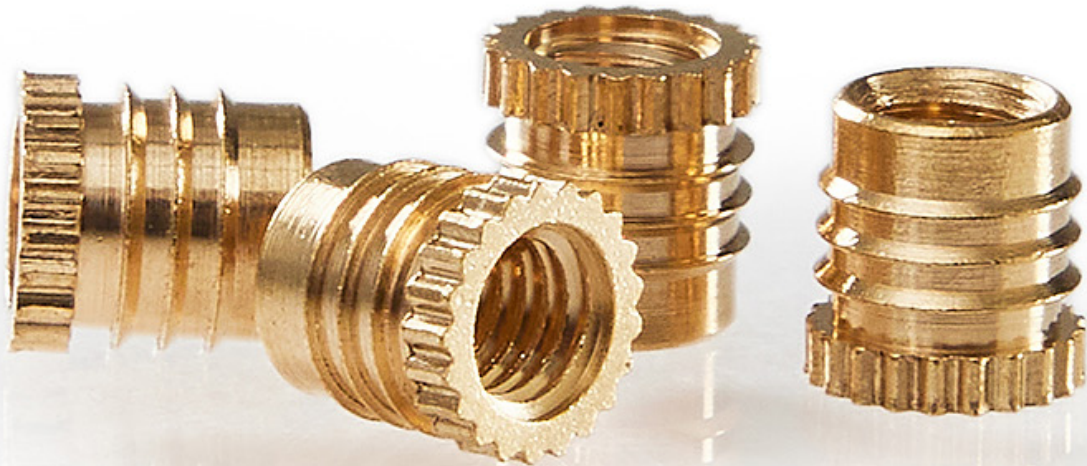


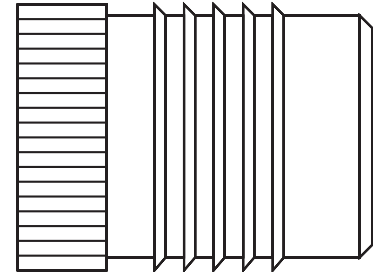
FIN-LOK[®] INSERTS & STUDS

A PRESS-IN INSERT, WHICH CAN BE EASILY INSTALLED
INTO MOST THERMOPLASTIC MATERIALS.



FIN-LOK[®] INSERTS & STUDS

A press-in insert, which can be easily installed into most thermoplastic materials. It features a combination of sharp fins and straight knurls. Unlike the Press-Lok range, this insert has a free running thread.



ADVANTAGES

- Easy press-in insertion
- High pull-out performance in most thermoplastics
- Self-aligning - assists installation

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. The top of the hole should not be chamfered or counterbored and care must be taken to avoid bell mousing. Hole diameter tolerance: -0.00 +0.10mm.

INSTALLATION

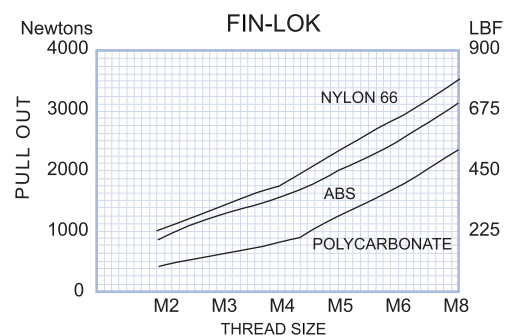
The inserts must be installed using a steady squeeze action press. A hammer blow type installation will prevent plastic flow and may damage the boss.

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

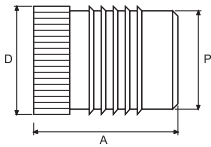
The complexity of materials and variations in service conditions make it impossible to detail fastener performance for specific applications. The chart gives a general guide and shows the relative performance of the insert in the range.



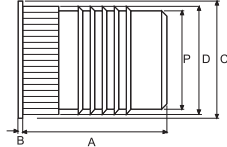
FIN-LOK[®] INSERTS & STUDS

TECHNICAL DATA

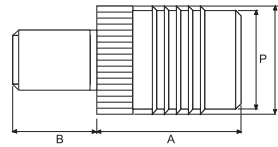
INSERTS
PRODUCT CODE [FL]



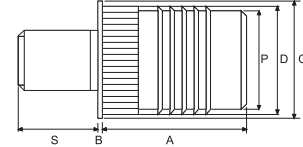
HEADED INSERTS
PRODUCT CODE [FLH]



STUDS
PRODUCT CODE [FLTS]



HEADED STUD
PRODUCT CODE [FLHS]



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

DIMENSIONS

ISO METRIC

Unit: Millimetres

Thread Size	Insert Length A	Stud Lengths (For FLTS & FLHS only)										Head Height B	Head Ø C	Insert Ø D	Pilot End Ø P	No. of Fins	Rec.Hole Size -0.00 +0.10	Min. Wall Thickness
		S																
M2	4.0	5	6	8	10	12	14	16	18	20	25	0.45	4.8	3.7	3.1	2	3.2	1.6
M2.5	4.8	5	6	8	10	12	14	16	18	20	25	0.58	5.5	4.5	3.9	3	4.0	2.0
M3	4.8	5	6	8	10	12	14	16	18	20	25	0.58	5.5	4.5	3.9	3	4.0	2.0
M3.5	6.4	5	6	8	10	12	14	16	18	20	25	0.74	6.4	5.3	4.7	4	4.8	2.4
M4	7.9	5	6	8	10	12	14	16	18	20	25	0.89	7.1	6.1	5.5	5	5.6	2.8
M5	9.5	5	6	8	10	12	14	16	18	20	25	1.07	7.9	7.0	6.3	5	6.4	3.2
M6	12.7	5	6	8	10	12	14	16	18	20	25	1.32	9.5	8.6	7.9	7	8.0	4.0
M8	12.7	5	6	8	10	12	14	16	18	20	25	1.32	11.1	10.2	9.5	7	9.6	4.8

Other lengths possible on quotation.

UNIFIED

Unit: Inches

Thread Size	Insert Length A	Stud Lengths (For FLTS & FLHS only)										Head Height B	Head Ø C	Insert Ø D	Pilot End Ø P	No. of Fins	Rec.Hole Size -0.000 +0.004	Min. Wall Thickness
		S																
2-56	.157	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	.018	.189	.147	.123	2	.126	.063
4-40	.187	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	.023	.217	.178	.154	3	.157	.079
6-32	.250	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	.029	.250	.209	.185	4	.189	.094
8-32	.312	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	.035	.281	.240	.218	5	.220	.110
10-24	.375	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	.042	.312	.274	.248	5	.252	.126
10-32	.375	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	.042	.312	.274	.248	5	.252	.128
1/4-20	.500	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	.052	.375	.337	.310	7	.315	.157
1/4-28	.500	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	.052	.375	.337	.310	7	.315	.157
5/16-18	.500	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	.052	.433	.400	.375	7	.378	.189
5/16-24	.500	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	.052	.433	.400	.375	7	.378	.189

Other lengths possible on quotation.

HOW TO SPECIFY

	FL	FLHS	FLTS	FLHS
Product Code	FL-B-M3	FLHS-B-M3	FLTS-B-M3-5.0	FLHS-B-M3-5.0
Material Code	FL-B-M3	FLHS-B-M3	FLTS-B-M3-5.0	FLHS-B-M3-5.0
Thread Size	FL-B-M3	FLHS-B-M3	FLTS-B-M3-5.0	FLHS-B-M3-5.0
Stud length			FLTS-B-M3-5.0	FLHS-B-M3-5.0