

# HEAT AND ULTRASONIC INSERTS

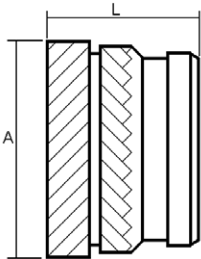


Heat and ultrasonic inserts are designed for use in thermoplastic materials. The insert is either pre-heated or uses heat generated by ultrasonic vibration to soften the walls of the hole as it is pressed into position. The softened plastic flows into the knurls and undercuts to lock the insert into place.

This method of insertion is ideal for high volume applications where suitable insertion equipment is available.

## SERIES 01

The Series 01 brass inserts are designed for heat or ultrasonic insertion into parallel holes. This series, which is available in two standard lengths, combine diagonal knurls and undercuts to achieve the optimum balance of resistance to pull-out and torque loads.

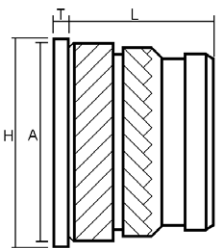


Nominal Thread Size	M2	M2.5	M3	M3.5	M4	M5	M6	M8
External Thread Size	3.6	4.6	4.6	5.43	6.3	7.06	8.66	10.23
Length in mm								
Short		4.00	4.00	4.00	4.80	5.80	7.00	
Long	4	5.74	5.74	7.14	8.15	9.53	12.70	12.70
Recommended Min	3.20	4.00	4.00	4.80	5.60	6.40	8.06	9.60
Hole Size Max	3.30	4.10	4.10	4.90	5.70	6.50	8.10	9.70

## SERIES 02

These are headed inserts in brass, for heat or ultrasonic insertion into parallel holes. They are the headed version of Series 01. They can be used in two ways:

- To provide an electrical contact face (in which case a countersink will normally be needed)
- To be inserted from the back of the moulding to achieve a much higher pull-out strength.



Nominal Thread Size	M2	M2.5	M3	M3.5	M4	M5	M6	M8
External Diameter 'A'	3.6	4.6	4.6	5.43	6.3	7.06	8.66	10.23
Head Diameter 'H'	4.75	5.54	5.54	6.35	7.14	7.92	9.52	11.10
Head Thickness 'T'	0.53	0.61	0.61	0.76	0.91	1.10	1.35	1.35
Length in mm								
Short		4.00	3.50	4.00	6.00	6.00	7.00	
Long	4	5.74	5.75	7.14	8.11	9.52	12.70	12.70
Recommended Min	3.20	4.00	4.00	4.80	5.60	6.40	8.00	9.60
Hole Size Max	3.30	4.10	4.10	4.90	5.70	6.50	8.10	9.70