

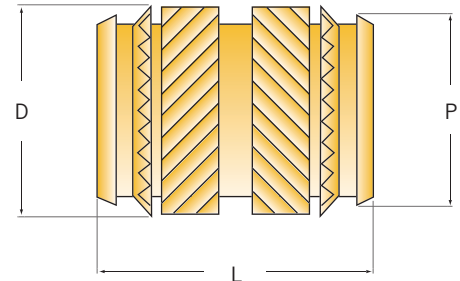


“Twin Zert” is designed to be installed into a wide variety of thermoplastics. The inserts double ended design eliminates the need for orientation during installation. Opposing helical knurls and knurled vanes give the insert superior pull-out performance over most inserts. Heat is the recommended method for installation. *Performance values are on page 34.*

Plastic Materials

PA- Filled	PP
PPS	PE
PBT	HDPE
PC / ABS Blends	PPO
PA - Unfilled	
POM (Acetal)	
PVC	

Insert



Installation

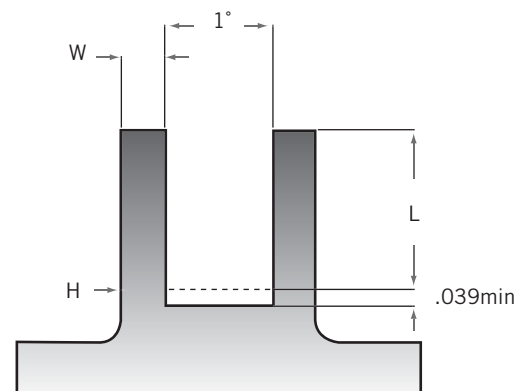
Direct Heat Fully Automated

Materials

Brass Aluminum (special order)
 Stainless Steel (special order)

Design Recommendations

“Twin Zert” is designed to be installed into a straight hole with a maximum of a 1° inclusive taper. Holes should not be counter sunk or counter bored as this will decrease the fasteners performance. The recommended hole size applies at the point reached by the bottom of the insert. Hole size tolerance $-0.000 + 0.004$ inches. When using heat to install the inserts, the heat should be sufficient to soften the plastic without it melting. This will allow for optimum performance without causing flash or degrading the plastic. Available In Brass. (other materials may be available on request)



Twin Zert Size Chart

Inch	Thread	L Insert Length	D Insert Dia.	P Pilot End Dia.	H Hole Size (+.004 -.000)	W Min. Wall Thickness	Part Number
	2 - 56	.155	.137	.123	.126	.051	TWZ - 256 - 155
4 - 40	.224	.174	.154	.157	.063	TWZ - 440 - 224	
6 - 32	.279	.206	.185	.189	.071	TWZ - 632 - 279	
8 - 32	.319	.239	.218	.220	.083	TWZ - 832 - 319	
10 - 24	.373	.269	.249	.252	.102	TWZ - 1024 - 373	
10 - 32	.373	.269	.249	.252	.102	TWZ - 1032 - 373	
1/4 - 20	.498	.333	.312	.315	.130	TWZ - 2520 - 498	
1/4 - 28	.498	.333	.312	.315	.130	TWZ - 2528 - 498	
5/16 - 18	.498	.394	.374	.378	.177	TWZ - 3118 - 498	
3/8 - 16	.498	.485	.465	.469	.236	TWZ - 3716 - 498	
1/2 - 13	.626	.643	.622	.630	.315	TWZ - 5013 - 626	

(All dimensions in inches)

Metric	Thread	L Insert Length	D Insert Dia.	P Pilot End Dia.	H Hole Size (+.010 -.000)	W Min. Wall Thickness	Part Number
	M2	3.94	3.48	3.12	3.20	1.30	TWZ - M2 - 3.94
M2.5	5.69	4.42	3.91	4.00	1.60	TWZ - M2.5 - 5.69	
M3	5.69	4.42	3.91	4.00	1.60	TWZ - M3 - 5.69	
M3.5	7.09	5.23	4.70	4.80	1.80	TWZ - M3.5 - 7.09	
M4	8.10	6.07	5.54	5.60	2.10	TWZ - M4 - 8.10	
M5	9.47	6.83	6.32	6.40	2.60	TWZ - M5 - 9.47	
M6	12.65	8.46	7.92	8.00	3.30	TWZ - M6 - 12.65	
M8	12.65	10.00	9.50	9.60	4.50	TWZ - M8 - 12.65	
M10	12.65	12.32	11.81	11.90	6.00	TWZ - M10 - 12.65	
M12	15.88	16.33	15.80	16.00	8.00	TWZ - M12 - 15.88	

(All dimensions in millimeters)

* Add "AL" to the end of the part number for Aluminum
ex: TWZ-632-281-AL

* Add "SS" to the end of the part number for stainless steel
ex: TWZ-632-281-SS