

MANUAL TOOLING GUIDE

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For Series 100, 500, 1000, 2000, 3000 & 4





Manual Tooling Guide

For Series 100, 500, 1000, 2000, 3000 & 4

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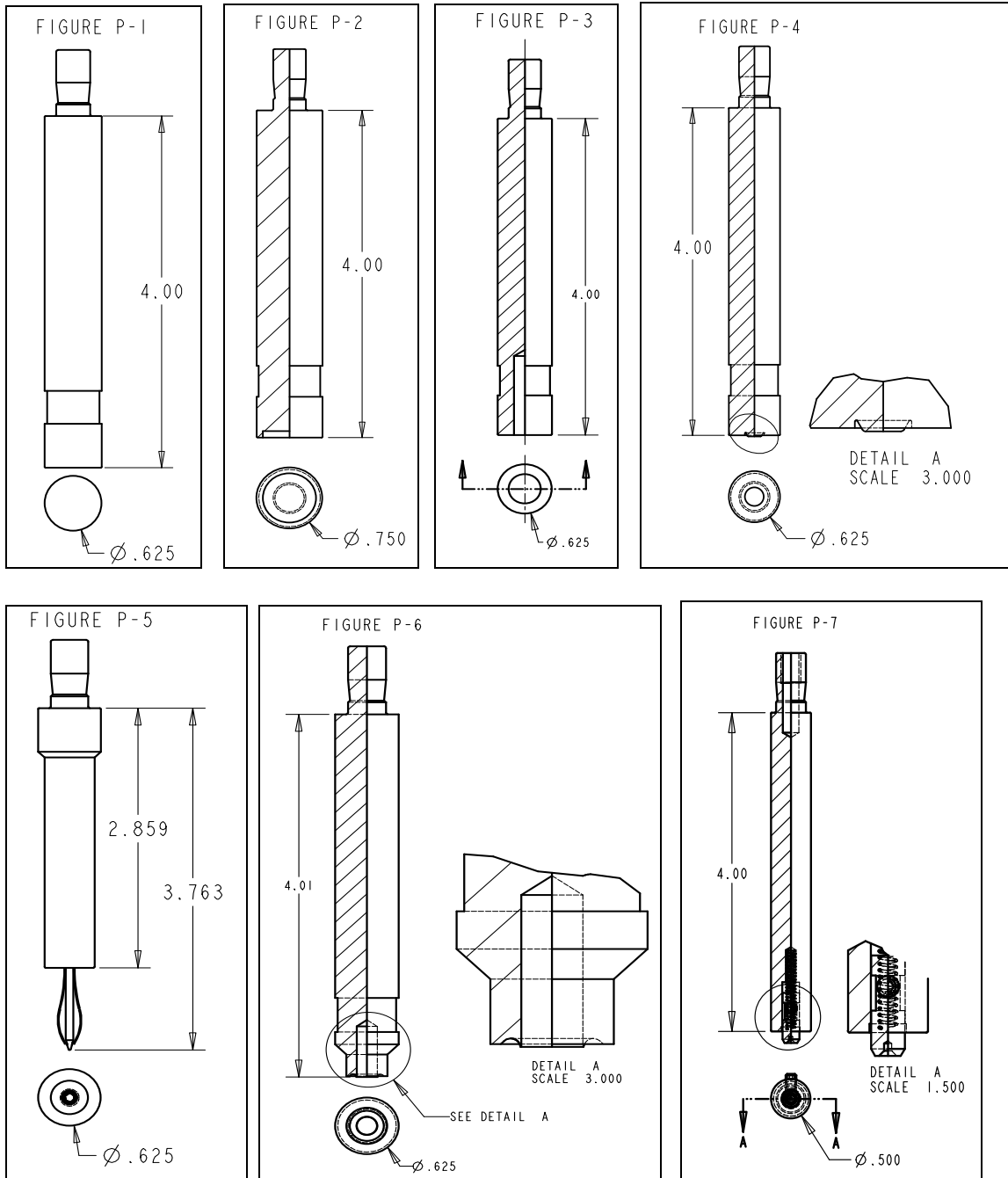


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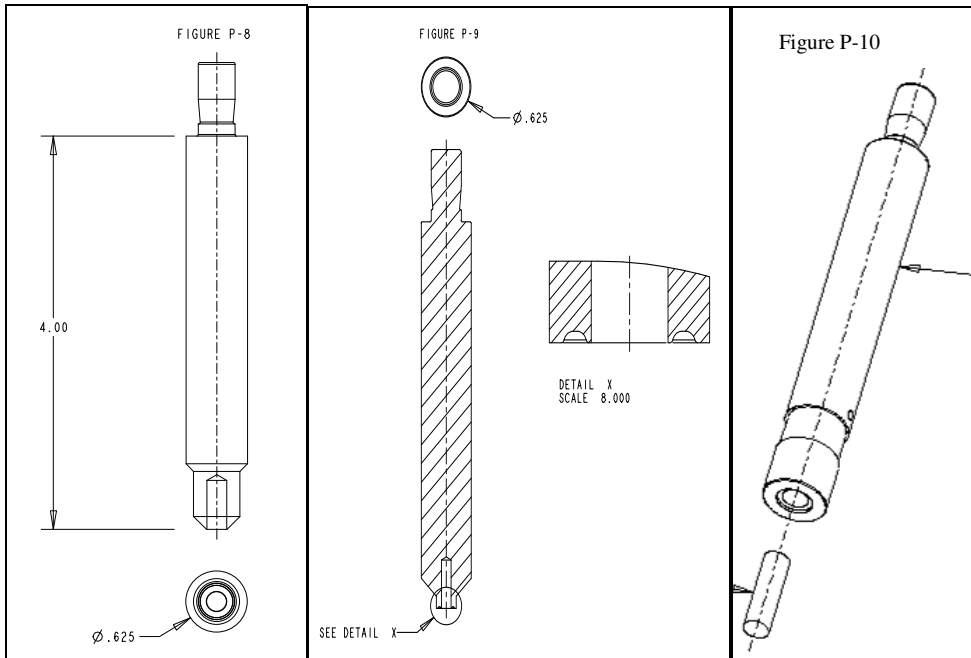
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PUNCH ASSEMBLY DRAWINGS

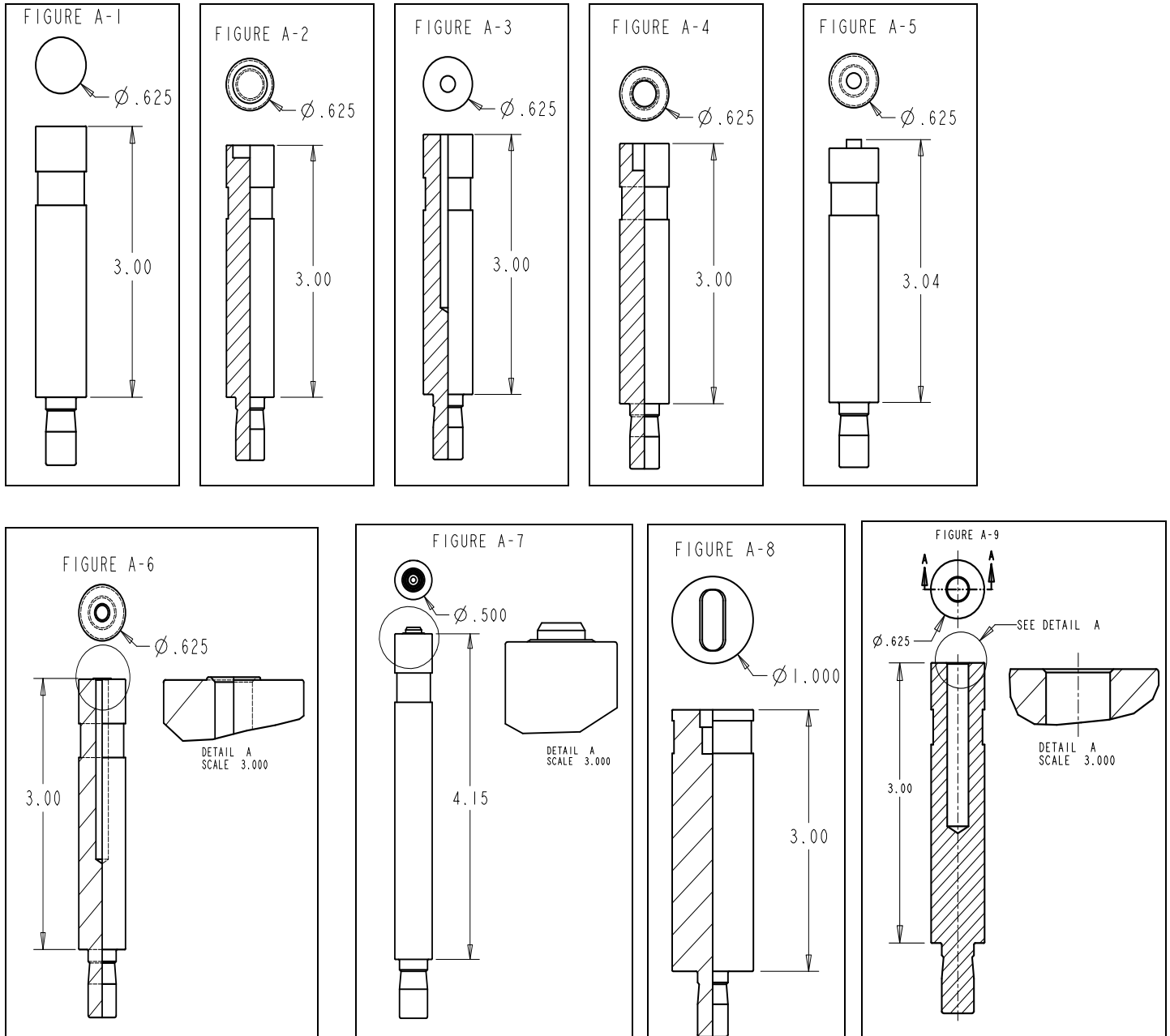


* Standard Length for Punches is 4" (101.6mm) and Anvils 3" (76.2mm). Most punches and anvils are 5/8" (15.9mm) in diameter. All are designed to fit the 3/8" (9.5mm) punch and anvil adapters of Pemsrter® presses. All tooling includes yellow shrink tubing in groove as warning for possible pinch point.



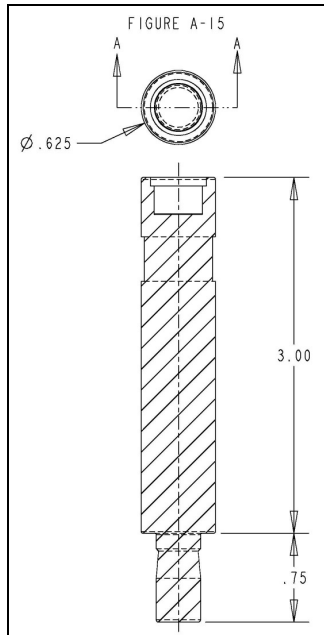
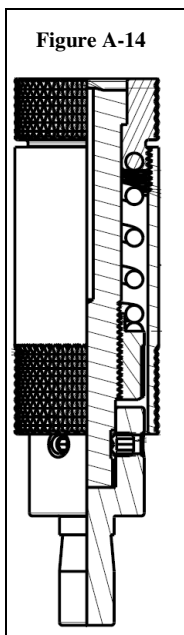
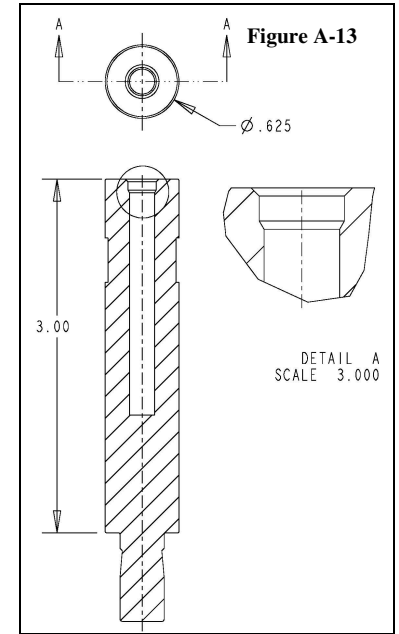
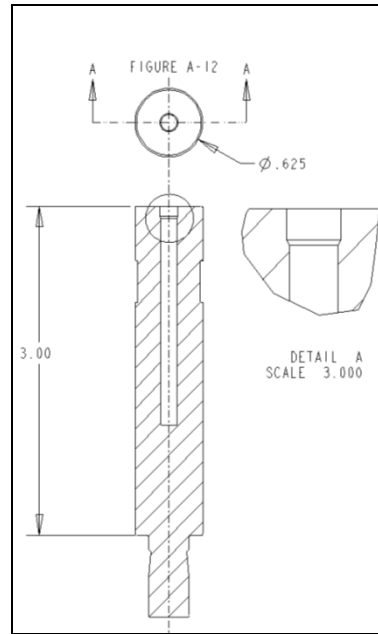
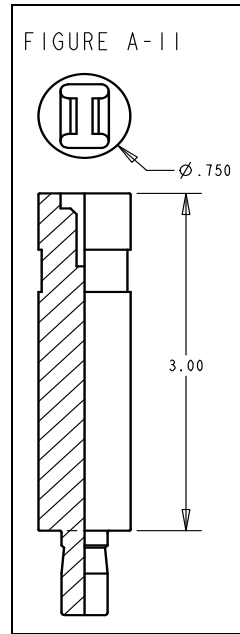
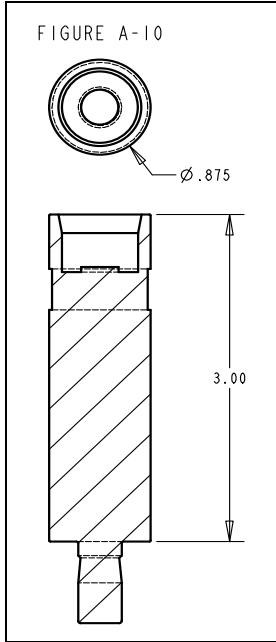
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ANVIL ASSEMBLY DRAWINGS



* Standard Length for Punches is 4" (101.6mm) and Anvils 3" (76.2mm). Most punches and anvils are 5/8" (15.9mm) in diameter. All are designed to fit the 3/8" (9.5mm) punch and anvil adapters of Pemsrter® presses. All tooling includes yellow shrink tubing in groove as warning for possible pinch point.

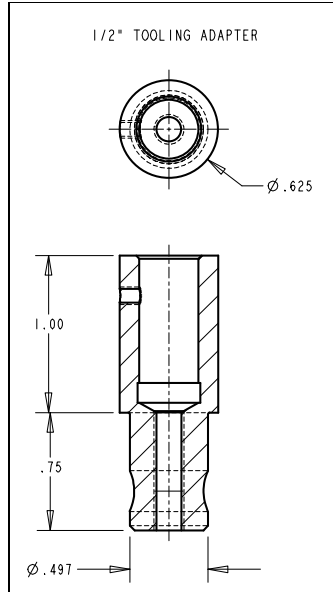
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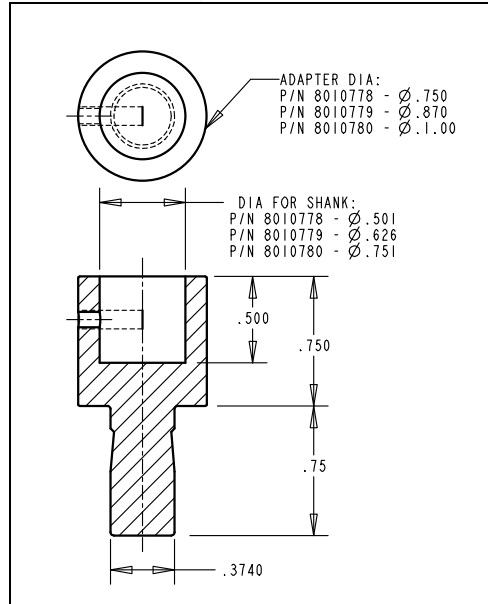
* Standard Length for Punches is 4" (101.6mm) and Anvils 3" (76.2mm). Most punches and anvils are 5/8" (15.9mm) in diameter. All are designed to fit the 3/8" (9.5mm) punch and anvil adapters of Pemsrter® presses. All tooling includes yellow shrink tubing in groove as warning for possible pinch point.

TOOLING ADAPTERS

**1/2" Tooling Adapter –
P/N 8007647**



**Anvil Adapter –
P/N 8010778, 8010779 & 8010780**





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IDENTIFY YOUR PRESS – THE SERIAL NUMBER IS LOCATED ON THE COVER OF THE INSTRUCTION MANUAL OR ON THE PEMSERTER® PRESS NAMEPLATE

AS, AC, LAS, LAC, A4, LA4 PEM® SELF-CLINCHING FLOATING – BULLETIN ALA

Size	Punch	Anvil
440/M3	975200048	8013889
632/M3.5		8013890
832/M4		8013891
1032/M5		8013892
0420/M6		8021392

Figure P-1

Figure A-15

B, BS PEM® BLIND NUT – BULLETIN B

Size	Punch	Anvil
440/M3	975200048	975200001
632/M3.5		975200002
832/M4		975200003
1032/M5		975200004
0420/M6		975200005

Figure P-1

Figure A-4

CFN, SLPS PEM® CONNECT'R WARE FASTENERS – BULLETIN CW

Size	Punch	Anvil
440/M3	975200048	8012038
	Figure P-1	Figure A-4

CHA, CHC, CFHA, CFHC PEM® CONCEALED-HEAD STUD – BULLETIN CH

Size	Punch	Anvil
440	975200048	970200006300
632/M3.5		970200007300
832		970200008300
1032		970200009300
M3		970200229300
M4		970200019300
M5		970200020300

NOTE: THESE ANVILS ARE SAME AS FH ANVILS

Figure P-1

Figure A-3



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CLA PEM® ALUMINUM SELF-CLINCHING NUTS – BULLETIN CL

Size	Punch	Anvil
256/440/M2/M3	975200048	975200034
632/M3.5		975200035
832/M4		975200036
1024/1032/M5		975200782300
0420/M6		975200038

NOTE: THESE ANVILS ARE SAME AS CLS, S ANVILS EXCEPT FOR 1032/M5.

Figure P-1

Figure A-2

CLS, CLSS, S, SS PEM® SELF-CLINCHING NUTS – BULLETIN CL

Size	Punch	Anvil
256/348/440/M2/M2.5/M3	975200048	975200034
632/M3.5		975200035
832/M4		975200036
1032/M5		975200037
12-24		975200786300
0420/M6		975200038
0518/M8		975200039
0616		975200045*
M10	975200901400	8005682*
0720		8020361*
0813/M12		975200900300*

Punch 13/16" (20.6mm) & Anvil 3/4" (19mm) dia
 Punch & Anvil 13/16" (20.6mm) dia
 Punch & Anvil 13/16" (20.6mm) dia

Figure P-1

*Figure A-2 / *Figure A-5*

*LARGE NUT ANVILS INSTEAD OF COUNTER BORE, USE PROTRUSION TO LOCATE PART.

CSOS, CSS PEM® CONCEALED-HEAD STANDOFF – BULLETIN CH

Size	Punch	Anvil
440/M3	975200048	970200014300
632/M3.5		970200015300
832/M4		970200016300
1032/M5		970200017300
0420/M6		970200018300

NOTE: THESE ANVILS ARE DIFFERENT THAN SO ANVILS

Figure P-1

Figure A-3

DPRS, DBRS PEM® WAVEGARD GROUNDING – BULLETIN DR

PACKAGE CONTAINS 2 PUNCHES AND 1 ANVIL	975201209
Anvil DBRS/DPRS – 975201224 : Punch DBRS – 975201208 : Punch DPRS – 975201225	

DSOS PEM® THREADED STANDOFF FOR CLOSE-TO-EDGE APPLICATIONS – BULLETIN SO

Size	Punch	Anvil
440/M3	975200048	970200487300

Figure P-1

Figure A-3



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F, F4 PEM® FLUSH NUTS – BULLETIN F

Size	Punch	Anvil
256/M2/M2.5	975200048	8006193
440/M3		975200040
632/M3.5		975200041
832/M4		975200042
1032/M5		975200043
0420/M6		975200044

Figure P-1

Figure A-5

FE, FEO, FEX, FEOX PEM® MINIATURE, SELF-LOCKING NUTS – BULLETIN FE

Size	Punch	Anvil
440/M3	975200048	975200021
632/M3.5		975200022
832/M4		975200023
1032/M5		975200024
0420		975200025
M6		8013143

Figure P-1

Figure A-4

FH, FHA, FHS PEM® FLUSH STUDS – BULLETIN FH

Size	Punch	Anvil	Anvil
		For material .060" +/1.51mm+	For material <= .059"/1.5mm
256	975200048	970200005300	970200240300
440		970200006300	970200241300
632/M3.5		970200007300	970200243300
832		970200008300	970200245300
1032/024		970200009300	970200246300
M2		8008451	8008452
M2.5		970200300300	970200493300
M3		970200229300	970200242300
M4		970200019300	970200244300
M5		970200020300	970200247300
		For material .093" +/2.41mm+	For material < .093"/2.41mm
0420	975200048	970200010300	970200249300
0518		970200011300	Contact Factory
M6		970200230300	970200248300
M8		970200231300	Contact Factory

Figure P-1

Figure A-3

Figure A-9

FHL, FHLS PEM® FLUSH STUDS FOR CLOSE-TO-EDGE & MINIMAL SPACE APPLICATIONS
BULLETIN FH

Size	Punch	Anvil For material .060"/+1.51mm+	Anvil For material <= .059"/1.5mm
256	975200997	8003313	8003297
440		8003618	8003298
632		8003314	8003299
832		8003315	8003300
1032		8003619	8003301
M2.5	975200997	8003316	8003302
M3		8003317	8003303
M3.5		8003318	8003304
M4		8003620	8003305
M5		8003319	8003306

*Figure P-1 –
1/2" (12.7mm) dia*

*Figure A-3 -
1/2" (12.7mm) dia*

*Figure A-9 –
1/2" (12.7mm) dia*

FH4 PEM® SERIES 400 STAINLESS FLUSH STUDS – BULLETIN FH

FHP PEM® A286 STAINLES STEEL FLUSH STUDS – BULLETIN FHP

Size	Punch	Anvil
440	975200048	8001645
632		8001644
832		8001643
1032		8001642
0420		8002535
M3		8001678
M4		8001677
M5		8001676
M6		8002536
M8		8016843

Anvil 3/4" (19.05mm) dia

Figure P-1

Figure A-6

FH-X PEM® FLUSH STUDS WITH X-PRESS™ THREADS – BULLETIN FHX

Size	Punch	Anvil For material .060"/+1.51mm+	Anvil For material <= .059"/1.5mm
X5	975200048	8021188	8021189
X6	975200048	8021190	8021191

Figure P-1

Figure A-3

Figure A-9



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FH-PINS PEM® FLUSH HEADED PINS – BULLETIN FH

Size	Punch	Anvil For material .060"/+1.51mm+	Anvil For material <= .059"/1.5mm
094	975200048	8018113	Contact Factory
141		8018114	Contact Factory
207		Contact Factory	8020072
3MM		8018942	Contact Factory
6MM		8018628	Contact Factory

Figure P-1

Figure A-12

Figure A-13

HF109 PEM® HIGH STRENGTH STUDS –

Size	Punch	Anvil (Standard Sheet)	Anvil (Thin Sheet)
M5	8014457	970200020300	8003704
M6**	8014459	8021611	8021615
M8**	8014461	8021612	8021616

Figure P-2

Figure A-3

Figure A-9

*Exceeds the installation force capability of the Series LT/4, Series 4 Press

**Exceeds the installation force capability of the Series 2000 and Series 3000 Presses. Tools are 1" (25.4mm) dia.

HFE PEM® HIGH STUDS – BULLETIN FH

Size	Punch	Anvil For material >= .060"/1.51mm	Anvil For material .040/1mm -.059"/1.5mm
1032	8003707	970200009300	970200246300
0420	8003708	970200010300	8003702
M5	8003710	970200020300	8003704
M6	8003711	970200230300	8003705
		For material >= .093"/2.4mm	For material .060/1.5mm -.092"/2.3mm
*0518	8003709	970200011300	8003703
*M8	8003712	970200231300	8003706

Figure P-2

Figure A-3

Figure A-9

*INSTALLATION FORCE MAY EXCEED CAPABILITIES OF SOME PEMSERTER® PRESSES SHOWN IN THIS TOOLING GUIDE. Punch and Anvil 3/4" (19mm) dia.

HFG8 PEM® HIGH STRENGTH STUDS –

Size	Punch	Anvil (Standard Sheet)	Anvil (Thin Sheet)
1032*	8014456	970200009300	970200246300
0420**	8014458	8021609	8021613
0518**	8014460	8021610	8021614

Figure P-2

Figure A-3

Figure A-9

*Exceeds the installation force capability of the Series LT/4 and Series 4 Presses

**Exceeds the installation force capability of the Series 2000 and Series 3000 Presses. Tools are 1" (25.4mm) dia.



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HFH, HFHS, HFHB PEM® HIGH STRENGTH STUDS – BULLETIN FH

Size	Punch		Anvil
1032	970200311400	Punch ¾" (19mm) dia Punch ¾" (19mm) dia Punch 15/16" (23.8mm) dia Punch ¾" (19mm) dia Punch ¾" (19mm) dia Punch 15/16" (23.8mm) dia Punch 1.10" (28mm) dia	970200009300
0420	970200312400		970200010300
0518	970200313400		970200011300
0616	970200314400		970200004300
M5	970200311400		970200020300
M6	970200312400		970200230300
M8	970200313400		970200231300
M10	970200491400		970200402300
M12	8011046		8011047

Figure P-2

Figure A-3

TFH, TFHS PEM® NON FLUSH THIN SHEET – BULLETIN FH

Size	Punch	Anvil For material .030" +/.76mm+	Anvil For material .020" / .51mm - .029" / .75mm
256	970200235400	970200005300	970200240300
440	970200236400	970200006300	970200241300
632/M3.5	970200237400	970200007300	970200243300
832	970200238400	970200008300	970200245300
1032	970200239400	970200009300	970200246300
0420	970200496400	970200010300	970200249300
M3	970200236400	970200229300	970200242300
M4	970200238400	970200019300	970200244300
M5	970200239400	970200020300	970200247300
M6	970200496400	970200230300	970200248300

Figure P-2

Figure A-3

Figure A-9

H, HN, HNL PEM® SELF-LOCKING AND NON-LOCKING NUTS – BULLETIN CL

Size	Punch	Anvil	
0420/M6	975200048	975200039	Anvil ¾" (19mm) dia
0518/M8	975200048	975200783300*	
0616	8003076	975201240*	
M10	8003076	8005682*	

Figure P-1

Figure A-2 / *Figure A-5

*LARGE NUT ANVILS USE PROTRUSION TO LOCATE PART INSTEAD OF COUNTER BORE.



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HFLH PEM® HARD PANEL STUDS – BULLETIN HPF

Size	Punch	Anvil For material >= .060"/1.51mm	Anvil For material .040/1mm -.059"/1.5mm
1032	8003707	970200009300	970200246300
0420	8003708	970200010300	8003702
M5	8003710	970200020300	8003704
M6	8003711	970200230300	8003705
		For material >= .075"/1.9mm	For material .060"/1.5mm -.075"/1.9mm
*0518	8003709	970200011300	8003703
*M8	8003712	970200231300	8003706

Figure P-2

Figure A-3

Figure A-9

*INSTALLATION FORCE MAY EXCEED CAPABILITIES OF SOME PEMSERTER® PRESSES SHOWN IN THIS TOOLING GUIDE. Punch and Anvil 3/4" (19mm) dia.

HSCB PEM® SELF-CAPTIVATING SCREW – BULLETIN HSCB

Size	Punch	Anvil	
440	970200006300	8018043*	*4" (102MM) LONG
632	970200007300	8018044*	*4" (102MM) LONG
M3	970200229300	8018045*	*4" (102MM) LONG

Figure A-3

Figure A-2

HSR PEM® BROACHING NUT/STANDOFF – BULLETIN HSCB

Size	Punch	Anvil
440	975200048	975200846300
632		975200849300
M3		975200846300

Figure P-1

Figure A-2

KF2, KFS2 PEM® BROACHING NUTS – BULLETIN K

Size	Punch	Anvil
080	975200048	8015899
256/440/M2/M2.5/M3	975200048	975200904300
632/M3.5	975200048	975200035
832/M4	975200048	975200037
1032/M5	975200048	975200905300

Figure P-1

Figure A-2



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KFB3, KFB4 PEM® FLARE-MOUNTED THREADED STANDOFF – BULLETIN K

Size	Punch	Anvil
440 -2	975201231400	975201213300
440 -4 to -8		975200846300
440 -10 to -12		975200847300
440 -16 to -20		975200848300
440 -22 to -24		975200882300
M3 -2		975201213300
M3 -3 to -6		975200846300
M3 -8 to -10		975200847300
M3 -12		975201222300
M3 -14 to -16		975200848300
632 -2		975201232400
632 -4 to -8	975200849300	
632 -10 to -12	975200850300	
632 -16 to -20	975200851300	
632 -22 to -24	975200883300	
632 -28 to -32	975200884300	
M4 -2	975201221400	975201216300
M4 -3 to -6		975201217300
M4 -8 to -10		975201218300
M4 -12 to -14		975201220300
M4 -14 to -16		975201219300

Figure P-4

Figure A-2

KFE, KFSE PEM® BROACHING STANDOFF – BULLETIN K

Size	Punch	Anvil
440/116 -4 to -8	975200048	975200846300
440/116 -10 to -12		975200847300
440/116 -16 to -20		975200848300
440/116 -20 to -24		975200882300
M3 -3 to -6		975200846300
M3 -8 to -10		975200847300
M3 -12		975201222300
M3 -14 to -16		975200848300
632/143 -4 to -8		975200849300
632/143 -10 to -12		975200850300
632/143 -16 to -20		975200851300
632/143 -22 to -24		975200883300
632/143 -28 to -32		975200884300

(Continued next page)

Figure P-1

Figure A-2



Manual Tooling Guide

For Series 100, 500, 1000, 2000, 3000 & 4

KFE, KFSE PEM® BROACHING STANDOFF – BULLETIN K (Continued)

Size	Punch	Anvil
3.6 –3 to –6	975200048	975200849300
3.6 –8 to –10		975200850300
3.6 –12 to –16		975200851300
4.2 –2		975201216300
4.2 –3 to –6		975201217300
4.2 –8 to –10		975201218300
4.2 –12 to –14		975201220300
4.2 –14 to –16		975201219300

Figure P-1

Figure A-2

KFH PEM® BROACHING STUDS – BULLETIN K

Size	Punch	Anvil
440	975200048	970200006300
632		970200007300
832		970200008300
1032		970200009300
M3		970200229300
M4		970200019300
M5		970200020300

Figure P-1

Figure A-3

KPS6 PEM® SELF-EXPANDING FOILGUARD® FASTENERS – BULLETIN K

Size	Punch	Anvil
440 (-4 TO -8)	975200048	975200846300
440 (-10 TO -12)		975200847300
440 (-16 TO -20)		975200848300
632 (-4 TO -8)		975200849300
632 (-10 TO -12)		975200850300
632 (-16 TO -20)		975200851300
832 (-4 TO -8)		975201217300
832 (-10 TO -12)		975201218300
832 (-16 TO -20)		975201220300
1032 (-4 TO -8)		975201234300
1032 (-10 TO -12)		975201236300
1032 (-16 TO -20)		975201237300
M3 (-3 TO -6)		975200846300
M3 (-8 TO -10)		975200847300
M3 (-12 TO -14)		975200848300
M4 (-3 TO -6)		975201217300
M4 (-8 TO -10)		975201218300
M4 (-12 TO -14)		975201220300

(Continued next page)

Figure P-1

Figure A-2



Manual Tooling Guide

For Series 100, 500, 1000, 2000, 3000 & 4

KPS6 PEM® SELF-EXPANDING FOILGUARD® FASTENERS – BULLETIN K (Continued)

Size	Punch	Anvil
M5 (-3 TO -6)	975200048	975201234300
M5 (-8 TO -10)		975201236300
M5 (-12)		975201237300

Figure P-1

Figure A-2

KSSB PEM® BROACHING SNAP-TOP STANDOFFS– BULLETIN SSA

Size	Punch	Anvil For material > .065"/1.65mm	Anvil For material .050/1.27mm - .065"/1.65mm
156 (-8 TO -32) 4mm (-8 TO -25)	975200048	970200015300	8022167

Figure P-1

Figure A-3

Figure A-12

LK, LKS, LKA PEM® SELF-LOCKING NUTS– BULLETIN LK

Size	Punch	Anvil
2-56/M2.5	975200048	975200015
440/M3		975200016
632		975201242
832/M4		975201241
1032/M5		975200019

Figure P-1

Figure A-4

MPP PEM® MINIATURE PINS-BULLETIN

Size	Punch	Anvil
1MM	8014167	8014168
1.5MM		8014169
2MM		8014170

Figure P-1

Figure A-3

1/4" (6.35mm) dia

1/4" (6.35mm) dia

MSO4 PEM® MINIATURE SELF-CLINCHING STANDOFFS

Size	Punch	Anvil
080/ M1/M1.2/M1.4/M1.6	975200997	8015796
256/M2		8015797

Figure P-1

Figure A-3

1/2" (12.7mm) dia

1/2" (12.7mm) dia

NFPC, NFPA PEM® INSERTS FOR PLASTICS – BULLETIN SI

Size	Punch	Anvil
ALL SIZES	975200048	975200046

Figure P-1

Figure A-1



Manual Tooling Guide

For Series 100, 500, 1000, 2000, 3000 & 4

FLUSH-MOUNTED PANEL SCREW COMPONENTS

PF10 COMPONENTS – BULLETIN PF

PR10 – FLUSH-MOUNTED RETAINER

Size	Punch	Anvil
440/M3	975200048	970200013300
632		970200011300
832/M4		970200393300
1032/M5		970200004300

Figure P-1

Figure A-3

N10 SELF-CLINCHING RECEPTACLE NUTS

Size	Punch	Anvil
440/M3	975200048	8006124
632		8006735
832/M4		8006736
1032/M5		8006174

Figure P-1

Figure A-4

PF11, PF11M, PF11PM, PF12, PF12M, PF13, PF14 PEM® PANEL FASTENER – BULLETIN PF

Size	Punch	Anvil
440/M3	8003518	8003521
632/M3.5	8003519	8003522
832/M4	8003520	8003523
1032/M5	8004350	8003523
0420/M6	8004352	8004351

Figure P-3

Figure A-2

PF11MF PEM® FLARING PANEL FASTENER – BULLETIN PF

Size	Punch	Anvil
440/M3	8013670	8003521
632/M3.5	8013671	8003522
832/M4	8013672	8003523
1032/M5	8013672	8003523
0420/M6	8013674	8004351

Figure P-8

Figure A-2

PF11MW PEM® PANEL FASTENER W/WASHER

Size	Punch	Anvil
440/M3	8014304	8003521
632/M3.5	8014305	8003522
832/M4	8014306	8003523
1032/M5	8014306	8003523
0420/M6	8014307	8004351

Figure P-9

Figure A-2

PF30, PF31, PF32, PF50, PF60 PEM® LOW PROFILE PANEL FASTENER – BULLETIN PF

Size	Punch	Anvil
440/M3	975200060	975201060
632	975200061	975201061
832/M4	975200062	975201062
1032/M5	975200063	975201063
0420/M6	975200064	975201064

Figure P-3

Figure A-2

PFC2, PFC2P, PFK, PFS2 PEM® PANEL FASTENER – BULLETIN PF

Size	Punch	Anvil
440/M3	975200060	975200026
632	975200061	975200027
832/M4	975200062	975200028
1032/M5	975200063	975200029
0420/M6	975200064	975200030

Figure P-3

Figure A-2

PFC4 PEM® PANEL FASTENER – BULLETIN PF

Size	Punch	Anvil
440/M3	975200060	975200027
632	975200061	975201243
832/M4	975200062	975200029
1032/M5	975200063	975201244

Figure P-3

Figure A-2

PFF PEM® FLOATING PANEL FASTENER – BULLETIN PF

Size	Punch	Anvil
1032/M5	8006702	8006825
1224	8006703	8006701
M6	8006704	

Figure P-6

Figure A-10

PFHV PEM® PANEL FASTENER – BULLETIN PF

Size	Punch	Anvil
440	970200009400	8004688
632	8015656	8004689
832	970200230400	8005439
M3	970200020400	8004688
M3.5	8015656	8004689
M4	970200230400	8005439

Figure P-3

Figure A-2

PFP PEM® PANEL FASTENER – BULLETIN PF

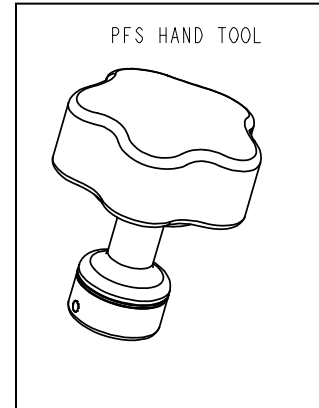
Size	Punch	Anvil
440/M3	8005440	8005413
632	8005441	8005413
832/M4	8005442	8005414
1032/M5	8005993	8005414

Figure P-3

Figure A-2

PFS PEM® SNAP-IN PANEL FASTENER – BULLETIN PF

Size	Hand Tool Assembly
440/M3	8006347
632/M3.5	8006347
832/M4	8006348



PF7M PEM® PANEL FASTENER – BULLETIN PF

Size	Punch	Anvil
440/M3	8003518	8016175
632	8003519	8016176
832/M4	8003520	8016177

Figure P-3

Figure A-2

PF7MF PEM® PANEL FASTENER – BULLETIN PF

Size	Punch	Anvil
440/M3	8013670	8016175
632	8013671	8016176
832/M4	8013672	8016177

Figure P-3

Figure A-2

PL, PLC PEM-HEX® SELF-LOCKING NUTS – BULLETIN PL

Size	Punch	Anvil
440/M3	975200048	975200011
632/M3.5		975200012
832/M4		975200013
1032/M5		975200014

Figure P-1

Figure A-4

PPB, PFLB, PKB PEM® INSERTS FOR PLASTICS – BULLETIN SI
– TOOLING TO BE DETERMINED

PTL2 PEM® SPRING-LOADED PLUNGER ASSEMBLIES – BULLETIN PF

Size	Punch	Anvil
04	970200013300	975201245

Figure P-3

Figure A-4



Manual Tooling Guide

For Series 100, 500, 1000, 2000, 3000 & 4

RAA, RAS PEM® R' ANGLE CLINCH FASTENER – BULLETIN RA

Size	Punch	Anvil
440	8003076	8002711
632		8002712
832		8003642
M3		8002713
M4		8002714

*Figure P-1 -
1"(25.4mm) dia*

*Figure A-8 -
1"(25.4mm) dia*

SCB/SCBJ PEM® SPINNING CLINCH BOLT – Bulletin SCB

Size	Punch	Anvil
440	8012730	970200006300
632	8012731	970200007300
832	8012732	970200008300
032	8022875	970200009300
M3	8012730	970200229300
M3.5	8012731	970200007300
M4	8012732	970200019300
M5	8022875	970200020300

Figure P-3

Figure A-3

SCBR PEM® MAGNETIC PUNCH ASSEMBLIES – BULLETIN

Size	Punch	Anvil
440	8016210	970200048300
632	8016211	970200052300
832	8016212	970200054300
M3	8016213	970200049300
M4	8016214	970200053300

Figure P-10

Figure A-7

SF, SFP, SFK PEM® SPOT FAST – BULLETIN SF

Size	Punch	Anvil
3-0.8	975200048	975200046
3-1.0		
3-1.2		
3-1.6		
5-0.8		
5-1.0		
5-1.2		
5-1.6		

Figure P-1

Figure A-1

SFN PEM® SELF-CLINCHING SPINNING FLARE NUT – BULLETIN SFN

Size	Punch	Anvil
M5	8018670	8018538
M6		8018539
M8		8018540

Figure P-1

Figure A-2

SFW PEM® SPOT FAST – BULLETIN SFW

Size	Punch	Anvil
3-0.8	975200048	970200229300 & 975200046
3-1.0		
3-1.2		
3-1.6		
5-0.8		970200020300 & 975200046
5-1.0		
5-1.2		
5-1.6		

Figure P-1 -

Figure A-4 & A-1

SGPC PEM® SWAGING COLLAR STUDS – BULLETIN SGPC

Size	Punch	Anvil
256	8015111	8016983
440	8015112	8016984
632	8015113	8016985
832	8015114	8016986
1032	8015115	8016987
0420	8015116	8016988
M2.5	8015117	8016989
M3	8015118	8016990
M4	8015119	8016991
M5	8015120	8016992
M6	8015121	8016993

Figure P-2

Figure A-14

SH PEM® HARD PANEL NUTS – BULLETIN HPF

Size	Punch	Anvil
0420/M6	975200048	975200038
0518/M8		975200039
0616		975200045*
M10	975200901400	8005682*

Figure P-1

*Figure A-2 / *Figure A-5*

Punch 13/16" (20.6mm) &
Anvil 3/4" (19mm) dia



Manual Tooling Guide

For Series 100, 500, 1000, 2000, 3000 & 4

SKC-6060 (SKC 61.5) PEM® KEYHOLE® SELF-CLINCHING STANDOFFS – BULLETIN SK

Size	Punch	Anvil
6060 / 61.5	975200048	970200012300

Figure P-1

Figure A-3

SKC-F1.5 PEM® KEYHOLE® INVERTED SELF-CLINCHING STANDOFFS – BULLETIN SK

Size	Punch	Anvil
F1.5	975200048	8012608

Figure P-1

Figure A-3

SL PEM® SELF-CLINCHING LOCK NUTS – BULLETIN CL

Size	Punch	Anvil	
440/M3	975200048	975200034	
632/M3.5		975200035	
832/M4		975200036	
1032/M5		975200037	
0420/M6		975200038	
0518/M8		975200039	
0618		975200045	
M10	975200901400	8005682*	Punch 13/16" (20.6mm) & Anvil 3/4" (19mm) dia

Figure P-1

*Figure A-2/Figure A-5**

NOTE: THESE ANVILS ARE SAME AS CLS, S ANVILS.

*LARGE NUT ANVILS INSTEAD OF COUNTER BORE, USE PROTRUSION TO LOCATE PART.

SMPP PEM® SELF-CLINCHING NUT FOR ULTRA THIN SHEETS – BULLETIN CL

Size	Punch	Anvil
256	975200048	8020023
440		8012386
632		8020024
M2.5		8020025
M3		8021474
M3.5		8020026

Figure P-1

Figure A-2

SMPS PEM® SELF-CLINCHING NUT FOR ULTRA THIN SHEETS – BULLETIN CL

Size	Punch	Anvil
2/440/M2.5/M3	975200048	975200904300
632/M3.5		975200034

Figure P-1

Figure A-2

SO, SO4, SOA, SOS, SON, BSO, BSO4, BSOA, BSOS, BSON PEM® STANDOFFS – BULLETIN SO
SOAG, SOSG PEM® STANDOFFS – BULLETIN K

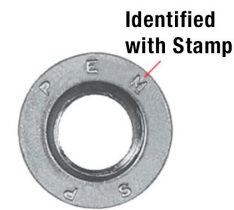
Size	Punch	Anvil
256/348/440/M2/M2.5/M3/4116/43.1	975200048	970200487300
632/6440/3.5M3/M3.5/6116/6143/63.1/63.6		970200012300
832/8632/M4/8143/8169/8194/83.6/84.1/85.1		970200013300
1032/M5		970200013300
0420/M6		970200393300

Figure P-1

Figure A-3

SP PEM® 300 STAINLESS STEEL SELF-CLINCHING NUTS – BULLETIN CL

Size	Punch (Stamped Version)	Anvil (Stamped Version)
440	975200048	8012821
632		8012822
832		8012823
1032		8012824
0420	8003076	8012825
0518	8003076	8015359
0616	8003076	8015863
M2.5-0	975200048	8019477
M2.5-1 & -2		8012821
M2/M3		8012821
M3.5		8012822
M4		8012823
M5	8012824	
M6	8003076	8012825
M8	8003076	8015360
M10	8003076	8015886



Punch & anvil 1”(25.4mm) dia

Punch & anvil 1”(25.4mm) dia

Figure P-1

Figure A-2

NOTE: These punch & anvils have special geometry for maximum clinch performance into stainless steel.

SSA, SSS, SSC, KSSB PEM® SNAP-TOP STANDOFFS – BULLETIN SSA

Size	Punch	Anvil
ALL	975200048	970200015300

Figure P-1

Figure A-3



Manual Tooling Guide

For Series 100, 500, 1000, 2000, 3000 & 4

TA/T4 microPEM® TackPin® – BULLETIN MPF

Size	Punch	Anvil
10-025	8014167	975200046
10-050		
10-075		

Figure P-1 (.250" dia)

Figure A-1

TD PEM® CABLE TIE-MOUNT SELF-CLINCHING – BULLETIN TD

Size	Punch	Anvil
40	8003076	8006136
60		8006137
175		8006138

Figure P-1 (1" dia)

Figure A-8 (1" dia)

TDO PEM® CABLE TIE HOOKS-CLINCHING – BULLETIN TD

Size	Punch	Anvil
40	975200048	8006865
50		8006864
120	8003076 (1" dia)	8006863

Figure P-1

Figure A-11

THFE PEM® HEAVY HEAD STUD FOR THIN SHEET– BULLETIN FH

Size	Punch	Anvil
0420	8019890	8019886
0518	8019891	8019887
M6	8019892	8019888
M8	8019893	8019889

Figure P-2

Figure A-9

TKA/TK4 microPEM® TackSert® – BULLETIN MPF

Size	Punch	Anvil
10-100	8014167	975200046
10-150		
10-200		
10-250		
10-300		

Figure P-1 (.250" dia)

Figure A-1



Manual Tooling Guide

For Series 100, 500, 1000, 2000, 3000 & 4

TPS, TP4 PEM® FLUSH-MOUNTED PILOT PINS – BULLETIN FH

Size	Punch 4”/101.6mm Long	Anvil For material .060”+/1.7mm+	Anvil For material .040-.060”/ 1mm – 1.7mm
.125 (.130)	975200048	8003278	8003284
.187 (.192)		8003279	8003285
.250 (.255)		8003280	8003286
3 mm (.122)		8008095	8008096
4 mm (.161)		8003281	8003287
5 mm (.201)		8003282	8003288
6 mm (.290)		8003283	8003289

Figure P-1

Figure A-3

Figure A-9

TPXS PEM® FLUSH-MOUNTED PILOT PINS – BULLETIN FH

Size	Punch 4”/101.6mm Long	Anvil For material .060”+/1.52n mm+	Anvil For material .040-.059”/ 1mm – 1.49mm
3 mm (.122)	975200048	8008095	8008096

Figure P-1

Figure A-3

Figure A-9

TS4 microPEM® TackScrew™ – BULLETIN MPF

Size	Punch	Anvil
10-050	8014167	975200046
10-075		

Figure P-1 (.250” dia)

Figure A-1

TSO, TSOS, TSOA, TSO4 PEM® THREADED STANDOFFS FOR THIN SHEETS- BULLETIN SO

Size	Punch	Anvil For material .032”+/0.81mm+	Anvil For material .025- .031” / .63mm - .781mm
256/440	975200048	970200487300	8003291
6256/6440/632		970200012300	8003292
M2.5/M3		970200487300	8003291
6M25/6M3/M35		970200012300	8003292

Figure P-1

Figure A-3

Figure A-9

U, UL PEM® MINIATURE SELF-CLINCHING FASTENERS – BULLETIN FE

Size	Punch	Anvil
080	975200048	8008451
164		970200300300
256/M2		975200020

Figure P-1

Figure A-4



Manual Tooling Guide

For Series 100, 500, 1000, 2000, 3000 & 4

TURRET ANVILS

STUDS – FH 4 – ¼-20 STANDOFFS – SO 4 AND 6	980020018
STUDS – FH M2.5 – M6	980020047
STANDOFFS – SO 4/M3/6/M3.5/8/M4/10/M5	980020053
NUTS – S AND CLS 2 – ¼-20 / M2 – M6	980020019
*SPECIAL TURRET ANVILS AVAILABLE UPON REQUEST	

QX4™ TURRET TOOL SYSTEM (SERIES 4® and SERIESLT/4™ ONLY)



KIT 8011600

The PEMSERTER® QX4™ Turret Tool System provides an efficient method to quickly change between four different anvil tools. The one-handed operation of this tool allows an operator to install four different types and/or sizes of fasteners with one set-up. The QX4™ Turret Tool System can be easily installed on all new and existing PEMSERTER® Series 4® and Series LT/4™ presses.

KIT INCLUDES: Anvil Holder, QX4 Table, Color Coded Parts Tray Assembly and 3" Flat Punch 975200046.

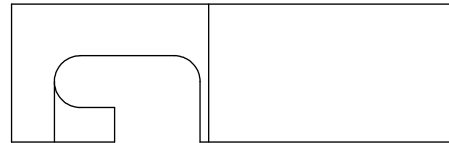
TOOLS FOR SERIES 4 & LT/4 BOTTOM MOUNT REVERSE FLANGE ANVIL HOLDER (ANVIL HOLDER MAX FORCE 6,000 LBS/26.7 kN) INCLUDED IN KIT:

PUNCH	975201037825 – 8.25" LONG
ANVIL FLAT	975200725019 - .190" LONG

ADDITIONAL ANVILS:

ANVIL S-440/M3	975200841019 - .190" LONG
ANVIL S-632/ M3.5	975200842019 - .190" LONG
ANVIL S-832/M4	975200843019 - .190" LONG
ANVIL S-1032/M5	975200844019 - .190" LONG
ANVIL S-12-24	975200845019 - .190" LONG

KIT 980020025



KIT 980020025 INCLUDES LONG PUNCH AND FLAT ANVIL

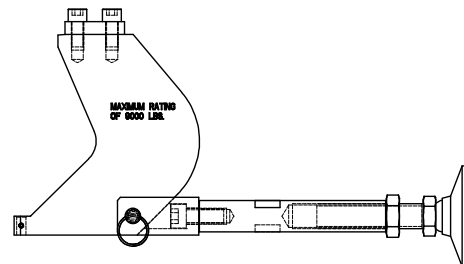
TOOLS FOR SERIES 4 TOP MOUNT REVERSE FLANGE ANVIL HOLDER (SERIES 4 PRESS ONLY) (ANVIL HOLDER MAX FORCE 9,000 LBS/40 kN)

INCLUDED IN KIT:

PUNCH FLAT	975200046 – 3" LONG
ANVIL FLAT	975200722025 - .25" LONG

NOTE: OTHER ANVILS AVAILABLE FOR TOP MOUNT REVERSE FLANGE ANVIL HOLDER-SEE ABOVE LIST OF ADDITIONAL ANVILS-SAME AS BOTTOM MOUNT REVERSE FLANGE ANVIL HOLDER.

KIT 980020068



KIT 980020068 INCLUDES PUNCH AND FLAT ANVIL

TOOLS FOR SERIES 2000 TOP MOUNT REVERSE FLANGE ANVIL HOLDER (SERIES 2000 PRESS ONLY)

(ANVIL HOLDER MAX FORCE 9,000 LBS/40 kN)

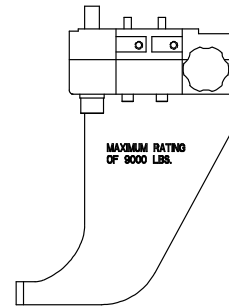
INCLUDED IN EACH KIT:

PUNCH FLAT	8004414 – 1.5” LONG
ANVIL FLAT	975200722025 - .25” LONG

Presses earlier than 2007/17 must be modified to accept the Top Mount Reverse Flange Anvil Holder. The frame must be drilled & tapped. Contact Service Department for information at 800-523-5321 or 215-766-8853.

NOTE: “FOR MODEL 2009 PRESS – MUST PURCHASE KIT P/N 8015190 IN ADDITION TO KIT 8006100”

KIT 8006100 (SERIES 2007/17 & UP)
KIT 8004300 (SERIES 2006/16 & LOWER)



EACH KIT INCLUDE PUNCH AND FLAT ANVIL
8004300 Kit includes new ram sensor that replaces existing sensor.

WORKPIECE ALIGNMENT PLATES KIT PART # 8004682 CONTAINS:

ALIGNMENT PLATE ROUND	980020059
ALIGNMENT PLATE RECTANGULAR	980020060

Reference Page 9 for the items listed below for diagrams:

TOOLING ADAPTER FOR .500” DIA ANVIL HOLDER & PUNCH ADAPTER – PART# 8007647 (Must be purchased in Qty 2)

ANVIL ADAPTER FOR .500” DIA SHANKS – PART# 8010778

ANVIL ADAPTER FOR .625” DIA SHANKS – PART# 8010779

ANVIL ADAPTER FOR .750” DIA SHANKS – PART# 8010780

.500” DIA FLAT PUNCHES AVAILABLE:

PART# 8010781 - .500” DIA X 5.25” LONG

PART# 8010782 - .500” DIA X 4.5” LONG

PART# 8010783 - .500” DIA X 3.75” LONG

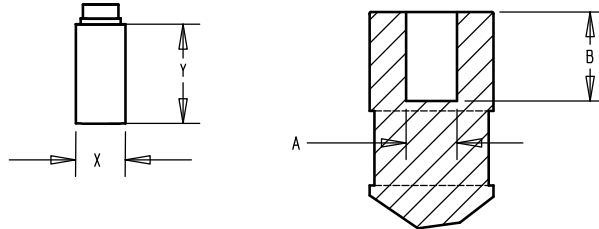
To Determine which of the above flat punches to use with each Anvil Adapter for use with the Series 4 & Series LT/4 presses: (Total length of tooling = 7”)

Anvil Adapter is .75” tall, allowing for anvil to sit in .50” leaving .25” to be accounted for tooling height.

Anvil Adapter Height	Anvil Length	1/2” Dia Flat Punch
.25”	1.5”	8010781 (5.25” Long)
.25”	2.25”	8010782 (4.50” Long)
.25”	3”	8010783 (3.75” Long)

TOOLING FOR SWAGE STANDOFFS

To determine the counterbore dimensions for the manual anvil, follow this formula:



A dimension = X (dia of fastener body) + .005 tolerance of “+.005 -.000”

B dimension = Y (length of fastener body) - .010

The list below references all of the manual anvils that have been designed for swage standoffs:

Anvil Part No.	Counterbore	
	Dia	Depth
8006936	.192	.150
8008455	.192	.235
8008454	.192	.675
8006946	.242	.150
8006937	.242	.580
8006195	.245	.485
8008459	.255	.080
8022168	.255	.295
8006935	.255	.450
8006190	.255	1.20
8006926	.260	.900
8009970	.380	.490
8009971	.380	.740

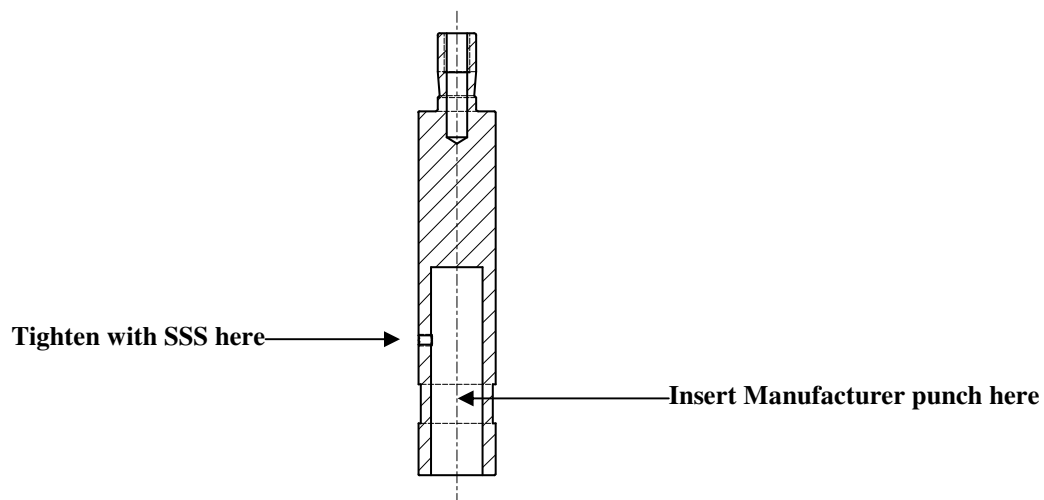
Punch Adapter

This adapter is for holding the manufacturer punches so that they can properly install the swage standoffs.

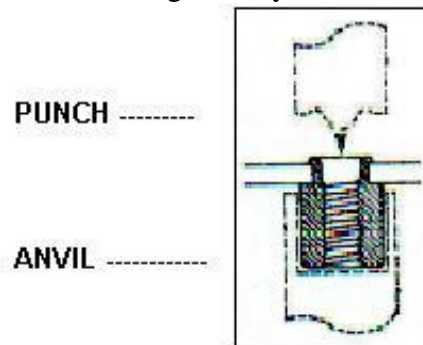
Adapter Part No.	Adapter Hole Dia	Adapter Hole Depth*
8007619	.501	2.00"
8009613	.501	1.50"
8009614	.501	1.20"

*The depth of the adapter hole will vary depending on the length of the Manufacturer tooling being adapted to our tooling. The length of the tooling must measure up to the standard 7".

The punches are inserted into the PEMSERTER® punch adapter and are held in with Qty 1 - SSS #4-40 x 1/4 LG.



The manufacturer punches contain the rounded geometry for installing the swage standoffs (see below):



For Series 2000, Series 4 & Series LT4 presses:



Important: The ram must contact the fastener fully in the workpiece (but not installed) and both the fastener and workpiece must be flat to the punch and anvil. The gap between the punch and the anvil must not exceed 5.5mm (7/32”) to conform to internationally recognized safety standards. This means that the stacked height of the fastener and the workpiece before installation must not exceed 5.5mm (7/32”). These include standards published by ISO, ANSI, OSHA, CEN and CSA.

PRESS ACCESSORIES:

Part Number	Description	Features and Benefits
8005538 (120V) (US)	Industrial Work Light	<ul style="list-style-type: none"> • Flexible, Efficient Coverage of Working Area • Bright 20W Halogen Bulb • Magnetic Base Mounts to Frame
8005539 (220V) (EUROPE)		
8005537	Anti-Fatigue Work Mat	<ul style="list-style-type: none"> • Solid polyurethane nodule design increases blood circulation and reduces cumulative trauma disorders associated with prolonged standing. • Chemical Resistant • Durable and easy to clean • Shock absorbent with Tapered Edges • 24" by 36" • Two Year Wear Warranty
8005531	Industrial Work Seat	<ul style="list-style-type: none"> • Ergonomic design improves comfort and increases worker productivity • Four Easy to use Height (16" to 32") and Tilt Adjustments • Durable Polyurethane Seat • Foot Rest Step Rail • Built tough for industrial environment • Swivel Stop Feature makes getting on and off the chair easy and safe • Five Year, Three shift Warranty