

Hapare Threaded Inserts

Self Tapping Threaded Inserts



PERMANENT THREAD FOR BASE MATERIALS

- MILD STEEL
- ALUMINIUM
- CAST IRON
- PLASTIC
- BRASS
- WOOD
- LIGHT ALLOY

Available in Materials

- STEEL HARDENED
- STAINLESS STEEL
- BRASS

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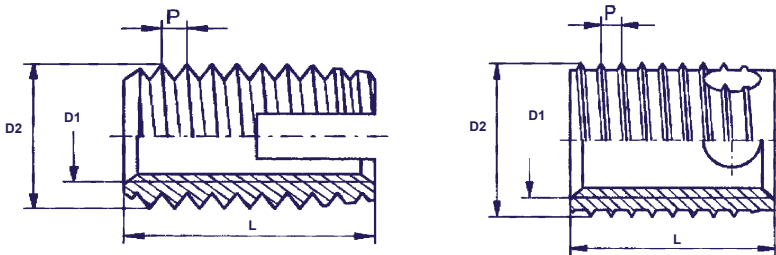
- ❖ Specially designed to cut their own threads as they are being driven into a drilled hole. The thread cutting action is performed by the cutting slots or holes on the insert.
- ❖ Ideal for thread reinforcement, especially when the mating stud or bolt will be removed frequently. They provide strong, permanent steel threads in a weaker parent material — ferrous, non-ferrous, or non-metallic. Hapare Self Tapping Threaded Inserts are also well suited for quick repair of stripped, damaged, or worn threads.
- ❖ Installation is simple and quick, using only one tool, which lowers installation cost. By tapping its own thread, the self tapping insert eliminates the need for base material to have pre-tapping. Unlike coil inserts, which require a special tap and installation tool, Hapare Self Tapping Threaded Inserts for metal are installed using standard tools. Simply drill the appropriately sized hole with a standard drill and turn in the Hapare Self Tapping Threaded Inserts like an ordinary fastener with a Hapare installation tool.
 - Solid, one-piece threaded insert construction provides a high degree of pull-out strength
 - Provide a positive mechanical lock which prevents rotation due to vibration or torsion
 - Easy threaded insert installation and removal
 - Installed with standard drills and taps
 - No pre-winder tool required
 - No tang to break off
 - Full range of Inch and Metric sizes in coarse or fine pitch threads
 - Industrial Style Threaded inserts can be purchased in bulk quantities or kits
 - These inserts are also available as per leading Aerospace & Defence specifications (MS/NAS Style)

***Thread repair kit containing 100 Nos. Inserts size M3 to M16 are available**



TECHNICAL SHEET

Self Tapping Threaded Inserts



Internal Thread D1 (mm)	External Thread D2 (mm)	Length L (mm)	Appro. Hole Size (for reference only)	Ordering No. (Slotted Type)	Ordering No. (3Hole Type)
M3	5	6	4,2 to 4,4	A030M	AH030M
M4	7	8	6,2 to 6,4	A040M	AH040M
M5	8	10	7,2 to 7,4	A050M	AH050M
M6	10	14	9,2 to 9,4	A060M	AH060M
M8	12	15	11,2 to 11,4	A080M	AH080M
M10	14	18	13,2 to 13,4	A100M	AH100M
M12	16	22	15,2 to 15,4	A120M	AH120M
M14	18	24	17,2 to 17,4	A140M	AH140M
M16	20	22	19,2 to 19,4	A160M	AH160M
M18	22	24	21,2 to 21,4	A180M	AH180M
M20	26	27	25,2 to 25,4	A200M	AH200M
M22	26	30	25,2 to 25,4	A220M	AH220M
M24	30	30	29,2 to 29,4	A240M	AH240M
M27	34	30	33,2 to 33,4	A270M	AH270M
M30	36	40	35,2 to 35,4	A300M	AH300M

TYP A = SLOTTED AH = 3 HOLE	MATERIAL: M = Steel hardened B = Brass S = Stainless Steel	HOLE DEPTH: Blanck = 1,2 x Insert Length (Minimum) Through = Insert Length + 1 mm	Wall Thickness (Min.) C.L. = 0,4 x D2 METAL = 0,35 x D2 PLASTIC = 0,6 x D2
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- Material: Stainless Steel / Steel Hardened / Brass
- Tolerances: +/- 0.25mm unless sepecified otherwise
- BSW, BSF, UNC & UNF Thread Series Available
- Steel Hardened Coating: Zinc Yellow Plated / Backodising
- Thin & Thick wall thickness inserts also available
- We also manufacture Non-Standard inserts as per specifications/drawing

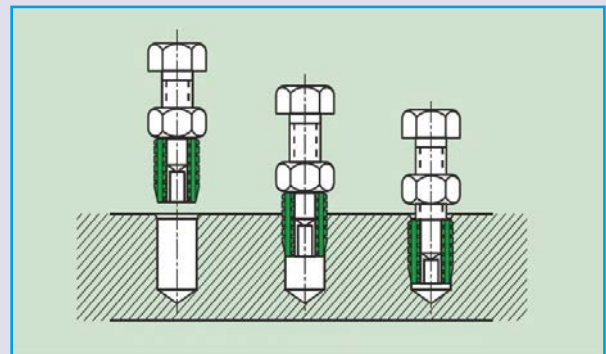
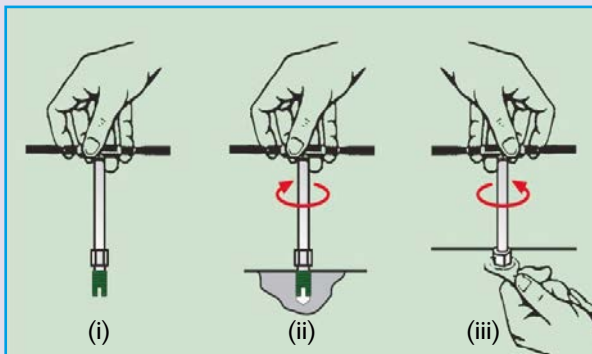


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Installation

1. From the thread size find the diameter of hole to be drilled in the base material as given in the technical sheet.
2. Hold the insert in the wrench and turn it in the hole as shown in (fig.ii)
3. Hold Hex nut with spanner to break lock. Unscrew the wrench leaving insert installed in base material (fig. iii)
4. In case of smaller size or hard base material 1st tap (out of 3) can be passed before installation of insert.



INSERTION (FITTING) TOOLS

Tool size confirms to internal of insert. Wrench type tools can be used by hand for small sizes and less quantity (Fig. a). In production assembly tools can be used (Fig. b).

