

# AUTOMATIC TOOLING GUIDE

Identify your press. The serial number is located on the cover of the Instruction Manual or on the PEMSERTER name plate.

**\*\*Please note that all tooling is top-feed unless noted otherwise.**

**Fastener Type  
and Size**

**Automatic Tool Part NO.  
Series 100, 500 & 1000**

<b>SELF-CLINCHING NUTS S, CLS, SP, SS, CLSS</b>	<b>UNIFIED</b>
4-40 (-0 & -1)	976200110
4-40 (-1 & -2)	976200111
4-40 (-2 & -3)	976200112
6-32 (-0 & -1)	976200113
6-32 (-1 & -2)	976200114
6-32 (-2 & -3)	976200115
8-32 (-0 & -1)	976200116
8-32 (-1 & -2)	976200117
8-32 (-2 & -3)	976200118
10-32 (-0 & -1)	976200122
10-32 (-1 & -2)	976200123
10-32 (-2 & -3)	976200124
12-24 (-0 & -1)	976200125
12-24 (-1 & -2)	976200126
12-24 (-2 & -3)	976200127
1/4-20 (-1)	976200128
1/4-20 (-2)	976200129
1/4-20 (-3)	976200130
	<b>1000 ONLY</b>
05-18 (-1 & -2)	976200131

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<b>SELF-CLINCHING NUTS</b>	<b>METRIC</b>
<b>S, CLS, SP, SS, CLSS</b>	
M3 (-0 & -1)	976200362400
M3 (-1 & -2)	976200283
M3 (-2 & -3)	976200404
M3.5 (-0 & -1)	976200363400
M3.5 (-1 & -2)	976200284
M3.5 (-2 & -3)	976200372
M4 (-0 & -1)	976200364400
M4 (-1 & -2)	976200285
M4 (-2 & -3)	976200349
M5 (-0 & -1)	976200354
M5 (-1 & -2)	976200286
M5 (-2 & -3)	976200381
M6 (-0 & -1)	976200486
M6 (-1 & -2)	976200287
M6 (-2 & -3)	976200375
	<b>1000 ONLY</b>
M8 (-1 & -2)	976200376
M8 (-2 & -3)	976200377

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## **Flush Studs**

**FH, FHA, FHS**

### **UNIFIED**

2-56 (-5 to -16)	977200001
4-40 (-5 to -20)	977200002
6-32 (-5 to -24)	977200003
8-32 (-6 to -24)	977200004
10-32 (-6 to -24)	977200005
1/4-20 (-6 to -24)	977200006
5/16,18 (-8 to -24)	977200007

### **METRIC**

M2.5 (-8 & longer)	977200008
M3 (-8 & longer)	977200009
M4 (-9 & longer)	977200010
M5 (-9 & longer)	977200011
M6 (-12 & longer)	977200012
M8 (-12 & longer)	977200013

## **Heavy Head Stud**

**HFH, HFHS**

### **UNIFIED**

10-32 (-6 to -24)	977200099
1/4-20 (-6 to -24)	977200104
05-18 (-8 to to -24)	977200078
06-16 (-8 to -24)	977200118

### **METRIC**

M5 (-9 & longer)	977200099
M6 (-12 & longer)	977200097
M8 (-12 & longer)	977200078

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## **Broaching Nuts**

**KF2, KFS2**

**UNIFIED & METRIC**

4-40 / M3	976200057
6-32 / M3.5	976200058

## **Broaching Studs**

**KFH**

4-40	977200018
6-32 / M3.5	977200095
8-32 / M4	977200020
10-32 / 10-24	977200021
1/4-20	977200024
M3	977200022

## **Self-Locking Nuts \*\*Top Feed Only**

**LK, LKS, LKA**

4-40 (-1 & -2)	976200071
6-32 (-1 & -2)	976200072
8-32 (-1 & -2)	976200073
10-32 (-1 & -2)	976200074

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## **Flush Nuts**

**F**

440 / M3 (-1)	976200300
440 / M3 (-2)	976200025
6-32 (-1)	976200301
6-32 (-2)	976200027
8-32 / M4 (-1)	976200028
8-32 / M4 (-2)	976200029
10-32 / M5 (-1)	976200030
10-32 / M5 (-2)	976200031
1/4-20 / M6 (-3)	976200032

**FE, FEX, FEO**

4-40 / M3	976200040
6-32 / M3.5	976200041
8-32 / M4	976200042
10-32 / M5	976200043

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**Standoffs  
SO,SOA,SOS,BSO,  
BSOA, BSOS,SOAG,SOSG**

## UNIFIED

4-40 (-4)	976200508
4-40 (-6)	977200117
4-40 (-8 & longer)	977200015
6-32 (-4)	976200424
6-32 (-6)	976200500
6-32 (-8 & longer)	977200016
6440 (-6)	976200459
6440 (-8 & longer)	977200016
8-32 (-8 & longer)	977200017
8632 (-8 & longer)	977200017
10-32 (6-)	976200457
10-32 (-8 & longer)	977200017

## METRIC

3.5M3 (-4)	976200414
M3 (-4)	976200428
M3 (-6)	977200117
M3 (-8 & longer)	977200015
M3.5 (-4)	976200414
M3.5 (-8 & longer)	977200016
M4 (-6)	976200423
M4 (-8 & longer)	977200017
M5 (-8 & longer)	977200017

**SSA/KSSB**

156	977200122
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# AUTOMATIC FEED BOWLS

Fastener Type	Bowl Part #
Studs/Standoffs	870200003
Nuts (Standard)	875200004
Nuts (Large)	975200974

# AUTOMATIC FEED PUNCHES

Fastener Type and Size	PUNCH PART#	PILOT PIN #
<b>NUTS</b>		
S, CLS - 4-40/M3	975200088	975200067
S, CLS - 6-32/M3.5	975200089	975200068
S, CLS - 8-32/M4	975200090	975200069
SS, CLSS -10-32/M5	975200091	975200070
S, CLS -1/4-20/M6	975200093	975200072

<b>STUDS</b>		
FH -4-40, 6-32/M3 & M3.5	970200025	
FH -8-32, 10-32/M4, M5	970200026	
FH -1/4-20, M6	970200027	

<b>STANDOFFS (VACUUM ONLY)</b>		
SO - 4-40/M3	970200028	
SO - 6-32/M3.5	970200029	
SO - 8-32/ 10-32/M4, M5	970200030	

NUTS THREAD SIZE	PILOT PIN WIRE PART#
#4, 6, 8	975201152
#10, 1/4	975201153
05, 06	975201154

# AUTOMATIC FEED ANVILS

**Fastener Type  
and Size**

**ANVIL PART#**

**PILOT PIN #**

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**NUTS**

S, CLS - 4-40/M3	975200203	975350203
S, CLS - 6-32/M3.5	975200205	975350208
S, CLS - 8-32/M4	975200208	975350214
SS, CLSS -10-32	975200212	975350222
SS, CLSS -M5	975201183	975351319
S, CLS -1/4-20/M6	975200024	975350261

**NUTS (BOTTOM FEED)**

S, CLS - 4-40/M3	975200148
S, CLS - 6-32/M3.5	975200149
S, CLS - 8-32/M4	975200150
S, CLS -10-32/M5	975200151
S, CLS -1/4-20/M6	975200153

**STUDS**

FH -4-40	970200048	970350069
FH -6-32/M3.5	970200052	970350073
FH -8-32	970200054400	970350075
FH -10-32	970200055	970350076
FH -1/4-20	970200059	970350282
FH -M3	970200049	970350070
FH -M4	970200053	970350074
FH -M5	970200056400	970350077
FH -M6	970200058	970350079

**STANDOFFS (VACUUM ONLY)**

SO -4-40/M3	970200054400	970350779
SO - 6-32/M3.5	970200057	970350078
SO -8-32,10-32/M4,M5	970200060	970350081