

INSERTS

FOR

PLASTICS

塑膠專用螺母

Wherever you are...

we have the solution!

ADVANTAGES

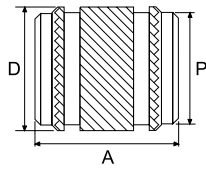
- Re-usable threads for miniature applications
- Eliminates thread stripping problems
- Double ended - assists automatic feeding
- Permits space-saving boss design

特點

- 針對迷你型產品設計。
- 可防止螺牙滑牙。
- 外型無方向性，方便自動送料加工。
- 可節省塑膠肉厚空間的設計。

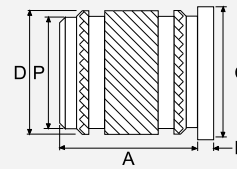
SELECTION OF INSERT OR STUD

INSERTS



PRODUCT [MTEC]
型號

HEADED



PRODUCT [HMTEC]
型號

ISO METRIC (公制)



Unit: Millimetres

Product Code 型	Thread Size 螺牙	Insert Length A 標準長度	Preferred Other Length A* 特殊長度			Head Height B 頭厚	Head ∅ C 頭外徑	Insert ∅ D 外徑	Pilot End ∅ P 圓頭	Rec. Hole Size -0.00 +0.10 孔直徑	Min. Wall Thickness 最少肉厚
MTEC-B HMTEC-B	M1	2.5	-	-	-	-	-	2.10	1.70	1.75	0.70
	M1.2	2.5	-	-	-	-	-	2.10	1.70	1.75	0.70
	M1.4	3.0	-	-	-	0.40	3.0	2.50	2.10	2.15	0.80
	M1.6	3.0	2.5	2.2	2.0	0.40	3.0	2.50	2.10	2.15	0.80
	M2	3.0	-	-	-	0.40	3.5	3.00	2.60	2.65	0.80
	M2.5	4.0	-	-	-	0.40	4.0	3.65	3.15	3.20	1.00

Other lengths possible on quotation. 其它長度也可估價。

STANDARD MATERIAL: BRASS (B) 標準材質: 黃銅 (B)
Other materials possible on quotation 其它長度也可估價。

SPECIFYING AN INSERT

INSERTS (METRIC)							
	MTEC	-	B	-	M1.6	x	2.0
	PRODUCT CODE		MATERIAL		THREAD SIZE		PREFERRED OTHER LENGTH
	型號		材質		螺牙		特殊長度
	HMTEC	-	B	-	M1.6	x	2.5

BOSS DESIGN SPECIFICATION

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 mouting. 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. 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 the 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. Please consults P.S.M Technology Centre or local sales offices for specific application advice.

塑膠孔徑之設計

1. 螺母規格之塑膠孔徑建議值，請參考規格表。
2. 塑膠成型後，內孔徑之脫模斜度應於 0.5 度以內。
3. 塑膠內孔徑公差值請設於 0.00+0.05mm 的範圍。
4. 塑膠內孔上方，可不必設計導角。

裝置

1. 適用於射出成型或熱熔加工。
2. 射出成型埋入時，請特別注意模具中套筒尺寸，以方便螺母置入模具中。
3. 套筒尺寸公差值請參閱建議值或洽 P.S.M 技術人員。
4. 熱熔加工時，溫度須低母材熔點 10-20 度。
5. 熱熔加工所須之壓力、時間及速度、須視塑膠材質及螺母大小而調整。

塑膠孔肉厚

1. 建議肉厚，請參考規格表。
2. 肉厚可視不同塑膠材質，而略作調整，但請先與 P.S.M 技術人員聯系，必要時我們將協助測試及作最適當之建議。

測試數據

1. P.S.M 為服務客戶，非常歡迎客戶委托代作測試，我們將提供完整及詳盡之測試報告及必要之建議。