

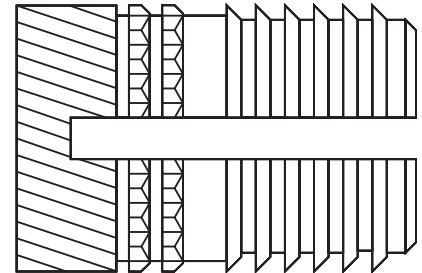
PRESS-LOK[®] INSERTS

OFFERS EASE OF INSTALLATION WITHOUT THE
TYPICAL HIGH SCREW INSTTORQUE.



PRESS-LOK[®] INSERTS

Offers ease of installation without the typical high screw insttorque and its plain and knurled vanes offer the levels of pull-out and torque resistance usually expected only of heat-installed inserts.



ADVANTAGES

- Degree of self locking action on screw
- High pull-out and torque performance
- Easy press-in insertion
- Suitable for most thermoplastics

DESIGN GUIDE

HOLE PREPARATION

Molded holes are recommended wherever possible. The taper on a molded hole should be 1° inclusive and the hole diameter recommended should apply at the point reached by the bottom of the insert. Drilled holes may be used but performance may be reduced when compared with a molded hole. The top of the hole should not be chamfered or counterbored and care must be taken to avoid bell mouching. Hole diameter tolerance: -0.00 +0.10mm.

DIRECTION OF LOADING

The fixing screw must always be assembled from the knurled end of the component to develop the necessary expansion action.

INFLUENCE OF SCREW DIMENSIONS

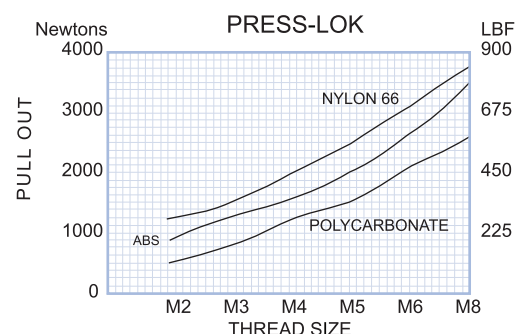
It is important that the fixing screw fully penetrates the insert in order to achieve full expansion, screw length should therefore be calculated to ensure that this condition is met before final clamp torque is applied.

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. The chart gives a general guide and shows the relative performance of the insert in the range.



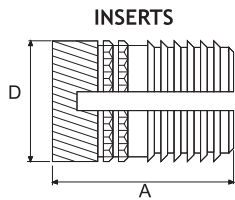
PRESS-LOK[®] INSERTS

TECHNICAL DATA

INSERTS

PRODUCT CODE [PLK]

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



DIMENSIONS

ISO METRIC

Unit: Millimetres

Thread Size	Insert Length A	Preferred Other Length A*		Insert Ø D	Rec.Hole Size -0.00 +0.10	Min. Wall Thickness
M2	4.0	-	-	3.7	3.2	1.6
M2.5	5.8	4.0	-	4.5	4.0	2.0
M3	5.8	4.0	-	4.5	4.0	2.0
M3.5	7.2	4.0	-	5.3	4.8	2.4
M4	8.2	5.8	-	6.2	5.6	2.8
M5	9.5	5.8	8.2	6.9	6.4	3.2
M6	12.7	7.2	9.5	8.5	8.0	4.0
M8	12.7	-	-	10.1	9.6	4.8

Other lengths possible on quotation.

UNIFIED

Unit: Inches

Thread Size	Insert Length A	Preferred Other Length A*		Insert Ø D	Rec.Hole Size -0.000 +0.004	Min. Wall Thickness
2-56	.157	-	-	.146	.126	.063
4-40	.228	.157	-	.177	.157	.079
6-32	.283	.157	-	.209	.189	.094
8-32	.323	.228	-	.242	.220	.110
10-24	.374	.228	.322	.272	.252	.126
10-32	.374	.228	.322	.272	.252	.126
1/4-20	.500	.283	.374	.335	.315	.157
1/4-28	.500	.283	.374	.335	.315	.157
5/16-18	.500	-	-	.398	.378	.189
5/16-24	.500	-	-	.398	.378	.189

Other lengths possible on quotation.

HOW TO SPECIFY

Product Code	PLK-B-M3
Material Code	PLK- B -M3
Thread Size	PLK-B- M3
Preferred Other Length	PLK-B-M3- 4.0