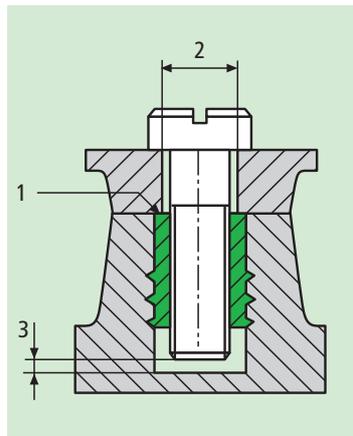




# B-Lok<sup>®</sup> self-locking threaded insert



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

B-Lok<sup>®</sup>  
Registered Trademark  
GB No. 2 314 786  
USA No. 2,002,588  
J No. 3 150 190

### Design of the moulded component and receiving hole

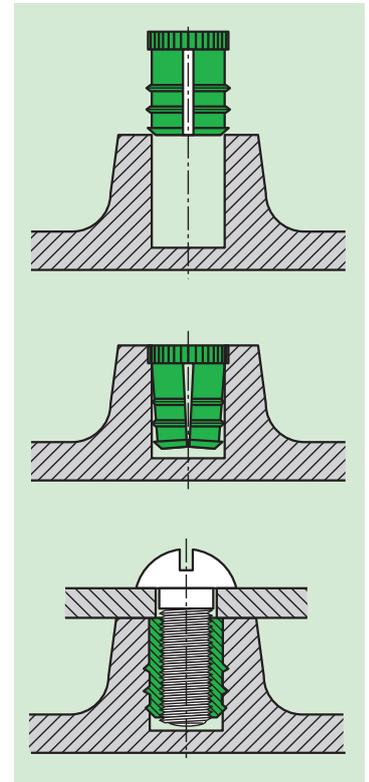
The part requiring fastening should be flush with the threaded insert, see (1). For this reason, the borehole (2) should be closely dimensioned and not countersunk. The B-Lok can be left projecting above the surface of the moulded component by appr. 0.1 mm.

Both plastic parts must lock into place for maximum torque safety to prevent the occurrence of a breakaway levering effect.

**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 max. +0.04 mm. 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).



### Installation

1. The B-Lok is pressed into the receiving hole, during which process the segments bend inwards.
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.

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.

Selection of the correct B-Lok type:

Material	B-Lok	Works Standard	Page
Thermoset plastic	-MV or -E	812/815, 830/831	19, 20
Duroplastic	-R	841	21
PU/PUR-foam	-R, -MV or -E	841, 812/815 830/831	21, 19, 20
Wood	-F or -E	821/823, 830/831	20
Through holes in laminate materials or side walls	-RK	842	21

### We recommend practical testing.

All table values apply only if the screw is inserted to at least 50% of its length in the threaded insert.

