

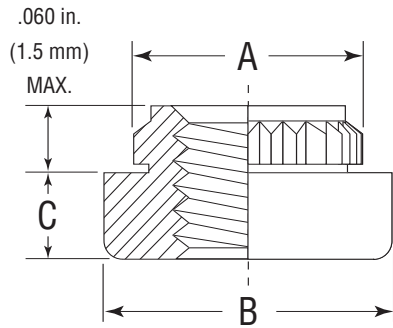
Broaching-Type Fasteners

Series CKF2 & CKFS2



CKF2 and CKFS2 broaching-type fasteners are designed for use on printed circuit boards and on most brittle or hard materials; such as, glass laminates, epoxy or resin with paper, nylon, or canvas bases. They are also used on materials too thin or unsuitable for threading, such as acrylic and polycarbonate panels.

Since the aforementioned materials do not flow under pressure, these fasteners are designed with a knurled shank that can be pressed into a drilled hole. The shank grips the board with an interference fit by broaching its way into the panel as it is squeezed into the holes.



| Series | Material | Finish |
|--------|----------------------------|--------------------------------------|
| CKF2 | Carbon Steel | Electro tin plating (Zinc* optional) |
| CKFS2 | 300 Series Stainless Steel | Passivated ASTM A967 |

*See Finish Spec. on Page 6.

Thread: Internal 2B, ANSI B1.1 (6H, ANSI/ASME B1.13M).

Use in: Materials with Rockwell Hardness of B-60 or less.

Dimensions & Specifications

| Thread Size | Part Number | | A ±.003 | B ±.005 | C ±.005 | + .003 - .000 | Min. | Min. | |
|-------------|--------------|-----------------|------------|------------|------------|------------------|------|------|------|
| | Carbon Steel | Stainless Steel | | | | | | | |
| INCH (in.) | #2-56 | CKF2256 | CKFS2256 | .165 | .219 | .065 | .147 | .16 | .060 |
| | #4-40 | CKF2440 | CKFS2440 | .184 | .219 | .065 | .166 | .17 | .060 |
| | #6-32 | CKF2632 | CKFS2632 | .231 | .281 | .065 | .213 | .22 | .060 |
| | #8-32 | CKF2832 | CKFS2832 | .268 | .344 | .096 | .250 | .25 | .060 |
| | #10-24 | CKF21024 | CKFS21024 | .290 | .375 | .127 | .272 | .28 | .060 |
| | #10-32 | CKF21032 | CKFS21032 | .290 | .375 | .127 | .272 | .28 | .060 |
| METRIC (mm) | M2 x 0.4 | CKF2M2 | CKFS2M2 | 4.19 | 5.56 | 1.5 | 3.73 | 4.2 | 1.53 |
| | M2.5 x 0.45 | CKF2M2.5 | CKFS2M2.5 | 4.68 | 5.56 | 1.5 | 4.22 | 4.4 | 1.53 |
| | M3 x 0.5 | CKF2M3 | CKFS2M3 | 4.68 | 5.56 | 1.5 | 4.22 | 4.4 | 1.53 |
| | M4 x 0.7 | CKF2M4 | CKFS2M4 | 6.81 | 8.74 | 2.0 | 6.4 | 6.4 | 1.53 |
| | M5 x 0.8 | CKF2M5 | CKFS2M5 | 7.37 | 9.53 | 3.0 | 6.9 | 7.1 | 1.53 |

Note: CKF2 & CKFS2 broaching fasteners are designed for unplated through-holes. When installed in plated through-holes, a hole tolerance of +.005 - .001 in. (+.13 - .03 mm) should be used.

When used in plated through-holes, performance will be reduced and plating may be damaged by knurl.

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

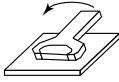
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Installation & Performance Data

| Fiberglass .060 in. (1.5 mm) | | | | |
|------------------------------|---|---|--|---|
| |  |  |  |  |
| | Thread Size | Installation Force (lbs.) | Pushout (lbs.) | Torque-out (in.-lbs.) |
| INCH (in.) | #2-56 | 400 | 60 | 6 |
| | #4-40 | 400 | 65 | 15 |
| | #6-32 | 500 | 80 | 30 |
| | #8-32 | 700 | 95 | 35 |
| | #10-24 | 700 | 100 | 40 |
| | #10-32 | 700 | 100 | 40 |
| | Thread Size | Installation Force (kN) | Pushout (N) | Torque-out (N•m) |
| METRIC (mm) | M2 | 2.22 | 265 | .65 |
| | M2.5 | 2.22 | 285 | 1.35 |
| | M3 | 2.22 | 285 | 1.70 |
| | M4 | 2.90 | 415 | 3.95 |
| | M5 | 2.90 | 435 | 4.52 |