

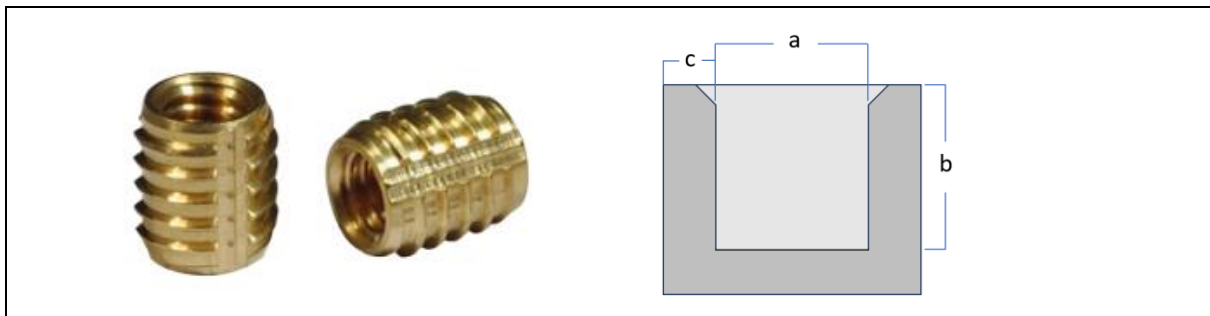
Design Guidelines

Inserts

ONKENHOUT TRISERT – MESSING insert for plastics

- Material: Messing Brass BS EN 12164CW 614N
- Thread: Metrisch Metric
- Assembly method: Inschroeven Screw in

Add a chamfer of 0.50 - 1.0 mm on the edges for the best visual result



Thread	Type	Hole diameter ¹⁾ [mm] (a)	Insert length [mm]	Min. hole depth [mm] (b)	Wall thickness ²⁾ [mm] (c)
M3	A	4.3	4.00	5.00	2.00
M3	B	4.3	5.25	6.25	2.00
M4	A	6.0	5.60	6.80	2.30
M4	B	6.0	7.10	8.30	2.30
M5	A	7.0	6.40	7.60	2.70
M5	B	7.0	8.40	9.60	2.70
M6	A	8.2	7.90	9.10	3.15
M6	B	8.2	9.80	11.00	3.15
M8	A	10.4	9.50	11.00	4.00
M8	B	10.4	12.40	13.90	4.00

Please note, direct access to the hole is required to be able to place the insert.
 Other sizes are available on request.

¹⁾ Required hole diameter for the 3D printed part.

²⁾ Minimum wall thickness surrounding the feature.

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Revision date: April 2024

Design Guidelines

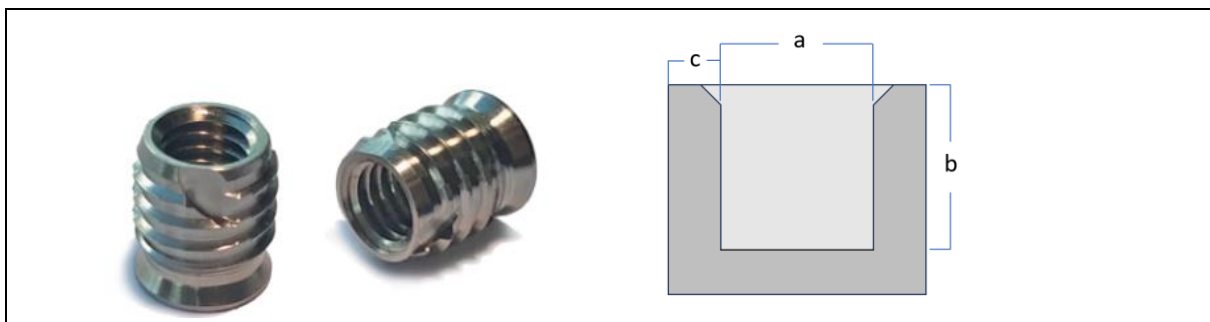
Inserts

ONKENHOUT TRISERT – RVS A4 insert for plastics

Selected for food contact applications

- Material: RVS A4 (316) SS 316
- Thread: Metrisch Metric
- Assembly method: Inschroeven Screw in

Add a chamfer of 0.50 - 1.0 mm on the edges for the best visual result



Thread	Hole diameter ¹⁾ [mm] (a)	Insert length [mm]	Min. hole depth [mm] (b)	Wall thickness [mm] (c)
M3	4.3	5.25	6.25	2.00
M4	6.0	7.10	8.30	2.30
M5	7.0	8.40	9.60	2.70
M6	8.2	9.80	11.00	3.15
M8	10.4	12.40	13.90	4.00

*Please note, direct access to the hole is required to be able to place the insert.
Other sizes are available on request.*

¹⁾ Required hole diameter for 3D printed part.

²⁾ Minimum wall thickness surrounding the feature.

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Design Guidelines

Ruimen // Reaming

WÜRTH NC-MACHINE REAMER H7

Add a chamfer of 0.50 - 1.0 mm on the edges for the best visual result

	Diameter [mm]	Tolerance ¹⁾ [mm]	Hole diameter ²⁾ [mm]	Max. depth ³⁾ [mm]
	Ø 3.0	± 0.05	2.8	15
	Ø 4.0	± 0.05	3.8	19
	Ø 5.0	± 0.05	4.8	23
	Ø 6.0	± 0.05	5.7	26
	Ø 8.0	± 0.05	7.7	33

*Please note, direct access to the hole is required to execute reaming.
Other sizes are available on request.*

Minimum wall thickness of 2.0 mm surrounding the feature.

¹⁾ Tolerance of H7 is valid for the used tooling. We do not deburr the edges.

²⁾ Required hole diameter for 3D printed part.

³⁾ Minimum hole depth for blind holes is the required depth + 2.0 mm.

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Design Guidelines

Tappen // Threading

THREADING WÜRTH Gas thread type BSP 55°

Add a chamfer of 0.50 - 1.0 mm on the edges for the best visual result

	Type	Hole diameter ^{1]} [mm]	Min. wall thickness ^{2]} [mm]	Max. depth ^{3]} [mm]
	G1/8	8.70	4.00	26
	G1/4	11.8	4.50	18
	G3/8	15.3	5.00	18

*Please note, direct access to the hole is required to execute threading.
Other sizes are available on request.*

^{1]} Required hole diameter for 3D printed part.

^{2]} Minimum wall thickness surrounding the feature.

^{3]} Minimum hole depth for blind holes is the required depth + additional hole depth of 6.0 mm.

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Design Guidelines

Tappen // Threading

THREADING Machine treading TCE HSSE

Add a chamfer of 0.50 - 1.0 mm on the edges for the best visual result

	Type	Hole diameter ¹⁾ [mm]	Min. wall thickness ²⁾ [mm]	Max. depth [mm]	Additional hole depth ³⁾ [mm]
M3	2.5	2.00	7.50	3.0	
M4	3.3	2.30	10.00	4.2	
M5	4.2	2.70	15.00	4.8	
M6	5.0	3.15	16.50	6.0	
M8	6.8	4.00	16.50	7.5	
M10	8.5	4.00	25.00	9.0	
M12	10.2	4.00	25.00	10.5	

¹⁾ Required hole diameter for 3D printed part.

²⁾ Minimum wall thickness surrounding the feature.

³⁾ Minimum hole depth for blind holes is the required depth + additional hole depth in mm.

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