

# PERFORMANCE DATA FOR BROACHING FASTENERS <sup>(1)</sup>

UNIFIED	Type	Thread Code	Max. Nut Tightening Torque (in. lbs.)	Test Sheet Thickness & Test Sheet Material	Installation (lbs.)	Pushout (lbs.) (2)	Torque-out (in. lbs.)
	KF2	256	(3)	.060" FR-4 Fiberglass	400	60	6
		KFS2	440	(3)	.060" FR-4 Fiberglass	400	65
	KFE	632	(3)	.060" FR-4 Fiberglass	500	80	30
		832	(3)	.060" FR-4 Fiberglass	700	95	35
	KFSE	032	(3)	.060" FR-4 Fiberglass	700	100	40
	KFB3	440	(3)	.060" FR-4 Fiberglass	1,000	140	18
		632	(3)	.060" FR-4 Fiberglass	1,500	170	28
	KFH	440	4	.060" FR-4 Fiberglass	400	65	7
		632	8	.060" FR-4 Fiberglass	400	70	11
832		15	.060" FR-4 Fiberglass	400	80	16	
032		18	.060" FR-4 Fiberglass	400	90	17	
PFK	440	(3)	.060" FR-4 Fiberglass	250	55	(3)	
	632	(3)	.060" FR-4 Fiberglass	400	60	(3)	
KPS6	440	(3)	.060" FR-4 Fiberglass (5)	2,500	40	5	
	632	(3)	.060" FR-4 Fiberglass (5)	3,300	50	7	
	832	(3)	.060" FR-4 Fiberglass (5)	5,000	70	12	
	032	(3)	.060" FR-4 Fiberglass (5)	6,000	80	15	

UNIFIED	Type	Panel 1 (.060" FR-4 Fiberglass) (4)		Panel 2 (Removable) (4)		
		Installation (lbs.)	Pushout (lbs.)	Max. First On Force (lbs.)	Min. First Off Force (lbs.)	Min. 15th Off Force (lbs.)
	KSSB	500	110	13	3.0	1.0

(1) The installation, pushout and torque-out values reported are averages when all installation specifications and procedures are followed. Variations in mounting hole size, sheet material and installation procedure will affect this data. Performance testing of this product in your application is recommended. We will be happy to provide samples for this purpose.

(2) These are typical values for parts installed in drilled mounting holes. Punched mounting holes yield values approximately 15% less.

(3) Not applicable.

(4) See Application Data drawing on page K-6.

(5) 1 Mil Cu, .5 Mil Sn/Pb plated thru-hole.

## PERFORMANCE DATA FOR BROACHING FASTENERS <sup>(1)</sup> (Continued)

METRIC	Type	Thread Code	Max. Nut Tightening Torque (N•m)	Test Sheet Thickness & Test Sheet Material	Installation (kN)	Pushout (N) (2)	Torque-out (N•m)
	KF2 KFS2 KFE KFSE	M3	(3)	1.5 mm FR-4 Fiberglass	2.2	290	1.7
		M4	(3)	1.5 mm FR-4 Fiberglass	2.2	420	3.4
		M5	(3)	1.5 mm FR-4 Fiberglass	2.9	440	4.5
	KFB3	M3	(3)	1.5 mm FR-4 Fiberglass	4.4	560	2.03
		M4	(3)	1.5 mm FR-4 Fiberglass	6	680	3.2
	KFH	M3	0.45	1.5 mm FR-4 Fiberglass	1.8	285	0.79
		M4	1.6	1.5 mm FR-4 Fiberglass	1.8	355	1.8
		M5	2.1	1.5 mm FR-4 Fiberglass	1.8	400	1.92
	PFK	M3	(3)	1.5 mm FR-4 Fiberglass	1.1	245	(3)
KPS6	M3	(3)	1.5 mm FR-4 Fiberglass (5)	9.8	178	.56	
	M4	(3)	1.5 mm FR-4 Fiberglass (5)	22.2	312	1.36	
	M5	(3)	1.5 mm FR-4 Fiberglass (5)	26.7	356	1.7	

METRIC	Type	Panel 1 (1.5 mm FR-4 Fiberglass) (4)		Panel 2 (Removable) (4)		
		Installation (kN)	Pushout (N)	Max. First On Force (N)	Min. First Off Force (N)	Min. 15th Off Force (N)
	KSSB	2.2	484	57.7	13.3	4.4

(1) The installation, pushout and torque-out values reported are averages when all installation specifications and procedures are followed. Variations in mounting hole size, sheet material and installation procedure will affect this data. Performance testing of this product in your application is recommended. We will be happy to provide samples for this purpose.

(2) These are typical values for parts installed in drilled mounting holes. Punched mounting holes yield values approximately 15% less.

(3) Not applicable.

(4) See Application Data drawing on page K-6.

(5) 1 Mil Cu, .5 Mil Sn/Pb plated thru-hole.

### PEMSERTER® PRESSES

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