

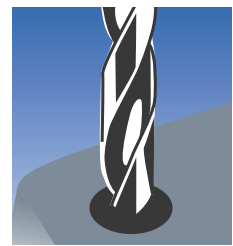
Self-locking “AMECOIL” thread inserts

Amecoil locking thread inserts

This self-locking series corresponds in all points to the conventional series, the screw threads being locked by polygonal deformation of one or more turns of the thread.

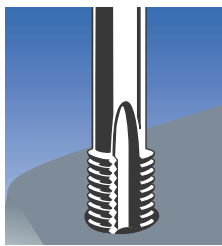
This deformation results in a powerful locking on the sides of the screw thread and counteracts the unscrewing effects of dynamic stresses, vibrations and thermal loads. The locking torques obtained are comparable with the values indicated in standard ISO 2320.

The stainless steel self-locking thread insert is recognised by its red colour.



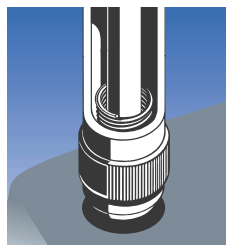
• Drilling

from +0.1 to +1 mm of the nominal diameter of the screw. Chamfer \leq at the diameter of the tap.



• Tapping

Performed using the AMECOIL tap.

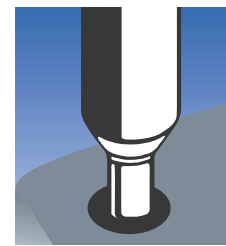


• Installation

Using tools of the conventional series...

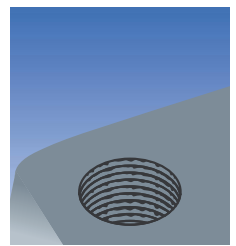


... or those of the SR series, for even quicker installation.



• Breaking of the drive stud

With the AMECOIL impact breaker or automatically.



• Thread insert

LOCKING TORQUE

Dimensions	Max 1st tightening	Min 1st loosening	Min 5th loosening
M3	0.43	0.12	0.08
M4	0.90	0.18	0.12
M5	1.60	0.29	0.20
M6	3.00	0.45	0.30
M8	6.00	0.85	0.60
M10	10.5	1.50	1.00
M12	15.5	2.30	1.60
M14	24.0	3.30	2.30
M16	32.0	4.50	3.00
M20	54.0	7.50	5.30
M24	80.0	11.5	8.00

Values in Nm quoted from ISO 2320 (class 8 screws)

GENERAL CHARACTERISTICS	Material	Maximum operating temperature	Surface coating options	Applications
	Standard material Stainless steel 18.8 AISI 304 (1.4301) AISI 302 (1.4310)	425°C (peak) 315°C (continuous)	<ul style="list-style-type: none"> - Dry lubrication - Cadmium plating - Silver plating - Zinc plating - Tinning 	All normal applications in all materials
	Special stainless steels: AISI 304L, 316, 316L, 316Ti, 321	Up to 400°C continuously		Special applications Resistance to acids, corrosion, high temperatures – non-magnetic
	Phosphorous bronze	300°C (peak) 250°C (continuous)	Cadmium plating	Copper parts High resistance to some electrolytic couples
	Inconel x 750 Nc 15Fe Nba	750°C (peak)	Silver plating	Thermal power plants Aerospace Aeronautics Turbochargers
	Nimonic90 Nc 20C18Tu	538°C (continuous)		