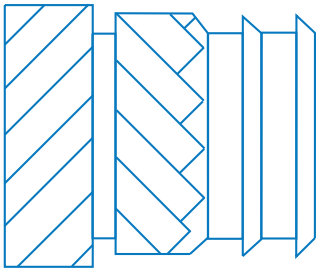
6030 INSERTS



Has been developed for installation into thermoplastics where the design incorporates a tapered hole configuration. The parallel body design combined with the opposing helical knurl bands enables users to achieve up to a 25% increase in productivity by the ability to reduce the recommended dwell time compared with standard tapered hole inserts.

ADVANTAGES

- INCREASED PRODUCTIVITY
- IMPROVED QUALITY
- ENSURE POSITIONAL ACCURACY
- HIGH TORQUE AND PULL-OUT
- AVOIDS FLASH ON NON-COUNTERSUNK HOLES

DESIGN GUIDE

HOLE PREPARATION

Molded holes are recommended wherever possible. The taper on the hole should be 8° inclusive and the hole diameter recommended applies at the top of the hole.

Where possible, chamfers and counterbores at the top of the hole should be avoided. If the existing design incorporates one of these features please contact PSM for application advice.

INSTALLATION

The fastener may be installed using either a pre-heating process or using heat generated by ultrasonic vibrations.

Where the pre-heating process is used, care must be exercised to ensure that the fastener softens but does not melt the plastic.

Ultrasonic installation is best carried out using low amplitude vibrations and the minimum power consistent with satisfactory softening of the plastic material.

WALL THICKNESS

A general guide to minimum wall thickness is given in the technical data table but this will vary dependant upon the nature of the plastic. Where thinner walls are required these can often be accommodated, but consultation with PSM and pre-production testing is strongly advised.

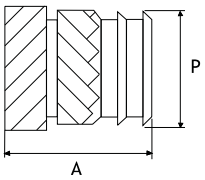
PERFORMANCE DATA

The complexity of materials and variations in service conditions make it impossible to detail fastener performance for specific applications, please contact P.S.M for specific application advice.

TECHNICAL DATA

STANDARD MATERIAL : BRASS (B)
Other materials possible on quotation

INSERTS



PRODUCT CODE [6030]

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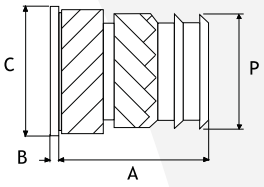
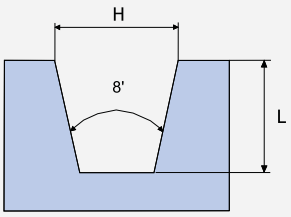


PRODUCT CODE [6030H]

HOLE CONFIGURATION



DIMENSIONS

METRIC

Unit: Millimetres

Thread Size	Insert Length A	Head Height B	Head Diamater C	Pilot End ⌀ P	Rec.Hole Size H -0.00 +0.10	Rec.Hole Size L	Min. Wall Thickness
M2	5.0	0.6	5.0	5.0	3.8	6.0	1.5
M3	5.5	0.6	6.0	6.0	4.4	6.5	1.8
M3.5	6.0	0.8	7.0	7.0	5.2	7.0	1.8
M4	7.5	0.8	8.0	8.0	5.8	8.5	2.0
M5	9.0	1.0	8.5	8.5	7.0	10.0	2.0
M6	10.0	1.0	10.0	10.0	8.5	11.0	2.5
M8	12.0	1.0	12.0	12.0	10.9	13.0	3.0

Other lengths possible on quotation.

HOW TO SPECIFY

	6030	6030H
PRODUCT CODE	6030-B-M3	6030H-B-M3
MATERIAL CODE	6030-B-M3	6030H-B-M3
THREAD SIZE	6030-B-M3	6030H-B-M3