

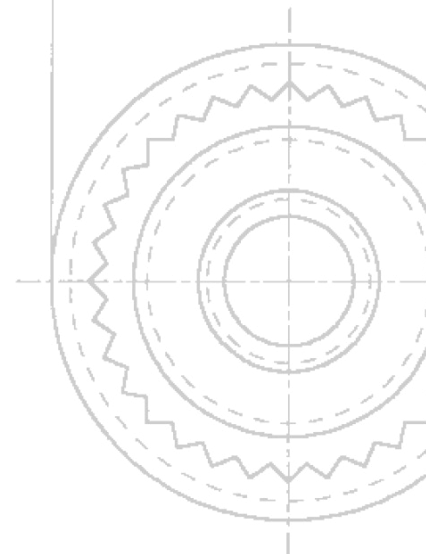
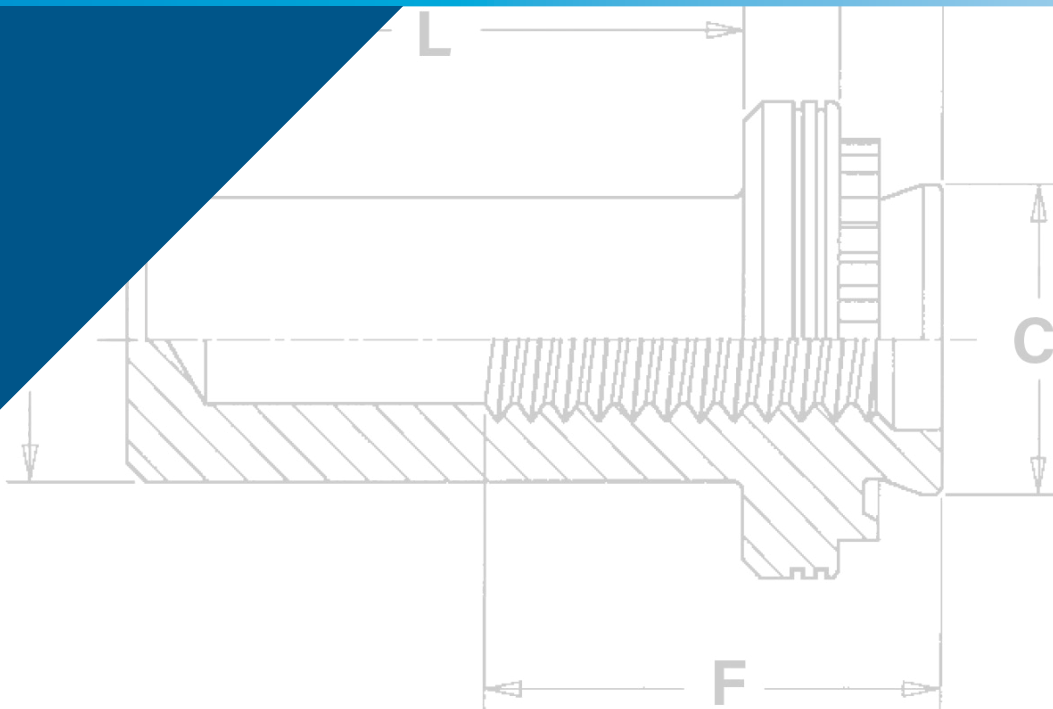


PEM® self-clinching blind fasteners are used in applications requiring closed thread ends.



B™

SELF-CLINCHING BLIND FASTENERS



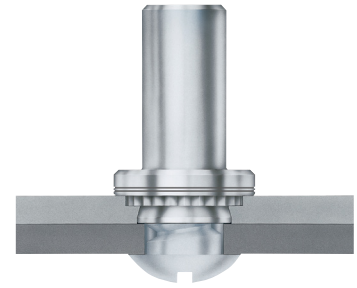
SELF-CLINCHING BLIND FASTENERS

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

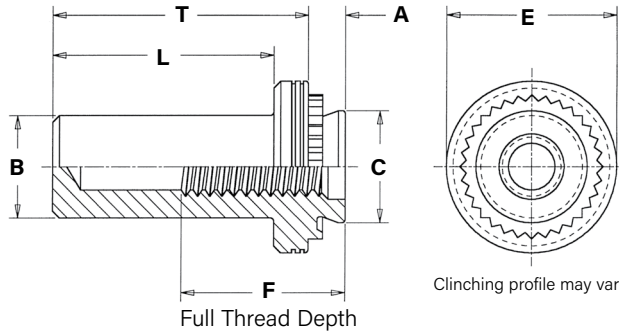
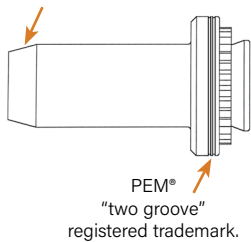
- Provides barrier to protect threads against foreign matter.
- Limits screw penetration, protecting internal components from potential damage.
- Available on special order with free-running locking thread feature.

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.

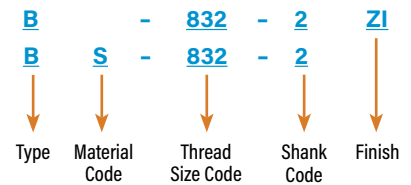
PEM® self-clinching blind fasteners are available in thread sizes from #4-40 through 1/4-20 / M3 through M6 in carbon or stainless steel.



Metric parts are identified by large chamfer at blind end.



PART NUMBER DESIGNATION



All dimensions are in inches.

| UNIFIED | Thread Size (#4-40) | Type | | Thread Code (1) | Shank Code | A (Shank) Max. | Min. Sheet Thickness | Hole Size in Sheet + .003 - .000 | B Max. | C Max. | E ± .010 | F Min. | L Max. | T ± .010 | Min. Dist. Hole \varnothing to Edge |
|---------|------------------------|-------------------|-----------------|-----------------|------------|----------------|----------------------|--|--------|--------|----------|--------|--------|----------|---------------------------------------|
| | | Fastener Material | | | | | | | | | | | | | |
| | | Steel | Stainless Steel | | | | | | | | | | | | |
| | | B | BS | 440 | 1 | .038 | .040 | .166 | .150 | .165 | .250 | .210 | .335 | .380 | .19 |
| | | | | | 2 | .054 | .056 | | | | | | | | |
| | | B | BS | 632 | 1 | .038 | .040 | .1875 | .169 | .187 | .280 | .230 | .335 | .380 | .22 |
| | | | | | 2 | .054 | .056 | | | | | | | | |
| | | B | BS | 832 | 1 | .038 | .040 | .213 | .204 | .212 | .310 | .280 | .385 | .440 | .27 |
| | | | | | 2 | .054 | .056 | | | | | | | | |
| | | B | BS | 032 | 1 | .038 | .040 | .250 | .235 | .249 | .340 | .280 | .385 | .440 | .28 |
| | | | | | 2 | .054 | .056 | | | | | | | | |
| | | B | BS | 0420 | 1 | .054 | .056 | .344 | .305 | .343 | .430 | .310 | .500 | .560 | .34 |
| | | | | | 2 | .087 | .090 | | | | | | | | |

All dimensions are in millimeters.

| METRIC | Thread Size x Pitch | Type | | Thread Code (1) | Shank Code | A (Shank) Max. | Min. Sheet Thickness | Hole Size in Sheet + 0.08 | B Max. | C Max. | E ± 0.25 | F Min. | L Max. | T ± 0.25 | Min. Dist. Hole \varnothing to Edge |
|----------|---------------------|-------------------|-----------------|-----------------|------------|----------------|----------------------|------------------------------|--------|--------|----------|--------|--------|----------|---------------------------------------|
| | | Fastener Material | | | | | | | | | | | | | |
| | | Steel | Stainless Steel | | | | | | | | | | | | |
| M3 x 0.5 | | B | BS | M3 | 1 | 0.97 | 1 | 4.22 | 3.84 | 4.2 | 6.35 | 5.3 | 8.5 | 9.6 | 4.8 |
| | | | | | 2 | 1.38 | 1.4 | | | | | | | | |
| M4 x 0.7 | | B | BS | M4 | 1 | 0.97 | 1 | 5.41 | 5.2 | 5.38 | 7.95 | 7.1 | 9.8 | 11.2 | 6.9 |
| | | | | | 2 | 1.38 | 1.4 | | | | | | | | |
| M5 x 0.8 | | B | BS | M5 | 1 | 0.97 | 1 | 6.35 | 6.02 | 6.33 | 8.75 | 7.1 | 9.8 | 11.2 | 7.1 |
| | | | | | 2 | 1.38 | 1.4 | | | | | | | | |
| M6 x 1 | | B | BS | M6 | 1 | 1.38 | 1.4 | 8.75 | 7.8 | 8.73 | 11.1 | 7.8 | 12.7 | 14.3 | 8.6 |
| | | | | | 2 | 2.21 | 2.29 | | | | | | | | |

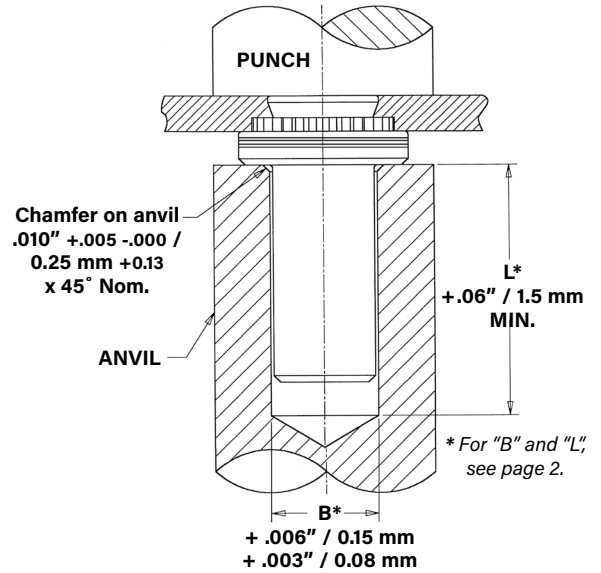
(1) PEM® B™ nuts are available on special order with a free-running locking thread feature allowing mating screw to turn freely until clamp load is applied. For more information, contact PEM® [Technical Support](#).



SELF-CLINCHING BLIND FASTENERS

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

| Thread Code | HAEGER® Part Number | | PEMSERTER® Part Number | |
|-------------|---------------------|-------------|------------------------|-----------|
| | Anvil | Punch | Anvil | Punch |
| 440/M3 | H-137-440/M3L | H-108-0020L | 975200001 | 975200048 |
| 632 | H-137-632/M3.5L | H-108-0020L | 975200002 | 975200048 |
| 832/M4 | H-137-832/M4L | H-108-0020L | 975200003 | 975200048 |
| 032/M5 | H-137-1032/M5L | H-108-0020L | 975200004 | 975200048 |
| 0420/M6 | H-137-0420/M6L | H-108-0020L | 975200005 | 975200048 |

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

Tooling ▾ Request ▾

- Auto Tooling Wizard
- Manual Tooling Wizard
- Force Chart
- BTM Tooling
- Manual Tooling Catalog

Go to haeger.com to access the Auto and Manual Tooling Wizards

Or download the HAEGER WIZZARD Phone App

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HAEGER® MANUAL TOOLING CATALOG

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SELF-CLINCHING BLIND FASTENERS

MATERIAL AND FINISH SPECIFICATIONS

| Type | Threads | Fastener Materials | | Standard Finishes | | For Use in Sheet Hardness: (2) | |
|-------------------------------|---|-----------------------|----------------------------|--|---|--------------------------------|-------------------------|
| | Internal, ASME B1.1, 2B / ASME B1.13M, 6H | Hardened Carbon Steel | 300 Series Stainless Steel | Passivated and/or Tested Per ASTM A380 | Zinc Plated per ASTM B633, SC1 (5µm), Type III, Colorless (1) | HRB 80 / HB 150 or less | HRB 70 / HB 125 or less |
| B | ▪ | ▪ | | | ▪ | ▪ | |
| BS | ▪ | | ▪ | ▪ | | | ▪ |
| Part Number Code For Finishes | | | | None | ZI | | |

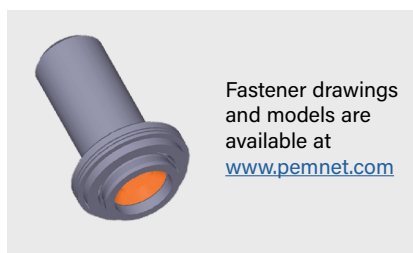
- (1) See PEM [Technical Support](#) section of our web site for related plating standards and specifications.
 (2) HRB - Hardness Rockwell "B" Scale. HB - Hardness Brinell.

PERFORMANCE DATA⁽¹⁾

| UNIFIED | Thread Code | Shank Code | Sheet Thickness (in.) | Test Sheet Material | | | | |
|---------|-------------|------------|-----------------------|---------------------|----------------|-----------------------|---------------------|----------------|
| | | | | 5052-H34 Aluminum | | | Cold-Rolled Steel | |
| | | | | Installation (lbs.) | Pushout (lbs.) | Torque-out (in. lbs.) | Installation (lbs.) | Pushout (lbs.) |
| 440 | 1 | .040 | 1600 | 90 | 10 | 2500 | 125 | 13 |
| | 2 | .056 | 2000 | 170 | 13 | 3500 | 230 | 18 |
| 632 | 1 | .040 | 1800 | 95 | 17 | 3000 | 130 | 18 |
| | 2 | .056 | 2800 | 190 | 22 | 4000 | 260 | 28 |
| 832 | 1 | .040 | 2000 | 105 | 23 | 3500 | 135 | 30 |
| | 2 | .056 | 3000 | 220 | 35 | 5000 | 285 | 45 |
| 032 | 1 | .040 | 2100 | 110 | 32 | 4000 | 140 | 35 |
| | 2 | .056 | 3500 | 190 | 50 | 5000 | 250 | 60 |
| 0420 | 1 | .056 | 4000 | 315 | 90 | 6000 | 400 | 105 |
| | 2 | .090 | | | | | | |

| METRIC | Thread Code | Shank Code | Sheet Thickness (mm) | Test Sheet Material | | | | |
|--------|-------------|------------|----------------------|---------------------|-------------|------------------|-------------------|-------------|
| | | | | 5052-H34 Aluminum | | | Cold-Rolled Steel | |
| | | | | Installation (kN) | Pushout (N) | Torque-out (N-m) | Installation (kN) | Pushout (N) |
| M3 | 1 | 1 | 7.1 | 400 | 1.15 | 11.1 | 550 | 1.5 |
| | 2 | 1.4 | 9 | 750 | 1.47 | 14 | 1010 | 2.05 |
| M4 | 1 | 1 | 8.9 | 470 | 2.6 | 15.6 | 600 | 3.4 |
| | 2 | 1.4 | 12.5 | 970 | 4 | 20 | 1250 | 5.1 |
| M5 | 1 | 1 | 9.3 | 480 | 3.6 | 17.8 | 620 | 4 |
| | 2 | 1.4 | 14 | 845 | 5.7 | 25 | 1112 | 6.8 |
| M6 | 1 | 1.4 | 17.8 | 1400 | 10.2 | 25.7 | 1760 | 11.9 |
| | 2 | 2.3 | | | | | | |

- (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.



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.

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