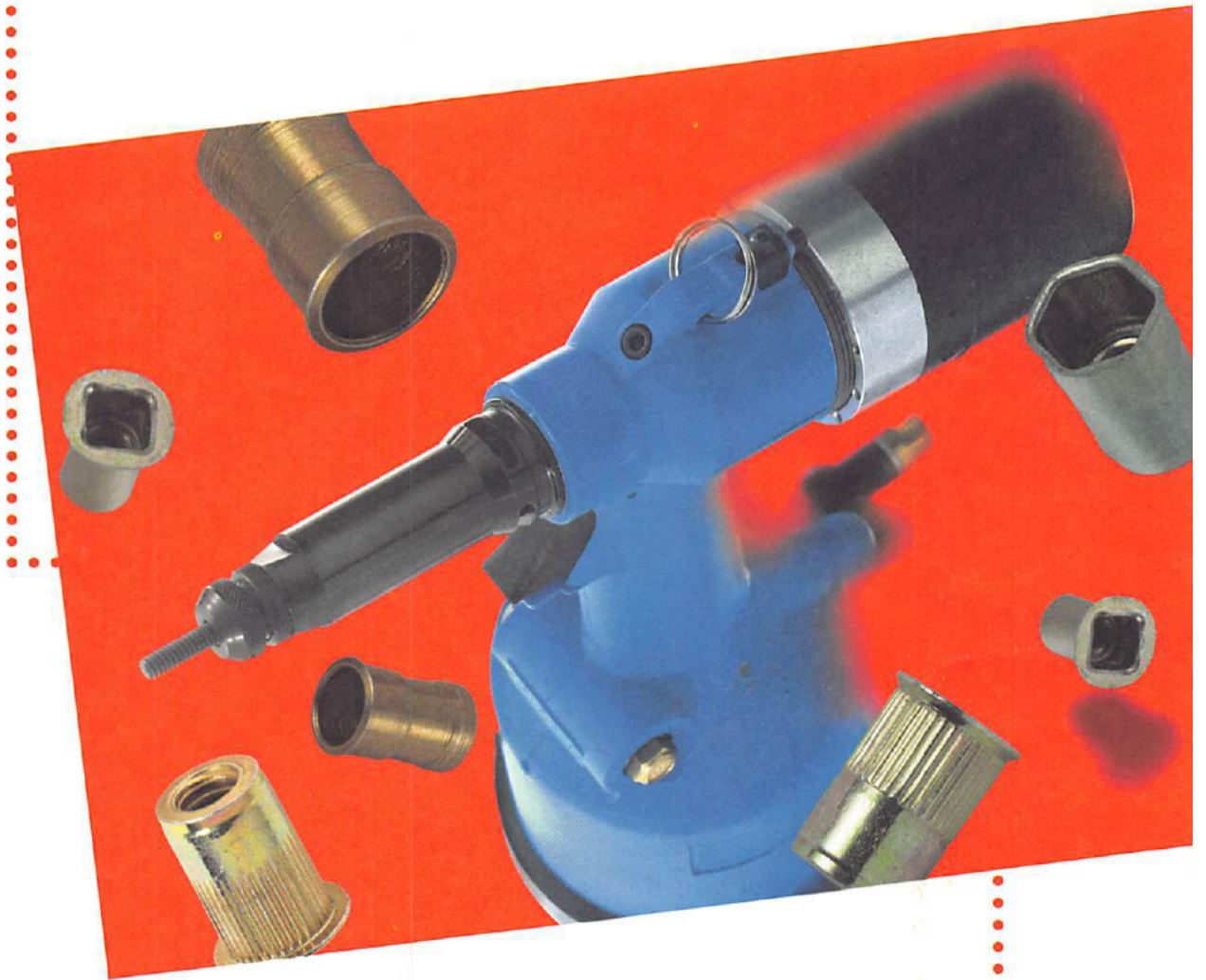


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## Blind Threaded Inserts

*Engineered Fasteners and Assembly Systems*



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## Warranty Information

Avdel Cherry Textron (hereinafter "Avdel Cherry"), hereby warrants to the initial retail customer and original installer ("Warrantee") only that its products will be free from defects in material and workmanship, provided that the products are used in accordance with Avdel Cherry's instructions as to maintenance, operation and use.

The warrantee's only remedy and Avdel Cherry's only obligation in the event of a defect or failure in the products, is that Avdel Cherry will, at its sole option, repair, replace, or rework the products, but in no case shall the cost of the foregoing exceed the invoice price of the products.

This warranty shall be void if any person seeking to make a claim for defective or failed products fails to notify Avdel Cherry within thirty (30) days of receipt of evidence that the product is defective or has failed, or if said person fails to provide Avdel Cherry with such evidence as is reasonably requested concerning the defect or failure, including without limitation, evidence of the date of purchase and date of installation.

THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING MERCHANTABILITY OR FITNESS PROVIDED FOR HEREIN. UNDER NO CIRCUMSTANCES SHALL AVDEL CHERRY BE LIABLE FOR INCIDENTAL OR CONSEQUENTIAL DAMAGES ARISING FROM ANY DEFECT OR FAILURE IN ITS PRODUCTS.

***NOTE: The properties, strengths, dimensions, installed characteristics and all other information in this catalog is for guidance only to aid in the correct selection of the products described herein and is not intended or implied as part of the above warranty. All applications should be evaluated for functional stability and available samples of the described parts can be requested for installed tests, suitability and evaluations***

All inquiries concerning this Warranty should be sent to:

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## Company Information

### **About Avdel Cherry Textron**

Avdel Cherry Textron is a 60-year leader in the design and manufacture of quality engineered assembly systems, including structural and non-structural blind rivets, threaded inserts, lockbolts, speed fastening, self-piercing rivets, and installation tools. Avdel Cherry supplies its world class products to the major automakers and their subcontractors, the transportation industry, major electronics manufacturers and their subcontractors, as well as a variety of other industries worldwide.

Avdel Cherry Textron was formed January 1, 1996, following the merger of Cherry Textron's Commercial Fastener Division with the U.S. operating company of UK-based Avdel Textron. Now part of Textron Fastening Systems — the global leader in fastening solutions — Avdel Cherry strengthens the group's international presence that already includes Camcar and Elco in the U.S., together with European-based Avdel Textron, Textron Industries, Boesner, BSK and Sükosim GmbH.

Textron Inc., with annual revenues exceeding \$10 billion (NYSE:TXT), is a global, multi-industry company with market-leading operations in five business segments: Aircraft, Automotive, Industrial, Systems and Components, and Finance. Current and more detailed information regarding Textron Inc. is available by contacting the company's Providence, RI headquarters, or via the Internet: <http://www.textron.com>.

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Page 98

# Blind Threaded-Insert Fastening

## General Information

### Why Threaded Inserts?

- Low installed cost
- Blind installation
- Permanent, reliable fastening
- Eliminates the need for welding or tapping
- Technically-advanced tooling systems

Avdel Cherry threaded inserts provide high-strength, load-bearing threads that are installed quickly and cost effectively into thin, thick, soft, hard and composite materials. The wide range of Avdel Cherry threaded inserts have been designed to meet and exceed the varied performance requirements of today's industry.

Avdel Cherry's threaded insert tooling utilizes leading-edge technology to provide a range of installation equipment, to best suit each applications requirements.

4

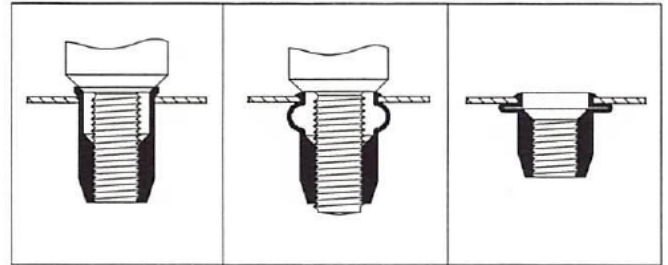
The combination of the extensive threaded insert product line and the wide range of in-house manufactured tooling, provides a unique fastening system to the end user. The advantages offered include:

- **Low Installed Cost** The speed and ease of assembly reduces the cost of the product manufactured versus other methods of providing threads in thin sheet material.
- **Blind Installation** One-side installation provides ease of placement and allows use in enclosed and solid applications.
- **Permanent, Reliable Fastening** A secure and permanent fixing that is resistant to vibration.
- **Eliminates The Need For Welding Or Tapping** Can be installed in pre-painted / pre-plated applications.
- **Technically-Advanced Tooling Systems** Ergonomic hand and power tools with simple one-press trigger action. Automated placing equipment which reduce labor costs, balance manufacturing lines and deal with high-volume applications.

### Installation

The installation of Avdel Cherry threaded inserts is easily accomplished with the use of our ergonomic, hand-held tooling through to fully automatic vibratory bowl feed equipment.

### Setting Sequence:



1. The insert is threaded onto the mandrel of the tool and then placed into a prepared hole.
2. The mandrel then retracts into the tool which collapses the wall of the sheet, or by expanding the insert into the parent material.
3. The mandrel then reverses from the threaded insert. The threaded insert is now installed.

### Selecting the Correct Threaded Insert

1. The required performance of the insert such as torque to turn, push out, pull out or torque out will help determine the selection.
2. Select the thread size.
3. Measure the application thickness; i.e., the grip range required.
4. Select the tooling and nose equipment.

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## Test Method

Avdel Cherry Textron threaded inserts are typically tested in four ways:

- Torque To Turn
- Pull Out
- Push Out
- Maximum Torque (Torque Out)

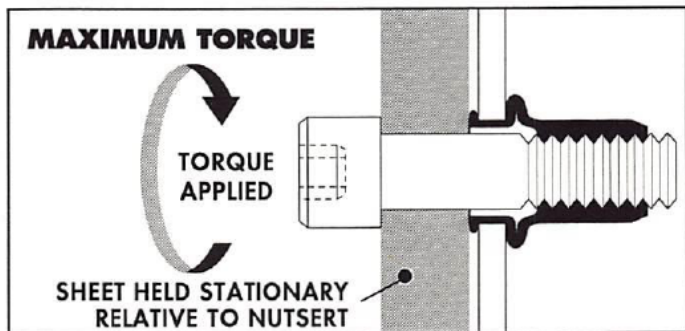
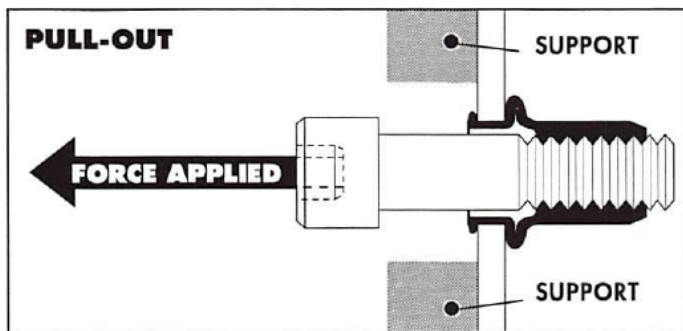
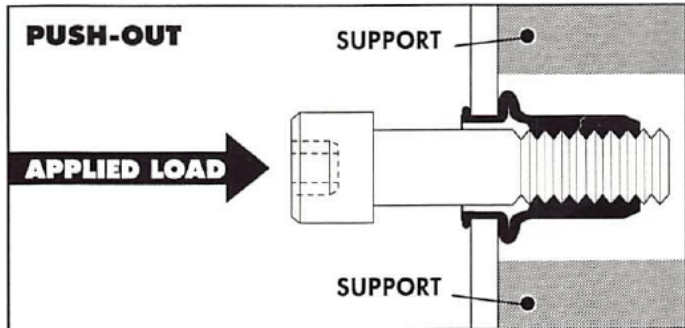
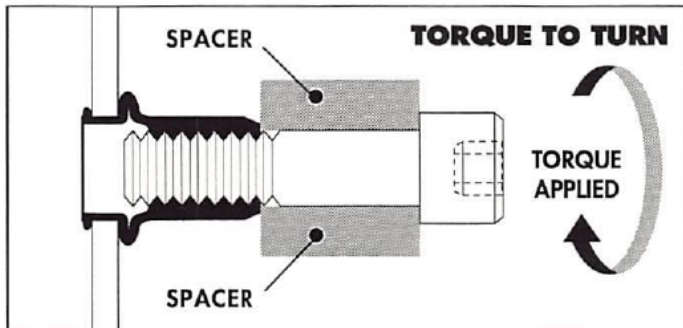
Below are diagrammatic representations of the method used for each test:

## Test Conditions

The test conditions are listed below and remain constant for all product in the catalog:

<b>Material Composition</b>	Mild Cold-Rolled Steel
<b>Material Thickness</b>	Min. Grip
<b>Hole Size</b>	Max. Hole Size
<b>Placing Tool</b>	Avdel Cherry Spin-Spin Tooling

**NOTE:** It is recommended that the selected threaded insert is tested in the application to provide application specific performance data.



# Blind Threaded-Insert Fastening

Catalog Format


The product information for each product in this catalog is divided into two sections:

## Product Identification, Benefits and Drawing

**LF-TSN<sup>®</sup> Fastening System**
*Product Information*

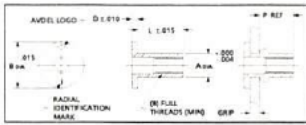
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Large-flange head style provides increased push-out performance.



**Benefits:**

- **Reduced Assembly Costs**  
Blind installation is installed fast and cleanly.
- **Designed for Thin Materials**  
Can work in materials as thin as .020" and greater
- **Permanent**  
Crimps the parent material, providing secure and permanent load-bearing threads.
- **Large Flange Head**  
Increased push-out performance.



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## Product Dimensions

*Technical Information*
**LF-TSN<sup>®</sup> Fastening System**

---

Material	Alloy	Finish
STEEL	1006/1010 Low Carbon Steel	2nd Phase, Type 1, Class 3 with Supplementary Clear Chromate

Thread Size	Part Number	Grp	L	B	D	A	n	Insert Mark	Dwell Size (Ref)	Hole Size	
										Min.	Max.
<b>Series M30</b>											
1/4-20 UNC	9434-0830	200-200	423	115.40	400	114.40	BLANK				
	9434-0832	200-140	407	114.00	400	113.00	1 RAD			332	338
	9434-0834	200-100	391	112.60	400	111.60	2 RAD		Ø2	316	322
	9434-0836	200-200	412	113.80	400	112.80	3 RAD				
3/8-16 UNC	9434-1034	200-275	540	152.40	500	151.40	BLANK				
	9434-1036	200-200	475	142.90	500	141.90	1 RAD		Ø2	413	429
	9434-1038	200-175	450	140.00	500	139.00	2 RAD			10.40	10.70
	9434-1040	200-175	450	140.00	500	139.00	2 RAD				
3/8-16 UNC	9434-1037	200-175	450	140.00	500	139.00	BLANK				
	9434-1039	200-175	450	140.00	500	139.00	1 RAD		Ø1.5mm	400	400
	9434-1041	200-175	450	140.00	500	139.00	2 RAD			12.40	12.70
	9434-1043	200-200	475	142.90	500	141.90	3 RAD				

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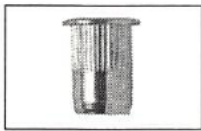
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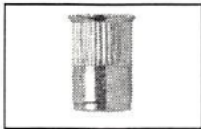
## Insert Range



**DL™ Insert**

**PAGE 8**

The DL series features a large flange-head configuration with a splined body.



**DK™ Insert**

**PAGE 12**

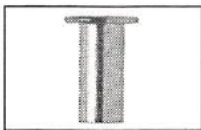
The DK series features a low-profile head configuration with a splined body.



**TSN® (Thin Sheet Nutsert)**

**PAGE 16**

Low-profile head style provides near flush fit to workpiece.



**Large Flange TSN®**

**PAGE 20**

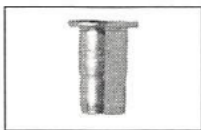
Large-flange head style provides increased push-out performance.



**Nutsert®**

**PAGE 24**

Provides captive threads in any material thickness greater than .030, up to and including blind holes.



**Eurosert®**

**PAGE 28**

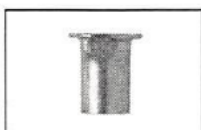
A range of four hard metric product lines in a combination of head and body styles.



**Hexsert®**

**PAGE 32**

Three product lines with a hexagonal body style provides superior torque-to-turn and pull-out performance.



**Squaresert®**

**PAGE 34**

Square-bodied product provides the ultimate in torque-to-turn performance.



**Supersert®**

**PAGE 36**

Provides captive threads in material thickness greater than .030" including blind holes.



**Closed End**

**PAGE 38**

Like TSN / LF TSN with closed-end nut section.

## Placement Tools

**PAGE 40**

## Placement Tools Cross-Reference Matrix

**PAGE 43**

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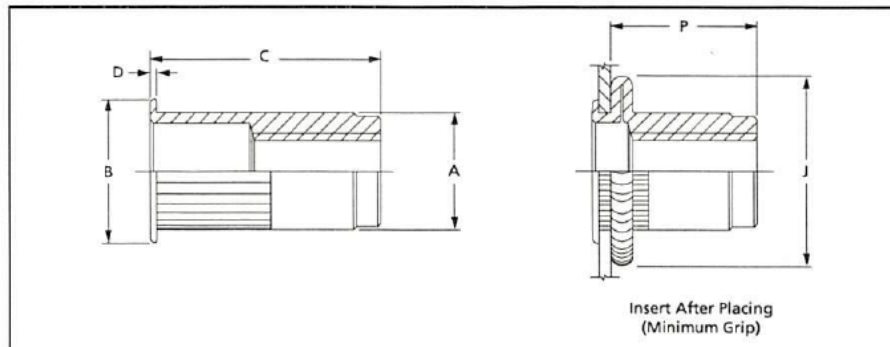
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The DL™ series features a large flange head configuration with a splined body.



### Benefits:

- **Splined Body**  
The splined body provides increased torque-to-turn resistance over conventional non-splined inserts.
- **Large Flange**  
Provides a large bearing surface which increases push-out performance.
- **Wide Grip Range**  
The range of products within the DL™ series provides a placing capability in material thickness ranging from .020" (0,5mm) to 0.312" (7,9mm).
- **High-Strength Threads**  
The threads are rolled into the product creating a work-hardened surface providing high-strength, load-bearing threads.
- **Lead-In Chamfer**  
The lead-in chamfer on the body provides ease of insertion into the work piece.



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## Imperial

Series	Material	Finish
DLA-XXXX-XXX	Aluminum	Clear Protective Coating
DLS-XXXX-XXX	Steel	ASTM 633-85, TYPE II, Fe/Zn8 Zinc Plate and Yellow Dichromate

Thread Designation	Grip Range	Hole +.006 Dia. -.000	Steel Series	Aluminum Series	A Max.	B Nom.	C Max.	P Ref.	D Max.	J Max.
<b>Imperial Series (all dimensions in inches)</b>										
#6-32 UNC	.020-.080	17/64 (.2656)	<b>DLS-632-80</b>	<b>DLA-632-80</b>	.265	.375	.460	.275	.032	.390
#6-32 UNC	.080-.130	17/64 (.2656)	<b>DLS-632-130</b>	<b>DLA-632-130</b>	.265	.375	.510	.275	.032	.390
#8-32 UNC	.020-.080	17/64 (.2656)	<b>DLS-832-80</b>	<b>DLA-832-80</b>	.265	.375	.460	.275	.032	.390
#8-32 UNC	.080-.130	17/64 (.2656)	<b>DLS-832-130</b>	<b>DLA-832-130</b>	.265	.375	.510	.275	.032	.390
#10-24 UNC	.020-.130	19/64 (.2969)	<b>DLS-1024-130</b>	<b>DLA-1024-130</b>	.296	.400	.515	.300	.037	.450
#10-24 UNC	.130-.225	19/64 (.2969)	<b>DLS-1024-225</b>	<b>DLA-1024-225</b>	.296	.400	.625	.300	.037	.450
#10-32 UNF	.020-.130	19/64 (.2969)	<b>DLS-1032-130</b>	<b>DLA-1032-130</b>	.296	.400	.515	.300	.037	.450
#10-32 UNF	.130-.225	19/64 (.2969)	<b>DLS-1032-225</b>	<b>DLA-1032-225</b>	.296	.400	.625	.300	.037	.450
1/4-20 UNC	.027-.165	25/64 (.3906)	<b>DLS-420-165</b>	<b>DLA-420-165</b>	.390	.500	.620	.355	.037	.450
1/4-20 UNC	.165-.260	25/64 (.3906)	<b>DLS-420-260</b>	<b>DLA-420-260</b>	.390	.500	.720	.355	.037	.450
1/4-28 UNF	.027-.165	25/64 (.3906)	<b>DLS-428-165</b>	<b>DLA-428-165</b>	.390	.500	.620	.355	.037	.450
1/4-28 UNF	.165-.260	25/64 (.3906)	<b>DLS-428-260</b>	<b>DLA-428-260</b>	.390	.500	.720	.355	.037	.450
5/16-18 UNC	.027-.150	17/32 (.5312)	<b>DLS-518-150</b>	<b>DLA-518-150</b>	.530	.670	.735	.430	.042	.740
5/16-18 UNC	.150-.312	17/32 (.5312)	<b>DLS-518-312</b>	<b>DLA-518-312</b>	.530	.670	.850	.430	.042	.740
5/16-24 UNF	.027-.150	17/32 (.5312)	<b>DLS-524-150</b>	<b>DLA-524-150</b>	.530	.670	.735	.430	.042	.740
5/16-24 UNF	.150-.312	17/32 (.5312)	<b>DLS-524-312</b>	<b>DLA-524-312</b>	.530	.670	.850	.430	.042	.740
3/8-16 UNC	.027-.150	17/32 (.5312)	<b>DLS-616-150</b>	<b>DLA-616-150</b>	.530	.670	.735	.430	.042	.740
3/8-16 UNC	.150-.312	17/32 (.5312)	<b>DLS-616-312</b>	<b>DLA-616-312</b>	.530	.670	.850	.430	.042	.740
3/8-24 UNF	.027-.150	17/32 (.5312)	<b>DLS-624-150</b>	<b>DLA-624-150</b>	.530	.670	.735	.430	.042	.740
3/8-24 UNF	.150-.312	17/32 (.5312)	<b>DLS-624-312</b>	<b>DLA-624-312</b>	.530	.670	.850	.430	.042	.740

**Notes:**

1. All dimensions are in inches unless otherwise specified.
2. Dimensions shown are for reference only. Specifications control drawings available upon request.

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### Metric

Series	Material	Finish
DLA-XXXX-X,X	Aluminum	Clear Protective Coating
DLS-XXXX-X,X	Steel	ASTM 633-85, TYPE II, Fe/Zn8 Zinc Plate and Yellow Dichromate

Thread Designation	Grip Range	Hole +.006 Dia. -.000	Steel Series	Aluminum Series	A Max.	B Nom.	C Max.	P Ref.	D Max.	J Max.
<b>Metric Series (all dimensions in millimeters)</b>										
M4x0,7 6H	,50-2,0	6,8	<b>DLS-470-2,0</b>	<b>DLA-470-2,0</b>	6,75	9,50	11,70	7,00	0,81	9,91
M4x0,7 6H	2,00-3,30	6,8	<b>DLS-470-3,3</b>	<b>DLA-470-3,3</b>	6,75	9,50	13,00	7,00	0,81	9,91
M5x0,8 6H	,50-3,3	7,6	<b>DLS-580-3,3</b>	<b>DLA-580-3,3</b>	7,55	10,10	13,10	7,60	0,94	11,43
M5x0,8 6H	3,30-5,70	7,6	<b>DLS-580-5,7</b>	<b>DLA-580-5,7</b>	7,55	10,10	15,90	7,60	0,94	11,43
M6x1,0 6H	,70-4,2	10,0	<b>DLS-610-4,2</b>	<b>DLA-610-4,2</b>	9,90	12,70	15,75	9,00	0,94	13,97
M6x1,0 6H	4,2-6,6	10,0	<b>DLS-610-6,6</b>	<b>DLA-610-6,6</b>	9,90	12,70	15,75	9,00	0,94	13,97
M8x1,25 6H	,70-3,8	13,5	<b>DLS-8125-3,8</b>	<b>DLA-8125-3,8</b>	13,45	17,00	18,65	11,00	1,02	18,80
M8x1,25 6H	3,80-7,90	13,5	<b>DLS-8125-7,9</b>	<b>DLA-8125-7,9</b>	13,45	17,00	21,60	11,00	1,02	18,80
M10x1,5 6H	,70-3,8	13,5	<b>DLS-1015-3,8</b>	<b>DLA-1015-3,8</b>	13,45	17,00	18,65	11,00	1,02	18,80
M10x1,5 6H	3,80-7,90	13,5	<b>DLS-1015-7,9</b>	<b>DLA-1015-7,9</b>	13,45	17,00	21,60	11,00	1,02	18,80

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Date: 5.26.1

Part Number (Imperial)	Minimum Performance			
	Torque-To-Turn (lbf - in)	Pull Out (lbf)	Push Out (lbf)	Torque Out (lbf - in)
DLS-632-80	10	520	180	47
DLS-632-130	10	520	180	47
DLS-832-80	10	520	180	65
DLS-832-130	10	520	180	65
DLS-1024-130	12	630	335	95
DLS-1024-225	12	630	335	95
DLS-1032-130	12	630	335	95
DLS-1032-225	12	630	335	95
DLS-420-165	12	685	320	235
DLS-420-260	12	685	320	235
DLS-428-165	12	685	320	N/A
DLS-428-260	12	685	320	N/A
DLS-518-150	24	1115	510	N/A
DLS-518-312	24	1115	510	N/A
DLS-524-150	24	1115	510	N/A
DLS-524-312	24	1115	510	N/A
DLS-616-150	24	1115	510	N/A
DLS-616-312	24	1115	510	N/A
DLS-624-150	24	1115	510	N/A
DLS-624-312	24	1115	510	N/A

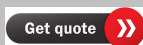
Part Number (Metric)	Minimum Performance			
	Torque-To-Turn (Nm)	Pull Out (N)	Push Out (N)	Torque Out (Nm)
DLS-470-2,0	1,1	2,3	0,80	6,2
DLS-470-3,3	1,1	2,3	0,80	6,2
DLS-580-3,3	1,4	2,8	1,5	10,7
DLS-580-5,7	1,4	2,8	1,5	10,7
DLS-610-4,2	1,4	3,0	1,4	18,1
DLS-610-6,6	1,4	3,0	1,4	18,1
DLS-8125-3,8	2,7	5,0	2,3	N/A
DLS-8125-7,9	2,7	5,0	2,3	N/A
DLS-1015-3,8	2,7	5,0	2,3	N/A
DLS-1015-7,9	2,7	5,0	2,3	N/A

**Note:**  
Aluminum performance data available upon request.

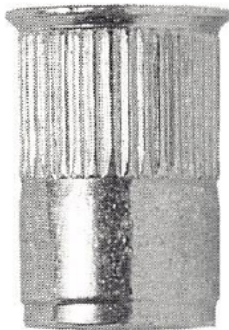
Avdel Cherry **TEXTRON**

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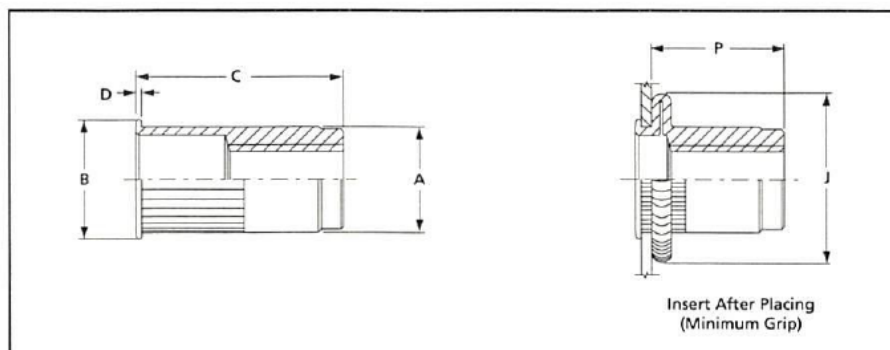


The DK™ series features a low-profile head configuration with a splined body.



### Benefits:

- Splined Body**  
 The splined body provides increased torque-to-turn resistance over conventional non-splined inserts.
- Near-Flush Installation**  
 The low-profile head provides near-flush seating without special hole preparation.
- Wide Grip Range**  
 The range of products within the DK™ series provides a placing capability in material thickness ranging from .020" (0,5mm) to 0.312" (7,9mm).
- High-Strength Threads**  
 The threads are rolled into the product creating a work-hardened surface providing high-strength, load-bearing threads.
- Lead-In Chamfer**  
 The lead-in chamfer on the body provides ease of insertion into the work piece.



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## Imperial

Series	Material	Finish
DKA-XXX-XXX	Aluminum	Clear Protective Coating
DKS-XXX-XXX	Steel	ASTM 633-85, TYPE II, Fe/Zn8 Zinc Plate and Yellow Dichromate

Thread Designation	Grip Range	Hole +.006 Dia. -.000	Steel Series	Aluminum Series	A Max.	B Nom.	C Max.	P Ref.	D Max.	J Max.
<b>Imperial Series (all dimensions in inches)</b>										
#6-32 UNC	.020-.080	17/64 (.2656)	<b>DKS-632-80</b>	<b>DKA-632-80</b>	.265	.310	.450	.305	.019	.390
#6-32 UNC	.080-.130	17/64 (.2656)	<b>DKS-632-130</b>	<b>DKA-632-130</b>	.265	.310	.500	.305	.019	.390
#8-32 UNC	.020-.080	17/64 (.2656)	<b>DKS-832-80</b>	<b>DKA-832-80</b>	.265	.310	.450	.305	.019	.390
#8-32 UNC	.080-.130	17/64 (.2656)	<b>DKS-832-130</b>	<b>DKA-832-130</b>	.265	.310	.500	.305	.019	.390
#10-24 UNC	.020-.130	19/64 (.2969)	<b>DKS-1024-130</b>	<b>DKA-1024-130</b>	.296	.340	.505	.315	.020	.450
#10-24 UNC	.130-.225	19/64 (.2969)	<b>DKS-1024-225</b>	<b>DKA-1024-225</b>	.296	.340	.615	.315	.020	.450
#10-32 UNF	.020-.130	19/64 (.2969)	<b>DKS-1032-130</b>	<b>DKA-1032-130</b>	.296	.340	.505	.315	.020	.450
#10-32 UNF	.130-.225	19/64 (.2969)	<b>DKS-1032-225</b>	<b>DKA-1032-225</b>	.296	.340	.615	.315	.020	.450
1/4-20 UNC	.027-.165	25/64 (.3906)	<b>DKS-420-165</b>	<b>DKA-420-165</b>	.390	.455	.610	.380	.021	.550
1/4-20 UNC	.165-.260	25/64 (.3906)	<b>DKS-420-260</b>	<b>DKA-420-260</b>	.390	.455	.710	.380	.021	.550
1/4-28 UNF	.027-.165	25/64 (.3906)	<b>DKS-428-165</b>	<b>DKA-428-165</b>	.390	.455	.610	.380	.021	.550
1/4-28 UNF	.165-.260	25/64 (.3906)	<b>DKS-428-260</b>	<b>DKA-428-260</b>	.390	.455	.710	.380	.021	.550
5/16-18 UNC	.027-.150	17/32 (.5312)	<b>DKS-518-150</b>	<b>DKA-518-150</b>	.530	.595	.720	.470	.023	.740
5/16-18 UNC	.150-.312	17/32 (.5312)	<b>DKS-518-312</b>	<b>DKA-518-312</b>	.530	.595	.835	.470	.023	.740
5/16-24 UNF	.027-.150	17/32 (.5312)	<b>DKS-524-150</b>	<b>DKA-524-150</b>	.530	.595	.720	.470	.023	.740
5/16-24 UNF	.150-.312	17/32 (.5312)	<b>DKS-524-312</b>	<b>DKA-524-312</b>	.530	.595	.835	.470	.023	.740
3/8-16 UNC	.027-.150	17/32 (.5312)	<b>DKS-616-150</b>	<b>DKA-616-150</b>	.530	.595	.720	.470	.023	.740
3/8-16 UNC	.150-.312	17/32 (.5312)	<b>DKS-616-312</b>	<b>DKA-616-312</b>	.530	.595	.835	.470	.023	.740
3/8-24 UNF	.027-.150	17/32 (.5312)	<b>DKS-624-150</b>	<b>DKA-624-150</b>	.530	.595	.720	.470	.023	.740
3/8-24 UNF	.150-.312	17/32 (.5312)	<b>DKS-624-312</b>	<b>DKA-624-312</b>	.530	.595	.835	.470	.023	.740



### Metric

Part Number	Material	Finish
DKA-XXXX-X,X	Aluminum	Clear Protective Coating
DKS-XXXX-X,X	Steel	ASTM 633-85, TYPE II, Fe/Zn8 Zinc Plate and Yellow Dichromate

Thread Designation	Grip Range	Hole $+.152$ Dia. $-.000$	Steel Series	Aluminum Series	A Max.	B Nom.	C Max.	P Ref.	D Max.	J Max.
<b>Metric Series (all dimensions in millimeters)</b>										
M4x0,7 6H	,50-2,0	6,8	<b>DKS-470-2,0</b>	<b>DKA-470-2,0</b>	6,75	7,87	11,45	7,75	0,48	9,91
M4x0,7 6H	2,00-3,30	6,8	<b>DKS-470-3,3</b>	<b>DKA-470-3,3</b>	6,75	7,87	12,70	7,75	0,48	9,91
M5x0,8 6H	,50-3,3	7,6	<b>DKS-580-3,3</b>	<b>DKA-580-3,3</b>	7,55	8,64	12,85	8,00	0,51	11,43
M5x0,8 6H	3,30-5,70	7,6	<b>DKS-580-5,7</b>	<b>DKA-580-5,7</b>	7,55	8,64	15,65	8,00	0,51	11,43
M6x1,0 6H	,70-4,2	10,0	<b>DKS-610-4,2</b>	<b>DKA-610-4,2</b>	9,90	11,56	15,50	9,65	0,53	13,97
M6x1,0 6H	4,20-6,60	10,0	<b>DKS-610-6,6</b>	<b>DKA-610-6,6</b>	9,90	11,56	18,05	9,65	0,53	13,97
M8x1,25 6H	,70-3,8	13,5	<b>DKS-8125-3,8</b>	<b>DKA-8125-3,8</b>	13,45	15,11	18,30	11,94	0,58	18,80
M8x1,25 6H	3,80-7,90	13,5	<b>DKS-8125-7,9</b>	<b>DKA-8125-7,9</b>	13,45	15,11	21,20	11,94	0,58	18,80
M10x1,5 6H	,70-3,8	13,5	<b>DKS-1015-3,8</b>	<b>DKA-1015-3,8</b>	13,45	15,11	18,30	11,94	0,58	18,80
M10x1,5 6H	3,80-7,90	13,5	<b>DKS-1015-7,9</b>	<b>DKA-1015-7,9</b>	13,45	15,11	21,20	11,94	0,58	18,80

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Part Number (Imperial)	Minimum Performance			
	Torque-To-Turn (lbf - in)	Pull Out (lbf)	Push Out (lbf)	Torque Out (lbf - in)
DKS-632-80	10	520	180	47
DKS-632-130	10	520	180	47
DKS-832-80	10	520	180	65
DKS-832-130	10	520	180	65
DKS-1024-130	12	630	335	95
DKS-1024-225	12	630	335	95
DKS-1032-130	12	630	335	95
DKS-1032-225	12	630	335	95
DKS-420-165	12	685	320	235
DKS-420-260	12	685	320	235
DKS-428-165	12	685	320	N/A
DKS-428-260	12	685	320	N/A
DKS-518-150	24	1115	510	N/A
DKS-518-312	24	1115	510	N/A
DKS-524-150	24	1115	510	N/A
DKS-524-312	24	1115	510	N/A
DKS-616-150	24	1115	510	N/A
DKS-616-312	24	1115	510	N/A
DKS-624-150	24	1115	510	N/A
DKS-624-312	24	1115	510	N/A

Part Number (Metric)	Minimum Performance			
	Torque-To-Turn (Nm)	Pull Out (N)	Push Out (N)	Torque Out (Nm)
DKS-470-2,0	1,1	2,3	0,80	6,2
DKS-470-3,3	1,1	2,3	0,80	6,2
DKS-580-3,3	1,4	2,8	1,5	10,7
DKS-580-5,7	1,4	2,8	1,5	10,7
DKS-610-4,2	1,4	3,0	1,4	18,1
DKS-610-6,6	1,4	3,0	1,4	18,1
DKS-8125-3,8	2,7	5,0	2,3	N/A
DKS-8125-7,9	2,7	5,0	2,3	N/A
DKS-1015-3,8	2,7	5,0	2,3	N/A
DKS-1015-7,9	2,7	5,0	2,3	N/A

**Note:**  
Aluminum performance data available upon request.



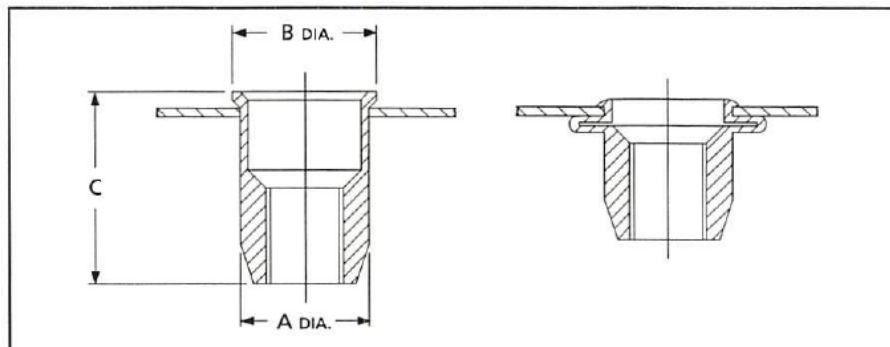
*Low-profile head style provides near flush fit to workpiece.*



### **Benefits:**

- **Reduced Assembly Costs**  
Blind Installation is installed fast and cleanly.
- **Designed for Thin Materials**  
Can work in materials as thin as .020" and greater.
- **Permanent**  
Crimps the parent material, providing secure and permanent load-bearing threads.
- **Low-Profile Head**  
Flush fit to workpiece.

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**Avdel Cherry** **TEXTRON**

Steel Zinc Plate/Clear Chromate						
Thread Size	Part Number	A Max.	C Max.	B Max.	Grip Range	Hole Size
4 MM	9658-04	.249 (6,32)	.410 (10,41)	.287 (7,28)	.020 - .079 (.508 - 2,00)	.250 - .254 (6,35 - 6,45)
5 MM	9658-05	.280 (7,11)	.465 (11,81)	.320 (8,12)	.020 - .118 (.508 - 3,00)	.281 - .285 (7,14 - 7,24)
6 MM	9658-06	.374 (9,50)	.610 (15,49)	.415 (10,53)	.030 - .128 (.762 - 3,25)	.375 - .379 (9,53 - 9,63)
8 MM	9658-08	.499 (12,67)	.720 (18,29)	.540 (13,70)	.040 - .200 (1,02 - 5,08)	.500 - .504 (12,70 - 12,80)
6-32 UNC	9655-06	.249 (6,32)	.415 (10,54)	.287 (7,28)	.020 - .079 (.508 - 2,00)	.250 - .254 (6,35 - 6,45)
8-32 UNC	9655-08	.249 (6,32)	.415 (10,54)	.287 (7,28)	.020 - .079 (.508 - 2,00)	.250 - .254 (6,35 - 6,45)
10-24 UNC	9655-10	.280 (7,11)	.465 (11,81)	.320 (8,12)	.020 - .118 (.508 - 3,00)	.281 - .285 (7,14 - 7,24)
10-24 UNC	9665-1018	.280 (7,11)	.575 (14,60)	.320 (8,12)	.125 - .225 (3,18 - 5,72)	.281 - .285 (7,14 - 7,24)
10-32 UNF	9657-10	.280 (7,11)	.465 (11,81)	.320 (8,13)	.020 - .118 (.508 - 3,00)	.281 - .285 (7,14 - 7,24)
10-32 UNF	9667-1018	.280 (7,11)	.575 (14,60)	.320 (8,13)	.125 - .225 (3,18 - 5,72)	.281 - .285 (7,14 - 7,24)
1/4-20 UNC	9654-08	.374 (9,50)	.610 (15,49)	.415 (10,53)	.030 - .128 (.762 - 3,25)	.375 - .379 (9,53 - 9,63)
1/4-20 UNC	9664-0823	.374 (9,50)	.710 (18,03)	.415 (10,53)	.150 - .260 (3,81 - 6,60)	.375 - .379 (9,53 - 9,63)
1/4-28 UNF	9656-08	.374 (9,50)	.610 (15,49)	.415 (10,53)	.030 - .128 (.762 - 3,25)	.375 - .379 (9,53 - 9,63)
5/16-18 UNC	9654-10	.499 (12,67)	.720 (18,29)	.540 (13,70)	.040 - .200 (1,02 - 5,08)	.500 - .504 (12,70 - 12,80)
5/16-18 UNC	9664-1026	.499 (12,67)	.835 (21,21)	.540 (13,70)	.185 - .312 (4,70 - 7,93)	.500 - .504 (12,70 - 12,80)
5/16-24 UNF	9656-10	.499 (12,67)	.720 (18,29)	.540 (13,70)	.040 - .200 (1,02 - 5,08)	.500 - .504 (12,70 - 12,80)
3/8-16 UNC	9654-12	.499 (12,67)	.720 (18,29)	.540 (13,70)	.040 - .200 (1,02 - 5,08)	.500 - .504 (12,70 - 12,80)

**Note:**

1. All dimensions shown in ( ) are millimeters, otherwise imperial.

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Aluminum Plain Finish						
Thread Size	Part Number	A Max.	C Max.	B Max.	Grip Range	Hole Size
4 MM	9488-0413	.249 (6,32)	.410 (10,41)	.287 (7,28)	.020 - .080 (,508 - 2,03)	.250 - .254 (6,35 - 6,45)
5 MM	9488-0514	.280 (7,11)	.465 (11,81)	.320 (8,12)	.020 - .130 (,508 - 3,30)	.281 - .285 (7,14 - 7,24)
6 MM	9488-0620	.374 (9,50)	.610 (15,49)	.415 (10,53)	.030 - .165 (,762 - 4,19)	.375 - .379 (9,53 - 9,63)
8 MM	9488-0821	.499 (12,67)	.660 (16,76)	.540 (13,70)	.040 - .140 (1,02 - 3,56)	.500 - .504 (12,70 - 12,80)
8 MM	9488-0823	.499 (12,67)	.720 (18,29)	.540 (13,70)	.140 - .200 (3,56 - 5,08)	.500 - .504 (12,70 - 12,80)
6-32 UNC	9485-0613	.249 (6,32)	.410 (10,41)	.287 (7,28)	.020 - .080 (,508 - 2,03)	.250 - .254 (6,35 - 6,45)
8-32 UNC	9485-0813	.249 (6,32)	.410 (10,41)	.287 (7,28)	.020 - .080 (,508 - 2,03)	.250 - .254 (6,35 - 6,45)
10-24 UNC	9485-1014	.280 (7,11)	.465 (11,81)	.320 (8,12)	.020 - .130 (,508 - 3,30)	.281 - .285 (7,14 - 7,24)
10-32 UNF	9487-1014	.280 (7,11)	.465 (11,81)	.320 (8,12)	.020 - .130 (,508 - 3,30)	.281 - .285 (7,14 - 7,24)
1/4-20 UNC	9484-0820	.374 (9,50)	.610 (15,49)	.415 (10,53)	.030 - .165 (,762 - 4,19)	.375 - .379 (9,53 - 9,63)
5/16-18 UNC	9484-1023	.499 (12,67)	.720 (18,29)	.540 (13,70)	.040 - .200 (1,02 - 5,08)	.500 - .504 (12,70 - 12,80)
3/8-16 UNC	9484-1223	.499 (12,67)	.720 (18,29)	.540 (13,70)	.040 - .200 (1,02 - 5,08)	.500 - .504 (12,70 - 12,80)

**Note:**

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Date: 5.28.



Stainless Steel - Under Head Splines Stainless Steel / Plain Finish						
Thread Size	Part Number	A Max.	C Max.	B Max.	Grip Range	Hole Size
6-32 UNC	9655-06SS	.248 (6,30)	.410 (10,41)	.273 (6,93)	.020 - .079 (.508 - 2,00)	.250 - .254 (6,35 - 6,45)
8-32 UNC	9655-08SS	.248 (6,30)	.410 (10,41)	.273 (6,93)	.020 - .079 (.508 - 2,00)	.250 - .254 (6,35 - 6,45)
10-24 UNC	9655-10SS	.280 (7,11)	.460 (11,68)	.305 (7,75)	.020 - .118 (.508 - 3,00)	.281 - .285 (7,14 - 7,24)
10-32 UNF	9657-10SS	.280 (7,11)	.460 (11,68)	.305 (7,75)	.020 - .118 (.508 - 3,00)	.281 - .285 (7,14 - 7,24)
1/4-20 UNC	9654-08SS	.372 (9,45)	.590 (14,99)	.410 (10,41)	.030 - .128 (.762 - 3,25)	.375 - .379 (9,53 - 9,63)
5/16-18 UNC	9654-10SS	.497 (12,62)	.730 (18,54)	.540 (13,70)	.040 - .200 (1,02 - 5,08)	.500 - .504 (12,70-12,80)
3/8-16 UNC	9654-12SS	.497 (12,62)	.730 (18,54)	.540 (13,70)	.040 - .200 (1,02 - 5,08)	.500 - .504 (12,70-12,80)

**Note:**

1. All dimensions shown in ( ) are millimeters, otherwise imperial.

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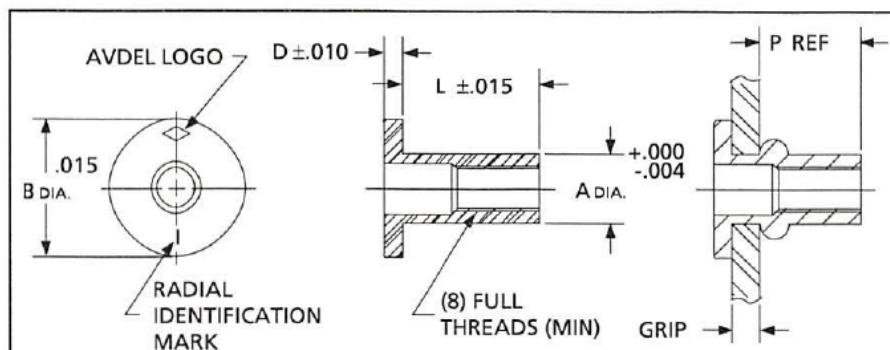
*Large-flange head style provides increased push-out performance.*



### Benefits:

- Reduced Assembly Costs**  
 Blind installation is installed fast and cleanly.
- Designed for Thin Materials**  
 Can work in materials as thin as .020" and greater.
- Permanent**  
 Crimps the parent material, providing secure and permanent load-bearing threads.
- Large Flange Head**  
 Increased push-out performance.

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**Avdel Cherry** **TEXTRON**

Material	Alloy	Finish
STEEL	1006/1010 Low Carbon Steel	Zinc Plate, Type 1, Class 3 with Supplementary Clear Chromate

Series 9434											
Thread Size	Part Number	Grip	L	B	D	A	P	Ident Mark	Drill Size (Ref)	Hole Size	
										Min.	Max.
1/4-20 UNC	9434-0820	.020-.080 (0,51-2,03)	.625 (15,88)	.475 (12,07)	.058 (1,47)	.332 (8,43)	.450 (11,43)	BLANK	#Q	.332 (8,43)	.338 (8,59)
	9434-0822	.080-.140 (2,03-3,56)	.687 (17,45)					1 RAD			
	9434-0824	.140-.200 (3,56-5,08)	.750 (19,05)					2 RAD			
	9434-0826	.200-.260 (5,08-6,60)	.812 (20,62)					3 RAD			
5/16-18 UNC	9434-1024	.030-.125 (0,76-3,18)	.750 (19,05)	.665 (16,89)	.062 (1,57)	.413 (10,49)	.505 (12,83)	BLANK	#Z	.413 (10,49)	.423 (10,74)
	9434-1028	.125-.200 (3,18-5,08)	.875 (22,23)					1 RAD			
	9434-1030	.200-.275 (5,08-6,99)	.937 (23,80)					2 RAD			
3/8-16 UNC	9434-1227	.030-.115 (0,76-2,92)	.844 (21,44)	.781 (19,84)	.088 (2,24)	.490 (12,45)	.585 (14,86)	BLANK	#12,5mm	.490 (12,45)	.500 (12,70)
	9434-1230	.115-.200 (2,92-5,08)	.938 (23,83)					1 RAD			
	9434-1233	.200-.285 (5,08-7,24)	1.031 (26,19)					2 RAD			

**Note:**

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Material	Alloy	Finish
STEEL	1006/1010 Low Carbon Steel	Zinc Plate, Type 1, Class 3 with Supplementary Clear Chromate

Series 9435											
Thread Size	Part Number	Grip	L	B	D	A	P	Ident Mark	Drill Size (Ref)	Hole Size	
										Min.	Max.
6-32 UNC	9435-0614	.010-.075 (0,25-1,91)	.438 (11,13)	.325 (8,26)	.032 (0,81)	.189 (4,80)	.300 (7,62)	1 RAD	#12	.189 (4,80)	.193 (4,90)
	9435-0616	.075-.120 (1,91-3,05)	.500 (12,70)				.315 (8,00)	3 RAD			
	9435-0617	.120-.160 (3,05-4,06)	.500 (12,70)				.270 (6,86)	5 RAD			
8-32 UNC	9435-0814	.010-.075 (0,25-1,91)	.438 (11,13)	.357 (9,07)	.032 (0,81)	.221 (5,61)	.300 (7,62)	1 RAD	#2	.221 (5,61)	.226 (5,74)
	9435-0816	.075-.120 (1,91-3,05)	.500 (12,70)				.315 (8,00)	3 RAD			
	9435-0817	.120-.160 (3,05-4,06)	.500 (12,70)				.270 (6,86)	5 RAD			
10-24 UNC	9435-1017	.010-.080 (0,25-2,03)	.531 (13,49)	.406 (10,31)	.038 (0,97)	.250 (6,35)	.380 (9,65)	1 RAD	#E	.250 (6,35)	.256 (6,50)
	9435-1019	.080-.130 (2,03-3,30)	.594 (15,09)				.390 (9,91)	3 RAD			
	9435-1021	.130-.180 (3,30-4,57)	.641 (16,28)				.390 (9,91)	5 RAD			

Series 9437											
Thread Type	Part Number	Grip	L	B	D	A	P	Drill Size (Ref.)	Hole Size		
									Min.	Max.	
10-32 UNF	9437-1017	.010-.080 (0,25-2,03)	.531 (13,49)	.406 (10,31)	.038 (0,97)	.250 (6,35)	.380 (9,65)	#E	.250 (6,35)	.256 (6,50)	
	9437-1019	.080-.130 (2,03-3,30)	.594 (15,09)				.390 (9,91)				
	9437-1021	.130-.180 (3,30-4,57)	.641 (16,28)				.390 (9,91)				

**Note:**

1. All dimensions shown in ( ) are millimeters, otherwise imperial.

**Avdel Cherry** **TEXTRON**

Material	Finish
Aluminum	Plain

Series 9444									
Size	Part Number	Grip	L	B	D	A	P	Ident Mark	
1/4 UNC	9444-0820	.020-.080	.625	.475	.058	.332	.450	Blank	
	9444-0822	.080-.140	.687					1 Rad	
	9444-0824	.140-.200	.750					2 Rad	
	9444-0826	.200-.260	.812					.445	3 Rad
5/16 UNC	9444-1024	.030-.125	.750	.665	.062	.413	.505	Blank	
	9444-1028	.125-.200	.875					.555	1 Rad
3/8 UNC	9444-1227	.030-.115	.844	.781	.088	.490	.585	Blank	
	9444-1230	.115-.200	.938					.595	1 Rad
	9444-1233	.200-.285	1.031					.605	2 Rad

Series 9445											
Thread Type	Part Number	Grip	L	B	D	A	P	Indent Mark	Drill Size (Ref.)	Hole Size	
										Min.	Max.
6-32 UNC	9445-0614	.010-.075 (0,25-1,91)	.438 (11,13)	.325 (8,26)	.032 (0,81)	.189 (4,80)	.300 (7,62)	1 RAD	#12	.189 (4,80)	.193 (4,90)
8-32 UNC	9445-0814	.010-.075 (0,25-1,91)	.438 (11,13)	.357 (9,07)	.032 (0,81)	.221 (5,61)	.300 (7,62)	1 RAD	#2	.221 (5,61)	.226 (5,74)
	9445-0816	.075-.120 (1,91-3,05)	.500 (12,70)				.315 (8,00)	3 RAD			
	9445-0817	.120-.160 (3,05-4,06)	.500 (12,70)				.270 (6,86)	5 RAD			
10-24 UNC	9445-1017	.010-.080 (0,25-2,03)	.531 (13,49)	.406 (10,31)	.038 (0,97)	.250 (6,35)	.380 (9,65)	1 RAD	#E	.250 (6,35)	.256 (6,50)
	9445-1019	.080-.130 (2,03-3,30)	.594 (15,09)				.390 (9,91)	3 RAD			

Series 9447										
Thread Type	Part Number	Grip	L	B	D	A	P	Drill Size (Ref.)	Hole Size	
									Min.	Max.
10-32 UNF	9447-1017	.010-.080 (0,25-2,03)	.531 (13,49)	.406 (10,31)	.038 (0,97)	.250 (6,35)	.380 (9,65)	#E	.250 (6,35)	.256 (6,50)
	9447-1019	.080-.130 (2,03-3,30)	.594 (15,09)				.390 (9,91)			
	9447-1021	.130-.180 (3,30-4,57)	.641 (16,28)				.390 (9,91)			

Note:

- All dimensions shown in ( ) are millimeters, otherwise imperial.

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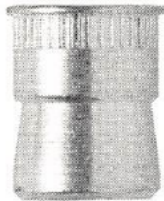
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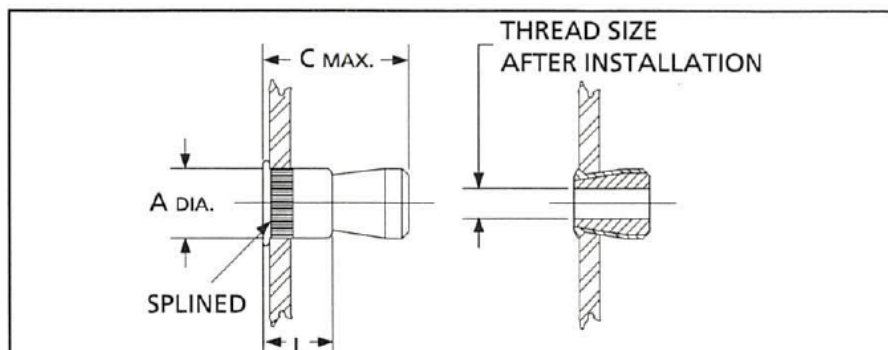
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Provides captive threads in any material thickness greater than .030, up to and including blind holes.



### Benefits:

- **Reduced Assembly Costs**  
Installed from one side of the workpiece.
- **Not Grip Sensitive**  
Can be used in any material thickness from .030" through solid materials.
- **Permanent**  
Radial expansion of Nutsert® provides 360° contact with parent material.
- **Portability**  
Allows installation anywhere and at any time in the assembly process.
- **Rear Protrusion**  
Reduced rear-sheet protrusion.



Avdel Cherry **TEXTRON**

Splined Body

Material	Alloy	Finish
Carbon Steel	12L14-T	Cadmium Plate

Series 9506								
Thread Size	Part Number	A	L	C	*Recommend Hole Size			
					Material Thickness	Material Thickness	Material Thickness	Material Thickness
					.030-.090 (0,76-2,29)	.091-.124 (2,31-3,15)	.125-.186 (3,18-4,72)	.187-OVER (4,75-OVER)
1/4-28 UNF	9506-08	.3699-.3749 (9,40-9,52)	.252-.262 (6,40-6,65)	.525 (13,34)	.375 (9,53)	.375 (9,53)	.386 (9,80)	.3906 (9,92)
5/16-24 UNF	9506-10	.4949-.4999 (12,57-12,70)	.302-.312 (7,67-7,92)	.625 (15,88)	.500 (12,70)	.500 (12,70)	.5156 (13,10)	.5156 (13,10)

Series 9507								
Thread Size	Part Number	A	L	C	*Recommend Hole Size			
					Material Thickness	Material Thickness	Material Thickness	Material Thickness
					.030-.090 (0,76-2,29)	.091-.124 (2,31-3,15)	.125-.186 (3,18-4,72)	.187-OVER (4,75-OVER)
10-32 UNF	9507-10	.2760-.2810 (7,01-7,14)	.180-.190 (4,57-4,83)	.385 (9,78)	.2812 (7,14)	.2900 (7,37)	.2968 (7,54)	.2968 (7,54)

Series 9504								
Thread Size	Part Number	A	L	C	*Recommend Hole Size			
					Material Thickness	Material Thickness	Material Thickness	Material Thickness
					.030-.090 (0,76-2,29)	.091-.124 (2,31-3,15)	.125-.186 (3,18-4,72)	.187-OVER (4,75-OVER)
1/4-20 UNC	9504-08	.3699-.3749 (9,40-9,52)	.252-.262 (6,40-6,65)	.525 (13,34)	.375 (9,53)	.375 (9,53)	.386 (9,80)	.3906 (9,92)
5/16-18 UNC	9504-10	.4949-.4999 (12,57-12,70)	.302-.312 (7,67-7,92)	.625 (15,88)	.500 (12,70)	.500 (12,70)	.5156 (13,10)	.5156 (13,10)

\*DEPENDENT UPON MATERIAL THICKNESS AND APPLICATION.

Notes:

1. All dimensions shown in ( ) are millimeters, otherwise imperial.
2. Fasteners may not perform properly if altered from the manufacturer's as-shipped condition or installed in conditions other than specified herein.

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### Splined Body

Material	Alloy	Finish
Carbon Steel	12L14-T	Cadmium Plate

Series 9505								
Thread Size	Part Number	A	L	C	*Recommend Hole Size			
					Material Thickness	Material Thickness	Material Thickness	Material Thickness
					.030-.090 (0,76-2,29)	.091-.124 (2,31-3,15)	.125-.186 (3,18-4,72)	.187-OVER (4,75-OVER)
4-40 UNC	9505-04	.1820-.1870 (4,63-4,75)	.180-.190 (4,57-4,83)	.385 (9,78)	.1875 (4,76)	.1935 (4,91)	.1935 (4,91)	.1935 (4,91)
6-32 UNC	9505-06	.2136-.2186 (5,42-5,55)	.180-.190 (4,57-4,83)	.385 (9,78)	.2187 (5,55)	.2210 (5,61)	.2280 (5,79)	.2280 (5,79)
8-32 UNC	9505-08	.2449-.2499 (6,20-6,35)	.180-.190 (4,57-4,83)	.385 (9,78)	.2500 (6,35)	.2570 (6,53)	.2656 (6,75)	.2656 (6,75)
10-24 UNC	9505-10	.2760-.2810 (7,01-7,14)	.180-.190 (4,57-4,83)	.385 (9,78)	.2812 (7,14)	.2900 (7,37)	.2968 (7,54)	.2968 (7,54)

Series 9508								
Thread Size	Part Number	A	L	C	*Recommend Hole Size			
					Material Thickness	Material Thickness	Material Thickness	Material Thickness
					.030-.090 (0,76-2,29)	.091-.124 (2,31-3,15)	.125-.186 (3,18-4,72)	.187-OVER (4,75-OVER)
M3 X 0,5	9508-03	.1820-.1870 (4,63-4,75)	.180-.190 (4,57-4,83)	.385 (9,78)	.1875 (4,76)	.1935 (4,91)	.1935 (4,91)	.1935 (4,91)
M4 X 0,7	9508-04	.2449-.2499 (6,20-6,35)	.180-.190 (4,57-4,83)	.385 (9,78)	.2500 (6,35)	.2570 (6,53)	.2656 (6,75)	.2656 (6,75)
M5 X 0,8	9508-05	.2760-.2810 (7,01-7,14)	.180-.190 (4,57-4,83)	.385 (9,78)	.2812 (7,14)	.2900 (7,37)	.2968 (7,54)	.2968 (7,54)
M6 X 1,0	9508-06	.3699-.3749 (9,40-9,52)	.252-.262 (6,40-6,65)	.525 (13,34)	.3750 (9,53)	.3750 (9,53)	.3860 (9,80)	.3906 (9,92)
M8 X 1,25	9508-08	.4949-.4999 (12,57-12,70)	.302-.312 (7,68-7,94)	.625 (15,88)	.5000 (12,70)	.5000 (12,70)	.5156 (13,10)	.5156 (13,10)
M10 X 1,5	9508-10	.5572-.5622 (14,15-14,28)	.365-.375 (9,27-9,52)	.750 (19,05)	.5625 (14,29)	.5625 (14,29)	.5625 (14,29)	.5781 (14,68)

\*DEPENDENT UPON MATERIAL THICKNESS AND APPLICATION.

#### Notes:

1. All dimensions shown in ( ) are millimeters, otherwise imperial.
2. Fasteners may not perform properly if altered from the manufacturer's as-shipped condition or installed in conditions other than specified herein.

Avdel Cherry **TEXTRON**

Plain Body

Material	Alloy	Finish
Carbon Steel	12L14-T	Cadmium Plate

Series 9504P								
Thread Size	Part Number	A	L	C	*Recommend Hole Size			
					Material Thickness	Material Thickness	Material Thickness	Material Thickness
					.030-.090 (0,76-2,29)	.091-.124 (2,31-3,15)	.125-.186 (3,18-4,72)	.187-OVER (4,75-OVER)
1/4-20 UNC	9504-08P	.3699-.3749 (9,40-9,52)	.252-.262 (6,40-6,65)	.525 (13,34)	.375 (9,53)	.375 (9,53)	.386 (9,80)	.3906 (9,92)
5/16-18 UNC	9504-10P	.4949-.4999 (12,57-12,70)	.302-.312 (7,67-7,92)	.625 (15,88)	.500 (12,70)	.500 (12,70)	.5156 (13,10)	.5156 (13,10)
3/8-16 UNC	9504-12P	.5572-.5622 (14,15-14,28)	.365-.375 (9,27-9,53)	.750 (19,05)	.5625 (14,29)	.5625 (14,29)	.5781 (14,68)	.5781 (14,68)

Series 9505P								
Thread Size	Part Number	A	L	C	*Recommend Hole Size			
					Material Thickness	Material Thickness	Material Thickness	Material Thickness
					.030-.090 (0,76-2,29)	.091-.124 (2,31-3,15)	.125-.186 (3,18-4,72)	.187-OVER (4,75-OVER)
4-40 UNC	9505-04P	.1820-.1870 (4,63-4,75)	.180-.190 (4,57-4,83)	.385 (9,78)	.1875 (4,76)	.1935 (4,91)	.1935 (4,91)	.1935 (4,91)
6-32 UNC	9505-06P	.2136-.2186 (5,42-5,55)	.180-.190 (4,57-4,83)	.385 (9,78)	.2187 (5,55)	.2210 (5,61)	.2280 (5,79)	.2280 (5,79)
8-32 UNC	9505-08P	.2449-.2499 (6,20-6,35)	.180-.190 (4,57-4,83)	.385 (9,78)	.2500 (6,35)	.2570 (6,53)	.2656 (6,75)	.2656 (6,75)
10-24 UNC	9505-10P	.2760-.2810 (7,01-7,14)	.180-.190 (4,57-4,83)	.385 (9,78)	.2812 (7,14)	.2900 (7,37)	.2968 (7,54)	.2968 (7,54)

Series 9508P								
Thread Size	Part Number	A	L	C	*Recommend Hole Size			
					Material Thickness	Material Thickness	Material Thickness	Material Thickness
					.030-.090 (0,76-2,29)	.091-.124 (2,31-3,15)	.125-.186 (3,18-4,72)	.187-OVER (4,75-OVER)
M3 X 0,5	9508-03P	.1820-.1870 (4,63-4,75)	.180-.190 (4,57-4,83)	.385 (9,78)	.1875 (4,76)	.1935 (4,91)	.1935 (4,91)	.1935 (4,91)
M4 X 0,7	9508-04P	.2449-.2499 (6,20-6,35)	.180-.190 (4,57-4,83)	.385 (9,78)	.2500 (6,35)	.2570 (6,53)	.2656 (6,75)	.2656 (6,75)
M5 X 0,8	9508-05P	.2760-.2810 (7,01-7,14)	.180-.190 (4,57-4,83)	.385 (9,78)	.2812 (7,14)	.2900 (7,37)	.2968 (7,54)	.2968 (7,54)
M6 X 1,0	9508-06P	.3699-.3749 (9,40-9,52)	.252-.262 (6,40-6,65)	.525 (13,34)	.3750 (9,53)	.3750 (9,53)	.3860 (9,80)	.3906 (9,92)
M8 X 1,25	9508-08P	.4949-.4999 (12,57-12,70)	.302-.312 (7,68-7,94)	.625 (15,88)	.5000 (12,70)	.5000 (12,70)	.5156 (13,10)	.5156 (13,10)
M10 X 1,5	9508-10P	.5572-.5622 (14,15-14,28)	.365-.375 (9,27-9,52)	.750 (19,05)	.5625 (14,29)	.5625 (14,29)	.5625 (14,29)	.5781 (14,68)

\*DEPENDENT UPON MATERIAL THICKNESS AND APPLICATION.

Notes:

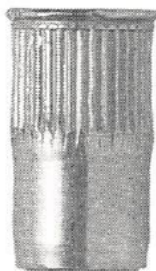
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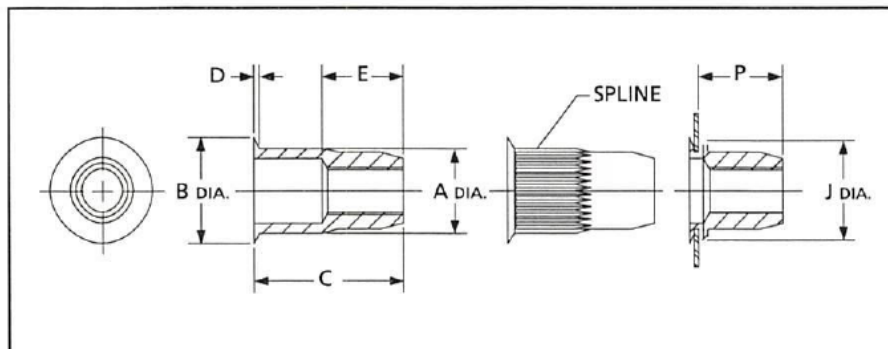
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A range of four hard metric product lines in a combination of head and body styles.



### Benefits:

- **Choice of Body Style**  
Available with plain or splined-body style.
- **Choice of Head Style**  
Available in low-profile or large-flange head styles.
- **Hard Metric Design**  
Increasing demand for hard metric product.
- **Easy Insertion Into Hole**  
Double-diameter body and lead-in chamfer make insert-to-hole orientation simple and fast.
- **Roll Formed Threads**  
Increased thread strength.
- **Common Hole and Grip Sizes**  
All four lines in range share common hole and grip sizes. Therefore, applications requiring a combination of these products will not require different hole preparation or tooling.



Avdel Cherry **TEXTRON**

**Large Flange**

Material	Finish
Low Carbon Steel	Zinc Plated Yellow Dichromate

Series 9408 Splined Body											
Thread Size	Part Number	Sheet Thickness	Recommended Hole Size	øA Max.	øB	D (±0,13)	øJ Max.		C Nom.	P Max.	E Nom.
							Min. Sheet	Max. Sheet			
M3 X 0,5	9408-2314	.010-.078 (0,25-2,0)	.197 (5,0)	.195 (4,95)	.307-.323 (7,80-8,20)	.030 (0,75)	.291 (7,4)	.264 (6,7)	.413 (10,5)	.236 (6,0)	.213 (5,4)
M4 X 0,7	9408-2415	.010-.118 (0,25-3,0)	.236 (6,0)	.234 (5,95)	.346-.362 (8,80-9,20)	.030 (0,75)	.346 (8,8)	.299 (7,6)	.453 (11,5)	.280 (7,1)	.232 (5,9)
M5 X 0,8	9408-2517	.010-.118 (0,25-3,0)	.276 (7,0)	.274 (6,95)	.386-.402 (9,80-10,20)	.039 (1,00)	.402 (10,2)	.350 (8,9)	.512 (13,0)	.311 (7,9)	.260 (6,6)
M6 X 1,0	9408-2621	.020-.118 (0,5-3,0)	.354 (9,0)	.352 (8,95)	.504-.520 (12,80-13,20)	.059 (1,50)	.500 (12,7)	.449 (11,4)	.630 (16,0)	.370 (9,4)	.343 (8,7)
M8 X 1,25	9408-2822	.020-.118 (0,5-3,0)	.433 (11,0)	.431 (10,95)	.614-646 (15,60-16,40)	.059 (1,50)	.059 (15,0)	.520 (13,2)	.689 (17,5)	.433 (11,0)	.386 (9,8)
	9408-2825	.118-.217 (3,0-5,5)									

Series 9418 Plain Body											
Thread Size	Part Number	Sheet Thickness	Recommended Hole Size	øA Max.	øB	D (±0,13)	øJ Max.		C Nom.	P Max.	E Nom.
							Min. Sheet	Max. Sheet			
M3 X 0,5	9418-2314	.010-.078 (0,25-2,0)	.197 (5,0)	.195 (4,95)	.307-.323 (7,80-8,20)	.030 (0,75)	.291 (7,4)	.264 (6,7)	.413 (10,5)	.236 (6,0)	.213 (5,4)
M4 X 0,7	9418-2415	.010-.118 (0,25-3,0)	.236 (6,0)	.234 (5,95)	.346-.362 (8,80-9,20)	.030 (0,75)	.346 (8,8)	.299 (7,6)	.453 (11,5)	.280 (7,1)	.232 (5,9)
M5 X 0,8	9418-2517	.010-.118 (0,25-3,0)	.276 (7,0)	.274 (6,95)	.386-.402 (9,80-10,20)	.039 (1,00)	.402 (10,2)	.350 (8,9)	.512 (13,0)	.311 (7,9)	.260 (6,6)
M6 X 1,0	9418-2621	.020-.118 (0,5-3,0)	.354 (9,0)	.352 (8,95)	.504-.520 (12,80-13,20)	.059 (1,50)	.500 (12,7)	.449 (11,4)	.630 (16,0)	.370 (9,4)	.343 (8,7)
M8 X 1,25	9418-2822	.020-.118 (0,5-3,0)	.433 (11,0)	.431 (10,95)	.614-646 (15,60-16,40)	.059 (1,50)	.591 (15,0)	.520 (13,2)	.689 (17,5)	.433 (11,0)	.386 (9,8)
	9418-2825	.118-.217 (3,0-5,5)							.787 (20,0)		
M10 X 1,5	9418-2028	.020-.138 (0,5-3,5)	.512 (13,0)	.510 (12,95)	.713-.744 (18,10-18,90)	.089 (2,25)	.689 (17,5)	.610 (15,5)	.866 (22,0)	.571 (14,5)	.512 (13,0)

**Note:**

1. All dimensions shown in ( ) are millimeters, otherwise imperial.

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### Low Profile

Material	Finish
Low Carbon Steel	Zinc Plated Yellow Dichromate

Series GJ08 Plain Body											
Thread Size	Part Number	Sheet Thickness	Recommended Hole Size	øA Max.	øB	D (±0,13)	øJ Max.		C Nom.	P Max.	E Nom.
							Min. Sheet	Max. Sheet			
M4 X 0,7	<b>GJ08-2414</b>	.010-.079 (0,25-2,0)	.236 (6,0)	.234 (5,95)	.250-.264 (6,35-6,70)	.018 (0,46)	.346 (8,8)	.299 (7,6)	.445 (11,3)	.280 (7,1)	.256 (6,5)
M5 X 0,8	<b>GJ08-2516</b>	.010-.118 (0,25-3,0)	.276 (7,0)	.274 (6,95)	.293-.307 (7,45-7,80)	.018 (0,46)	.402 (10,2)	.350 (8,9)	.500 (12,7)	.311 (7,9)	.268 (6,8)
M6 X 1,0	<b>GJ08-2619</b>	.020-.118 (0,50-3,0)	.354 (9,0)	.352 (8,95)	.388-.402 (9,85-10,20)	.020 (0,50)	.500 (12,7)	.449 (11,4)	.602 (15,3)	.370 (9,4)	.358 (9,1)
M8 X 1,25	<b>GJ08-2822</b>	.020-.138 (0,50-3,5)	.433 (11,0)	.431 (10,95)	.467-.480 (11,85-12,20)	.025 (0,63)	.591 (15,0)	.520 (13,2)	.681 (17,3)	.433 (11,0)	.413 (10,5)
M10 X 1,5	<b>GJ08-2026</b>	.020-.138 (0,50-3,5)	.512 (13,0)	.510 (12,95)	.545-.559 (13,85-14,20)	.031 (0,80)	.689 (17,5)	.610 (15,5)	.846 (21,5)	.570 (14,5)	.512 (13,0)

30

#### Note:

1. All dimensions shown in ( ) are millimeters, otherwise imperial.

Avdel Cherry **TEXTRON**

**Low-Profile Splined**

Material	Finish
Low Carbon Steel / 1008	Zinc Plated Yellow Dichromate

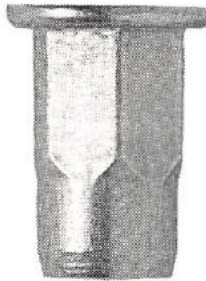
Series 39006 Splined Body											
Thread Size	Part Number	Sheet Thickness	Recommended Hole Size	øA Max.	øB	D (±.005)	øJ Max.		C Nom.	P Max.	E Nom.
							Min. Sheet	Max. Sheet			
M4 X 0,7	<b>39006-24020</b>	.010-.079 (0,25-2,0)	.236 (6,0)	.234 (5,95)	.250-.264 (6,35-6,70)	.018 (0,46)	.346 (8,8)	.299 (7,6)	.445 (11,3)	.280 (7,1)	.232 (5,9)
M5 X 0,8	<b>39006-25030</b>	.010-.118 (0,25-3,0)	.276 (7,0)	.274 (6,95)	.293-.307 (7,45-7,80)	.018 (0,46)	.402 (10,2)	.350 (8,9)	.500 (12,7)	.311 (7,9)	.268 (6,8)
M6 X 1,0	<b>39006-26030</b>	.020-.118 (0,50-3,0)	.354 (9,0)	.352 (8,95)	.388-.402 (9,85-10,20)	.020 (0,50)	.500 (12,7)	.449 (11,4)	.602 (15,3)	.370 (9,4)	.331 (8,4)
M8 X 1,25	<b>39006-28035</b>	.020-.138 (0,50-3,5)	.433 (11,0)	.431 (10,95)	.467-.480 (11,85-12,20)	.025 (0,63)	.591 (15,0)	.520 (13,2)	.681 (17,3)	.433 (11,0)	.402 (10,2)

**Note:**

1. All dimensions shown in ( ) are millimeters, otherwise imperial.

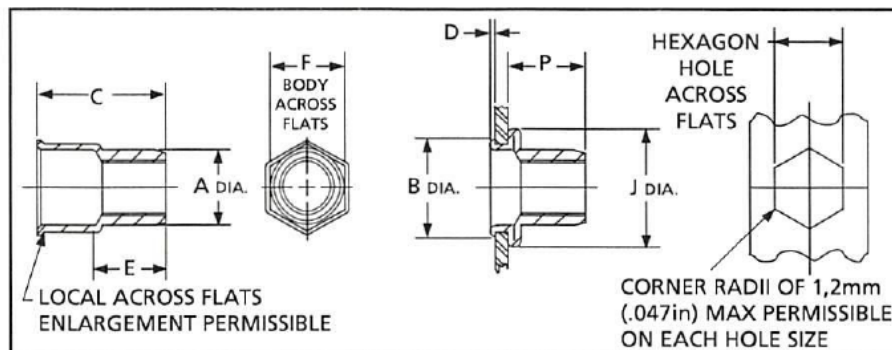


Three product lines with a hexagonal body style provides superior torque-to-turn and pull out performance.



### Benefits:

- Choice of Head Style**  
 Available in low-profile or large-flange head styles.
- Hard and Soft Metric Design**  
 Available in either hard-metric or soft-metric body style.
- Easy Insertion Into Hole**  
 Double-diameter body and lead-in chamfer make insert-to-hole orientation simple and fast.
- High Performance**  
 Hexagon body style provides superior torque-to-turn performance over round and splined threaded inserts. Pull-out performance is exceptional.
- Roll-Formed Threads**  
 Increased thread strength.



Avdel Cherry **TEXTRON**

Material	Finish
Steel	Zinc Plate Yellow Dichromate

TSN Series 9688												
Thread Size	Part Number	Sheet Thickness	Recommended Hexagon Hole A/F	øA Max.	øB Max.	D Max.	F Max.	øJ Max.		C Max.	P Max.	E Max.
								Min. Sheet	Max. Sheet			
M4 X 0,7	9688-0413	.020-.064 (0,51-1,63)	.251-.253 (6,38-6,43)	.249 (6,33)	.315 (8,00)	.027 (0,69)	.2507 (6,37)	.39 (10,0)	.34 (8,7)	.410 (10,42)	.29 (7,4)	.260 (6,61)
M5 X 0,8	9688-0514	.020-.080 (0,51-2,03)	.286-.288 (7,26-7,32)	.281 (7,14)	.363 (9,22)	.028 (0,72)	.2857 (7,26)	.48 (12,2)	.42 (10,7)	.465 (11,82)	.28 (7,2)	.250 (6,35)
M6 X 1,0	9688-0619	.030-.115 (0,76-2,92)	.380-.382 (9,65-9,70)	.375 (9,53)	.470 (11,94)	.035 (0,89)	.3792 (9,64)	.59 (15,0)	.50 (12,7)	.575 (14,61)	.38 (9,7)	.345 (8,77)
M8 X 1,25	9688-0821	.036-.128 (0,91-3,25)	.421-.425 (10,70-10,80)	.413 (10,50)	.510 (12,96)	.035 (0,89)	.4200 (10,67)	.65 (16,6)	.56 (14,3)	.630 (16,00)	.41 (10,5)	.375 (9,52)

EURO Low Profile / Series 39101												
Thread Size	Part Number	Sheet Thickness	Recommended Hexagon Hole A/F	øA (±0,08)	øB Across Corners Max.	D (ø0,13)	F (±0,08)	C (±0,50)	P Max.	øS (±0,08)	E Nom.	
M4 X 0,7	39101-24020	.020-.079 (0,5-2,0)	.236 (6,0)	.232 (5,89)	.307 (7,8)	.020 (0,50)	.232 (5,89)	.413 (10,5)	.236 (6,0)	.206 (5,22)	.213 (5,4)	
M5 X 0,8	39101-25030	.020-.118 (0,5-3,0)	.276 (7,0)	.272 (6,91)	.358 (9,1)	.030 (0,76)	.272 (6,91)	.500 (12,7)	.268 (6,8)	.240 (6,10)	.244 (6,2)	
M6 X 1,0	39101-26030	.020-.118 (0,5-3,0)	.354 (9,0)	.351 (8,91)	.457 (11,6)	.033 (0,84)	.351 (8,91)	.591 (15,0)	.398 (10,1)	.313 (7,95)	.342 (8,7)	
M8 X 1,25	39101-28030	.020-.118 (0,5-3,0)	.433 (11,0)	.429 (10,89)	.559 (14,2)	.041 (1,03)	.429 (10,89)	.689 (17,5)	.449 (11,4)	.394 (10,01)	.386 (9,8)	

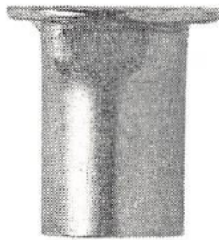
EURO Large Flange / Series 9498												
Thread Size	Part Number	Sheet Thickness	Recommended Hexagon Hole A/F	øA (±0,08)	øB	D (ø0,13)	F (±0,08)	C (±0,50)	P Max.	R (±0,10)	S (±0,08)	E (±0,40)
M4 X 0,7	9498-0415	.020-.079 (0,5-2,0)	.236-.240 (6,0-6,1)	.232 (5,89)	.346-.361 (8,79-9,17)	.039 (1,00)	.232 (5,89)	.394 (10,0)	.197 (5,0)	.01 (0,4)	.206 (5,22)	.170 (4,4)
M5 X 0,8	9498-0516	.020-.118 (0,5-3,0)	.276-.280 (7,0-7,1)	.271 (6,89)	.385-.400 (9,79-10,17)	.039 (1,00)	.271 (6,89)	.520 (13,2)	.268 (6,8)	.02 (0,5)	.240 (6,10)	.240 (6,2)
M6 X 1,0	9498-0620	.020-.118 (0,5-3,0)	.354-.358 (9,0-9,1)	.350 (8,89)	.504-.520 (12,80-13,20)	.059 (1,50)	.350 (8,89)	.610 (15,5)	.400 (10,1)	.03 (0,7)	.313 (7,95)	.342 (8,7)
M8 X 1,25	9498-2823	.020-.118 (0,5-3,0)	.433-.437 (11,0-11,1)	.429 (10,89)	.617-.641 (15,68-16,28)	.059 (1,50)	.429 (10,89)	.709 (18,0)	.449 (11,4)	.03 (0,7)	.394 (10,01)	.386 (9,8)
M10 X 1,5	9498-2026	.040-.138 (1,0-3,5)	.512-.516 (13,0-13,1)	.507 (12,89)	.736-.760 (18,70-19,30)	.079 (2,00)	.507 (12,89)	.827 (21,0)	.520 (13,2)	.03 (0,7)	.463 (11,75)	.476 (12,1)

Note:

1. All dimensions shown in ( ) are millimeters, otherwise imperial.

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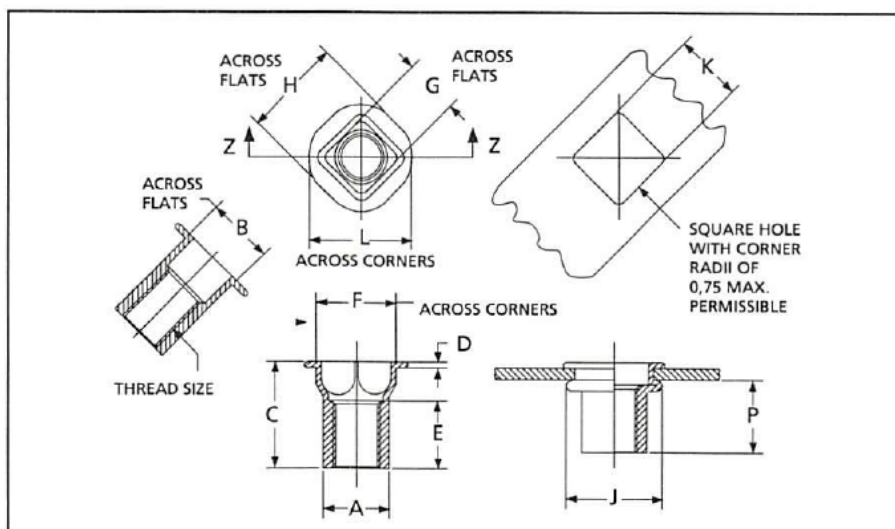
*Square-bodied product provides the ultimate in torque-to-turn performance.*



### Benefits:

- Square Body**  
 Increased torque-to-turn performance over all round, splined and hexagon bodied products in a range.
- Large Flange Head**  
 Increased push-out performance.
- Metric and Imperial Design**  
 Available in both metric and imperial thread sizes.
- Roll-Formed Threads**  
 Increased thread strength.

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**Avdel Cherry** **TEXTRON**

## Large Flange/Series GK

Material	Finish
Low Carbon Steel 1008	Zinc Plated Yellow Dichromate

Part Number	Thread Size	Sheet Thickness	øA Max.	B A/F	C Max.	D Max.	E Max.	F Max.	G Max.	H Max.	J Max.	K ±0,10 Hole Size	L Max.	P Max.
GK08-0514	M5	(0,5-1,5)	(7,10)	(7,10)	(11,40)	(0,90)	(7,25)	(8,60)	(5,85)	(10,50)	(10,40)	(7,30)	(10,90)	(8,20)
GK08-0619	M6	(0,5-2,0)	(9,10)	(9,10)	(15,50)	(0,95)	(8,65)	(10,75)	(7,65)	(13,20)	(13,50)	(9,30)	(13,50)	(9,90)

Part Number	Thread Size	Sheet Thickness	øA Max.	B A/F	C Max.	D Max.	E Max.	F Max.	G Max.	H Max.	J Max.	K ±0,10 Hole Size	L Max.	P Max.
GK05-0814	8-32	(0,5-1,5)	(7,10)	(7,10)	(11,40)	(0,90)	(7,25)	(8,60)	(5,85)	(10,50)	(10,40)	(7,30)	(10,90)	(8,20)
GK05-1014	10-24													
GK07-1014	10-32													
GK04-0819	1/4-20	(0,5-2,0)	(9,10)	(9,10)	(15,50)	(0,95)	(8,65)	(10,75)	(7,65)	(13,20)	(13,50)	(9,30)	(13,50)	(9,90)

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**Note:**

- All dimensions shown in ( ) are millimeters, otherwise imperial.

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[errytextron.com](http://www.errytextron.com)

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1-888-872-0690

<https://www.AngicGlobal.com> [Sales@AngicGlobal.com](mailto:Sales@AngicGlobal.com)

28.98

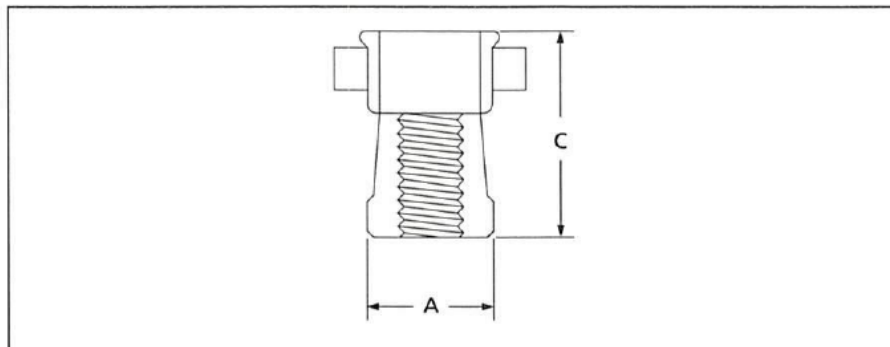


Provides captive threads in material thickness greater than .030" including blind holes.



### Benefits:

- **Improved Locking Mechanism**  
Greater push / pull out over Nutsert®.
- **Not Grip Sensitive**  
Can be used in any material thickness from .030" through solid materials.
- **Permanent**  
Radial expansion of Nutsert® provides 360° contact with parent material.
- **Portability**  
Allows installation anywhere and at any time in the assembly process.
- **Rear Protrusion**  
Reduced rear-sheet protrusion.



Avdel Cherry **TEXTRON**

Material	Finish
Low Carbon Steel SAE 12C14	Zinc Plated Yellow Passivated

Series FB08								
Thread Size	Supersert Part Number	A Max.	C Max.	Hole Size vs. Material Thickness				
				.031-.063 (0,8-1,6mm)	.063-.090 (1,6-2,3mm)	.091-.126 (2,3-3,2mm)	.126-.156 (3,2-3,95mm)	Over .156 (3,95mm)
M3	<b>FB08-0313</b>	.187 (4,75)	.415 (10,55)	.187 (4,77)	.187 (4,77)	.189 (4,8)	.193 (4,9)	.193 (4,9)
M4	<b>FB08-0414</b>	.249 (6,338)	.455 (11,56)	.250 (6,35)	.250 (6,35)	.252 (6,4)	.256 (6,5)	.260 (6,6)
M5	<b>FB08-0514</b>	.280 (7,130)	.455 (11,56)	.281 (7,14)	.288 (7,3)	.291 (7,4)	.295 (7,5)	.295 (7,5)
M6	<b>FB08-0616</b>	.375 (9,513)	.525 (13,34)	.375 (9,53)	.378 (9,6)	.382 (9,7)	.386 (9,8)	.386 (9,8)
M8	<b>FB08-0820</b>	.499 (12,688)	.625 (15,88)		.500 (12,7)	.504 (12,8)	.508 (12,9)	.512 (13)
8-32 UNC	<b>FB08-0814</b>	.2495 (6,338)	.455 (11,56)	.250 (6,35)	.250 (6,35)	.252 (6,4)	.256 (6,5)	.260 (6,6)
10-32 UNF	<b>FB07-1014</b>	.2807 (7,13)	.455 (11,56)	.281 (7,14)	.287 (7,3)	.291 (7,4)	.295 (7,5)	.295 (7,5)
1/4-20 UNC	<b>FB04-0816</b>	.3745 (9,51)	.525 (13,34)	.375 (9,53)	.378 (9,6)	.382 (9,7)	.386 (9,8)	.386 (9,8)

**Notes:**

1. All dimensions shown in ( ) are millimeters, otherwise imperial.
2. Supersert® inserts are supplied prelubricated. DO NOT DEGREASE.

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x 704.888.0258  
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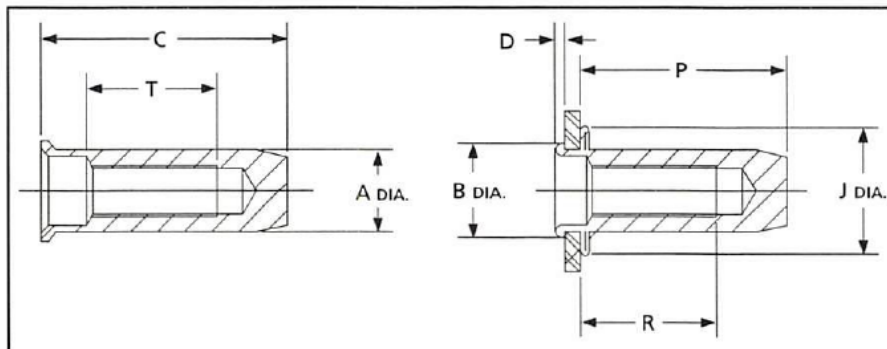
Like TSN / LF TSN with closed-end nut section.



### Benefits:

- **Closes Through Hole**  
Prevents ingress of foreign materials, water and gas.

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Material	Finish
Low Carbon Steel 12C14	Zinc Plated Yellow Dichromate

Low Profile / Series FS38												
Thread Size	Part Number	Sheet Thickness	Recommended Hole Size	øA Max.	øB Max.	D Max.	øJ Max.		C Max.	P Max.	R Min.	T Min.
							Min. Sheet	Max. Sheet				
M4 X 0,7	<b>FS38-0418</b>	.020-.079 (0,51-2,00)	.2500-.2535 (6,35-6,44)	.2495 (6,338)	.295 (7,50)	.025 (0,64)	.39 (10,0)	.36 (9,2)	.587 (14,91)	.46 (11,7)	.27 (6,8)	.26 (6,6)
M5 X 0,8	<b>FS38-0521</b>	.020-.118 (0,51-3,00)	.2811-.2845 (7,14-7,23)	.2807 (7,130)	.325 (8,26)	.025 (0,64)	.48 (12,2)	.45 (11,5)	.797 (20,26)	.61 (15,5)	.26 (6,7)	.25 (6,4)
M6 X 1,0	<b>FS38-0626</b>	.030-.128 (0,76-3,25)	.3752-.3785 (9,53-9,61)	.3745 (9,513)	.427 (10,85)	.030 (0,77)	.59 (15,0)	.49 (12,5)	.925 (23,49)	.73 (18,6)	.37 (9,3)	.36 (9,1)
M8 X 1,25	<b>FS38-0829</b>	.036-.146 (0,91-3,70)	.4173-.4205 (10,60-10,68)	.4168 (10,587)	.462 (11,74)	.030 (0,77)	.66 (16,8)	.56 (14,3)	.930 (23,63)	.71 (18,1)	.41 (10,5)	.40 (10,2)

Large Flange / Series FS58												
Thread Size	Part Number	Sheet Thickness	Recommended Hole Size	øA Max.	øB Max.	D ±0,13	øJ Max.		C Max.	P Max.	R Min.	T Min.
							Min. Sheet	Max. Sheet				
M4 X 0,7	<b>FS58-0421</b>	.020-.100 (0,50-2,50)	.240 (6,10)	.238 (6,05)	.343-.366 (8,70-9,30)	.031 (0,80)	.41 (10,5)	.33 (8,4)	.655 (16,64)	.48 (12,1)	.27 (6,9)	.26 (6,6)
M5 X 0,8	<b>FS58-0522</b>	.020-.100 (0,50-2,50)	.280 (7,10)	.278 (7,05)	.382-.406 (9,70-10,30)	.039 (1,00)	.52 (13,3)	.44 (11,2)	.691 (17,56)	.49 (12,3)	.26 (6,8)	.25 (6,5)
M6 X 1,0	<b>FS58-0628</b>	.020-.118 (0,50-3,00)	.358 (9,10)	.356 (9,05)	.500-.524 (12,70-13,30)	.059 (1,50)	.59 (15,0)	.50 (12,7)	.885 (22,48)	.63 (16,0)	.37 (9,5)	.36 (9,2)
M8 X 1,25	<b>FS58-0832</b>	.039-.157 (1,00-4,00)	.437 (11,10)	.435 (11,05)	.539-.563 (13,70-14,30)	.059 (1,50)	.73 (18,6)	.60 (15,3)	1.017 (25,84)	.78 (19,8)	.43 (10,7)	.42 (10,7)

**Note:**

1. All dimensions shown in ( ) are millimeters, otherwise imperial.

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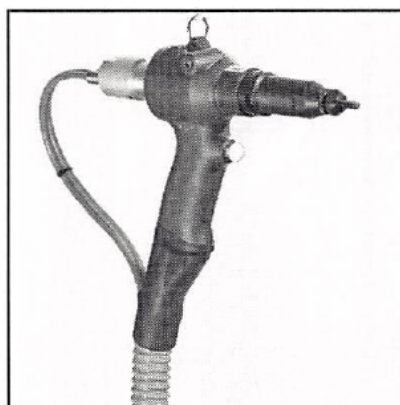


### MODEL 742

Lightweight and ergonomically designed, the Model 742 tool is a pneumatic-hydraulic "spin-pull" type tool. Blind threaded inserts are installed with a simple "spin-on, pull-up, spin-off" sequence utilizing a fast and simple one-step trigger. The extensive working range includes M3 to M10 Metric and 4-40 to 5/16 Imperial, including some M12 and 3/8 variants.

<b>Weight</b>	4.85 lbs (2.2 kg)
<b>Stroke</b>	.276" (7mm)
<b>Pull Force</b>	4,380 lbf @ 75 psi (19.5 kN @ 5 bar)

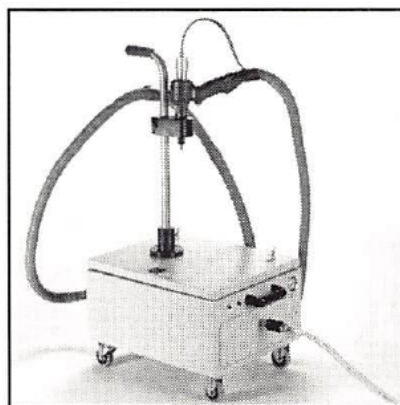
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### MODEL 744

The remote-head Model 744 tool is designed for placement of large-diameter blind threaded inserts. The separate hydraulic system generates power to pull large diameter inserts while using a small lightweight placing head. The 744 uses a fast and simple one-step trigger to "spin-on, pull-up, spin-off" all blind threaded inserts from M3 to M12 Metric and 4-40 to 3/8 Imperial. Available options include special-purpose "in-line head" and foot-pedal actuation.

<b>Weight (head)</b>	4.5 lbs (2 kg)
<b>Stroke</b>	552" (14mm)
<b>Pull Force</b>	8,220 lbf @ 75 psi (36.6 kN @ 5 bar)



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### MODEL 7556 and Model 7557

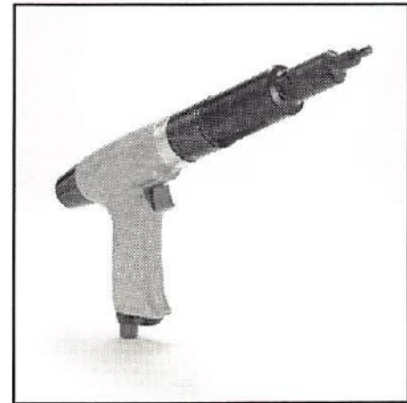
The 7556 and 7557 are high-production, rugged, lightweight "spin-spin" tools utilizing an internal torque-sensing clutch for consistent blind threaded insert placement. These tools permit complete portability on any assembly line, and have been used in industry for many years because of their durable construction and reliability.

**Model 7556 Range** Most styles of inserts from 4-40 to #10 Imperial, M3 to M8 Metric, except stainless steel as noted on page 35.

**Weight** 3.9 lbs (1.76 kg)  
**Motor Speed** 1,000 RPM @ 75 psi (5 bar)  
**Cycle Time** Approximately 3 seconds

**Model 7557 Range** Most styles of inserts from 6-32 to 1/4 Imperial, M5 to M10 Metric.

**Weight** 3.64 lbs (1.65 kg)  
**Motor Speed** 550 RPM @ 75 psi (5 bar)  
**Cycle Time** Approximately 3 seconds

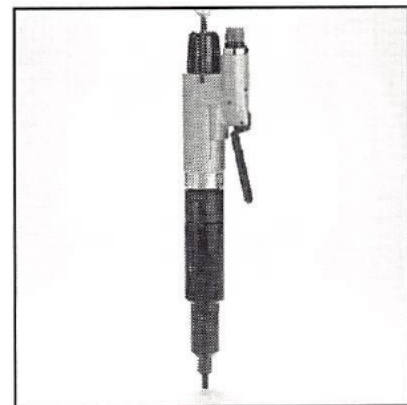


### MODEL 7572

Model 7572 incorporates all the features of the 7556/7557 series tools in a smaller, lighter "in-line" style.

**Model 7572 Range** Most styles of inserts from 4-40 to #10 Imperial, M3 to M6 Metric, except stainless steel as noted on page 35.

**Weight** 2.5 lbs (1.15 kg)  
**Motor Speed** 900 RPM @ 75 psi (5 bar)  
**Cycle Time** Approximately 3 seconds



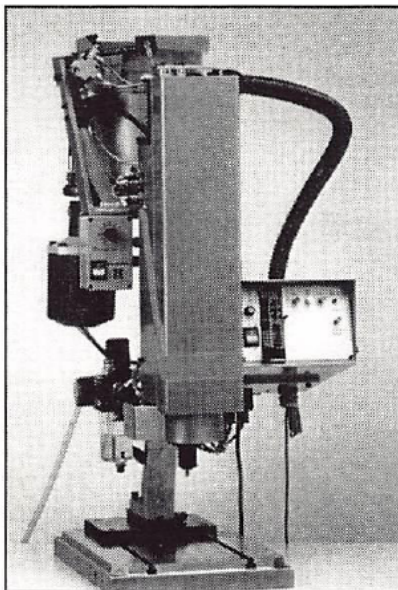


### **Model 9600**

Model 9600 is a manually-operated "squeeze" tool to install blind threaded inserts. It is designed for use where a compressed air source is unavailable.

Available nose assembly conversion kits allow installation of blind threaded inserts from 4-40 to 3/8 Imperial, M3 to M10 Metric. Tool kits are available for prototyping, re-work and maintenance applications.

Dimensions are approximately 10-1/2" X 7-1/4" in the "open" position.

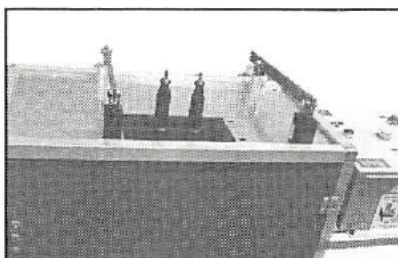


### **Autosert**

High-volume production capability and cutting-edge assembly technology come together for blind threaded insert applications with the Avdel Cherry Autosert and Autosert 360 automated assembly systems.

The Autosert is a "stand-alone" table top unit designed for high-volume batch or flow-line assembly. The Autosert 360 is a fully "robotic-integratable" unit designed for blind threaded insert installation requiring multiple orientations to the workpiece.

Avdel Cherry offers design support technicians to help determine the optimum equipment for your application.



### **Hydra 3000**

Modular-based multi-head workstations designed to install M3 to M6 Nutserts.

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Tooling and Fastener Cross Reference									
		TSN	CLOSED END	NUTSERT	SUPERSERT	EUROSERT	HEXSERT	LF HEXSERT	SQUARESERT
742	<b>Metric</b>	M3 - M12	M3 - M10	M3 - M12	M3 - M12	M3 - M10	M3 - M10	M3 - M10	ALL SIZES
	<b>Imperial</b>	4 - 3/8	4 - 5/16	4 - 3/8	4 - 3/8	N/A	N/A	N/A	ALL SIZES
744	<b>Metric</b>	M3 - M12	M3 - M12	M3 - M12	M3 - M12	M3 - M10	M3 - M10	M3 - M10	ALL SIZES
	<b>Imperial</b>	4 - 3/8	4 - 3/8	4 - 3/8	4 - 3/8	N/A	N/A	N/A	ALL SIZES
7556	<b>Metric</b>	M3 - M8	M3 - M6 Except Stainless Steel	M3 - M8	M3 - M8	M3 - M6 Except Stainless Steel	M3 - M6 Except Stainless Steel	M3 - M6 Except Stainless Steel	M3 - M6 Except Stainless Steel
	<b>Imperial</b>	4 - 5/16	4 - 1/4 Except Stainless Steel	4 - 5/16	4 - 5/16	4 - 1/4 Except Stainless Steel	4 - 1/4 Except Stainless Steel	4 - 1/4 Except Stainless Steel	4 - 1/4 Except Stainless Steel
7557	<b>Metric</b>	M3 - M10	M3 - M8 Except Stainless Steel	M3 - M10	M3 - M10	M3 - M8 Except Stainless Steel	M3 - M8 Except Stainless Steel	M3 - M8 Except Stainless Steel	M3 - M8 Except Stainless Steel
	<b>Imperial</b>	4 - 3/8	4 - 5/16 Except Stainless Steel	4 - 3/8	4 - 3/8	4 - 5/16 Except Stainless Steel	4 - 5/16 Except Stainless Steel	4 - 5/16 Except Stainless Steel	4 - 5/16 Except Stainless Steel
7572	<b>Metric</b>	M3 - M5	M3 - M5 Except Stainless Steel	M3 - M6	M3 - M6	M3 - M5 Except Stainless Steel	M3 - M5 Except Stainless Steel	M3 - M5 Except Stainless Steel	M3 - M5 Except Stainless Steel
	<b>Imperial</b>	4 - 10	4 - 10 Except Stainless Steel	4 - 1/4	4 - 1/4	4 - 10 Except Stainless Steel	4 - 10 Except Stainless Steel	4 - 10 Except Stainless Steel	4 - 10 Except Stainless Steel
9600	<b>Metric</b>	M3 - M6	N/A	N/A	N/A	N/A	N/A	N/A	N/A
	<b>Imperial</b>	4 - 1/4	N/A	N/A	N/A	N/A	N/A	N/A	N/A
Autosert *		All Sizes	All Sizes	All Sizes	All Sizes	All Sizes	All Sizes	All Sizes	All Sizes
Hydra 3000 *		All Sizes	All Sizes	All Sizes	All Sizes	All Sizes	All Sizes	All Sizes	All Sizes

\* These tooling systems are of a highly technical nature. Prior to specification please consult Technical Services.

The matrix above represents whether the tool listed is capable of placing the respective fastener. To obtain specific nose equipment details, refer to the operations manual or contact Avdel Cherry Textron technical services.

**Note:** For placement of LF TSN, we recommend that only model numbers 742 and 744 be used.

# Notes

Large empty area for notes, bounded by a red dotted line.

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