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(71) Applicant (for all designated States except US): **PEM MANAGEMENT, INC.** [US/US]; 103 Foulk Road, Suite 108, Wilmington, Delaware 19803 (US).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **BENTRIM, Brian** [US/US]; 3830 Forest Hill Drive, Furlong, Pennsylvania 18925 (US). **BRUNO, David** [US/US]; 4088 Gregory Drive, Doylestown, Pennsylvania 18901 (US).

(74) Agent: **GORE, Gregory J.**; 70 West Oakland Avenue, Suite 316, Doylestown, Pennsylvania 18901 (US).

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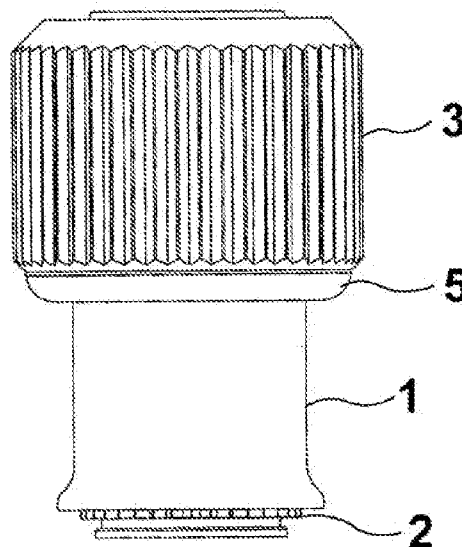
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(54) Title: METHOD OF MANUFACTURE FOR A PLASTIC-CAPPED PANEL FASTENER

**FIG. 1**



(57) Abstract: A captive panel fastener is manufactured by first overmolding a plastic cap around the head of a screw, the cap having a cylindrical plastic skirt extending downwardly beyond the base of the screw head and formed with a circular opening at the bottom. After a compression spring is placed around the shank of the screw, the screw is pressed against a top surface of a ferrule to a point where the capped-skirt extends downwardly below a ferrule flange. At that point, heat and pressure are applied radially inwardly around the periphery of the plastic skirt along its bottom edge until it is permanently deformed to a point where the bottom of the skirt is smaller in diameter than the ferrule flange. The screw is thereby captivated to the ferrule between extended and retracted positions.