

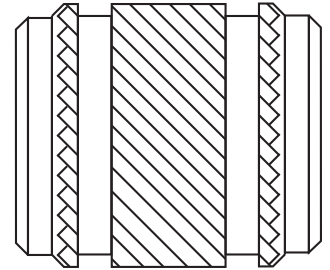
MINI-TECH[®] INSERTS

A MINIATURE INSERT WITH ALL THE DESIGN FEATURES
AND CHARACTERISTICS OF THE TECH-SONIC RANGE.



MINI-TECH[®] INSERTS

A miniature insert with all the design features and characteristics of the Tech-Sonic range. It is ideal for today's smaller plastic products and enables the use of very small screws that will provide complete re-usability with no risk of thread stripping problems.



ADVANTAGES

- Re-usable threads for miniature applications
- Eliminates thread stripping problems
- Double ended - assists automatic feeding
- Permits space-saving boss design

DESIGN GUIDE

HOLE PREPARATION

Molded holes are recommended wherever possible. The taper on a molded hole should be 0.5° inclusive and the hole diameter recommended should apply at the point reached by the bottom of the insert. The top of the hole should not be chamfered or counterbored and care must be taken to avoid bell mouting. Hole diameter tolerance: -0.00 +0.05mm.

INSTALLATION

The fastener has been designed for installation using a pre-heating process. Care must be exercised to ensure that the fastener softens but does not melt the plastic. This will avoid any tendency to generate unsightly flash around the top of the insert. Excessive pressure should be avoided, since this may result in the insert being forced into the hole without allowing the plastic to soften and flow around the surface profile.

WALL THICKNESS

A general guide to minimum wall thickness is given in the technical data table but this will vary dependant upon the nature of the plastic. Where thinner walls are required these can often be accommodated, but consultation with Bulten and pre-production testing is strongly advised.

PERFORMANCE DATA

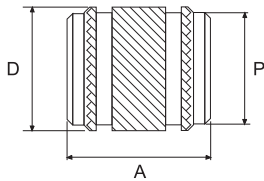
The complexity of materials and variations in service conditions make it impossible to detail fastener performance for specific applications, please contact P.S.M for specific application advice.

MINI-TECH[®] INSERTS

TECHNICAL DATA

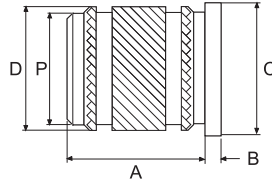
INSERTS

PRODUCT [MTEC]



HEADED

PRODUCT [HMTEC]



STANDARD MATERIAL: BRASS (B)
Other materials possible on quotation

DIMENSIONS

ISO METRIC

Unit: Millimetres

Thread Size	Insert Length A	Preferred Other Length A*			Head Height B	Head Ø C	Insert Ø D	Pilot End Ø P	Rec.Hole Size -0.00 +0.10	Min. Wall Thickness
M1	2.5	-	-	-	-	-	2.10	1.70	1.75	0.70
M1.2	2.5	-	-	-	-	-	2.10	1.70	1.75	0.70
M1.4	3.0	-	-	-	0.40	3.0	2.50	2.10	2.15	0.80
M1.6	3.0	2.5	2.2	2.0	0.40	3.0	2.50	2.10	2.15	0.80
M2	3.0	-	-	-	0.40	3.5	3.00	2.60	2.65	0.80
M2.5	4.0	-	-	-	0.40	4.0	3.65	3.15	3.20	1.00

Other lengths possible on quotation.

HOW TO SPECIFY

	MTEC	HMTEC
Product Code	MTEC-B-M1.6	HMTEC-B-M1.6
Material Code	MTEC- B -M1.6	HMTEC- B -M1.6
Thread Size	MTEC-B- M1.6	HMTEC-B- M1.6
Preferred other length	MTEC-B-M1.6- 2.2	HMTEC-B-M1.6- 2.2