B-Lok® self-locking threaded insert

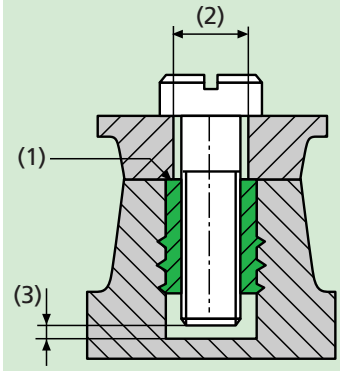


Fig. 18

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 borehole (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).

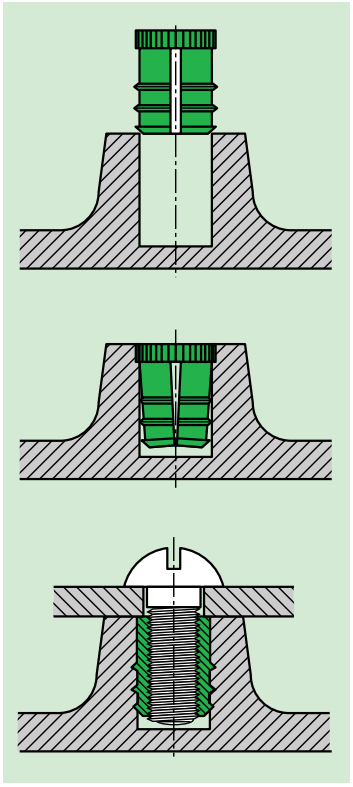


Fig. 19

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.

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

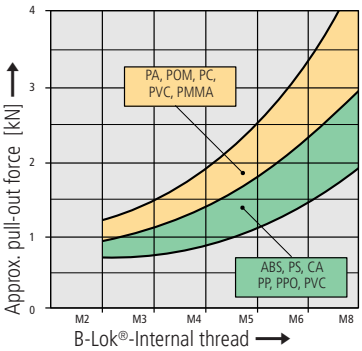


Fig. 21

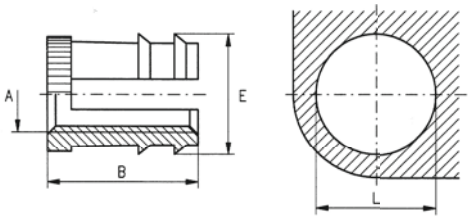
Kerb Konus

Expansion inserts
self-locking

B-Lok®-F
Works Standard
821 / 823

Application

For creation of wear and vibration-resistant screw fastenings with high load capacity in
– Soft plastic
– Wood / fibreboard
– Composite materials



Dimensions in mm

Article number	Internal thread A	Biggest external diameter E	Length B	Number of vanes	Hole diameter (guideline values) L +0,2
821 000 025.800	M 2,5	5,35	4,8	1	4,5
821 000 030.800	M 3	5,35	4,8	1	4,5
821 000 035.800	M 3,5	6,0	4,8	1	5,2
822 000 040.800	M 4	6,65	9,5	2	5,8
822 000 050.800	M 5	7,35	9,5	2	6,5
822 000 060.800	M 6	9,05	9,5	2	8,2
823 000 080.800	M 8	12,45	14,3	3	11,8

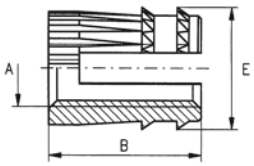
Different lengths and numbers of vanes with the same internal thread on request. This changes the guideline values for hole diameters..

Example for finding the article number Self-locking threaded insert B-Lok®-F to Works Standard 822 0 with internal thread M5 and 2 vanes made of brass: B-Lok®-F 822 000 050.800

Kerb Konus

Expansion inserts
self-locking

B-Lok®-E
Works Standard
830 / 831



Dimensions in mm

Article number	Internal thread A	Biggest external diameter E	Length B	Number of vanes	Hole diameter (guideline values) L +0,1	Article number	Biggest external diameter E	Length B	Number of vanes
830 000 020.800	M 2	3,9	3,5	1	3,4				
830 000 025.800	M 2,5	4,4	4	1	3,9				
830 000 030.800	M 3	5,5	5	1	4,9	831 000 030.800	5,5	8	2
830 000 040.800	M 4	6,5	5	1	5,9	831 000 040.800	6,5	8	2
830 000 050.800	M 5	7,6	6	1	6,9	831 000 050.800	7,6	9	2
830 000 060.800	M 6	8,6	7	1	7,9	831 000 060.800	8,6	9	2

Example for finding the article number Self-locking threaded insert B-Lok®-E to Works Standard 831 0 with internal thread M5 and 2 vanes made of brass: B-Lok®-E 831 000 050.800

Materials Brass — Article no. (**fourth** group of digits) … … … 800

Tolerances ISO 2768-m

Thread Internal thread A: as per ISO 6H