

Self-tapping thread inserts installation information

Installing by hand

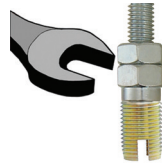
1. Drilling

Drill out the old hole with a core drill. If necessary, countersink the hole. By hard and tough materials the thread must be pre-tapped (max. intermediate tap).



2. Screw threaded insert onto the installation tool

Screw the thread insert onto the installation tool with the slot or hole downwards and lock in place with the locknut using a spanner.



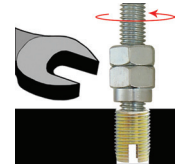
3. Screw in the thread insert

Screw in thread insert into the hole. The thread insert cuts its own thread. The installation tool has a 1/4" hexagon spigot and can be driven by a cordless driver, ratchet and socket etc.



4. Screw out the installation tool

Loosen the lock nuts with a spanner and screw the installation tool out. With the thread insert the thread is now more wear resistant, more durable and vibration resistant than the original thread.



Installation on a machine

1. Drilling

Drill out the old hole with a core drill. If necessary countersink the borehole. By hard and tough materials the thread must be pre-tapped (max. intermediate tap).



2. Machine settings and positioning

Position the workpiece under the machine. Set the machine to the screw in depth. Turn the outer sleeve so that the stop pin makes contact and carries the sleeve when screwing in begins. Screw the threaded insert 2 to 4 turns onto the threaded pin.



3. Screw in the thread insert

Allow the machine to run until the threaded insert is screwed into the workpiece. Introduce the tool gently to the workpiece down to prevent damaging or breaking the thread insert or the installation tool.



4. Screw the tool out

Set the machine into reverse. The outer sleeve is carried by the stop pin and counters the thread insert.



Recommended drilling diameter

		Threaded inserts with cutting slot case-hardened steel, galvanized, yellow-chromated				Threaded inserts with cutting holes case-hardened steel, galvanized, yellow-chromated			
Materials	Light metal alloys tensile strength [N/mm ²]	< 250 N/mm ² < 300 N/mm ² < 350 N/mm ² > 350 N/mm ²				< 300 N/mm ² < 350 N/mm ² > 350 N/mm ²			
	Brass, non-ferrous metals, bronze	> 350 N/mm ²				> 350 N/mm ²			
	Cast iron Brinell hardness [HB]	< 150 HB < 200 HB > 200 HB				< 150 HB < 200 HB > 200 HB			
Internal thread D	M3 x 0,5	-	4,6 mm	4,7 mm	4,8 mm	4,6 mm	4,7 mm	4,8 mm	
	M4 x 0,7	5,9 mm	6,0 mm	6,1 mm	6,2 mm	6,0 mm	6,1 mm	6,2 mm	
	M5 x 0,8	7,2 mm	7,3 mm	7,5 mm	7,6 mm	7,4 mm	7,5 mm	7,6 mm	7,7 mm
	M6 x 1,0	8,8 mm	9,0 mm	9,2 mm	9,4 mm	9,3 mm	9,4 mm	9,5 mm	9,6 mm
	M8 x 1,25	10,8 mm	11,0 mm	11,2 mm	11,4 mm	11,1 mm	11,2 mm	11,3 mm	11,5 mm
	M10 x 1,5	12,8 mm	13,0 mm	13,2 mm	13,4 mm	-	-	-	-
	M12 x 1,75	14,8 mm	15,0 mm	15,2 mm	15,4 mm	-	-	-	-
M16 x 2,0	18,8 mm	19,0 mm	19,2 mm	19,4 mm	-	-	-	-	
Flank coverage		ca. 60%	ca. 50%	ca. 40%	ca. 30%	ca. 80%	ca. 70%	ca. 60%	ca. 50%

Lubrication may be required

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