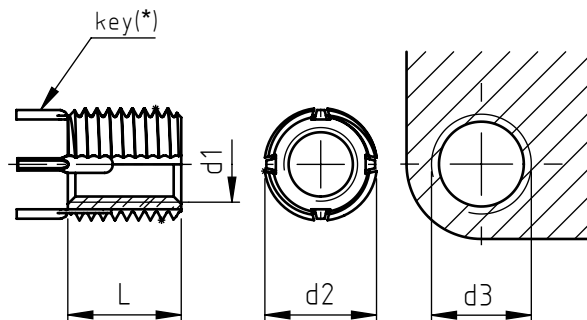


Application: on prepared material with threaded seat.
The locking keys, inserted into the receiving material, prevent the insert from unscrewing.

Assembly: screwing by hand or with specific manual tools.
Locking keys are inserted by pressing.



(*) ≤ 1/4, 2 locking keys; > 1/4, 4 locking keys

Product features					Installation				Disassembly	
steel	stainless steel	d1 3B	d2 2A	L	pre-bored hole	Ø chamfer + 0,25 - 0	d3		Ø hole	depth
					Ø		2B	depth min.		
910010.24	911010.24	10-24	5/16-18	.31	.272	.32	5/16-18	.37	7/32	1/8
910010.32	911010.32	10-32		.31	.272	.32		.37	7/32	1/8
91001/4.20	91101/4.20	1/4-20	3/8-16	.37	.332	.38	3/8-16	.43	9/32	3/16
91001/4.28	91101/4.28	1/4-28		.37	.332	.38		.43	9/32	3/16
91005/16.18	91105/16.18	5/16-18	7/16-14	.43	.397	.44	7/16-14	.50	11/32	3/16
91005/16.24	91105/16.24	5/16-24		.43	.397	.44		.50	11/32	3/16
91003/8.16	91103/8.16	3/8-16	1/2-13	.50	.453	.51	1/2-13	.56	13/32	3/16
91003/8.24	91103/8.24	3/8-24		.50	.453	.51		.56	13/32	3/16
91007/16.14	91107/16.14	7/16-14	9/16-12	.56	.516	.57	9/16-12	.62	15/32	3/16
91007/16.20	91107/16.20	7/16-20		.56	.516	.57		.62	15/32	3/16
91001/2.13	91101/2.13	1/2-13	5/8-11	.62	.578	.63	5/8-11	.68	17/32	3/16
91001/2.20	91101/2.20	1/2-20		.62	.578	.63		.68	17/32	3/16

Non binding dimensions, expressed in inches.

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

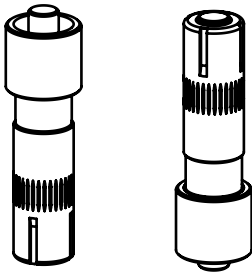
Finishing: dowel-insert steel: manganese phosphating
 dowel-insert stainless steel: passivation

Thread: d1 internal UNC/UNF standard

Other threads, shapes and types on request.

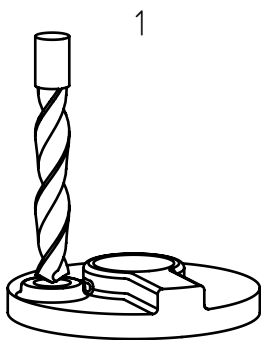
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Complete tool

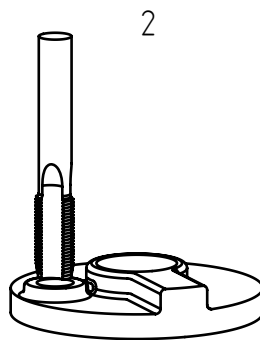


Complete tool	Dowel insert
915 10.00	91_010.24
	91_010.32
915 1/4.00	91_01/4.20
	91_01/4.28
915 5/16.00	91_05/16.18
	91_05/16.24
915 3/8.00	91_03/8.16
	91_03/8.24
915 7/16.00	91_07/16.14
	91_07/16.20
915 1/2.00	91_01/2.13
	91_01/2.20

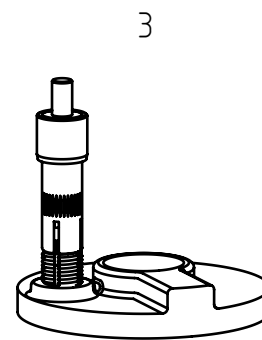
Assembly instructions:



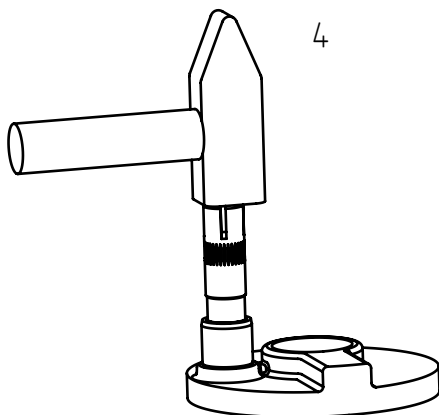
drill according to table references, perform a chamfer at 82°-100°



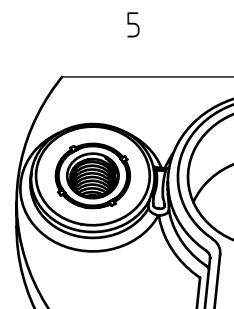
thread with standard male



screw the bush by hand or with manual tool to 0,010-0,030 inches below the surface line



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



bush placed

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