PEM® brand self-clinching blind fasteners provide permanently mounted blind threads in metal sheets as thin as .040"/1 mm.
PEM® brand self-clinching blind fasteners provide permanently mounted blind threads in metal sheets as thin as .040”/1 mm.

- Provides barrier to protect threads against foreign matter.
- Limits screw penetration, protecting internal components from potential damage.
- Available on special order with free-running locking thread feature.

PEM® blind fasteners employ the proven PEM® self-clinching design and are easily installed into properly sized holes. Shanks of PEM® fasteners act as their own pilots. PEM® blind fasteners can be installed with any standard press applying squeezing forces between parallel surfaces.

PEM® self-clinching blind fasteners are available in thread sizes from #4-40 through 1/4-20 / M3 through M6 in carbon or stainless steel.

Fastener drawings and models are available at [www.pemnet.com](http://www.pemnet.com). Custom sizes are available on special order. Contact us for more information.

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**Thread Size x Pitch**

<table>
<thead>
<tr>
<th>Material</th>
<th>Type Code</th>
<th>Shank Code</th>
<th>A (Shank) Max</th>
<th>Min. Sheet Thickness</th>
<th>Hole Size in Sheet +0.003 –0.000</th>
<th>B Max.</th>
<th>C ± 0.10</th>
<th>E ± 0.010</th>
<th>F Min.</th>
<th>L Min.</th>
<th>T Min.</th>
<th>Min. Dist. Hole C/L to Edge (2)</th>
</tr>
</thead>
<tbody>
<tr>
<td>M3 x 0.5</td>
<td>B BS M3</td>
<td>1</td>
<td>.097</td>
<td>1</td>
<td>4.22</td>
<td>3.84</td>
<td>4.2</td>
<td>6.35</td>
<td>5.3</td>
<td>8.5</td>
<td>9.6</td>
<td>4.8</td>
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<tr>
<td></td>
<td></td>
<td>2</td>
<td>.138</td>
<td>1.4</td>
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<td>M4 x 0.7</td>
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<td>5.38</td>
<td>7.95</td>
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<td>9.8</td>
<td>11.2</td>
<td>6.9</td>
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<td>2</td>
<td>.138</td>
<td>1.4</td>
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<tr>
<td>M5 x 0.8</td>
<td>B BS M5</td>
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<td>1</td>
<td>6.35</td>
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<td>6.33</td>
<td>8.75</td>
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<td>11.2</td>
<td>71</td>
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<td></td>
<td>2</td>
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<td>1.4</td>
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</tr>
<tr>
<td>M6 x 1</td>
<td>B BS M6</td>
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<td>.138</td>
<td>1.4</td>
<td>8.75</td>
<td>7.8</td>
<td>8.73</td>
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<td>12.7</td>
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</tr>
</tbody>
</table>

(1) PEM® B™ nuts are available on special order with a free-running locking thread feature allowing mating screw to turn freely until clamp load is applied. For more information, contact PEM® Technical Support.

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

1. Prepare properly sized mounting hole in the sheet. Do not perform any secondary operations such as deburring.
2. Place the barrel of the fastener into the anvil hole and place the mounting hole (preferably the punch side) over the shank of the fastener.
3. With the installation punch and anvil surfaces parallel, apply squeezing force until the flange contacts the mounting sheet. The sketch at the right indicates suggested tooling for applying these forces.

**Installation Tooling - B and BS Nuts**

<table>
<thead>
<tr>
<th>Thread Code</th>
<th>HAEGER® Part Number</th>
<th>PEMSERTER® Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td>440 &amp; M3</td>
<td>H-137-440L</td>
<td>H-108-0020L 975200001</td>
</tr>
<tr>
<td>632</td>
<td>H-137-632L</td>
<td>H-108-0020L 975200002</td>
</tr>
<tr>
<td>832 &amp; M4</td>
<td>H-137-832L</td>
<td>H-108-0020L 975200003</td>
</tr>
<tr>
<td>032 &amp; M5</td>
<td>H-137-1032L</td>
<td>H-108-0020L 975200004</td>
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<tr>
<td>0420 &amp; M6</td>
<td>H-137-0420L</td>
<td>H-108-0020L 975200005</td>
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</tbody>
</table>

**Installation Notes**

- For best results we recommend using a HAEGER® or PEMSERTER® machine for installation of PEM® self-clinching fasteners. See our website for more information.
- Visit the Animation Library on our website to view the installation process.

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

Go to [haeger.com](http://haeger.com) to access the Auto and Manual Tooling Wizards

Or download the HAEGER WIZARD Phone App

[HAEGER® MANUAL TOOLING CATALOG](#)
[HAEGER® AUTO TOOLING CATALOG](#)
[PEMSERTER® MANUAL TOOLING CATALOG](#)
[PEMSERTER® AUTO TOOLING CATALOG](#)
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.

All PEM® products meet our stringent quality standards. If you require additional industry or other specific quality certifications, special procedures and/or part numbers are required. Please contact your local sales office or representative for further information.

Performance Data(1)

<table>
<thead>
<tr>
<th>Type</th>
<th>Ship Code</th>
<th>Shank Code</th>
<th>Sheet Thickness (in.)</th>
<th>Test Sheet Material</th>
<th>Cold-Rolled Steel</th>
</tr>
</thead>
<tbody>
<tr>
<td>B</td>
<td>440</td>
<td>0.040</td>
<td>1600</td>
<td>安装力 (lbs)</td>
<td>90</td>
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<tr>
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<td>0.056</td>
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<td>170</td>
<td>2000</td>
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<tr>
<td>BS</td>
<td>832</td>
<td>0.040</td>
<td>1800</td>
<td>3000</td>
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<tr>
<td></td>
<td>0.056</td>
<td>2800</td>
<td>190</td>
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<tr>
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<td>3500</td>
<td>190</td>
<td>3500</td>
<td>50</td>
</tr>
</tbody>
</table>

(1) See PEM Technical Support section of our web site for related plating standards and specifications.

(2) HRB - Hardness Rockwell "B" Scale. HB - Hardness Brinell.

Custom sizes are available on special order. Contact us for more information.

All PEM® products meet our stringent quality standards. If you require additional industry or other specific quality certifications, special procedures and/or part numbers are required. Please contact your local sales office or representative for further information.

Regulatory compliance information is available in Technical Support section of our website. Specifications subject to change without notice. See our website for the most current version of this bulletin.

PEM® “Two Groove” (Registered Trademark)