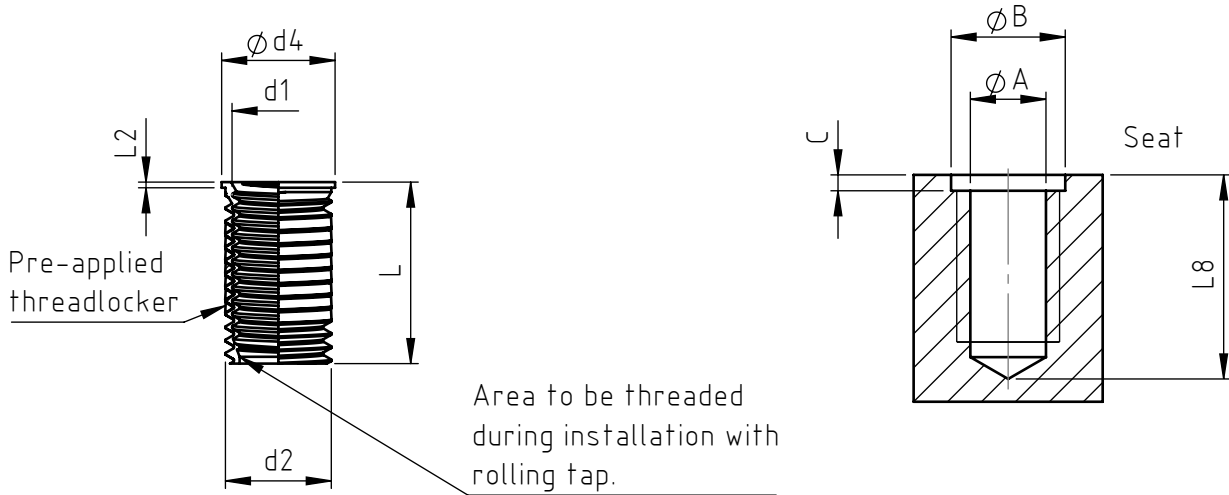


Application: on materials with threaded seats.
Assembly: by special equipment.



Code	Features					Assembly			
	Internal thread d1	External thread d2	Length L	d4	L2	A	B	C	L8
SYT 04X070X08.50.593	M4x0,7	M4.8x0,7	8,0	5,5	0,75	4,2	7,0	1,2	11,8
SYT 05X080X10.50.593	M5x0,8	M5.9x0,8	10,0	7,0	0,75	5,2	8,5	1,2	14,2
SYT 06X100X12.50.593	M6x1,0	M7.2x1,0	12,0	8,0	0,75	6,3	9,5	1,2	17,2
SYT 08X125X16.50.593	M8x1,25	M9.5x1,25	16,2	10,6	0,75	8,4	12,5	1,2	22,2
SYT 10X150X20.50.593	M10x1,5	M11.8x1,5	20,0	12,6	0,75	10,4	14,5	1,6	27,3
SYT 12X125X24.50.593	M12x1,25	M13.6x1,25	24,0	14,0	0,75	12,4	16,5	1,6	30,2
SYT 12X175X24.50.593	M12x1,75	M14.2x1,75	24,0	15,0	0,75	13,0	16,5	1,6	32,3

Non binding dimensions, expressed in mm.

For other sizes not listed in the table, please contact Specialinsert® technical/sales department.

Standard

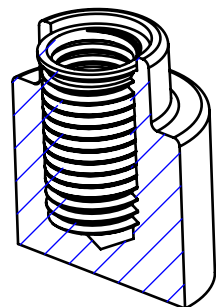
On demand

Not manufactured

Material: stainless steel no. 1.4305
Finishing: natural
Threadlocker: blue epoxy-based microspheres
curing time at a 23°C / 73°F
8H= 80% / 24H= 95% / 72H= 100%

Example:
double-threaded synchronised bush with pre-applied ND593,
M6 thread, length 12mm, in stainless steel:

SYT 06X100X12.50.593



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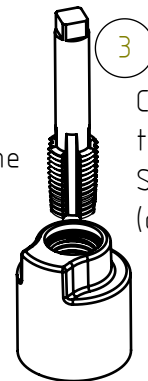
ASSEMBLY INSTRUCTIONS



1 Drill according to table reference (dimensions A and L8)



2 Perform a seat for the bush collar (dimensions B and C)

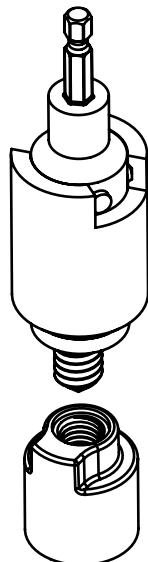


3 Create the external thread to receive SYNC-TEC bush (dimension d2)

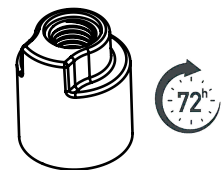
Insert the bush with rolling tap (dimension d1).
The use of lubricating oil is recommended, taking care not to damage the pre-applied threadlocker.



4 At the end of the insertion the rolling tap will complete the lower part of the internal thread, deforming the insert with a gripping effect.



5 Apply a tightening torque according to the torque indicated in the table.



6 Bush placed. Wait the specified curing time.

Tools table for threaded seat creation (d2)

Code	Thread	External thread tap	Tightening torque tool	Tightening torque (Nm)
SYT 04X070X08.50.593	M4	MM 04x70	635 0040.00	5,5
SYT 05X080X10.50.593	M5	MM 05x80	635 0050.00	10
SYT 06X100X12.50.593	M6	MM 06x100	635 0060.00	15
SYT 08X125X16.50.593	M8	MM 08x125	635 0080.00	28
SYT 10X150X20.50.593	M10	MM 10x150	635 0100.00	40
SYT 12X125X24.50.593	M12x1.25	MM 12x125	635 0126.00	60
SYT 12X175X24.50.593	M12	MM 12x175	635 0120.00	60

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