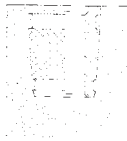




The advantages

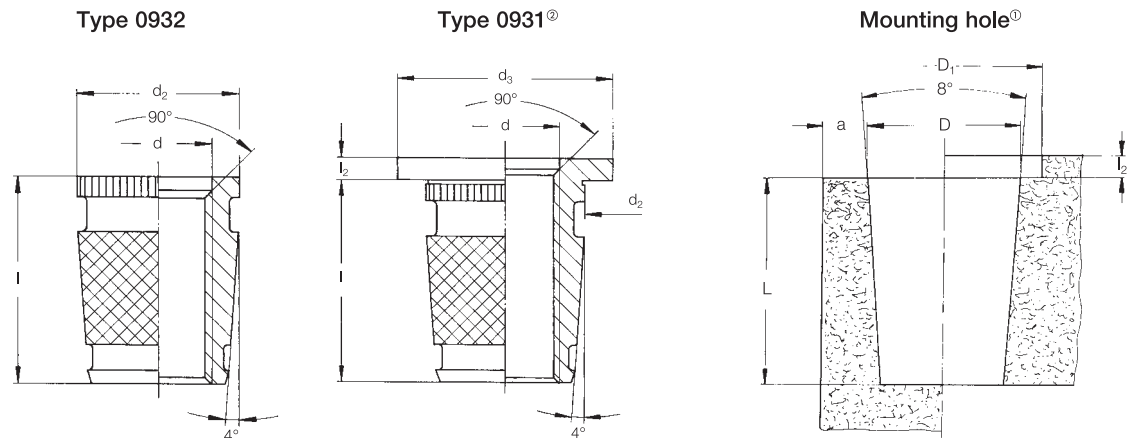
- Ideal for thermoplastic parts
 - Especially designed for thermal installation
 - Screw-locked and low-tension anchoring
 - High pull-out values
 - Efficient installation due to single-spindle, multiple-spindle or automatic machines with preheating device
- Material: Cu Zn 38 Pb 2 (EU 2000/53 compliant)

Principle



The HITsert® 2 thread insert is heated to the melting temperature of the plastic. As a result of the heat transfer upon insertion, the plastic is plasticised for a short time and flows into the undercut of the thread insert. Upon cooling, a low-stress interference is realised.

Technical data



For installation tools and machines, see pages 16 – 18

d	Type 0932 Order No	Type 0931 [®] Order No	l	l ₂	d ₂	d ₃	D ^{+0.1}	D ₁	L _{min.}	a _{min.}
M 2	0932 102 0005	0931 102 0056	5.0	0.6	4.1	5.0	3.8	5.2	6.0	1.5
M 2.5	0932 125 0005	0931 125 0056	5.0	0.6	4.1	6.0	3.8	6.2	6.0	1.5
M 3	0932 103 0005	–	5.0	–	4.7	–	4.4	6.2	6.0	1.8
M 3	0932 103 0055	0931 103 0061	5.5	0.6	4.7	6.0	4.4	6.2	6.5	1.8
M 3.5	0932 135 0006	0931 135 0068	6.0	0.8	5.5	7.0	5.2	7.2	7.0	1.8
M 4	0932 104 0006	–	6.0	–	5.9	–	5.8	8.2	7.0	2.0
M 4	0932 104 0075	0931 104 0083	7.5	0.8	5.9	8.0	5.8	8.2	8.5	2.0
M 5	0932 105 0007	–	7.0	–	7.0	–	6.9	8.7	8.0	2.0
M 5	0932 105 0009	0931 105 0010	9.0	1.0	7.0	8.5	6.9	8.7	10.0	2.5
M 6	0932 106 0009	–	9.0	–	8.6	–	8.5	10.2	10.0	2.5
M 6	0932 106 0010	0931 106 0011	10.0	1.0	8.6	10.0	8.5	10.2	11.0	2.5
M 8	0932 108 0012	0931 108 0013	12.0	1.0	11.1	12.0	10.9	12.2	13.0	3.0

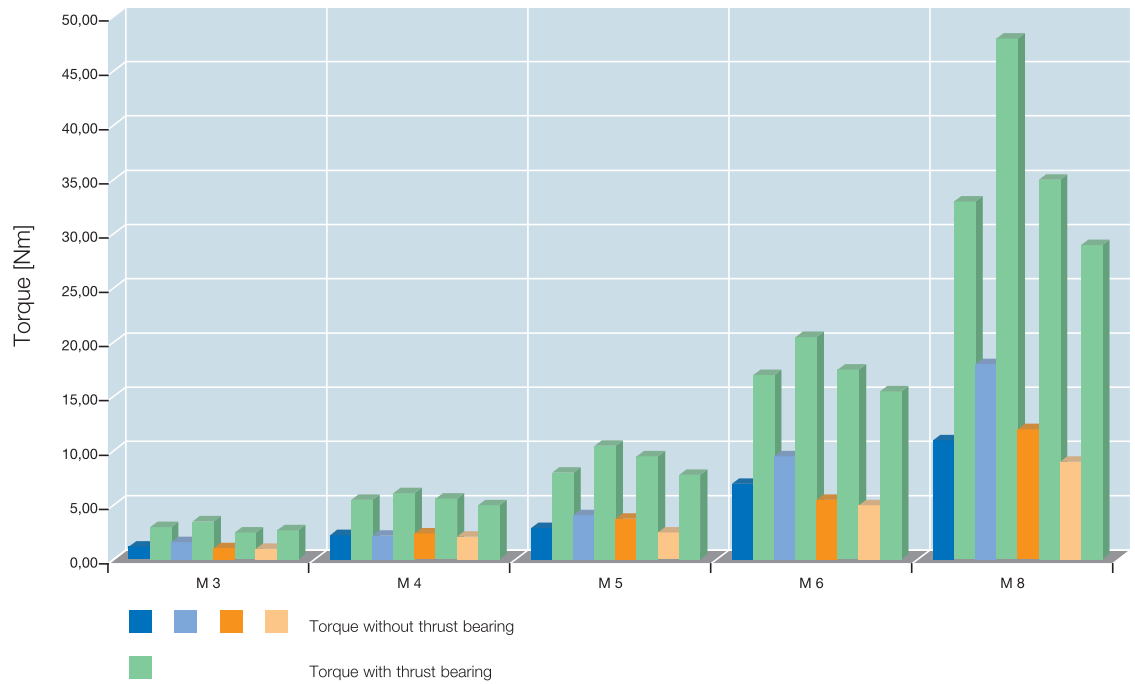
Metric ISO thread according to DIN 13-6H.
Technical modifications reserved.
All dimensions in mm.

[®] Guide values: depend on moulding material, may have to be changed after setting trials.
[®] The flange has a large contact surface and thus reduces surface pressure.
Minimum quantity on request.

Other sizes, special designs and materials on request.

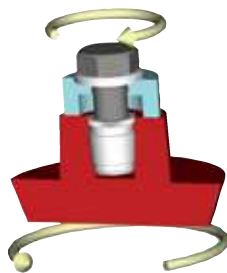
Technical data

Torque values HITSERT® M 3 to M 8

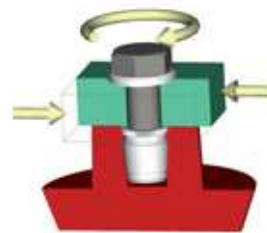


		M 3	M 4	M 5	M 6	M 8
■ ABS	MA [Nm]	1.20	2.25	2.90	7.00	11.00
■ ABS	MR [Nm]	3.00	5.50	8.00	17.00	33.00
■ PC	MA [Nm]	1.60	2.20	4.10	9.50	18.00
■ PC	MR [Nm]	3.50	6.10	10.50	20.50	48.00
■ PA	MA [Nm]	1.05	2.40	3.75	5.50	12.00
■ PA	MR [Nm]	2.50	5.60	9.50	17.50	35.00
■ PE/PP	MA [Nm]	1.00	2.10	2.50	5.00	9.00
■ PE/PP	MR [Nm]	2.70	5.00	7.80	15.50	29.00

All dimensions in mm.



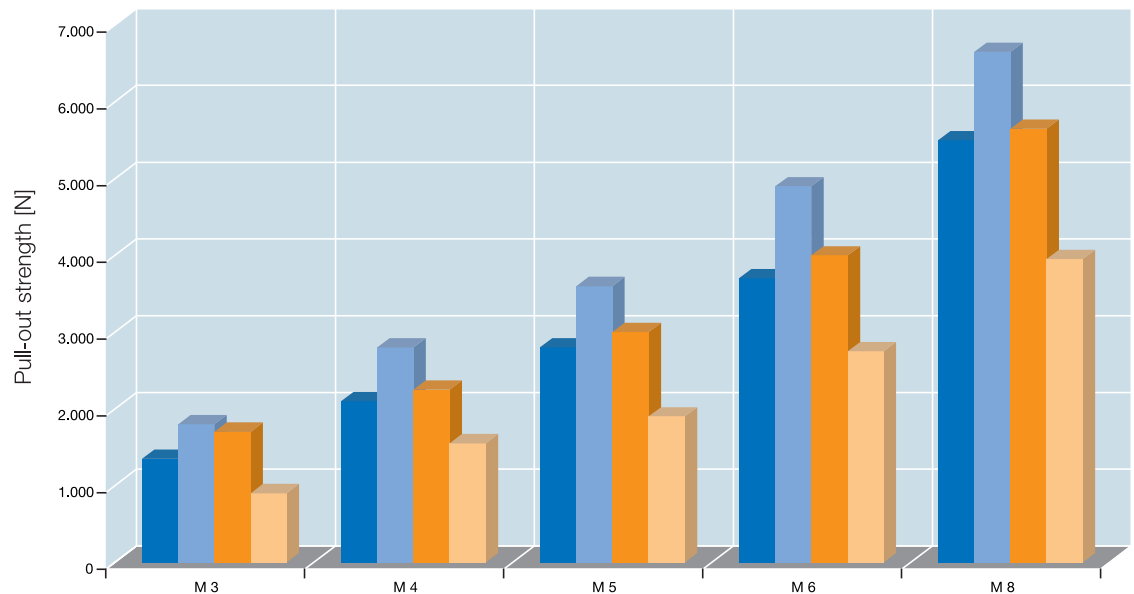
Torque without thrust bearing (MA[Nm])
(jack out)



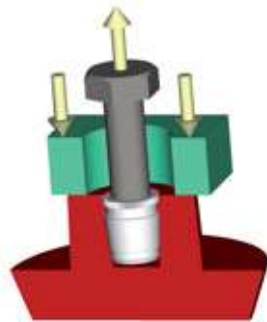
Torque with thrust bearing (MR[Nm])

Technical data

Pull-out values HITSERT® M 3 to M 8



	M 3	M 4	M 5	M 6	M 8
■ ABS FA [N]	1,350	2,100	2,800	3,700	5,500
■ PC FA [N]	1,800	2,800	3,600	4,900	6,650
■ PA FA [N]	1,700	2,250	3,000	4,000	5,650
■ PE/PP FA [N]	900	1,550	1,900	2,750	3,950



Pull-out strength (FA[N])

Technical notes

Indicated values are guide values. We recommend an installation test for the respective application. To be on the safe side, for fibre-reinforced plastics, the strengths of the non-reinforced material should be assumed. If you use brass thread inserts in plastics susceptible to stress cracks (e.g. polycarbonate), we recommend additional surface treatment of the thread inserts (nickel plating or surface coating as required). Strength values for other thread inserts on request.