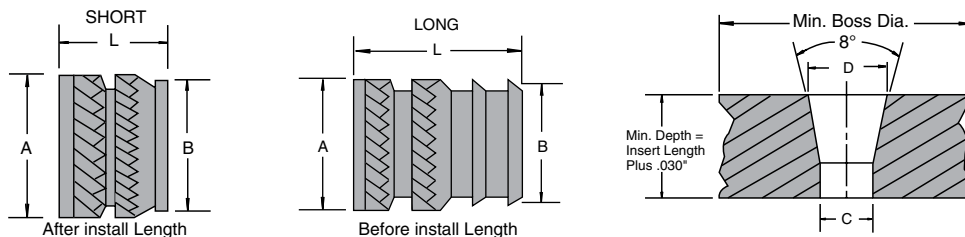


Inch and Metric
Pouce et Métrique

STANLEY
Engineered Fastening

Dodge® Threaded Inserts
Inserts filetés Dodge^{MD}

BRASS



Ultrasert II Inch

- Diagonal knurls & under cuts provide superior assembly strength in plastics
- Excellent design for automated systems
- Installed ultrasonically or with heat
- Two lengths to choose from allowing design flexibility

INSERT SPECIFICATIONS					HOLE SIZE RECOMMENDATIONS			
SPAENAUR No.	Internal Thread Size	Diameter (Inch)		Lgth. (Inch) L ±.004	Diameter (Inch)		Min. Boss Dia. (Inch)	PKG QTY.
		A ±.005	B ±.005		C ±.001	D ±.001		
628-570	0-80	.141	.123	.115	.118	.123	.282	100
628-571	0-80	.141	.112	.188	.107	.123	.282	100
628-572	2-56	.141	.123	.115	.118	.123	.282	100
628-B80-1T	4-40	.172	.157	.135	.153	.159	.344	100
628-575	4-40	.172	.146	.219	.141	.159	.344	100
628-576	6-32	.219	.203	.150	.199	.206	.438	100
628-577	6-32	.219	.190	.250	.185	.206	.438	100
628-578	8-32	.250	.230	.185	.226	.234	.500	100
628-579	8-32	.250	.213	.312	.208	.234	.500	100
628-580	10-24	.297	.272	.225	.267	.277	.594	100
628-581	10-24	.297	.251	.375	.246	.277	.594	100
628-582	10-32	.297	.272	.225	.267	.277	.594	100
628-583	10-32	.297	.251	.375	.246	.277	.594	100
628-584	1/4-20"	.375	.354	.300	.349	.363	.750	100
628-585	1/4-20"	.375	.332	.500	.321	.363	.750	100
628-586	1/4-28"	.375	.354	.300	.349	.363	.750	100
628-587	1/4-28"	.375	.332	.500	.321	.363	.750	100
628-588	5/16-18"	.469	.439	.335	.431	.448	.938	100
628-589	5/16-18"	.469	.406	.562	.401	.448	.938	100
628-590	5/16-24"	.469	.439	.335	.431	.448	.938	100
628-591	5/16-24"	.469	.406	.562	.401	.448	.938	100
628-592	3/8-16"	.563	.532	.375	.523	.540	1.126	100
628-593	3/8-16"	.563	.493	.625	.488	.540	1.126	100
628-594	3/8-24"	.563	.532	.375	.523	.540	1.126	100
628-595	3/8-24"	.563	.493	.625	.488	.540	1.126	100

Ultrasert II Metric

SPAENAUR No.	Internal Thread Size (mm)	Diameter (mm)		Lgth. (mm) L ± 0.10	Diameter (mm)		Min. Boss Dia. (mm)	PKG QTY.
		A ± 0.13	B ± 0.13		C ± 0.03	D ± .03		
628-610	M2.2 x 0.45	3.58	3.12	2.9	3.00	3.12	7.16	100
628-611	M2.2 x 0.45	3.58	2.84	4.8	2.72	3.12	7.16	100
628-612	M2.5 x 0.45	4.37	3.99	3.4	3.89	4.04	8.74	100
628-613	M2.5 x 0.45	4.37	3.71	5.6	3.58	4.04	8.74	100
628-614	M3 x 0.5	5.56	5.16	3.8	5.05	5.23	11.13	100
628-615	M3 x 0.5	5.56	4.38	6.4	4.70	5.23	11.23	100
628-616	M3.5 x 0.6	5.56	5.16	3.8	5.05	5.23	11.23	100
628-617	M3.5 x 0.6	5.56	4.83	6.4	4.70	5.23	11.23	100
628-618	M4 x 0.7	6.35	5.84	4.7	5.74	5.94	12.70	100
628-619	M4 x 0.7	6.35	5.41	7.9	5.28	5.94	12.70	100
628-620	M5 x 0.8	8.33	7.82	6.7	7.70	8.00	16.66	100
628-621	M5 x 0.8	8.33	7.19	11.1	7.06	8.00	16.66	100
628-622	M6 x 1	9.53	8.99	7.6	8.86	9.22	19.06	100
628-623	M6 x 1	9.53	8.43	12.7	8.15	9.22	19.06	100
628-624	M8 x 1.25	11.91	11.15	8.5	10.95	11.38	23.83	100

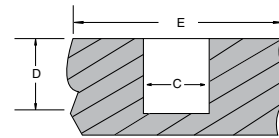
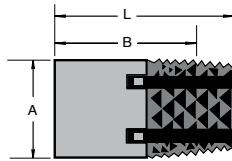
Dodge® Threaded Inserts

Inserts filetés Dodge^{MD}

STANLEY
Engineered Fastening

Inch
Pouce

BRASS



All Dimensions in Inches.

STANDARD EXPANSION Inch

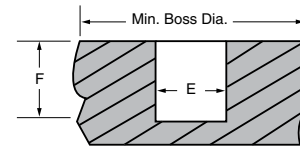
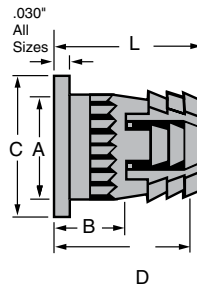
- Versatile - can be used in any type of plastic
- Simple press-in installation

INSERT SPECIFICATIONS					HOLE SIZE RECOMMENDATIONS			
Standard Expansion	Body Dia. A	Installed Length L	Min Threaded Length B		Dia. C	Depth D	Min. Boss Dia. E	PKG QTY.
SPAENAUR No.	Thread Size	±.003	±.004		±.001	Ref		
628-596	4-40	.156	.250	.178	.158	.250	.312	100
628-597	5-40	.188	.313	.240	.190	.313	.376	100
628-598	6-32	.188	.313	.240	.190	.313	.376	100
628-599	6-32	.188	.375	.303	.190	.375	.376	100
628-600	8-32	.219	.313	.240	.221	.313	.438	100
628-601	8-32	.219	.375	.303	.221	.375	.438	100
628-602	10-24	.250	.375	.303	.252	.375	.500	100
628-603	10-24	.250	.438	.365	.252	.438	.500	100
628-604	10-32	.250	.313	.240	.252	.313	.500	100
628-605	10-32	.250	.375	.303	.252	.375	.500	100
628-606	10-32	.250	.438	.365	.252	.438	.500	100
628-607	1/4"-20	.313	.500	.428	.315	.500	.626	100

BRASS

WEDGE EXPANSION Inch

- Strong brass threads in wood, particle board or soft plastics
- Straight knurl prevents rotation



All Dimensions in Inches.

INSERT SPECIFICATIONS						HOLE SIZE RECOMMENDATIONS			
Wedge Expansion	Body Dia. A	Installed Length L	Min Threaded Length B	Flange Dia. C	Max. Screw Penetration D	Drill Diameter E	Depth F	Min. Boss Dia.	PKG QTY.
SPAENAUR No.	Thread Size	±.003	±.004	±.003			Ref.		
628-626	8-32	.270	.313	.138	.344	.250	.313	.540	100

See Page C207 for Application Tools



Inch and **Metric**
Pouce et **Métrique**

STANLEY
Engineered Fastening

Barb-Sert®
Barb-Sert®

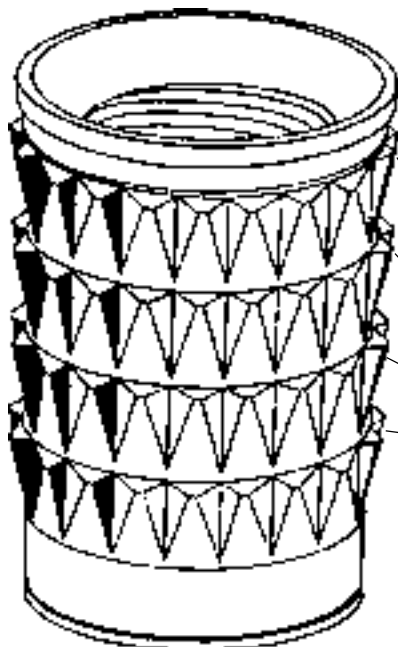
BRASS



Designed to provide metallic screw threads in preformed substrates of plastic, laminates, or any low-strength material.

For **ULTRASONIC...or PUSH-IN INSTALLATION**

Furnished in **INCH** and **METRIC** Thread Sizes



Barb-Sert!



It's the rings and the barbs that make the difference. The rings and a unique barbed external form are specially designed to allow low installation force but deliver high pull-out and torque-out performance.

A 360° ring at the top, which directs the dislodged material downward, resulting in a neat, smooth appearance at the surface, and closing off paths of the barbs.

See
Next
Page



A full 360° pilot ring at the bottom guides the insert during installation.

360° barbed retaining rings make installation faster and apply higher resistance to pull- and torque-out.

U.S. Patent No. 4,046,181 - Foreign Patents Granted

Typical
Barb-Sert
Usage



ASSORTMENT **805-493**
ASSORTIMENT

Barb-Sert®
Brass Inserts

Ideal for prototype work

INCH & METRIC
25 SIZES - 475 PIECES



Put up in a regular size grey Enamelled Steel Drawer.

Fits the Slide Racks shown on page A2.

Shipping Weight: **2.72 kg** (6 lbs.)



For the complete assortment contents turn to A68

CATALOG 14
SPAENAUR

Knurled & Barbed Threaded Inserts

Inserts filetés moletés et crantés

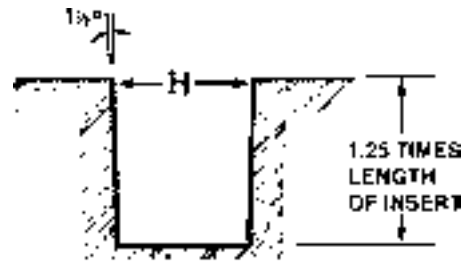
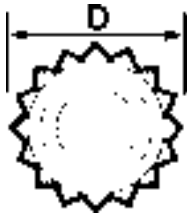
STANLEY

Engineered Fastening

Inch and Metric
Pouce et Métrique

SPECIFICATIONS

MATERIAL: BRASS



DIMENSIONS AND HOLE-SIZE RECOMMENDATIONS

INCH SIZES		METRIC SIZES		"D"	LENGTH "L"		RECOMMENDED HOLE SIZE* Ultrasonic or Push-in "H"
Internal Thread Size	SPAENAUR No.	Internal Thread Size	SPAENAUR No.		Reg.	Short	
2-56	628-500	M2.5 x 0.45	628-550	.173"	.205"	-	.159"
2-56	628-501			.173"	-	.160"	.159"
4-40	628-502	M3 x 0.5	628-B82-1W	.173"	.205"	-	.159"
4-40	628-B83-1M	M3 x 0.5	628-553	.173"	-	.160"	.159"
6-32	628-504	M3.5 x 0.6	628-554	.217"	.276"	-	.196"
6-32	628-B77-1N	M3.5 x 0.6	628-555	.217"	-	.160"	.196"
8-32	628-B79-1K	M4 x 0.7	628-556	.250"	.335"	-	.229"
8-32	628-507	M4 x 0.7	628-B84-1X	.250"	-	.217"	.229"
10-24	628-508	M5 x 0.8	628-558	.280"	.395"	-	.255"
10-24	628-509	M5 x 0.8	628-559	.280"	-	.257"	.255"
10-32	628-B81-1K	-	-	.280"	.395"	-	.255"
10-32	628-511	-	-	.280"	-	.257"	.255"
1/4"-20	628-512	M6 x 1	628-B76-1C	.335"	.500"	-	.320"
1/4"-20	628-513	M6 x 1	628-561	.335"	-	.296"	.320"

*Recommended hole sizes only. Tests should be carried out to establish the most suitable hole sizes for your specific application and material.

PERFORMANCE DATA

PKG QTY. 100
All Sizes

MATERIAL	THREAD SIZE															
	4-40 (M3)				6-32 (M3.5)				8-32 (M4)				10-24 (M5)			
	Ultrasonic		Push-In		Ultrasonic		Push-In		Ultrasonic		Push-In		Ultrasonic		Push-In	
	Pull Out (Lbs.)	Torque Out (In. Lbs.)	Pull Out (Lbs.)	Torque Out (In. Lbs.)	Pull Out (Lbs.)	Torque Out (In. Lbs.)	Pull Out (Lbs.)	Torque Out (In. Lbs.)	Pull Out (Lbs.)	Torque Out (In. Lbs.)	Pull Out (Lbs.)	Torque Out (In. Lbs.)	Pull Out (Lbs.)	Torque Out (In. Lbs.)	Pull Out (Lbs.)	Torque Out (In. Lbs.)
Nylon	175	26	175	26	500	48	400	52	700	85	700	74	925	110	950	100
Lexan	187	30	142	24	430	56	400	56	725	76	600	100	1000	95	950	110
PVC	125	26	150	24	470	44	450	52	750	64	725	85	1000	85	850	100
Delrin	157	24	140	20	395	46	335	44	700	80	450	74	850	90	600	90
Polyethylene	57	5	45	3	165	13	90	9	210	16	100	20	290	25	210	20