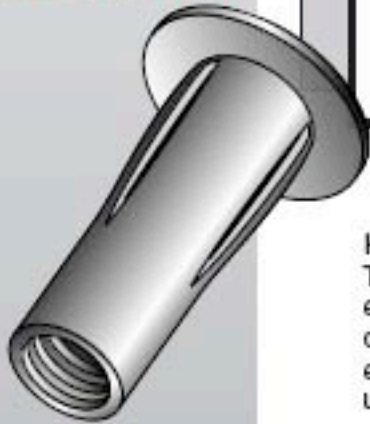


A-R SERIESTM INSERT PROFILE

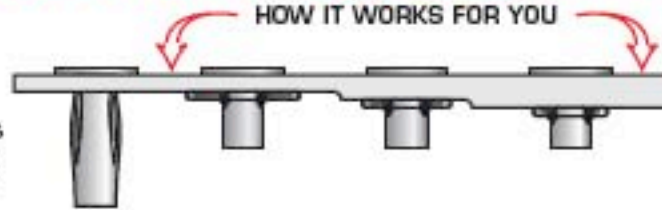
The A-R SeriesTM threaded insert has been designed for use in plastics and thin gauge sheet metal applications where increased pull-out resistance is required.

The A-R Series features a PreSetTM slotted body design that when installed folds into four segments gripping the backside of the parent material. This design feature allows the A-R Series to be installed into single, variable or multiple thickness materials using AVK's ARO torque-stall pneumatic tools or AVK's SPPTM pneumatic/hydraulic tools.



A-R SeriesTM PreSetTM Design

How it works for you:
The PreSetTM slightly expanded slotted body design of the A-R Series enables it to be installed using torque type tools.



Hand or pneumatic torque tools will install the A-R Series in single, variable or multiple thickness materials.

DESIGN BENEFITS

- ◆ **INSTALLS USING TORQUE** stall type tooling due to the slightly expanded slotted body design. This is important when working with plastics that vary in thickness. No adjustment of the tool is necessary when installing the part into variable thickness materials.
- ◆ **INSTALLS USING HAND WRENCHED TORQUE** type tools. Ideal for use in kits and consumer installation applications
- ◆ **PROVIDES EXCEPTIONAL** pull out resistance in soft plastics or thin sheet metal applications even if holes are hand drilled and oversized.
- ◆ **SUPERIOR CORROSION RESISTANCE** because all surfaces of the slotted body are plated. Standard plating is zinc/yellow dichromate finish (96 hours to white corroding). For exceptional corrosion protection we offer a tin/zinc alloy finish.
- ◆ Superior thread strength due to AVK's internal roll threading process.
- ◆ **AVAILABLE IN STEEL.**

AIR TOOL SELECTION SPPTM TOOL

The A-R has been designed to install with either the SPP Tool or the ARO type tool. The SPP Tool will install the A-R per the suggested grip ranges shown on page 17. See page 33 for SPP tool information.

AIR TOOL SELECTION AROTM TOOL

The ARO pneumatic tool shown on pages 28 and 29 will install the A-R Series threaded insert. It will affect the published grip range of the part based on the tools' RPM and the density of the parent material. See the chart on page 17 for grip range information. AVK suggests trial installations in the actual application before specifying the optimum ARO tool.

ADDITIONAL DESIGN TYPES

A-R STUDS

An A-R blind side, petaled footprint produces exceptional pull-out combined with a stud for component attachment.

Contact AVK for availability.



SPECIAL HEAD DESIGNS

Special head configurations such as square or wedge head can increase the inserts holding resistance in the parent material.

Contact AVK for availability.



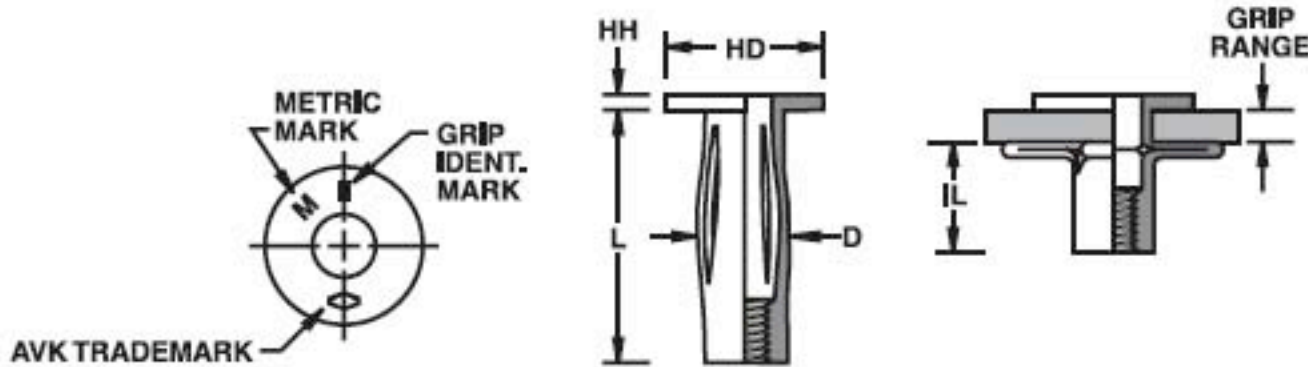
STRAIGHT BODY DESIGN

A straight body A-R Series[®] insert is ideal for thin sheet metals, tubing & plastic applications where high pull-out is required.

Contact AVK for availability.



UNIFIED (INCH) AND METRIC THREAD SIZES

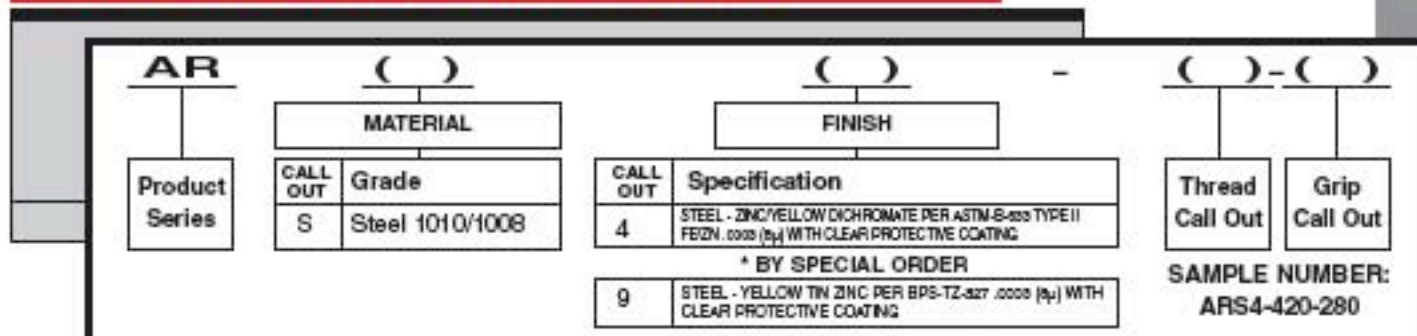


THREAD CLASS: Unified 2B/21 per ASME B1.1
Metric 6H/21 per ASME B1.13M
MATERIAL: S=Steel C1010/1008
PLATING: 4=Yellow Zinc Plate per ASTM-B633TYII, FE/ZN 8,
.0003 (8µ) with clear protective coating

THREAD SIZE	THREAD CALL OUT	GRIP RANGE	GRIP CALL OUT	HOLE SIZE	HD	HH'	L	D	IL MAX	GRIP ID MARK
1/4-20 UNC	420	.020-.280	.280	.390	.645	.063	1.015	.382	.520	Blank
				.396	.610	.053	.985	.368		
1/4-20 UNC	420	.280-.500	.500	.390	.645	.063	1.249	.382	.520	1 Rad
				.396	.610	.053	1.219	.368		
5/16-18 UNC	518	.020-.280	.280	.500	.770	.067	1.156	.495	.775	Blank
				.506	.740	.057	1.126	.490		
5/16-18 UNC	518	.280-.500	.500	.500	.770	.067	1.390	.495	.775	1 Rad
				.506	.740	.057	1.360	.490		
3/8-16 UNC	616	.020-.280	.280	.594	.865	.083	1.205	.582	.775	Blank
				.600	.895	.093	1.233	.587		
M6x1,0 ISO	610	0,5-7,1	7.1	10,00	16,38	1,60	25,78	9,8	13,21	Blank
				10,15	15,49	1,35	25,02	9,35		
M6x1,0 ISO	610	7,1-12,7	12.7	10,00	16,38	1,60	31,72	9,8	13,21	1 Rad
				10,15	15,49	1,35	30,96	9,35		
M8x1,25 ISO	8125	0,5-7,1	7.1	12,70	19,56	1,70	29,63	12,57	19,69	Blank
				12,85	18,80	1,45	28,60	12,47		
M8x1,25 ISO	8125	7,1-12,7	12.7	12,70	19,56	1,70	35,31	12,57	19,69	1 Rad
				12,85	18,80	1,45	34,54	12,47		
M10x1,5 ISO	1015	0,5-7,1	7.1	15,09	22,73	2,36	31,32	14,91	19,69	Blank
				15,24	21,97	2,11	30,61	14,78		

NOTE 1: Grip range stated in the dimensional chart above can be achieved using pull type installation tools and may be variable based on hole size and parent material density. AVK recommends trial installations to determine actual grip range in the application. NOTE 2: Grip ranges will be less than stated above when using torque type installation tools. Grip range will be affected by the tool RPM speed, stall torque, hole size and parent material density. AVK recommends trial installations to determine actual grip. See page 33 for torque tool selection guidelines.

PART NUMBERING SYSTEM



* Special order items are subject to minimum order requirements. Contact AVK for details.

For air tool selection see pages 33 and 35