Press Inserts For Plastic

Typical Torque-Out and Tensile Loads

Insert	Material	Lexan		Zytel Nylon		Glass Filled Epoxy (GEE)		Glass Filled Epoxy (GEB		Phenolic-Paper Comp. Laminate		Glass Reinforced Plastic	
	Hole Size	Torque-Out In. Lbs.	Tensile Lbs.	Torque-Out In. Lbs.	Tensile Lbs.	Torque-Out In. Lbs.	Tensile Lbs.	Torque-Out In. Lbs.	Tensile Lbs.	Torque-Out In. Lbs.	Tensile Lbs.	Torque-Out In. Lbs.	Tensile Lbs.
240-004-BR 4-40/Brass	.156	14	80	22*	69	18	140	19*	180	10	100	11	105
	.158	13	69	14	57	15	117	14	139	-	-	-	-
	.160	6	40	6	32	10	70	9	80	-	-	-	-
	.162	5	20	4	14	7	33	6	64	-	-	-	-
240-004-CR 4-40/Stainless	.156	14	82	22*	71	20*	145	19*	182	-	-	-	-
	.158	12	70	14	60	15	120	13	140	-	-	-	-
	.160	7	35	8	35	11	70	9	85	-	-	-	-
	.162	5	16	5	15	8	29	6	60	-	-	-	-
240-006-BR 6-32/Brass	.188	30	85	30	100	42*	230	45*	240	22	240	20	210
	.190	24	75	25	90	38	180	37	235	-	-	-	-
	.192	13	50	15	77	19	170	22	150	24	210	24	200
	.194	6	40	8	65	13	160	17	120	10	165	-	-
240-006-CR 6-32/Stainless	.188	30	93	30	122	42*	262	45*	240	-	-	-	-
	.190	20	80	20	110	34	205	33	235	-	-	-	-
	.192	15	70	16	90	21	195	24	145	-	-	-	-
	.194	10	50	12	75	14	180	21	125	-	-	-	-
240-008-BR 8-32/Brass	.219	40	180	40	210	85*	300	85*	280	41	230	45	230
	.221	35	178	35	200	70	273	75*	208	-	-	-	-
	.223	22	130	25	160	51	235	72*	190	-	-	-	-
	.225	15	80	19	110	43	132	67*	165	-	-	-	-
240-008-CR 8-32/Stainless	.219	30	190	35	220	75	310	85*	281	-	-	-	-
	.221	25	145	30	175	60	240	75*	200	-	-	-	-
	.223	15	70	20	100	44	175	72*	192	-	-	-	-
	.225	14	50	18	80	42	102	65	165	-	-	-	-
240-332-BR 10-32/Brass	.250	80	240	82	375	90*	420	110*	420	75	420	80	450
	.252	45	172	54	250	66	320	110*	405	-	-	-	-
	.254	27	105	26	160	38	175	110*	300	-	-	-	-
	.256	18	30	20	132	22	150	105	205	-	-	-	-
240-332-CR 10-32/Stainless	.250	85*	250	85	420	90*	510	110*	490	-	-	-	-
	.252	59	220	61	265	75*	460	107	425	-	-	-	-
	.254	31	122	32	175	41	310	111*	257	-	-	-	-
	.256	25	42	21	140	24	280	105	240	-	-	-	-

All tests run with bolt thread of sufficient length to ensure full thread engagement of insert. Torque-out was determined using a torque wrench on a bolt in conjuction with a bushing. The bushing's maximum outside diameter was in all cases less than the insert outside diameter, ensuring pure torque was recorded, not clamp-up. Torque out was recorded at the point the insert rotated relative to the parent material. Tensile load was applied until the first indication of insert movement was noted. *Bolt Broke

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