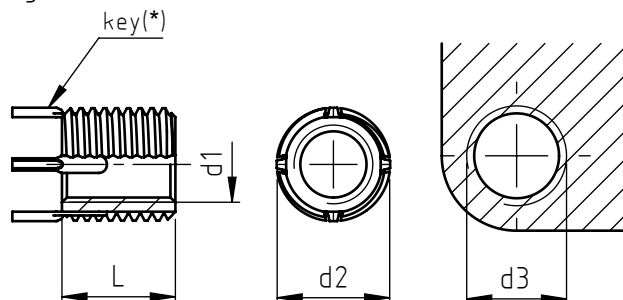


Application: on prepared material with threaded seat.

Dowels are pressed into the receiving material to prevent unscrewing of the insert.

Assembly: by manual or machine tools.

Dowels are inserted by pressure.



(\*) ≤ M 6, 2 locking keys ; > M 6, 4 locking keys

Product features					Installation					Disassembly	
steel	stainless steel	d1 910 6H 911 5H	d2 910 6g 911 4h	L	hole preparation		φ chamfer + 0,25 0	d3		φ hole	depth
					φ	tolerance		6H	depth min.		
9100005080	9110005080	M 5X0,8	M 8X1,25	8,0	6,9	+0,100 -0,025	8,25	M 8X1,25	9,5	5,50	4,00
9100006100	9110006100	M 6X1,0	M 10X1,25	10,0	8,8	+0,100 -0,025	10,25	M 10X1,25	11,5	7,50	4,75
9100008125	9110008125	M 8x1,25	M 12X1,25	12,0	10,8	+0,100 -0,025	12,25	M 12X1,25	13,5	9,50	4,75
9100008100	9110008100	M 8x1,0									
9100010150	9110010150	M 10x1,5	M 14X1,5	14,0	12,8	+0,130 -0,025	14,25	M 14X1,5	15,5	11,50	4,75
9100010125	9110010125	M 10x1,25									
9100012175	9110012175	M 12x1,75	M 16X1,5	16,0	14,75	+0,130 -0,025	16,25	M 16X1,5	17,5	13,50	4,75
9100012125	9110012125	M 12x1,25									

For Dowel-Insert® bushes compliant with MS and NAS, please contact the Specialinsert® tech/sales office



Standard



On demand

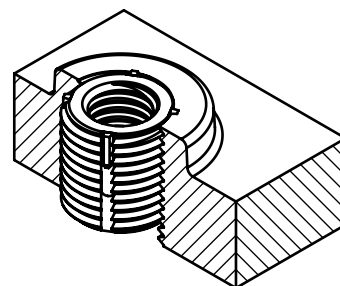
Material: bush steel 910 \_\_\_\_\_  
                  stainless steel AISI 303 911 \_\_\_\_\_  
          locking key stainless steel AISI 302

Finishing: dowel-insert steel: zinc phosphating  
              dowel-insert stainless steel: passivation

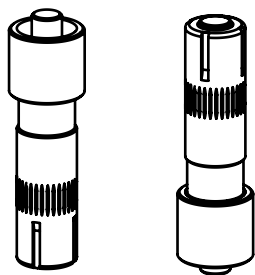
Thread: d1 internal standard metric

Other threads, forms and types on request.

Non binding dimensions, expressed in mm.

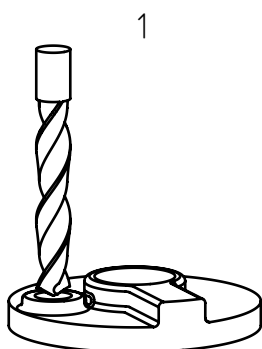


## Complete tool

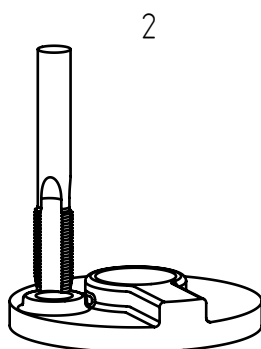


Complete tool	Dowel insert
	steel/stainless steel
915 0050.00	91_0005080
915 0060.00	91_0006100
915 0080.00	91_0008125
	91_0008100
915 0100.00	91_0010150
	91_0010125
915 0120.00	91_0012175
	91_0012125

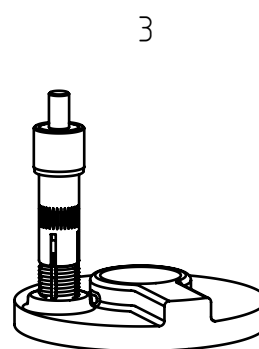
## Assembly instructions:



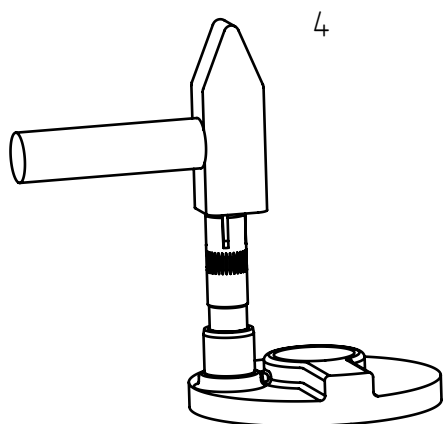
1  
drill according to table  
references, perform  
chamfer at 82°-100°



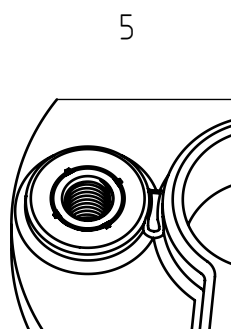
2  
thread with standard  
male



3  
screw with bushing by hand  
or with manual installation  
tool at 0,25-0,70 mm  
under the edge of the surface



4  
turn the tool upside down to drive the keys  
with a few hammer blows



5  
bushing positioned