

B-Lok[®] self-locking threaded insert

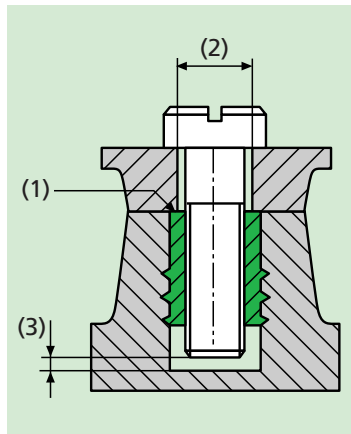


Fig. 18

The B-Lok[®] is a threaded insert with different external profiles, which guarantee optimum anchorage in all types of moulded plastic components.

Product features

- Unbeatably short installation times
- Screw is secured automatically against loosening.
- Cost savings for locking elements.

Design of the moulded component and receiving hole

The part requiring fastening should be flush with the threaded insert, see (1, fig. 18). For this reason, **the bore-hole (2) should be closely dimensioned and not countersunk.** The B-Lok[®] press in flush into the formed part (1).

The screw length must be selected so that the B-Lok[®] is completely expanded

Hole diameter and wall thicknesses are dependent on the material used for the formed part. Please enquire or ascertain by testing. For guideline values, see the Works Standard sheets. Conicity 0,5° to max. 1°.

For B-Lok[®], we recommend the smallest possible hole diameter in which it is still possible to reliably insert the screw. Although a larger hole means that the screw is less stiff running, at the same time reduces pull-out resistance and torque safety.

Hole depth. This should be overdimensioned if possible. The screw must not under any circumstances come to rest at the bottom of the hole, see (3).

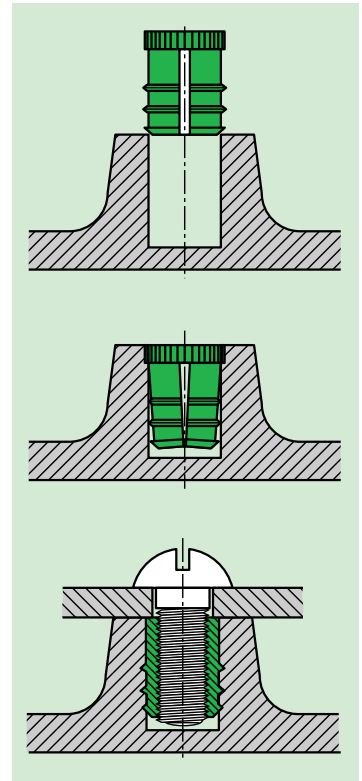


Fig. 19

Installation

1. The B-Lok[®] is pressed into the receiving hole, during which process the segments bend inwards (fig. 19).
2. When inserting the screw, the segments resume their original shape, in which process the external profile becomes anchored in the hole wall. The residual tension acts to lock the screw in place (fig. 19).

In the case of small-scale series, the B-Lok[®] is embedded with a simple manual levering device (possibly a small press or drill at a standstill).

For large series: Single or multiple installation machines on request.

We recommend practical testing.

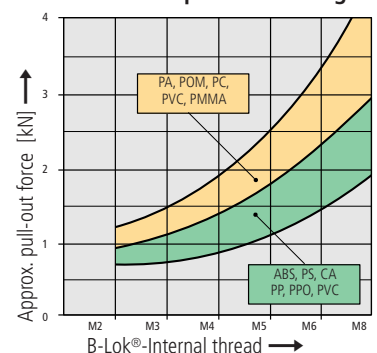


Fig. 21

Selection of the correct B-Lok[®]-type:

Material	B-Lok [®]	Works Standard	Page
Thermoset plastic	-MV or -E	812/815, 830/831	25, 26
Duroplastic	-R	841	27
PU/PUR-foam	-R, -MV or -E	841, 812/815 830/831	27, 25, 26
Wood	-F or -E	821/823, 830/831	26
Through holes in laminate materials or side walls	-RK	842	27

Fig. 20

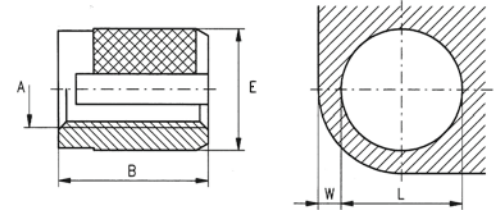


Expansion inserts
self-locking

B-Lok®-R
Works Standard
841

Application

For creation of wear and vibration-resistant screw fastenings with high load capacity in plastic, preferably duroplastics.



Dimensions in mm

Article number	Internal thread	External diameter	Length	Minimum wall thickness	Hole diameter (guideline values)
	A	E	B	W	L +0,1
841 000 020.800	M 2	3,55	4,0	2,4	3,2
841 000 025.800	M 2,5	4,3	4,8	3,2	4,0
841 000 030.800	M 3	4,3	4,8	3,2	4,0
841 000 035.800	M 3,5	5,1	6,4	3,6	4,7
841 000 040.800	M 4	6,0	8,0	4,0	5,5
841 000 050.800	M 5	6,8	9,5	4,8	6,3
841 000 060.800	M 6	8,4	12,7	6,0	7,9
841 000 080.800	M 8	9,9	12,7	7,0	9,5

Example for finding the article number

Self-locking threaded insert B-Lok®-R to Works Standard 841 0 with internal thread M5 and made of brass: B-Lok®-R 841 000 050.800

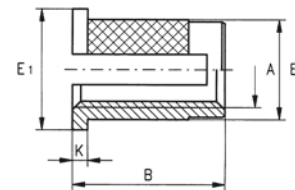


Expansion inserts
self-locking

B-Lok®-RK
Works Standard
842

Application

With additional countering head, used in through holes in laminates and housing walls.



Dimensions in mm

Article number	Internal thread	External diameter	Length	Head dia.	Head height	Minimum wall thickness	Hole diameter (guideline values)
	A	E	B	E ₁	K	W	L +0,1
842 000 020.800	M 2	3,55	4,0	4,8	0,6	2,4	3,2
842 000 025.800	M 2,5	4,3	4,8	5,6	0,6	2,8	4,0
842 000 030.800	M 3	4,3	4,8	5,6	0,6	3,2	4,0
842 000 035.800	M 3,5	5,1	6,4	6,4	0,8	3,6	4,7
842 000 040.800	M 4	6,0	8,0	7,2	0,8	4,0	5,5
842 000 050.800	M 5	6,8	9,5	8,0	1,0	4,8	6,3
842 000 060.800	M 6	8,4	12,7	9,5	1,3	6,0	7,9
842 000 080.800	M 8	9,9	12,7	11,0	1,3	6,0	9,5

Example for finding the article number

Self-locking threaded insert B-Lok®-RK to Works Standard 842 0 with internal thread M5 and made of brass: B-Lok®-RK 842 000 050.800

Materials

Brass

Article no. (**fourth** group of digits) 800

Tolerances

ISO 2768-m

Thread

Internal thread A: as per ISO 6H