






PRESS-LOK is a *press-in expansion insert designed for use in thermoplastic mouldings.*

It has been developed to give the ease of installation associated with this type of fastener but without the high screw installation torque which has previously been typical.

The incorporation of plain and knurled vanes gives levels of pull-out and torque resistance usually expected from heat installed inserts.

ADVANTAGES

-  DEGREE OF SELF LOCKING ACTION ON SCREW
-  HIGH PULL-OUT AND TORQUE PERFORMANCE
-  EASY PRESS-IN INSERTION
-  LOW SCREW INSTALLATION TORQUE
-  SUITABLE FOR MOST THERMOPLASTICS



DESIGN GUIDE

HOLE PREPARATION

Moulded holes are recommended wherever possible. The taper on a moulded 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 moulded hole. The top of the hole should not be chamfered or counterbored and care must be taken to avoid bell mouthing. 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.

JOINT DESIGN

Joints should be designed to eliminate jack-out conditions wherever possible. If in any doubt please contact your PSM Sales Engineer or the PSM Technology Centre for advice.

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 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 the P.S.M Technology Centre or local Sales Office and pre-production testing is strongly advised.

LOWER SCREW INSTALLATION TORQUE

Where service conditions dictate lower screw installation torque, this can often be achieved by increasing the hole size. This will affect fastener performance and prior consultation with your PSM Sales Engineer, or PSM Technology Centre, is recommended.

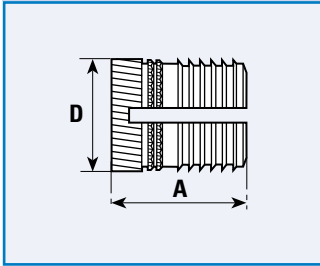
Note: Expansion type inserts are not recommended for use in notch sensitive plastics.

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.

Note: Press-Lok has a low friction surface treatment and should not be subjected to any cleaning process prior to use.

INSERTS



Product Code PLK

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

DIMENSIONS

INTERNAL THREAD SIZES		A	A*	D	Rec. Hole Size	Min. Wall Thickness
Unified	ISO Metric	mm	mm	mm	-0.00 +0.10	mm
2	2	4.0	-	3.7	3.2	1.6
-	2.5	5.8	4.0	4.5	4.0	2.0
4	3	5.8	4.0	4.5	4.0	2.0
6	3.5	7.2	4.0	5.3	4.8	2.4
8	4	8.2	5.8	6.2	5.6	2.8
10	5	9.5	5.8/8.2	6.9	6.4	3.2
1/4	6	12.7	7.2/9.5	8.5	8.0	4.0
5/16	8	12.7	-	10.1	9.6	4.8

A* - Preferred shorter lengths
Other lengths possible on quotation.

HOW TO SPECIFY

INSERTS

PRODUCT CODE	PLK-B-M3
MATERIAL	PLK-B-M3
THREAD SIZE	PLK-B-M3
LENGTH (if applicable)	PLK-B-M3-4.0

NOTE:

*It is not necessary to specify a length where a standard insert is required.
If the application requires a shorter than standard insert they may be selected from the table above (A*).*

PRESS-LOK™ INSERTS

