	400
	PF31	M4	12.5	489	26.7	578
	PF32	M4	12.5	890	26.7	1334
	PF30	M5	15.6	320	35.6	423
	PF31	M5	15.6	667	35.6	712
	PF32	M5	15.6	1156	35.6	1890
	PF32	M6	19.1	1423	53.4	2002

- (1) Published installation forces are for general reference. Actual set-up and confirmation of complete installation should be made by observing proper seating of fastener as described in the installation steps. Other performance values reported are averages when all proper installation parameters and procedures are followed. Variations in mounting hole size, sheet material, and installation procedure may affect performance. Performance testing this product in your application is recommended. We will be happy to provide technical assistance and/or samples for this purpose.
- (2) Torque values shown will produce a preload of 70% minimum tensile with nut factor "k" equal to 1.

Captive Panel Screw Performance Data⁽¹⁾

PF50™/PF51™/PF52™/PF60™/PF61™/PF62™ Fasteners

Unified	Type	Thread Code	Test Sheet Material			
			Aluminum		Cold-Rolled Steel	
			Installation (lbs.)	Retainer Pushout (lbs.)	Installation (lbs.)	Retainer Pushout (lbs.)
	PF50/PF60	440	2200	64	5000	90
	PF51/PF61	440	2200	105	5000	110
	PF52/PF62	440	2200	185	5000	300
	PF50/PF60	632	2400	66	5500	90
	PF51/PF61	632	2400	105	5500	130
	PF52/PF62	632	2400	190	5500	300
	PF50/PF60	832	2800	68	6000	90
	PF51/PF61	832	2800	110	6000	130
	PF52/PF62	832	2800	200	6000	300
	PF50/PF60	032	3500	72	8000	95
	PF51/PF61	032	3500	150	8000	160
	PF52/PF62	032	3500	260	8000	425
	PF52/PF62	0420	4300	320	12000	450

Metric	Type	Thread Code	Test Sheet Material			
			Aluminum		Cold-Rolled Steel	
			Installation (kN)	Retainer Pushout (N)	Installation (kN)	Retainer Pushout (N)
	PF50/PF60	M3	9.8	285	22.2	400
	PF51/PF61	M3	9.8	465	22.2	489
	PF52/PF62	M3	9.8	823	22.2	1334
	PF50/PF60	M3.5	10.7	294	24.4	400
	PF51/PF61	M3.5	10.7	465	24.4	578
	PF52/PF62	M3.5	10.7	845	24.4	1334
	PF50/PF60	M4	12.5	302	26.7	400
	PF51/PF61	M4	12.5	489	26.7	578
	PF52/PF62	M4	12.5	890	26.7	1334
	PF50/PF60	M5	15.6	320	35.6	423
	PF51/PF61	M5	15.6	667	35.6	712
	PF52/PF62	M5	15.6	1156	35.6	1890
	PF52/PF62	M6	19.1	1423	53.4	2002

PFC4™ Fasteners

Unified	Type	Thread Code	Test Sheet Material	
			304 Stainless Steel	
			Installation (lbs.)	Retainer Pushout (lbs.)
	PFC4	440	9100	350
		632	10300	400
		832	10800	450
		032	11800	550

Metric	Type	Thread Code	Test Sheet Material	
			304 Stainless Steel	
			Installation (kN)	Retainer Pushout (N)
	PFC4	M3	40.5	1557
		M4	48	2002
		M5	52.5	2447

PFC2™/PFS2™/PFC2P™ Fasteners

Unified	Type	Thread Code	Test Sheet Material			
			Aluminum		Cold-Rolled Steel	
			Installation (lbs.)	Retainer Pushout (lbs.)	Installation (lbs.)	Retainer Pushout (lbs.)
	PFC2	440	2400	240	3000	300
		632	2700	275	3500	350
	PFS2	832	2900	300	3800	400
	PFC2P	032	3000	400	4000	500
		0420	3500	400	5000	600

Metric	Type	Thread Code	Test Sheet Material			
			Aluminum		Cold-Rolled Steel	
			Installation (kN)	Retainer Pushout (N)	Installation (kN)	Retainer Pushout (N)
	PFC2	M3	10.7	1068	13.3	1334
		M4	12.9	1334	16.9	1779
	PFS2	M5	13.3	1779	17.8	2224
	PFC2P	M6	15.6	1779	22.2	2669

PTL2™/PSL2™ Fasteners

Unified	Type	Test Sheet Material			
		Aluminum		Cold-Rolled Steel	
		Installation (lbs.)	Retainer Pushout (lbs.)	Installation (lbs.)	Retainer Pushout (lbs.)
	PTL2	3000	400	4000	500
	PSL2				

Metric	Type	Test Sheet Material			
		Aluminum		Cold-Rolled Steel	
		Installation (kN)	Retainer Pushout (N)	Installation (kN)	Retainer Pushout (N)
	PTL2	13.3	1779	17.8	2224
	PSL2				

(1) Published installation forces are for general reference. Actual set-up and confirmation of complete installation should be made by observing proper seating of fastener as described in the installation steps. Other performance values reported are averages when all proper installation parameters and procedures are followed. Variations in mounting hole size, sheet material, and installation procedure may affect performance. Performance testing this product in your application is recommended. We will be happy to provide technical assistance and/or samples for this purpose.

Captive Panel Screw Performance Data⁽¹⁾

SCBR™ Fasteners

Unified	Type	Thread Code	Rec. Tightening Torque (in. lbs.) (2)	Min. Screw Tensile (lbs.)	Test Sheet Material			
					5052-H34 Aluminum		Cold-rolled Steel	
					Installation (lbs.)	Pushout (lbs.)	Installation (lbs.)	Pushout (lbs.)
	SCBR	440	5	590	1900	130	2600	145
	SCBR	632	9	990	2000	175	3500	200
	SCBR	832	17	1460	2250	225	3825	260

Metric	Type	Thread Code	Rec. Tightening Torque (N · m) (2)	Min. Screw Tensile (N)	Test Sheet Material			
					5052-H34 Aluminum		Cold-rolled Steel	
					Installation (kN)	Pushout (N)	Installation (kN)	Pushout (N)
	SCBR	M3	0.74	3400	8	580	12	650
	SCBR	M4	1.7	5700	10	1000	17	1150

SCB™/SCBJ™ Fasteners

Unified	Type	Thread Code	Rec. Tightening Torque (in. lbs.) (2)	Min. Screw Tensile (lbs.)	Test Sheet Material			
					5052-H34 Aluminum		Cold-rolled Steel	
					Installation (lbs.)	Pushout (lbs.)	Installation (lbs.)	Pushout (lbs.)
	SCB / SCBJ	440	5	590	1900	130	2600	145
	SCB / SCBJ	632	9	990	2000	175	3500	200

Metric	Type	Thread Code	Rec. Tightening Torque (N · m) (2)	Min. Screw Tensile (N)	Test Sheet Material			
					5052-H34 Aluminum		Cold-rolled Steel	
					Installation (kN)	Pushout (N)	Installation (kN)	Pushout (N)
	SCB / SCBJ	M3	0.74	3400	8	580	12	650
	SCB / SCBJ	M4	1.7	5700	10	1000	17	1150

HSCB™ Fasteners

Unified	Type	Thread Code	Test Sheet Material			
			Aluminum		Cold-rolled Steel	
			Installation (lbs.)	Pushout (lbs.)	Installation (lbs.)	Pushout (lbs.)
	HSCB	440	1900	60	2600	80
	HSCB	632	2000	90	3500	120

Metric	Type	Thread Code	Test Sheet Material			
			Aluminum		Cold-rolled Steel	
			Installation (kN)	Pushout (N)	Installation (kN)	Pushout (N)
	HSCB	M3	8	265	12	355

HSR™ Fasteners

Unified	Type	Thread Code	Test Sheet Material	
			.060" FR-4 Panel	
			Installation (lbs.)	Pushout (lbs.)
	HSR	440	400	65
	HSR	632	500	80

Metric	Type	Thread Code	Test Sheet Material	
			1.5mm FR-4 Panel	
			Installation (kN)	Pushout (N)
	HSR	M3	2.2	290

- (1) Published installation forces are for general reference. Actual set-up and confirmation of complete installation should be made by observing proper seating of fastener as described in the installation steps. Other performance values reported are averages when all proper installation parameters and procedures are followed. Variations in mounting hole size, sheet material, and installation procedure may affect performance. Performance testing this product in your application is recommended. We will be happy to provide technical assistance and/or samples for this purpose.
- (2) Torque values shown will produce a preload of 70% minimum tensile (125 ksi / 935 MPa) with nut factor "k" equal to .1

Captive Panel Screw Performance Data⁽¹⁾

PR10™ Fasteners

Unified	Type	Thread Code	Test Sheet Material	
			Aluminum	Cold-Rolled Steel
			Installation (lbs.)	Installation (lbs.)
	PR10			
		440	2100	3000
		632	2100	3000
		832	2100	3600
		032	2400	4200

Metric	Type	Thread Code	Test Sheet Material	
			Aluminum	Cold-Rolled Steel
			Installation (kN)	Installation (kN)
	PR10			
		M3	9.3	13.3
		M4	9.3	16
		M5	10.7	18.7

N10™ Fasteners

Unified	Type	Thread Code	Test Sheet Material			
			Aluminum		Cold-Rolled Steel	
			Installation (lbs.)	Pushout (lbs.)	Installation (lbs.)	Pushout (lbs.)
	N10					
		440	2500	95	3600	130
		632	2500	105	4000	145
		832	3000	110	5000	180
		032	3500	120	6300	200

Metric	Type	Thread Code	Test Sheet Material			
			Aluminum		Cold-Rolled Steel	
			Installation (kN)	Pushout (N)	Installation (kN)	Pushout (N)
	N10					
		M3	11.1	423	16	578
		M4	13.3	489	22.2	800
		M5	15.6	534	28	890

REELFAST® SMTFPLSM™ Fasteners⁽²⁾

Unified	Type and Thread Size	Min. Tensile Strength (lbs.)	Rec. Tightening Torque (in. lbs.) ⁽³⁾	Test Sheet Material
				.060" P.C. Board
				Pull-off (lbs.) ⁽⁴⁾
	SMTFPLSM-440	556	4.4	100
	SMTFPLSM-632	724	7.0	105

Metric	Type and Thread Size	Min. Tensile Strength (N)	Rec. Tightening Torque (N-m) ⁽³⁾	Test Sheet Material
				1.5 mm P.C. Board
				Pull-off (N) ⁽⁴⁾
	SMTFPLSM-M3	2900	0.61	445
	SMTFPLSM-M3.5	3269	0.8	465

REELFAST® SMTPR™ Retainer⁽²⁾

Part Number	Test Sheet Material	
	.062" Single Layer RF-4	
	Pushout (lbs.)	Pushout (N)
SMTPR-6-IET	161.4	718

Testing Conditions For SMTFPLSM Fasteners And SMTPR Retainer

Oven	Quad ZCR convection oven
High Temp	473°F / 245°C
Spokes	2 Spoke Pattern
Board Finish	62% Sn, 38% Pb
Screen Printer	Ragin Manual Printer
Vias	None
Paste	Amtech NC559LF Sn96.5/3.0Ag/0.5Cu (SAC305) (SMTPR) Alpha CVP-390 Sn96.5/3.0Ag/0.5Cu (SAC305) (SMTFPLSM)
Stencil	.0067" / 0.17 mm thick (SMTPR) .005" / 0.13 mm thick (SMTFPLSM)

PFK™ Fasteners

Unified	Type	Thread Code	Test Sheet Material	
			FR-4 Fiberglass	
			Installation (lbs.)	Pushout (lbs.)
	PFK			
		440	250	55
		632	400	60

Metric	Type	Thread Code	Test Sheet Material	
			FR-4 Fiberglass	
			Installation (kN)	Pushout (N)
	PFK			
		M3	1.1	245

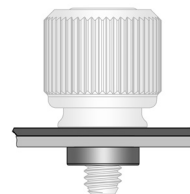
- (1) Published installation forces are for general reference. Actual set-up and confirmation of complete installation should be made by observing proper seating of fastener as described in the installation steps. Other performance values reported are averages when all proper installation parameters and procedures are followed. Variations in mounting hole size, sheet material, and installation procedure may affect performance. Performance testing this product in your application is recommended. We will be happy to provide technical assistance and/or samples for this purpose.
- (2) With lead-free paste. Average values of 30 test points. The data presented here is for general comparison purposes only. Actual performance is dependent upon application variables. We will be happy to provide samples for you to install. If required, we can also test your installed hardware and provide you with the performance data specific to your application.
- (3) Torque values shown will produce a preload of 70% minimum tensile with a nut factor "k" equal to .1.
- (4) Failure occurred at the solder joint.

Captive Panel Screw Capabilities

Most Commonly Used And Recommended Captive Mating Hardware For Use With Captive Panel Screws

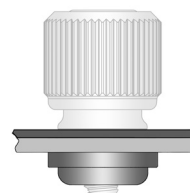
Self-Clinching Nuts Mated With Captive Panel Screw (See PEM® [CL Datasheet](#))

- S/CLS/SS/CLSS provide load-bearing threads in thin sheets with high pushout and torque-out resistance.
- SP nuts provide load-bearing threads in stainless steel sheets with a hardness of HRB 90 (Rockwell "B" scale) / HB 192 (Hardness Brinell) or less.
- CLA aluminum nuts are recommended for aluminum sheets with a hardness of HRB 50 (Rockwell "B" scale) / HB 89 (Hardness Brinell) or less.
- SMPS nuts are for installation into ultra-thin sheets and can be mounted closer to the edge of a sheet than other self-clinching nuts.
- SL nuts have a unique TRI-DENT® locking feature which meets demanding locking performance requirements.



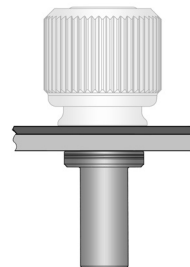
As/Ac/A4 Floating Nuts Mated With Captive Panel Screw (See PEM® [ALA Datasheet](#))

- AS (carbon steel) and AC (300 series stainless steel) floating nuts install into sheets with hardness up to HRB 70 / HB 125 on the Rockwell "B" scale.
- A4 (400 series stainless steel) floating nuts install into sheets with hardness up to HRB 88 / HB 183 on the Rockwell "B" scale.
- Thread locking versions also available.



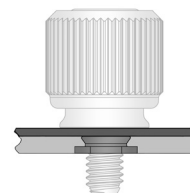
B/Bs Blind Nuts Mated With Captive Panel Screw (See PEM® [B Datasheet](#))

- B/BS nuts are used in applications requiring closed thread ends.
- Provides barrier to protect threads against foreign matter.
- Protects internal components from intrusion of screws.



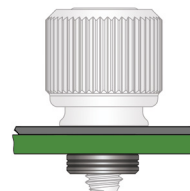
F Flush Nuts Mated With Captive Panel Screw (See PEM® [F Datasheet](#))

- Designed to be completely flush in sheets as thin as .060"/1.5mm.
- Ideal for applications where a thin sheet requires load-bearing threads but still must remain smooth, with no protrusions on either surface.
- The hexagonal head ensures high axial and torsional strength.
- F nuts can be ordered to conform to US NASM45938/4 specifications.



Pc Board Nuts Mated With Captive Panel Screw (See PEM® [K Datasheet](#))

- KF2/KFS2 broaching nuts utilize specially formed axially grooves that can be mounted into a hole to provide a permanent, strong, threaded attachment point in PC boards.
- SMTSO surface mount nuts also available.



For the best mating hardware for your application please contact our [Tech Support](#) line or your local representative.

PEM® Trademarks



"PEM" Stamp
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PSHP



Single Groove
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PFC4



Skirted Shoulder Identifier
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PF11, PF11M, PF11MF, PF11MW, PF11PM,
PF12, PF12M, PF12MF, PF12MW, PF15,
PF15M, PF7M, PF7MF, SMTPLLSM



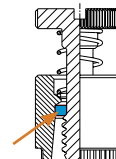
Double Squares
(Registered Trademark)
F10



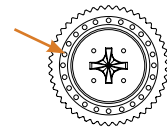
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PF10, PF30, PF31, PF32, PF50, PF51, PF52, PF60, PF61,
PF62, PF11, PF11M, PF11MF, PF11MW, PF11PM, PF12, PF12M,
PF12MF, PF12MW, PF15, PF15M, PF7M, PF7MF, PFC2,
PFC2P, PFC4, PFHV, PFK, PFS2, PSHP, SCB, SCBJ, SCBR



Two Groove
(Registered Trademark)
PF7M, PF7MF, N10, HSR



Blue Retaining Ring
(Trademark)
PFC4, PFC2P, PFC2, PFS2, PFK



PEM C.A.P.S. Dot Pattern
(Trademark)
PF11PM

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