





**MINI TECH** is 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. A headed version is also available.

## 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

Moulded holes are recommended wherever possible. The taper on a moulded 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 mousing. 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 and ensure optimum performance. 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 data table but this will vary depending upon the nature of the plastic. Where thinner walls are required these can often be accommodated, but consultation with P.S.M Technology Centre or local Sales Office and pre-production testing is strongly advised.

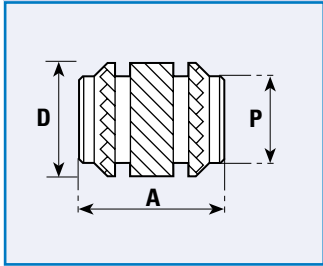
### PERFORMANCE DATA

The complexity of materials and variations in service conditions make it impossible to detail fastener performance for specific applications. The charts on page 28 give a general guide.

# TECHNICAL DATA

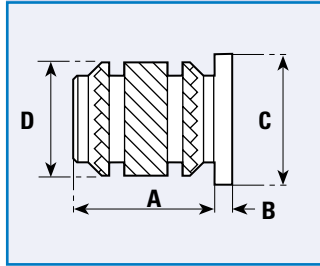
# MINI-TECH

## INSERTS



Product Code MTEC

## HEADED INSERTS



Product Code MTH

**STANDARD MATERIAL** - Brass (B) - Other materials possible on quotation

## DIMENSIONS

INTERNAL THREAD SIZES	A	B	C	D	P	Rec. Hole Size		Min. Wall Thickness
						-0.00	+0.05	
ISO Metric	mm	mm	mm	mm	mm	mm	mm	mm
1.4	3.0	0.40	3.00	2.50	2.10	2.15	0.80	
1.6	3.0	0.40	3.00	2.50	2.10	2.15	0.80	
2.0	3.0	0.40	3.50	3.00	2.60	2.65	0.80	
2.5	4.0	0.40	4.00	3.65	3.15	3.20	1.00	

MINI-TECH™ INSERTS

## HOW TO SPECIFY

### INSERTS

PRODUCT CODE	MTEC-B-M1.2
MATERIAL	MTEC-B-M1.2
THREAD SIZE	MTEC-B-M1.2

### HEADED INSERTS

PRODUCT CODE	MTH-B-M1.2
MATERIAL	MTH-B-M1.2
THREAD SIZE	MTH-B-M1.2