



SOLID BODIES LINE

Insert Lt, MB  
+37061042402  
info@insert-lt.com



# Ensat<sup>®</sup>

## SELF-TAPPING INSERTS

# Index

DESCRIPTION	Page
Presentation	3
Materials and Applications	4
Features	5
Preparing the receiving hole	6
Tools Codes	7
Ensat® Series 302	8
Ensat® Series 303	9
Ensat® Series 305	10
Ensat® Series 307 - 308	11
Ensat® Series 309	12
Ensat® Serie 317 - 318	13
Ensat® Series 337 - 338	14
Ensat® Series 347 - 348	15
Ensat® Series 304	16
Ensat® Series 304 assembly tools	17
Mubux® Series M 970	18
Conversion table for metric/imperial threads	19



## Ensat® Features, applications and benefits.

The **Ensat®** is a self-tapping metal insert, with internal and external thread and slots or holes providing a tapping effect.

The **Ensat®** bush is installed into materials with low resistance (such as alloys, plastics and castings) requiring threaded seats with high specifications of resistance and wear.

They can also be used for re-tapping worn thread. The Ensats 302 bush (with tapping grooves) is ideal for use with most applications.

The **Ensat®** bush may create a slight self-locking effect with some materials.

If this is not required, we recommend the Ensats 307-308 series (with tapping holes), whose shape is ideal for materials that are particularly resistant to cutting.

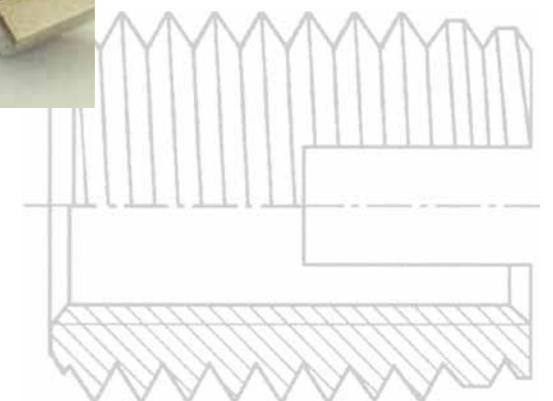
The Ensats 307 series is short and compact and is particularly suitable for low thicknesses.

The **Ensat®** bush can be used for all machining and processing of plastics.

The **Ensat®** bush has a large cutting surface and therefore offers greater resistance to traction. It can be inserted into the finished item, which means higher efficiency for machining centres and the elimination of positioning errors or material deposited in the thread.



A casting hole or tool with standard tolerances is all that is needed to fit **Ensat®** bushes. Its fast and easy fitting makes the system extremely cost effective.



# Materials and Applications

	Material	For applications on:						
		Steel	Stainless steel *	Brass	Soft metal alloys	Hard metal alloys	Plastics Resins	Wood
Ensat® 302		Orange	Orange	Orange	Blue	Blue	Blue	Grey
Ensat® 303		Orange	Orange	Orange	Blue	Blue	Blue	Grey
Ensat® 305		Grey	Grey	Orange	Grey	Grey	Blue	Grey
Ensat® 307 Ensat® 308		Orange	Orange	Grey	Blue	Blue	Blue	Grey
Ensat® 309		Grey	Grey	Orange	Grey	Grey	Blue	Blue
Ensat® 317 Ensat® 318		Orange	Orange	Grey	Blue	Blue	Blue	Grey
Ensat® 337 Ensat® 338		Orange	Orange	Grey	Blue	Blue	Blue	Grey
Ensat® 347 Ensat® 348		Orange	Orange	Grey	Blue	Blue	Blue	Grey
Mubux® M970		Orange	Grey	Grey	Blue	Blue	Blue	Grey
Ensat® 304		Orange	Grey	Grey	<b>WORN SPARK PLUG HOUSINGS IN MOTORS</b>			

\* for ferritic and austenitic stainless steel, refer to the relative product data sheet for the available sizes.

Other materials, shapes and finishes available on request.

# Features

## APPLICATION

Ferrous and non-ferrous metals, light alloys, cast iron, brass, plastics, resins, soft thermoplastics, wood and derivatives, materials designed with threaded housings.

## ASSEMBLY

Using specific hand-operated or machine tools.

## MATERIAL

Steel, stainless steel, brass.

## THREADING

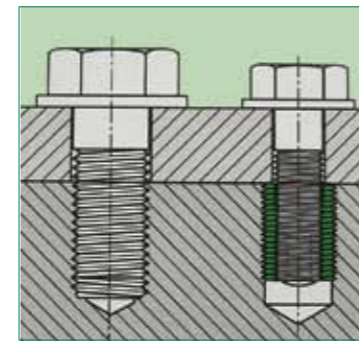
Metric ISO 6 H

## TOLERANCES

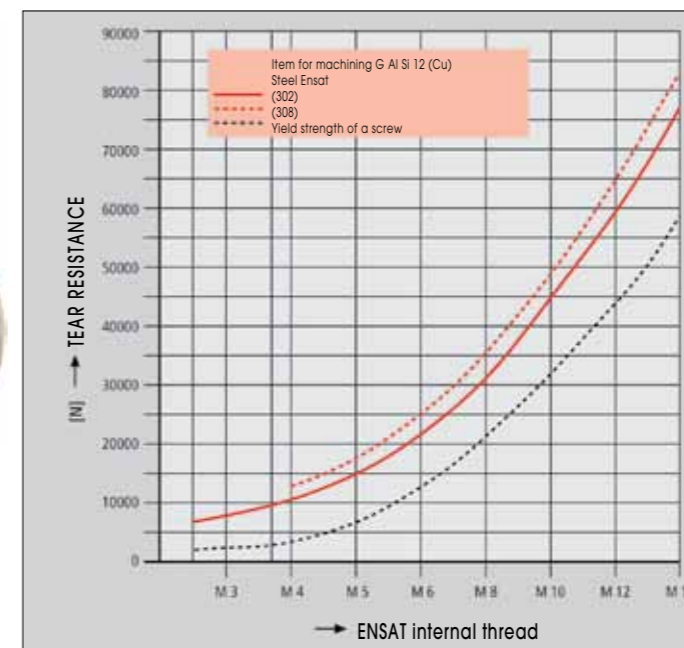
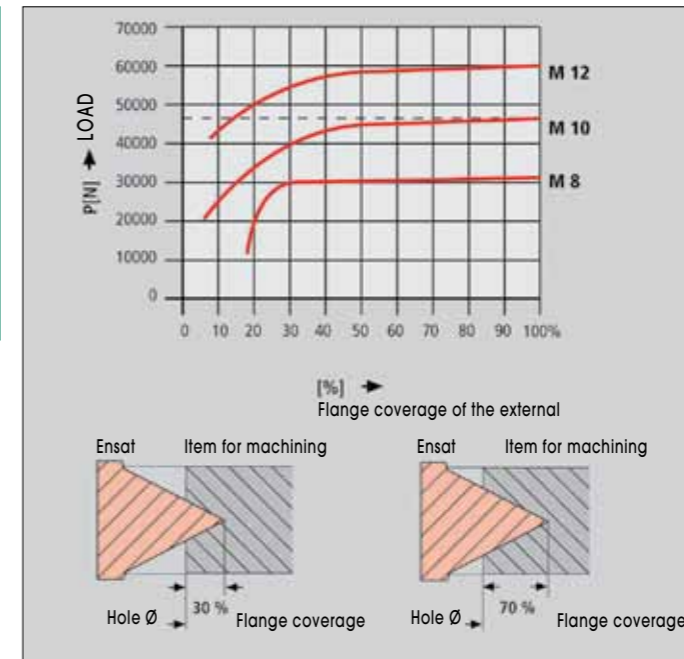
ISO 2768-m

## SURFACE FINISH

Steel bushes: Galvanization.  
Stainless steel bushes: natural state.  
Brass bushes: natural state.



Ensat® bushes allow use of smaller sized screws or tension rods to achieve the same resistance to traction. The illustration shows two screw-connections with the same resistance to traction (note the smaller screw used with Ensat®).



# Preparing the receiving hole

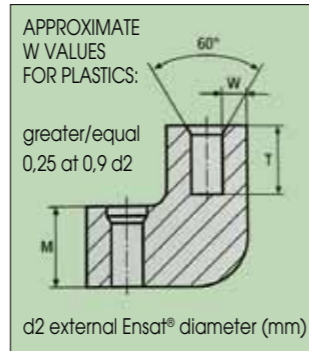
The receiving hole can be simply drilled or already provided for in the casting. It is generally not necessary to countersink the hole. However, we do recommend that you take care not to warp the workpiece surface when screwing in the **Ensats**.

**Passing hole:** the length of the **Ensats** must not exceed the thickness of the material (**M**).

**Dummy hole:** the minimum depth (**T**) is indicated in the datasheet for each product.

**Hole walls:** the minimum thickness required (**W**) depends on the envisaged load and the elasticity of the material where the **Ensats** bush is inserted.

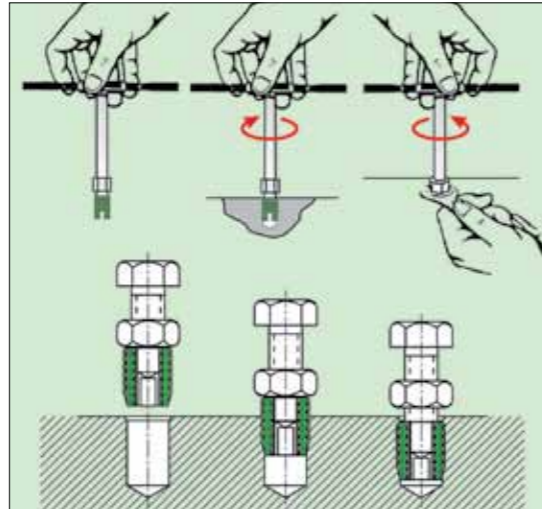
**Hole diameter:** hard, resistant materials require larger holes compared to soft, elastic materials.



The specifications are indicated on the datasheets for each product. The **Ensats** bush must be fitted at least 0,1-0,2 mm below the assembly surface. The perforation diameter is calculated according to the material and the **Ensats** bush. Larger holes mean easier insertion but can be detrimental for resistance to traction. Testing the assembly is therefore recommended.

## Manual installation

Screw the **Ensats** onto the driving tool with the cutting slot or cutting bore pointing downwards. Drive in the **Ensats** until appr. 0,1 -0,2 mm below the surface of the workpiece. It's very important to keep the insert perpendicular to the workpiece during installation. Back out the driver tool holding the hex nut using a spanner until the lock breaks.



## Tools

Use 610 manual tools and the use of a tap wrench and spanner. Use tool 620 or 621 for fitting on:

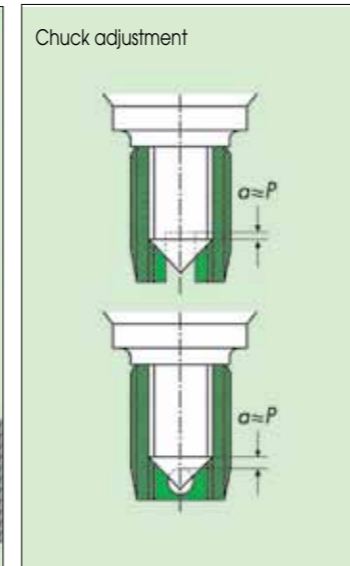
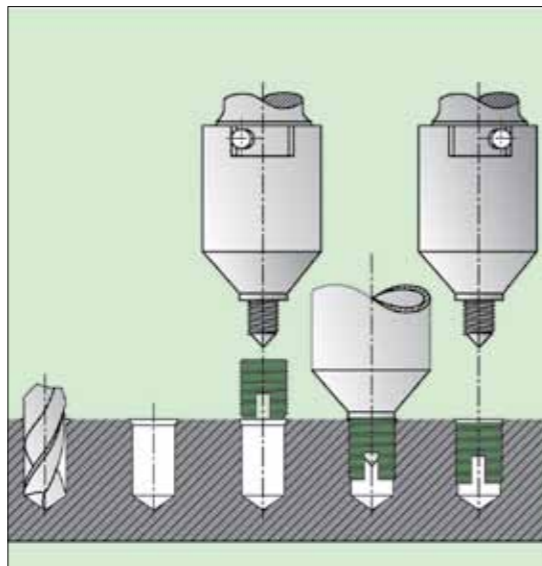
- tapping machines or machining centres; no guide; no advancement. Never pass the maximum moment;
- special hand-operated machines; stops in depth or return; lubrication only for materials resistant to cutting.

INTERNAL THREAD	RPM (rounds per minute)	MAX TORQUE VALUES
M 2,5 / M3	650 - 900	Ensats M 2,5 Nm 1,5
M4 / M5	400 - 600	Ensats M 3 Nm 2,5
M6 / M8	280 - 400	Ensats M 4 Nm 5,5
M10 / M12	200 - 300	Ensats M 5 Nm 10
M14 / M16	150 - 200	Ensats M 6 Nm 15
M18 / M20	120 - 200	Ensats M 8 Nm 28
M22 / M24	100 - 160	Ensats M 10 Nm 40
M27 / M30	80 - 140	Ensats M 12 Nm 60

Average values for RPM light alloys.

### Ensats insertion by machine

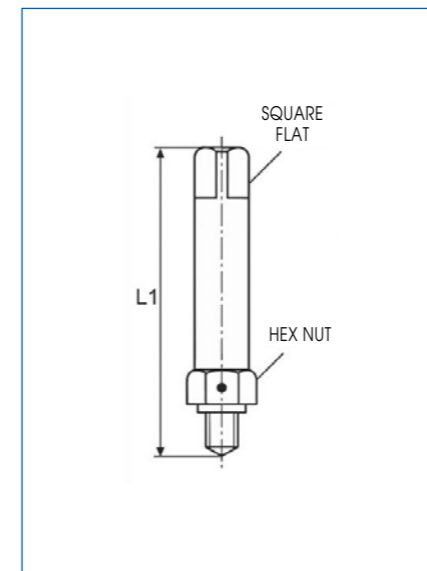
Adjust the position of the chuck with respect to the bush. The **Ensats** machine tool must be fitted on tapping machines or drills with reverse travel. Put the receiving item into the correct position, respecting the common axis of the hole/chuck. Adjust the end limit so that the **Ensats** bush is 0,1-0,2 mm below the assembly surface after fitting. If there are any studs, they must rest on the bottom of the hole. Select the operating speed. At the beginning of the insertion stage, the body of the tool must have the insertion pin as shown



in the illustration. Screw about 3 turns of the **Ensats** bush onto the tool with the grooves or holes facing downwards. Bring the **Ensats** bush adjacent to the receiving item. The advancement and insertion will take place by inertia, without the need for automatic advancement. Change the direction of rotation to remove the tool. The advancement must be gradual to avoid the "hard" impact of the tool on the item as this could cause component breakage or be detrimental to the fastening.

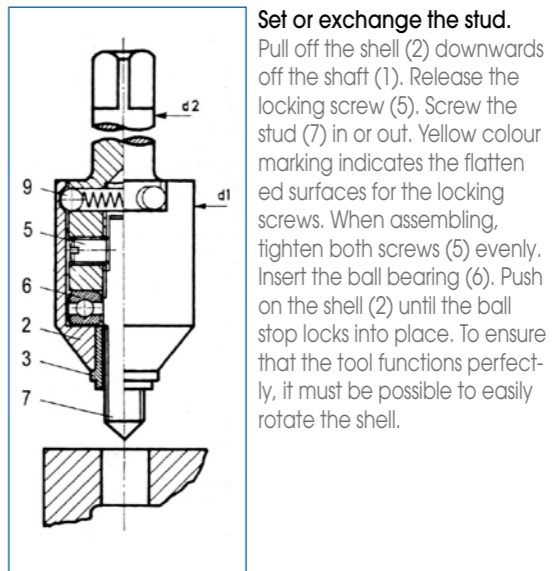
# Tools Codes

## TOOL 610 FOR MANUAL INSTALLATION



TOOL FOR ENSATS	CODE	L1	SQUARE FLAT	HEX NUT
M 2,5 x 0,45	610 0025.00	55	5	7
M 3 x 0,5	610 0030.00	55	5	7
M 3,5 x 0,6	610 0035.00	55	5	7
M 4 x 0,7	610 0040.00	60	5	7
M 5 x 0,8	610 0050.00	75	8	13
M 6 x 1	610 0060.00	75	8	13
M 8 x 1,25	610 0080.00	75	8	13
M 10 x 1,5	610 0100.00	95	12,5	19
M 12 x 1,75	610 0120.00	95	12,5	19
M 14 x 2	610 0140.00	95	12,5	19
M 16 x 2				
M 18 x 2,5				
M 20 x 2,5				
M 22 x 2,5				
M 24 x 3				
M 27 x 3				
M 30 x 3,5				

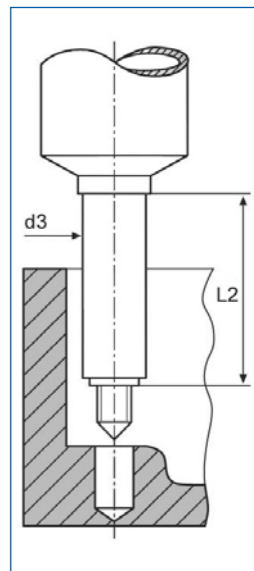
## TOOL 620 FOR MACHINE INSTALLATION



**Set or exchange the stud.**  
Pull off the shell (2) downwards off the shaft (1). Release the locking screw (5). Screw the stud (7) in or out. Yellow colour marking indicates the flattened surfaces for the locking screws. When assembling, tighten both screws (5) evenly. Insert the ball bearing (6). Push on the shell (2) until the ball stop locks into place. To ensure that the tool functions perfectly, it must be possible to easily rotate the shell.

CODE	d1	d2	SQUARE FLAT	TOTAL LENGHT ca
620 0025.00	18	8	6,3	82
620 0030.00	18	8	6,3	82
620 0035.00	18	8	6,3	78
620 0040.00	18	8	6,3	83
620 0050.00	24	12,5	10	101
620 0060.00	24	12,5	10	102
620 0080.00	24	12,5	10	105
620 0100.00	32	16	12,5	131
620 0120.00	32	16	12,5	134
620 0140.00	50	25	20	166
620 0160.00	50	25	20	166
620 0180.00	50	25	20	166
620 0200.00	58	25	20	195
620 0220.00	58	25	20	195
620 0240.00	70	30	25	220
620 0270.00	70	30	25	220
620 0300.00	70	30	25	220

## TOOL 621 FOR DEEP RECEIVING HOLES



CODE	L2	d3
621 0025.00	40	7
621 0030.00	40	7
621 0035.00	40	7
621 0040.00	40	7
621 0050.00	50	9
621 0060.00	50	10
621 0080.00	50	12
621 0100.00	60	15
621 0120.00	60	18
621 0140.00	60	20
621 0160.00	60	22
621 0180.00	60	24
621 0200.00	60	26
621 0220.00	60	28
621 0240.00	60	32
621 0270.00	60	35
621 0300.00	60	38

Dimensions expressed in mm. Other METRIC, UNC, UNF, WHITWORTH threads are available on demand.

The spindle code differs from the tool code changing the final digits 00 with the number 70.

Spare parts for the 610 manual tools are not provided.

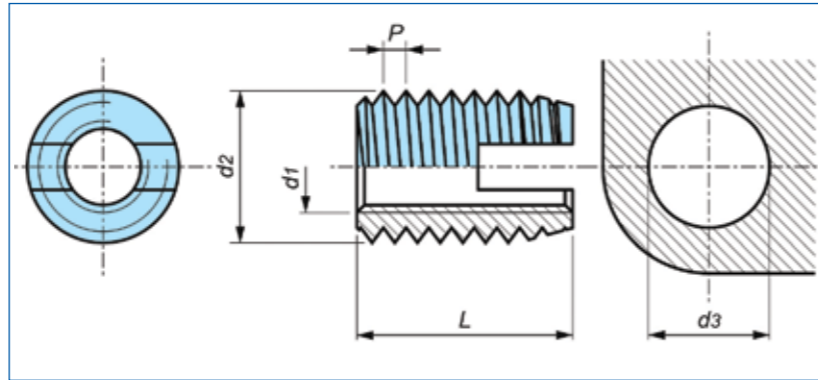
Example: spindle spare part M6X1 code 620 0060.70

# Ensat® Series 302



Applications:  
ferrous and no-ferrous  
metals, light alloy,  
cast iron, brass, plastic  
materials, resins.

Assembly:  
by special equipment.



CODE	METRIC THREAD d 1	SPECIAL EXTERNAL THREAD		TOTAL LENGHT L	APPOX. HOLE DIAMETER d 3			MIN. HOLE DEPTH
		d 2	P		Light alloy Rm < 250 < 150 HB Plastic	Light alloy Rm < 350 C. Iron < 200 HB Plastic Hard	Light alloy Rm > 350 C. Iron > 200 HB Brass, No-ferrous metal	
302 0020. __ *	M 2	4,5	0,5	6	4,1	4,1 - 4,2	4,2 - 4,3	8
302 0025. __ *	M 2,5	4,5	0,5	6	4,1	4,1 - 4,2	4,2 - 4,3	8
302 0030. __ *	M 3	5	0,5	6	4,6	4,6 - 4,7	4,7 - 4,8	8
302 0035. __ *	M 3,5	6	0,75	8	5,4	5,5 - 5,6	5,6 - 5,7	10
302 0040. __	M 4	6,5	0,75	8	5,9 - 6,0	6,0 - 6,1	6,1 - 6,2	10
302 0050. __	M 5	8	1	10	7,2 - 7,3	7,3 - 7,5	7,5 - 7,6	13
302 0061. __	M 6	9	1	12	8,2 - 8,3	8,3 - 8,5	8,5 - 8,6	15
302 0060. __	M 6	10	1,5	14	8,8 - 9,0	9,0 - 9,2	9,2 - 9,4	17
302 0080. __	M 8	12	1,5	15	10,8 - 11,0	11,0 - 11,2	11,2 - 11,4	18
302 0100. __	M 10	14	1,5	18	12,8 - 13,0	13,0 - 13,2	13,2 - 13,4	22
302 0120. __	M 12	16	1,5	22	14,8 - 15,0	15,0 - 15,2	15,2 - 15,4	26
302 0140. __	M 14	18	1,5	24	16,8 - 17,0	17,0 - 17,2	17,2 - 17,4	28
302 0160. __	M 16	20	1,5	22	18,8 - 19,0	19,0 - 19,2	19,2 - 19,4	27
302 0180. __	M 18	22	1,5	24	20,8 - 21,0	21,0 - 21,2	21,2 - 21,4	29
302 0200. __	M 20	26	1,5	27	24,8 - 25,0	25,0 - 25,2	25,2 - 25,4	32
302 0220. __	M 22	26	1,5	30	24,8 - 25,0	25,0 - 25,2	25,2 - 25,4	36
302 0240. __	M 24	30	1,5	30	28,8 - 29,0	29,0 - 29,2	29,2 - 29,4	36
302 0270. __	M 27	34	1,5	30	32,8 - 33,0	33,0 - 33,2	33,2 - 33,4	36
302 0300. __	M 30	36	1,5	40	34,8 - 35,0	35,0 - 35,2	35,2 - 35,4	46

Non binding dimensions, expressed in mm.

\* Use only with soft materials otherwise the mandrel resistance could be insufficient.

Rm = ultimate tensile strenght N/mm²  
HB = Brinell hardness

Other METRIC, UNC, UNF, WHITWORTH, threads are available on demand.

In order to use correctly the products, we suggest to carry out some preliminary assembly tests to determine the right hole.

STANDARD  
 ON DEMAND

### MATERIAL

Steel			-----	.16
Ferritic stainless steel	1.4105	(Up to M16)	-----	.40
Austenitic stainless stell	1.4305	(Up to M20)	-----	.50
Brass		(Up to M16)	-----	.80

### FINISHING

Steel bushings: zinc-plated  
Stainless steel bushings: natural  
Brass bushings: natural

### TOLERANCES

ISO 2768 - m

### THREADING d1

ISO 6 H Metric

### EXAMPLE

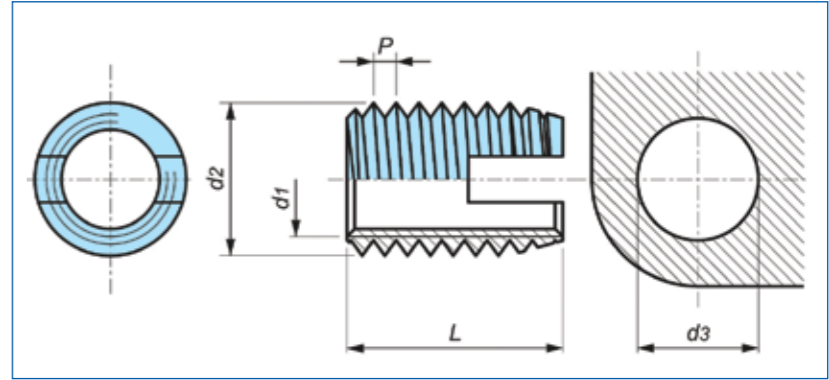
Self-tapping Ensat® series 302, M5 thread, zinc-plated steel:  
**302 0050.16**

# Ensat® Series 303



Applications:  
ferrous and no-ferrous  
metals, light alloy, cast  
iron, brass, plastic  
materials, resins.

Assembly:  
by special equipment.



CODE	METRIC THREAD d 1	SPECIAL EXTERNAL THREAD		TOTAL LENGHT L	APPOX. HOLE DIAMETER d 3			MIN. HOLE DEPTH
		d 2	P		Soft Materials Plastic	Brittle Materials Hard Plastic Light Alloy	Light Alloy No-ferrous Materials	
303 0030. __	M 3	4,5	0,5	6	4,0 - 4,1	4,1 - 4,2	4,2 - 4,3	8
303 0035. __	M 3,5	5	0,6	6	4,5 - 4,6	4,6 - 4,7	4,7 - 4,8	8
303 0040. __	M 4	6	0,7	6	5,3 - 5,4	5,5 - 5,6	5,6 - 5,7	8
303 0050. __	M 5	7	0,8	8	6,3 - 6,4	6,5 - 6,6	6,6 - 6,7	10
303 0060. __	M 6	8	1,0	10	7,1 - 7,2	7,3 - 7,5	7,5 - 7,6	13
303 0080. __	M 8	10	1,25	12	8,6 - 8,8	8,9 - 9,2	9,2 - 9,4	15
303 0100. __	M 10	12	1,5	15	10,6 - 10,8	10,9 - 11,2	11,2 - 11,4	18

Non binding dimensions, expressed in mm.

In order to use correctly the products, we suggest to carry out some preliminary assembly tests to determine the right hole.

### MATERIAL

Steel			-----	.16
Ferritic stainless steel	1.4105	(Thread excluded M3,5)	-----	.40 On demand
Austenitic stainless stell	1.4305	(Threads excluded M3,5 - M8 - M10)	-----	.50 On demand
Brass		(Threads excluded M3,5 - M8 - M10)	-----	.80 On demand

### FINISHING

Steel bushings: zinc-plated  
Stainless steel bushings: natural  
Brass bushings: natural

### TOLERANCES

ISO 2768 - m

### THREADING d1

ISO 6 H Metric

### EXAMPLE

Self-tapping Ensat® series 303, M5 thread, zinc-plated steel:  
**303 0050.16**

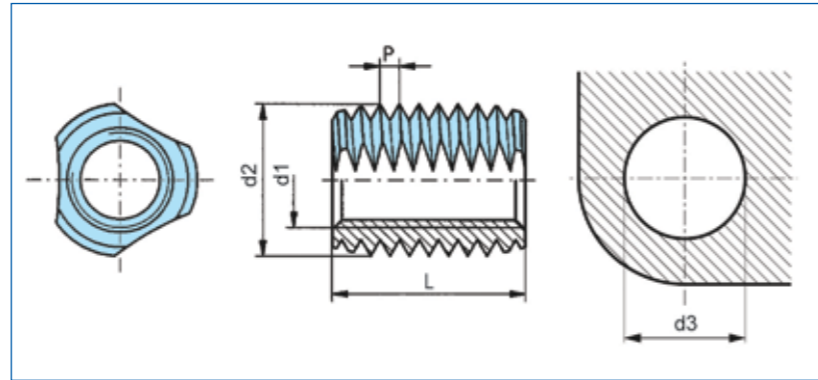
STANDARD  
 ON DEMAND

# Ensat® Series 305



Application:  
soft thermoplastic  
materials.

Assembly:  
by special equipment.



CODE	METRIC THREAD	SPECIAL EXTERNAL THREAD		TOTAL LENGHT	APPROX. HOLE DIAMETER	MIN. HOLE DEPTH
	d 1	d 2	P	L	d 3	
305 0030.80	M 3	5	0,5	6	4,6 - 4,7	7
305 0040.80	M 4	6,5	0,75	8	6,0 - 6,1	9
305 0050.80	M 5	8	1	10	7,3 - 7,4	11
305 0060.80	M 6	10	1,5	14	9,0 - 9,2	15

Non binding dimensions, expressed in mm.

Other METRIC, UNC, UNF, WHITWORTH, threads are available on demand.

In order to use correctly the products, we suggest to carry out some preliminary assembly tests to determine the right hole.

### MATERIAL

Brass \_\_\_\_\_ .80

### FINISHING

Natural

### TOLERANCES

ISO 2768 -m

### THREADING d1

ISO 6 H Metric

### EXAMPLE

Self-tapping Ensat® series 305, M5 thread, brass bushing:  
305 0050.80

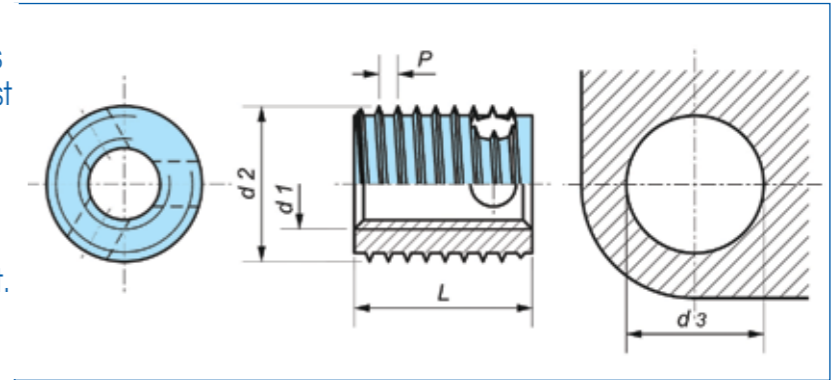
STANDARD  
 ON DEMAND

# Ensat® Series 307 - 308



Applications:  
ferrous and no-ferrous  
metals, light alloy, cast  
iron, plastic  
materials, resins.

Assembly:  
by special equipment.



CODE	METRIC THREAD	SPECIAL EXTERNAL THREAD		TOTAL LENGHT	APPOX. HOLE DIAMETER d 3			MIN. HOLE DEPTH
		d 2	P		Light alloy Rm < 250 < 150 HB Plastic	Light alloy Rm < 350 C. Iron < 200 HB Hard Plastic	Light alloy Rm > 350 C. Iron > 200 HB Brass, No-ferrous metal	
307 0030.____	M 3	5	0,6	4	4,6 - 4,7	4,7	4,7 - 4,8	6
308 0030.____				6				8
307 0035.____	M 3,5	6	0,8	5	5,5 - 5,6	5,6	5,6 - 5,7	7
308 0035.____				8				10
307 0040.____	M 4	6,5	0,8	6	6,0 - 6,1	6,1	6,1 - 6,2	8
308 0040.____				8				10
307 0050.____	M 5	8	1	7	7,4 - 7,5	7,5 - 7,6	7,6 - 7,7	9
308 0050.____				10				13
307 0060.____	M 6	10	1,25	8	9,3 - 9,4	9,4 - 9,5	9,5 - 9,6	10
308 0060.____				12				15
307 0080.____	M 8	12	1,5	9	11,1 - 11,2	11,2 - 11,3	11,3 - 11,5	11
308 0080.____				14				17
307 0100.____	M 10	14	1,5	10	13,1 - 13,2	13,2 - 13,3	13,3 - 13,5	13
308 0100.____				18				22
307 0120.____	M 12	16	1,75	12	15,0 - 15,1	15,1 - 15,2	15,2 - 15,4	15
308 0120.____				22				26
307 0140.____	M 14	18	2	14	17,0 - 17,1	17,1 - 17,2	17,2 - 17,4	17
308 0140.____				24				28
307 0160.____	M 16	20	2	14	19,0 - 19,1	19,1 - 19,2	19,2 - 19,4	17
308 0160.____				24				28

Non binding dimensions, expressed in mm.

Rm = ultimate tensile strenght N/mm²  
HB = Brinell hardness

Other METRIC, UNC, UNF, WHITWORTH, threads are available on demand.

In order to use correctly the products, we suggest to carry out some preliminary assembly tests to determine the right hole.

### MATERIAL

Steel

Ferritic stainless steel 1.4105 (Up to M14) \_\_\_\_\_ .16  
Austenitic stainless steel 1.4305 (Up to M12) \_\_\_\_\_ .40  
\_\_\_\_\_ .50

### FINISHING

Steel bushings: zinc-plated  
Stainless steel bushings: natural

### TOLERANCES

ISO 2768 - m

### THREADING d1

ISO 6 H Metric

### EXAMPLE

Self-tapping Ensat® series 308, M5 thread, zinc-plated steel:  
308 0050.16

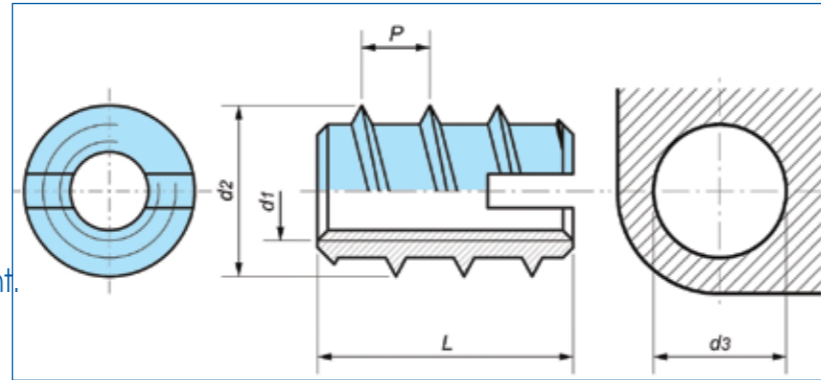
STANDARD  
 ON DEMAND

# Ensats® Series 309



Application:  
soft thermoplastic  
materials, wood  
and its derived  
products.

Assembly:  
by special equipment.



CODE	METRIC THREAD d 1	SPECIAL EXTERNAL THREAD		TOTAL LENGHT L	APPROX. HOLE DIAMETER d 3		MIN. HOLE DEPTH
		d 2	P		Soft Material	Hard Material	
309 0025.80	M 2,5	5	1,6	6	3,5	3,6 - 3,8	8
309 0030.80	M 3	5,5	1,6	6	4,1	4,2 - 4,3	9
309 0035.80	M 3,5	6,5	1,6	8	4,6	4,7 - 4,8	10
309 0040.80	M 4	7	2,5	10	5,1	5,2 - 5,3	13
309 0050.80	M 5	9	3	12	6,6	6,7 - 6,9	15
309 0060.80	M 6	10	4	14	7,6	7,7 - 7,9	17
309 0080.80	M 8	13	4	20	9,9	10,1 - 10,3	23
309 0100.80	M 10	16	5	23	12,4	12,6 - 12,8	26
309 0120.80	M 12	19	5	26	15,4	15,6 - 15,8	30
309 0140.80	M 14	22	5	26	18,4	18,6 - 18,8	30
309 0160.80	M 16	24	5	26	20,4	20,6 - 20,8	30

Non binding dimensions, expressed in mm.

In order to use correctly the products, we suggest to carry out some preliminary assembly tests to determine the right hole.

### MATERIAL

Brass ----- .80

### FINISHING

Natural

### TOLERANCES

ISO 2768 - m

### THREADING d1

ISO 6 H Metric

### EXAMPLE

Self-tapping Ensats® series 309, M5 thread, brass bushing:

**309 0050.80**

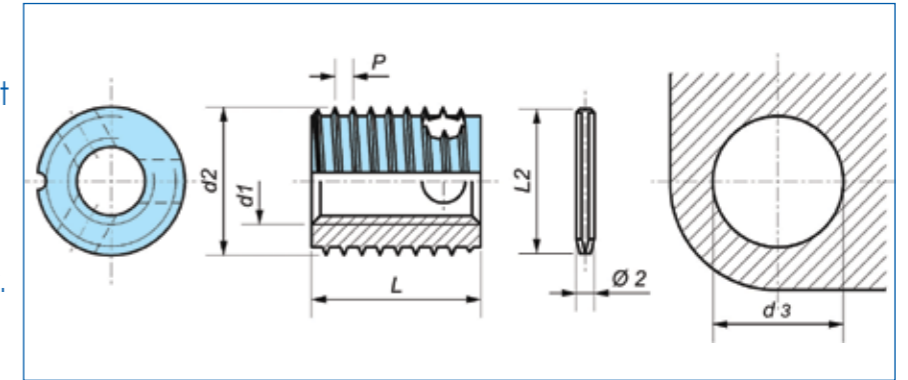
STANDARD  
 ON DEMAND

# Ensats® Series 317 - 318



Applications:  
ferrous and no-ferrous  
metals, light alloy, cast  
iron, plastic  
materials, resins.

Assembly:  
by special equipment.



CODE	METRIC THREAD d 1	SPECIAL EXTERNAL THREAD		TOTAL LENGHT		APPROX. HOLE DIAMETER d 3			MIN. HOLE DEPTH
		d 2	P	L	L2	Light alloy Rm < 250 < 150 HB Plastic	Light alloy Rm < 350 C. Iron < 200 HB Hard Plastic	Light alloy Rm > 350 C. Iron > 200 HB Brass, No-ferrous metal	
317 0040.____	M 4	6,5	0,8	6	4	6,0 - 6,1	6,1 - 6,1	6,1 - 6,2	8
318 0040.____				8	6				10
317 0050.____	M 5	8	1	7	4	7,4 - 7,5	7,5 - 7,6	7,6 - 7,7	9
318 0050.____				10	6				13
317 0060.____	M 6	10	1,25	8	6	9,3 - 9,4	9,4 - 9,5	9,5 - 9,6	10
318 0060.____				12	10				15
317 0080.____	M 8	12	1,5	9	6	11,1 - 11,2	11,2 - 11,3	11,3 11,5	11
318 0080.____				14	10				17
317 0100.____	M 10	14	1,5	10	6	13,1 - 13,2	13,2 - 13,3	13,3 - 13,5	13
318 0100.____				18	16				22
317 0120.____	M 12	16	1,75	12	10	15,0 - 15,1	15,1 - 15,2	15,2 - 15,4	15
318 0120.____				22	16				26
317 0140.____	M 14	18	2	14	10	17,0 - 17,1	17,1 - 17,2	17,2 - 17,4	17
318 0140.____				24	16				28
317 0160.____	M 16	20	2	14	10	19,0 - 19,1	19,1 - 19,2	19,2 - 19,4	17
318 0160.____				24	16				28

Non binding dimensions, expressed in mm.

Rm = ultimate tensile strenght N/mm²  
HB = Brinell hardness

Other METRIC, UNC, UNF, WHITWORTH, threads are available on demand.

In order to use correctly the products, we suggest to carry out some preliminary assembly tests to determine the right hole.

### MATERIAL

Steel ----- .16  
Ferritic stainless steel 1.4105 ----- .40  
Austenitic stainless stell 1.4305 ----- .50

### FINISHING

Steel bushings: zinc-plated  
Stainless steel bushings: natural

### TOLERANCES

ISO 2768 - m

### THREADING d1

ISO 6 H Metric

### EXAMPLE

Self-tapping Ensats® series 318, M5 thread, zinc-plated steel:

**318 0050.16**

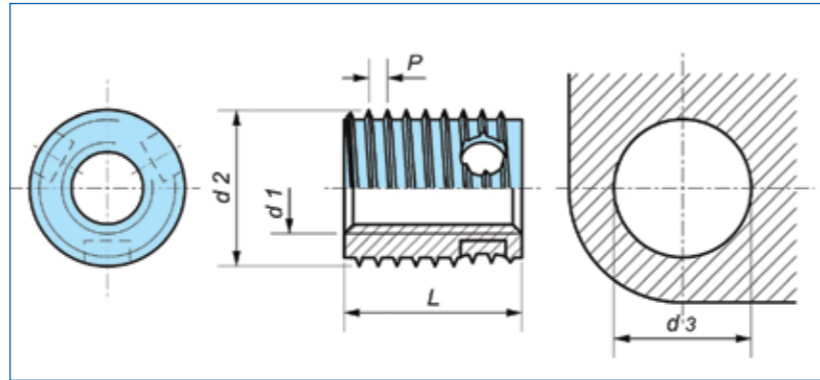
STANDARD  
 ON DEMAND

# Ensat® Series 337 - 338



Applications:  
ferrous and no-ferrous  
metals, light alloy,  
cast iron, plastic  
materials, resins.

Assembly:  
by special equipment.



CODE	METRIC THREAD d 1	SPECIAL EXTERNAL THREAD		TOTAL LENGHT L	APPROX. HOLE DIAMETER d 3			MIN. HOLE DEPTH
		d 2	P		Light alloy Rm < 250 < 150 HB Plastic	Light alloy Rm < 350 C. Iron < 200 HB Hard Plastic	Light alloy Rm > 350 C. Iron > 200 HB Brass, No-ferrous metal	
337 0030.____	M 3	5	0,6	4	4,6 - 4,7	4,7 - 4,7	4,7 - 4,8	6
338 0030.____				6				8
337 0035.____	M 3,5	6	0,8	5	5,5 - 5,6	5,6 - 5,6	5,6 - 5,7	7
338 0035.____				8				10
337 0040.____	M 4	6,5	0,8	6	6,0 - 6,1	6,1 - 6,1	6,1 - 6,2	8
338 0040.____				8				10
337 0050.____	M 5	8	1	7	7,4 - 7,5	7,5 - 7,6	7,6 - 7,7	9
338 0050.____				10				13
337 0060.____	M 6	10	1,25	8	9,3 - 9,4	9,4 - 9,5	9,5 - 9,6	10
338 0060.____				12				15
337 0080.____	M 8	12	1,5	9	11,1 - 11,2	11,2 - 11,3	11,3 - 11,5	11
338 0080.____				14				17
337 0100.____	M 10	14	1,5	10	13,1 - 13,2	13,2 - 13,3	13,3 - 13,5	13
338 0100.____				18				22
337 0120.____	M 12	16	1,75	12	15,0 - 15,1	15,1 - 15,2	15,2 - 15,4	15
338 0120.____				22				26
337 0140.____	M 14	18	2	14	17,0 - 17,1	17,1 - 17,2	17,2 - 17,4	17
338 0140.____				24				28
337 0160.____	M 16	20	2	14	19,0 - 19,1	19,1 - 19,2	19,2 - 19,4	17
338 0160.____				24				28

Non binding dimensions, expressed in mm.

Rm = ultimate tensile strenght N/mm²  
HB = Brinell hardness

Other METRIC, UNC, UNF, WHITWORTH, threads are available on demand.

In order to use correctly the products, we suggest to carry out some preliminary assembly tests to determine the right hole.

### MATERIAL

Steel		-----	.16
Ferritic stainless steel	1.4105	-----	.40
Austenitic stainless stell	1.4305	-----	.50

### FINISHING

Steel bushings: zinc-plated  
Stainless steel bushings: natural

### TOLERANCES

ISO 2768 - m

### THREADING d1

ISO 6 H Metric

### EXAMPLE

Self-tapping Ensat® series 338, M5 thread, zinc-plated steel:  
**338 0050.16**

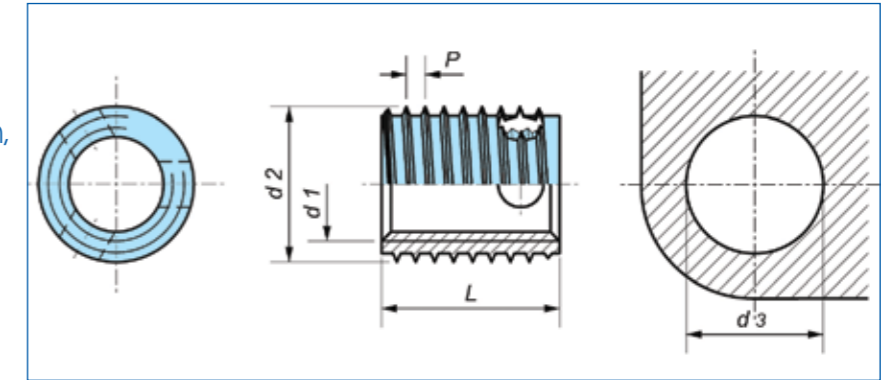
STANDARD  
 ON DEMAND

# Ensat® Serie 347 - 348



Applications:  
ferrous and  
no-ferrous metals,  
light alloy, cast iron,  
plastic materials,  
resins.

Assembly:  
by special  
equipment.



CODE	METRIC THREAD d 1	SPECIAL EXTERNAL THREAD		TOTAL LENGHT L	APPROX. HOLE DIAMETER d 3		MIN. HOLE DEPTH
		d 2	P		Plastic	Metal - Light alloy	
347 0040.____	M 4	6	0,7	6	5,4 - 5,6	5,6 - 5,7	8
348 0040.____				8			10
347 0050.____	M 5	6,5	0,8	7	6,0 - 6,1	6,1 - 6,2	9
348 0050.____				10			13
347 0060.____	M 6	8	1	8	7,4 - 7,6	7,5 - 7,7	10
348 0060.____				12			15
347 0080.____	M 8	10	1,25	9	9,3 - 9,5	9,4 - 9,6	11
348 0080.____				14			17
347 0100.____	M 10	12	1,5	10	11,1 - 11,3	11,2 - 11,5	13
348 0100.____				18			22
347 0120.____	M 12	14	1,75	12	13,1 - 13,3	13,2 - 13,5	15
348 0120.____				22			26

Non binding dimensions, expressed in mm.

In order to use correctly the products, we suggest to carry out some preliminary assembly tests to determine the right hole.

### MATERIAL

Steel		-----	.16
Ferritic stainless steel	1.4105	-----	.40
Austenitic stainless stell	1.4305	-----	.50

### FINISHING

Steel bushings: zinc-plated  
Stainless steel bushings: natural

### TOLERANCES

ISO 2768 - m

### THREADING d1

ISO 6 H Metric

### EXAMPLE

Self-tapping Ensat® series 348, M5 thread, zinc-plated steel:  
**348 0050.16**

STANDARD  
 ON DEMAND

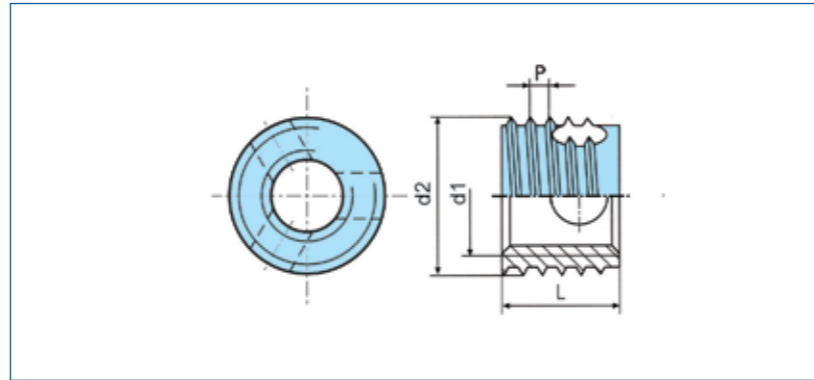


# Ensats® Series 304



Application:  
for the repair of torn  
and damaged spark  
plug retaining threads  
in engines.

Assembly:  
by special equipment.



CODE	EXTERNAL SPECIAL THREAD			THREAD		LENGHT L	Ø HOLE (1)
	d 1	P	DIN	d 2	P		
304 0140.16	14	1,25	72502	17,7	1,25	9	17,0
304 0141.16	14	1,25	72502	17,7	1,25	15	17,0
304 0180.16	18	1,5	72501	21,7	1,25	9	21,0

Guidelines values for normal applications.  
(1) Deviations, depending on the strenght of the cylinder head alloy  
+/-0,1 mm

**MATERIAL**  
Steel

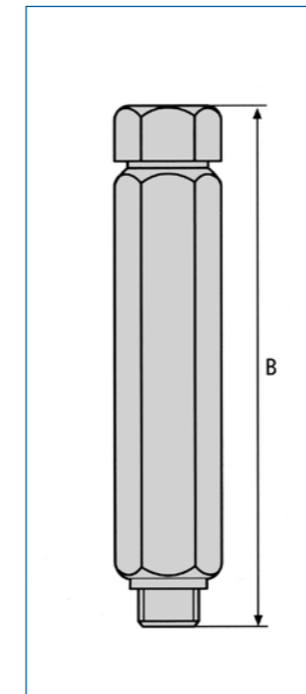
**FINISHING**  
Zinc-plated

**EXAMPLE**  
Spark plug insert with internal thread A = M14 x 1,25 mm, length B = 9 mm  
made of hardened zinc plated steel:  
**304 0140.16**

STANDARD  
 ON DEMAND

# Ensats® Series 304 assembly tools

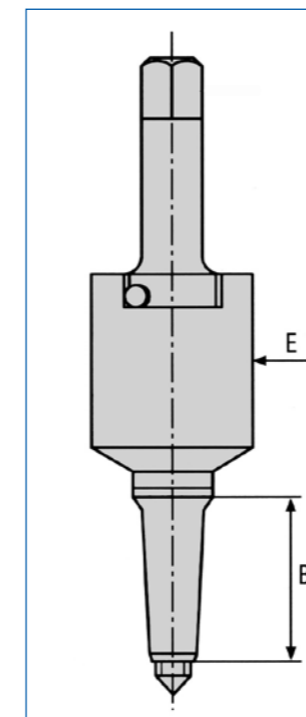
## TOOLS 619 FOR MANUAL INSTALLATION



CODE	TOOL FOR	SQUARE FLAT	LENGHT B ca
619 0140.00	304 0140.16 304 0141.16	22	100
619 0180.00	304 0180.16	22	100

Dimensions expressed in mm.

## TOOLS 629 FOR MACHINE INSTALLATION



CODE	TOOL FOR	MAX DIAMETER E	LENGHT B1 ca
629 0146.00	304 0140.16 304 0141.16	50	72
629 0187.00	304 0180.16	50	73

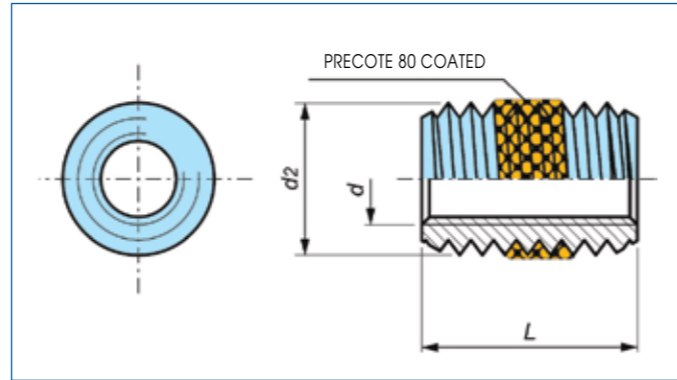
Dimensions expressed in mm.

# Mubux® Series M 970



Application:  
materials with suitable  
threaded holes.

Installation by screwing



CODE	TOTAL LENGTH L
971 ____	1 d
972 ____	1,5 d
973 ____	2 d
974 ____	2,5 d

Non binding dimensions, expressed in mm.

CODE	INTERNAL THREAD d	EXTERNAL THREAD d 2	STANDARD LENGTHS			
			1 d	1,5 d	2 d	2,5 d
___0030___	M 3	M 5		4,5	6	
___0040___	M 4	M 6		6	8	10
___0050___	M 5	M 7		7,5	10	12,5
___0060___	M 6	M 8		9	12	15
___0080___	M 8	M 12		12	16	20
___0100___	M 10	M 14		15	20	25
___0120___	M 12	M 16	12	18	24	30

**MATERIAL**  
Steel

**FINISHING**  
Zinc-plated, \_\_\_\_\_,10  
Precote 80 Coating \_\_\_\_\_,16

**TOLERANCES**  
Length L ± 0,25

**THREADING**  
Metric Internal ISO 6 H  
Metric External

**EXAMPLE**  
Threaded insert Mubux-M 970 series with internal thread M5, external thread M7 length 2d made of zinc plated steel and coated with precote 80:

**Mubux-MO 973 000 050.16**

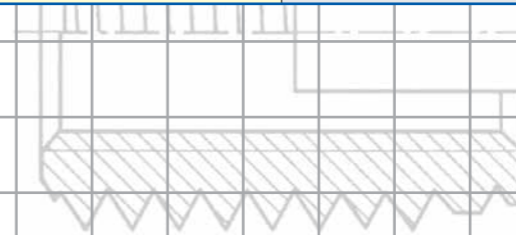
WORKPIECE: SHEAR STRENGTH N/mm²	TENSILE: STRENGTH OF SCREW (DIN)	RECCOMENDED LENGTH				
		M 3	M 4	M 5	M 6 - M 10	M 12
≥ 70	4,8	2 d	1,5 d	2 d	2 d	
≥ 140	4,8	2 d	1,5 d	2 d	1,5 d	1 d
	6,8	2 d	1,5 d	2 d	1,5 d	1,5 d
≥ 210	8,8	2 d	1,5 d	2 d	2 d	2 d
	6,8	2 d	1,5 d	2 d	1,5 d	1 d
	8,8	2 d	1,5 d	2 d	1,5 d	1,5 d
≥ 280	12,9	2 d	1,5 d	2 d	1,5 d	2 d
	14,9	2 d	2 d	2 d	2 d	2,5 d
	6,8	2 d	1,5 d	2 d	1,5 d	1 d
≥ 280	8,8 - 12,9	2 d	1,5 d	2 d	1,5 d	1,5 d
	14,9	2 d	1,5 d	2 d	1,5 d	2 d

**Example:**  
Shearing strength of the workpiece appr. 160 N/mm 2, screw M6, strength class 8.8  
Recommended length: 2A = 2x6 mm = 12 mm.

STANDARD  
 ON DEMAND

# Conversion table for metric/imperial threads

METRIC		WHITWORTH		UNC		UNF	
CORRESPONDING TO	THREAD	CODE	THREAD	CODE	THREAD	CODE	THREAD
___030___	M 3			604	4-40	704	4-48
___035___	M 3,5			606	6-32	706	6-40
___040___	M 4			608	8-32	708	8-36
___050___	M 5			610	10-24	710	10-32
___060___	M 6	525	1/4	625	1/4"-20	725	1/4"-28
___080___	M 8	531	5/16	631	5/16"-18	731	5/16"-24
___100___	M 10	537	3/8	637	3/8"-16	737	3/8"-24
___120___	M 12	544	7/16	644	7/16"-14	744	7/16"-20
___140___	M 14	550	1/2	650	1/2"-13	750	1/2"-20
___160___	M 16	562	5/8	662	5/8"-11	762	5/8"-18



Special products are available on request.  
For further information please contact  
SPECIALINSERT technical department.

