



Broaching Type Nuts

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.

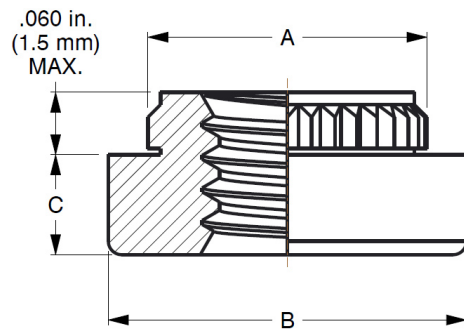
Since the aforementioned materials do not flow under pressure, these fasteners are designed with a knurled shank that can be pressed into a drilled hole. The shank grips the board with an interference fit by broaching its way into the panel as it is squeezed into the holes.

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.

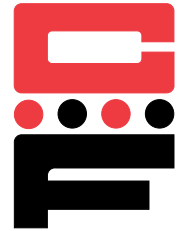
When used in plated through-holes, performance will be reduced and plating may be damaged by knurl.

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

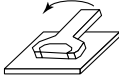
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Installation & Performance Data

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