



# AUTOMATIC TOOLING GUIDE FOR PEMSERTER® SERIES 4® AUTOMATIC FEED PRESS





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PEMSERTER® SERIES 4®  
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**This tooling guide references the automatic tooling available for the Series 4AF® Press**

## Top Feed Nut Tooling for S & CLS

### S, CLS PEM® Self-Clinching Nuts

### Unified and Metric Combined

<b>Size</b>	<b>-0,-1,-2</b>	<b>Top Feed</b>	<b>Color</b>
256/M2		8000751*	Bright Yellow
348/M2.5		8000751**	Bright Yellow
440/M3		8000751	Bright Yellow
632/M3.5		8000752	Bright Red
832/M4		8000753	Orange
024/032/M5		8000754	Metallic Brown
0420/M6		8000755	Blue

\* For 256/M2 fasteners, purchase additional Pin Punch, Part No. 8003312, Top Feed Only

\*\* For 348/M2.5 fasteners, purchase additional Pin Punch Part No. 8003273, Top Feed Only

### F PEM® Self-Clinching Flush Nuts

### Unified and Metric Combined

<b>Size</b>	<b>-1,-2</b>	<b>Top Feed</b>	<b>Color</b>
440/M3		8001098	Ocean Blue
632/M3.5		8001099	Bright Red
832/M4		8005307	Teal Pearl
032/M5		[8005550]	Buckskin
0420-3		[8019538]	Black



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**Top Feed Stud Tooling for FH, FHS, FHL, TPS & HFE**

**FH, FHS PEM® Self-Clinching Flush Studs**                      **Unified and Metric Combined**

<b>Size</b>	<b>Top Feed Vacuum</b>	<b>Color</b>
256 -8 to -12	8018178	Red Metallic
M2.5 -12 to -18	8018166	Red Metallic
440 -4 to -16/M3 -6 to -25	8018167	Green
632 -8 to -16/M3.5 -12 to -25	8018168	Gray
832 -6 to -16/M4 -8 to -25	8018169	Beige
032 -6 to -16/M5 -8 to -25	8018170	Metallic Light Blue
0420 -6 to -16	8018171	White
M6 -10 to -25	8018172	White

**FHL PEM® Low Displacement Head Studs**                      **Unified and Metric Sizes**

<b>Size</b>	<b>Top Feed Vacuum</b>	<b>Color</b>
440-4 to -16	[8021315]	Black
632-6 to -16	[8024807]	Dove Grey

**TPS PEM® Self-Clinching Pilot Pins**                      **Unified and Metric Sizes**

<b>Size</b>	<b>Top Feed Vacuum</b>	<b>Color</b>
187-6-16	[8020085]	Black
4MM -8 to -16	[8019595]	Sandstone

**HFE PEM® High Strength Studs**                      **Metric Sizes Only**

<b>Size</b>	<b>Top Feed Vacuum</b>	<b>Color</b>
M6 -12 to -25	[8020071]	Black

**HFH PEM® High Strength Studs**                      **Metric Sizes Only**

<b>Size</b>	<b>Top Feed Vacuum</b>	<b>Color</b>
032 -8 to -16/M5 -15 to -25	[8023193]	Silver Blue Metallic
M6 -15 to -25	[8022857]	White

**TFH, TFHS PEM® Self-Clinching Flush Studs**

<b>Size</b>	<b>Top Feed Vacuum</b>	<b>Color</b>
832 -6 to -16	8020705	Sandstone



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**Top Feed Tooling for SO, SOS, SOA**

**SO, SOS, SOA PEM® Self Clinching Standoffs – Short Dash Lengths**

Size – Unified and Metric Combined	Top Feed Pin	Color
440-3 to –4 /M3-3	8000818	Yellow
632-3 to –4 /M3.5-3	8000819	Teal
832/032-3 to –4 /M4/M5-3	8000820	Dark Gray

**Note:** Above tooling is nut-style with a nutgate.

**SO, SOS, SOA PEM® Self Clinching Standoffs – Middle Dash Lengths**

Size – Unified and Metric Combined	Top Feed Pin	Color
440-5 /M3-4	8001426	Gold Metallic
632-5 to –6 /M3.5-4 to –5	8002102	Lavender
832/032-5 to –8 /M4/M5-4 to –6	8002574	Black Metallic

**Note:** Above tooling is nut-style with a ramp escapement.

**SO, SOS, SOA PEM® Self Clinching Standoffs – Longer Dash Lengths**

Size – Unified and Metric Combined	Top Feed Pin	Color
440-8 to 20 /M3-6 to -25	8018173	Magenta
6440-10 to –20 /3.5M3-8 to –25	8018174	Aqua Green
632-8 to –20 /M3.5-8 to –25	8018175	Aqua Green
832/032-10 to 20 /M4/M5-8 to –25	8018176	Bronze Metallic

**Note:** Above tooling is stud-style with pin punch pick-up.

**Top Feed Tooling for BSO, BSOS, BSOA**

**BSO, BSOS, BSOA PEM® Self Clinching Standoffs – Longer Dash Lengths**

Size – Unified and Metric Combined	Top Feed Vacuum	Color
440-10 to 20 /M3-8 to -25	8018184	Magenta
632-10 to –20 /M3.5-8 to –25	8018185	Aqua Green
832/032-10 to 20 /M4/M5-8 to –25	8018186	Bronze Metallic

**Note:** BSO Automatic Tooling Packages are different from SO-packages because they contain a vacuum punch instead of a pin punch.

**Note:** For 6440 and 3.5M3 thread codes use 632/M3.5 tooling set.  
For 8632 thread codes use 832/M4 tooling set.



**SPARE PARTS**  
**Rectangular Tubing**  
 (Order Qty by Length)

<b>S, CLS Nuts</b>	<b>Rectangular Tubing</b>	<b>Top Feed Length Req.</b>
440/M3, 632/M3.5	8000441	2.5 FT (.76m)
832/M4, 032/M5	8000442	2.5 FT (.76m)
0420/M6	8001340	2.5 FT (.76m)

<b>SO – Standoffs, Short</b>	<b>Rectangular Tubing</b>	<b>Top Feed Length Req.</b>
440-3,-4/M3 -3	8000831	2.5 FT (.76m)
440-5/M3-4	8000831	3.5 FT (1.07m)
632-3,-4/M3.5-3	8000831	2.5 FT (.76m)
632-5,-6/M3.5-4,-5	8001415	3.5 FT ( 1.07m)
832-3,-4 /M4-3	8000832	2.5 FT (.76m)
832 -5 to -8/M4 -10 to-16	8001583	3.5 FT (1.07m)
032 -3,-4/M5 -3	8000832	2.5 FT (.76m)

<b>F Nuts</b>	<b>Rectangular Tubing</b>	<b>Top Feed Length Req.</b>
440/M3, 632/M3.5	8000831	2.5 FT (.76m)
832/M4, 032/M5	8000832	2.5 Ft (.76m)
0420	8000832	2.5 Ft (.76m)

**Round Tubing** (Order Qty by Length)

<b>FH Studs</b>	<b>Round Tubing</b>	<b>Top Feed Length Req.</b>
256/M2.5	8001446	8.2 FT (2.5m)
440/M3	8000416	8.2 FT (2.5m)
632/M3.5	8000417	8.2 FT (2.5m)
832/M4	8000418	8.2 FT (2.5m)
032/M5	8000766	8.2 FT (2.5m)
0420/M6	8000421	8.2 FT (2.5m)



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**Round Tubing (Order Qty by Length)**

<b>SO/BSO Standoffs</b>	<b>Round Tubing</b>	<b>Top Feed Length Req.</b>
440-7 to-24/M3-6 to -18	8000417	8.2 FT (2.5m)
632-10 to-34/M3.5 to -18	8000766	8.2 FT (2.5m)
832 -12 to-22/M4 -10 to-16	8000421	8.2 FT (2.5m)
032 -12 to-22/M5 -10 to-16	8000421	8.2 FT (2.5m)

<b>FHL Low Displacement Head Studs</b>	<b>Round Tubing</b>	<b>Top Feed Length Req.</b>
440-4 to -16	8000416	8.2 FT (2.5m)
632-6 to -16	8000417	8.2 FT (2.5m)

<b>TPS Pilot Pins</b>	<b>Round Tubing</b>	<b>Top Feed Length Req.</b>
187-6-16	8000766	8.2 FT (2.5m)
4MM -8 to -16	8000418	8.2 FT (2.5m)

<b>HFE Studs</b>	<b>Round Tubing</b>	<b>Top Feed Length Req.</b>
M6 -12 to -25	8002816	8.2 FT (2.5m)

<b>HFH Studs</b>	<b>Round Tubing</b>	<b>Top Feed Length Req.</b>
032 -8 to -16/M5 -15 to -25	8001155	8.2 FT (2.5m)
M6 -15 to -25	8002368	8.2 FT (2.5m)

<b>TFH Studs</b>	<b>Round Tubing</b>	<b>Top Feed Length Req.</b>
832 -6 TO -16	8000418	8.2 FT (2.5m)



### Spare Auto Punches and Anvils

S/CLS Nuts	Top Feed Pin Punch	Top Feed Anvil – 4” Long
256/M2	8003312	975200203
348/M2.5	8003273	975200203
440/M3	8000546	975200203
632/M3.5	8000258	975200205
832/M4	8000547	975200208
024/032/M5	8000548	975200212
0420/M6	8000549	975200221

F Nuts	Top Feed Pin Punch	Top Feed Anvil – 4” Long
440/M3	8000546	975200204
632/M3.5	8000258	8005875
832/M4	8003084	975200217
0420	8000549	8019539

SO Standoffs	Top Feed Pin Punch	Top Feed Anvil – 4” Long (Nut Style Tooling)	Top Feed Anvil – 3” Long (Stud Style Tooling)
440/M3	8000546 (3/8dia)	970200486	970200486300
632/M3.5	8000258 (3/8dia)	970200057	970200057300
832/M4	8003084 (1/2dia)	8004301	8009917
032/M5	8003092 (1/2dia)	8004301	8009917

**Other diameter pin punches available:**

SO Standoffs	Top Feed Pin Punch
440/M3/6440/3.5M3	8006699 (1/2dia)
632/M3.5/8632/4M3.5	8006130 (1/2dia)
632/M3.5/8632/4M3.5	8006135 (5/8dia)

BSO-Blind Standoffs	Top Feed Vacuum Punch	Top Feed Anvil – 3” Long
440/M3	8000668	970200486300
632/M3.5	8000668	970200057300
832/M4	8000669	8009917
032/M5	8000669	8009917



### Spare Auto Punches and Anvils (Continued)

FH Studs	Top Feed Vacuum Punch	Top Feed Anvil – 3” Long	Top Feed Anvil (For Thin Sheet Applications) – 3” Long
256	8003203	970200046300	8010720
440	8000668	970200048300	8010722
632	8000669	970200052300	8010724
832	8000669	970200054300	8010725
032	8000669	970200055300	8010727
0420	8000670	970200059300	8010729
M2.5	8003203	970200047300	8010721
M3	8000668	970200049300	8010723
M3.5	8000669	970200052300	8010724
M4	8000669	970200053300	8010726
M5	8000669	970200056300	8010728
M6	8000670	970200058300	8010730

FHL Studs	Top Feed Vacuum Punch	Top Feed Anvil – 3” Long
440	8000668	970200048300
632	8000669	8024808 – Thin Sheet

TPS Self-Clinching Pilot Pins	Top Feed Vacuum Punch	Top Feed Anvil – 3” Long
187 –8 to –16	8000669	8010169
4MM –8 to –16	8000669	8011127

HFE Studs	Top Feed Vacuum Punch	Top Feed Anvil – 3” Long
M6	8006889	970200058300

HFH Studs	Top Feed Vacuum Punch	Top Feed Anvil – 3” Long
032	8005309	970200055300
M5	8005309	970200056300
M6	8005312	970200058300





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**Spare Auto Punches and Anvils (Continued)**

<b>TFH Studs</b>	<b>Top Feed Vacuum Punch</b>	<b>Top Feed Anvil – 3” Long</b>
832	8020707	970200054300

**Replacement Pin Assemblies for Standard Nut Punches**

<b>Standard Nut Punches</b>	<b>Punch Assembly</b>	<b>Pin Assembly With Wire</b>	<b>Pin dia.</b>	<b>Pilot Pin</b>	<b>Wire by foot 25 ft min.</b>	<b>Wire Dia</b>
#3/M2.5	8003273	975200066	.062 dia.	975350065	980039426	.010
#4/M3	8000546	975200067	.077 dia.	975350066	980039426	.010
#6/M3.5	8000258	975200068	.092 dia.	975350067	980039426	.010
#8/M4	8000547-A+	8002738	.114 dia.	8002737	980039426	.010
#10/M5	8000548-A+	8002735	.144 dia.	8001323	980039426	.010
04/M6	8000549-A+	8002736	.182 dia.	8001324	980039426	.010