



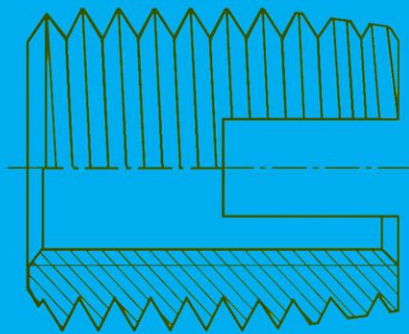
飞航紧固系统

Flight Fastening Systems

钢丝螺套
THREADED
INSERTS


自攻螺套
SELF-TAPPING
THREADED
INSERTS

插销螺套
KEYLOCKING
THREADED
INSERTS



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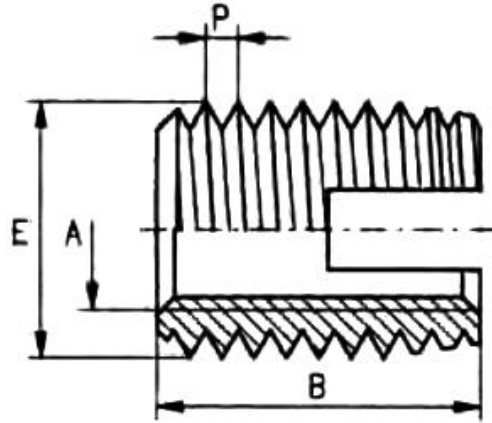
	公制自攻螺套 Threaded insert self-tapping metric inner thread	结构类型 Works Standard 302 0
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应用:

飞航 FH 带切割槽的自攻螺套，用于在低剪切强度材料中承担具有高承载能力的无磨损、抗振动的螺纹连接。

Application:

The threaded insert FH with cutting slot is a self-tapping fastener for the creation of wear-free, vibration resistant screw joints with high loading capacity in materials with low shearing strength.



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物品编号 Article number	内螺纹 Internal thread	外螺纹 External thread		长度 Length	预钻孔指导值 Guideline values for receiving hole diameter	盲孔最小钻孔深度 Minimum borehole depth for blind holes
	A	E	P	B	L	T
302 000 020 ...	M 2	4.5	0.5	6	4.2 to 4.3	8
302 000 025 ...	M 2.5	4.5	0.5	6	4.2 to 4.3	8
302 000 030 ...	M 3	5	0.5	6	4.7 to 4.8	8
302 000 035 ...	M 3.5	6	0.75	8	5.6 to 5.7	10
302 000 040 ...	M 4	6.5	0.75	8	6.1 to 6.2	10
302 000 050 ...	M 5	8	1	10	7.5 to 7.6	13
302 000 061 ...	M 6(a)	9	1	12	8.5 to 8.6	15
302 000 060 ...	M 6	10	1.5	14	9.2 to 9.4	17
302 000 080 ...	M 8	12	1.5	15	11.2 to 11.4	18
302 000 100 ...	M10	14	1.5	18	13.2 to 13.4	22
302 000 120 ...	M12	16	1.5	22	15.2 to 15.4	26
302 000 140 ...	M14	18	1.5	24	17.2 to 17.4	28
302 000 160 ...	M16	20	1.5	22	19.2 to 19.4	26
302 000 180 ...	M18	22	1.5	24	21.2 to 21.4	29
302 000 200 ...	M20	26	1.5	27	25.2 to 25.4	32
302 000 220 ...	M22	26	1.5	30	25.2 to 25.4	36
302 000 240 ...	M24	30	1.5	30	29.2 to 29.4	36
302 000 270 ...	M27	34	1.5	30	33.2 to 33.4	36
302 000 300 ...	M30	36	1.5	40	35.2 to 35.4	46

物品编号的示例
Example for finding the article number

符合工程标准 302 0 的自攻螺套，内螺纹 A=M5，表面硬化、镀锌和蓝色钝化钢：302.000.050.110

Self-tapping threaded insert FH to Works Standard 302 0 with internal thread A=M5 made of case-hardened, zinc plated and blue passivated steel: 302.000.050.110

材料

表面硬化钢，镀锌，蓝色钝化

物品编号（第四组数字）... ..110

Materials

Case-hardened steel, Zinc plated, blue passivated

Article no. (fourth group of digits)... ..110

表面硬化钢，镀锌镍，透明钝化

物品编号（第四组数字）... ..143

Case-hardened steel, Zinc-nickel plated, transparent passivated

Article no. (fourth group of digits)... ..143

表面硬化钢，镀锌，黄铬酸盐处理

物品编号（第四组数字）... ..160

Case-hardened steel, Zinc plated, yellow chromated

Article no. (fourth group of digits)... ..160

不锈钢 14301 (304)

物品编号（第四组数字）... ..400

Stainless steel 14301

Article no. (fourth group of digits)... ..400

不锈钢 14305 (303)

物品编号（第四组数字）... ..500

Stainless steel 14305

Article no. (fourth group of digits)... ..500

不锈钢 14401 (316F)

物品编号（第四组数字）... ..600

Stainless steel 14401

Article no. (fourth group of digits)... ..600

钛 3.7035

物品编号（第四组数字）... ..700

Ti 3.7035

Article no. (fourth group of digits)... ..700

黄铜

物品编号（第四组数字）... ..800

Brass

Article no. (fourth group of digits)... ..800

公差

ISO 2768-m

Tolerance

螺纹

内螺纹 A: 符合 ISO 6H / Internal thread A: as per ISO 6H

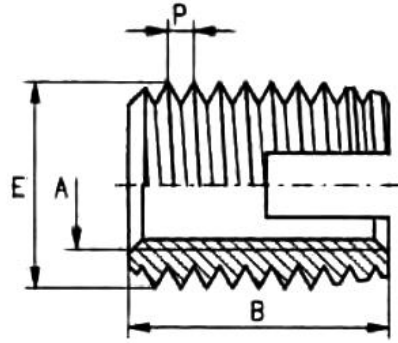
Thread

外螺纹 E: 按 FH 标准 / External thread E: as per FH standard

	英制自攻螺套 Threaded insert self-tapping imperial thread	结构类型 Works Standard 302
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应用：
 飞航 FH 带有切削槽和内螺纹的螺纹嵌件。
 粗牙 UNC 和细牙 UNF。

Application:
 Threaded insert with cutting slot and
 internal thread.
 Whitworth, UNC or UNF



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物品编号 Article number	内螺纹 Internal thread		外螺纹 External thread		长度 Length	预钻孔指导值 Guideline values for receiving hole diameter	盲孔最小钻孔深度 Minimum borehole depth for blind holes
	A	E	P	B			
302 000 604 ...	4-40	5	0.5	6	4.7 to 4.8	8	
302 000 606 ...	6-32	6	0.75	8	5.6 to 5.7	10	
302 000 608 ...	8-32	6.5	0.75	8	6.1 to 6.2	10	
302 000 610 ...	10-24	8	1	10	7.5 to 7.6	13	
302 000 625 ...	1/4-20	10	1.5	14	9.2 to 9.4	17	
302 000 631 ...	5/16-18	12	1.5	15	11.2 to 11.4	18	
302 000 637 ...	3/8-16	14	1.5	18	13.2 to 13.4	22	
302 000 644 ...	7/16-14	16	1.5	22	15.2 to 15.4	26	
302 000 650 ...	1/2-13	18	1.5	22	17.2 to 17.4	26	
302 000 662 ...	5/8-11	20	1.5	22	19.2 to 19.4	26	
302 000 704 ...	4-48	5	0.5	6	4.7 to 4.8	8	
302 000 706 ...	6-40	6	0.75	8	5.6 to 5.7	10	
302 000 708 ...	8-36	6.5	0.75	8	6.1 to 6.2	10	
302 000 710 ...	10-32	8	1	10	7.5 to 7.6	13	
302 000 725 ...	1/4-28	10	1.5	14	9.2 to 9.4	17	
302 000 731 ...	5/16-24	12	1.5	15	11.2 to 11.4	18	
302 000 737 ...	3/8-24	14	1.5	18	13.2 to 13.4	22	
302 000 744 ...	7/16-20	16	1.5	22	15.2 to 15.4	26	
302 000 750 ...	1/2-20	18	1.5	22	17.2 to 17.4	26	
302 000 762 ...	5/8-18	20	1.5	22	19.2 to 19.4	26	

物品编号的示例 符合工程标准 302 的自攻螺套, 内螺纹 A=UNF1/4-28, 表面硬化、镀锌和蓝色钝化钢:
 Example for finding the article number 302. 000. 725. 110
 Self-tapping threaded insert FH to Works Standard 302 with internal thread A=UNF 1/4-28 made of case-hardened, zinc plated and blue passivated steel: 302.000.725.110

材料	表面硬化钢, 镀锌, 蓝色钝化	物品编号 (第四组数字)110
Materials	Case-hardened steel, Zinc plated, blue passivated	Article no. (fourth group of digits)...110
	表面硬化钢, 镀锌镍, 透明钝化	物品编号 (第四组数字)143
	Case-hardened steel, Zinc-nickel plated, transparent passivated	Article no. (fourth group of digits)...143
	表面硬化钢, 镀锌, 黄铬酸盐处理	物品编号 (第四组数字)160
	Case-hardened steel, Zinc plated, yellow chromated	Article no. (fourth group of digits)...160
	不锈钢 14301 (304)	物品编号 (第四组数字)400
	Stainless steel 14301	Article no. (fourth group of digits)...400
	不锈钢 14305 (303)	物品编号 (第四组数字)500
	Stainless steel 14305	Article no. (fourth group of digits)...500
	不锈钢 14401 (316F)	物品编号 (第四组数字)600
	Stainless steel 14401	Article no. (fourth group of digits)...600
	钛 3.7035	物品编号 (第四组数字)700
	Ti 3.7035	Article no. (fourth group of digits)...700
	黄铜	物品编号 (第四组数字)800
	Brass	Article no. (fourth group of digits)...800

公差 ISO 2768-m
 Tolerance

螺纹 内螺纹 A: 符合 ANSI B1,1/BS 1580 2B / Internal thread A: as per ANSI B1,1/BS 1580 2B
 Thread 外螺纹 E: 按 FH 标准/ External thread E: as per FH standard

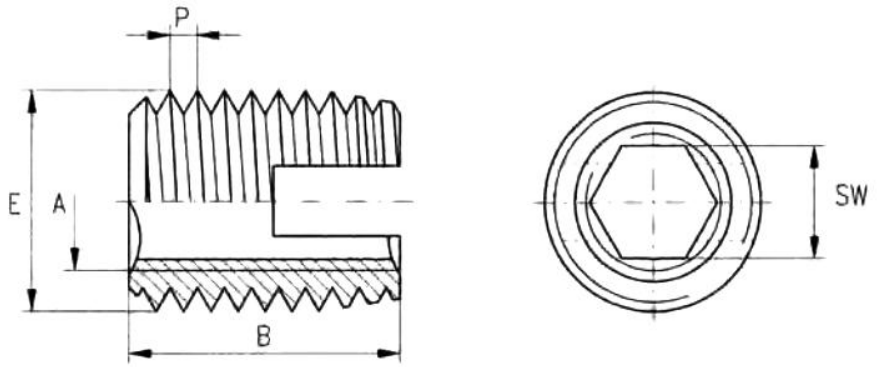
	带六角套筒自攻螺套 Threaded insert self-tapping with hexagonal socket	结构类型 Works Standard 302 2
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应用：
 飞航 FH 带切割槽的自攻螺套，用于在低剪切强度材料中承担具有高承载能力的无磨损、抗振动螺纹连接。

Application:
 The threaded insert FH with cutting slot is a self-tapping fastener for the creation of wear-free, vibration resistant screw joints with high loading capacity in materials with low shearing strength.

六角套筒：
 FH 通过六角套筒插入，从而缩短安装时间。优点：更简单只需要顺时针旋转的驱动工具和机器。FH 可在循环使用前顺利提取。

Hexagonal socket:
 The FH is inserted via the hexagonal socket, permitting the achievement of short installation time.
 Other benefits: More simple driving tools and machines which require only clockwise rotation.
 The FH can be extracted without problems before the recycling process.



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物品编号	内螺纹	外螺纹		长度	六角尺寸	预钻孔指导值	盲孔最小钻孔深度
Article number	Internal thread	External thread		Length	Hexagonal socket	Guideline values for receiving hole diameter	Minimum borehole depth for blind holes
	A	E	P	B	SW+0.1	L	T
302 200 040 ...	M 4	6.5	0.75	8	3.2	6.1 to 6.2	10
302 200 050 ...	M 5	8	1	10	4.1	7.5 to 7.6	13
302 200 060 ...	M 6	10	1.5	14	4.9	9.2 to 9.4	17
302 200 080 ...	M 8	12	1.5	15	6.6	11.2 to 11.4	18
302 200 100 ...	M10	14	1.5	18	8.3	13.2 to 13.4	22
302 200 120 ...	M12	16	1.5	22	10.1	15.2 to 15.4	26

物品编号的示例
 Example for finding the article number
 带内六角套筒，符合工程标准 302 2 的自攻螺套，内螺纹 A=M5，表面硬化、镀锌和蓝色钝化钢：302. 200. 050. 110
 Self-tapping threaded insert with hexagonal socket FH-SL to Works Standard 302 2 with internal thread A = M5 made of case-hardened , zinc plated and blue passivated steel : 302.200.050.110

材料	表面硬化钢，镀锌，蓝色钝化	物品编号（第四组数字）110
Materials	Case-hardened steel, Zinc plated, blue passivated	Article no. (fourth group of digits)...110
	表面硬化钢，镀锌镍，透明钝化	物品编号（第四组数字）143
	Case-hardened steel, Zinc-nickel plated, transparent passivated	Article no. (fourth group of digits)...143
	表面硬化钢，镀锌，黄铬酸盐处理	物品编号（第四组数字）160
	Case-hardened steel , Zinc plated , yellow chromated	Article no. (fourth group of digits)...160
	不锈钢 14301 (304)	物品编号（第四组数字）400
	Stainless steel 14301	Article no. (fourth group of digits)...400
	不锈钢 14305 (303)	物品编号（第四组数字）500
	Stainless steel 14305	Article no. (fourth group of digits)...500
	不锈钢 14401 (316F)	物品编号（第四组数字）600
	Stainless steel 14401	Article no. (fourth group of digits)...600
	钛 3.7035	物品编号（第四组数字）700
	Ti 3.7035	Article no. (fourth group of digits)...700
	黄铜	物品编号（第四组数字）800
	Brass	Article no. (fourth group of digits)...800

公差
 Tolerance
 ISO 2768-m

螺纹
 Thread
 内螺纹 A: 符合 ISO 6H / Internal thread A: as per ISO 6H
 外螺纹 E: 按 FH 标准 / External thread E: as per FH standard

	带凸肩的自攻螺套 Threaded insert self-tapping shouldered	结构类型 Works Standard 302 1
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应用：
 飞航 FH 自攻螺套 302 1 具有切割槽和头部，是一种自攻紧固件，用于在低剪切强度材料中创建具有高承载能力的耐磨、抗振动螺纹接头。

Application:

Threaded insert FH 302 1 with cutting slot and head is a self-tapping fastener for the creation of wear-free, vibration-resistant screw joints with high loading capacity in materials with low shearing strength.

适用于以下材料的安装：

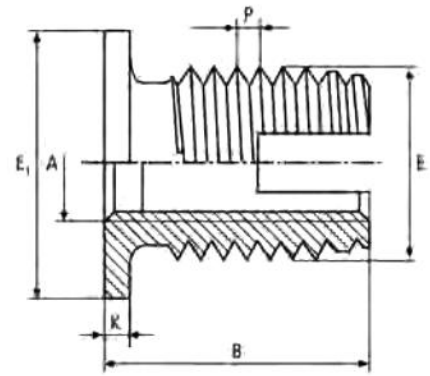
- 轻合金
- 铸铁、黄铜、青铜、NF 金属
- 塑料、层压板
- 硬木

It is suitable for installation in the following materials:

- Light alloys
- Cast iron, brass, bronze, NF metals
- Plastics, laminates
- Hardwoods

当同时紧固多个零件时，头部用作触点的支撑；
 当对头部施加应力时，拉力显著增加。

The head serves as a support for electrical contacts when fastening several parts simultaneously; when stress is applied against the head, the pull-through force is significantly increased.



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物品编号	内螺纹	外螺纹		头部直径	头部高度	长度	预钻孔指导值	盲孔最小钻孔深度
Article number	Internal thread	External thread		Head diameter	Head height	Length	Guideline values for receiving hole diameter	Minimum borehole depth for blind holes
	A	E	P	E1	K	B	L	T
302 100 040 ...	M 4	6.5	0.75	9	1	9	6.1 to 6.2	10
302 100 050 ...	M 5	8	1	11	1	11	7.5 to 7.6	12
302 100 060 ...	M 6	10	1.5	13	1.5	15.5	9.2 to 9.4	16
302 100 080 ...	M 8	12	1.5	15	1.5	16.5	11.2 to 11.4	17
302 100 100 ...	M10	14	1.5	17	1.5	19.5	13.2 to 13.4	20

物品编号的示例
 Example for finding the article number

带凸肩，符合工程标准 302 1 的自攻螺套，内螺纹 A=M5，表面硬化、镀锌和蓝色钝化钢：302.100.050.110
 Self-tapping threaded insert FH-SK to Works Standard 302 1 with internal thread A = M5 made of case-hardened , zinc plated and blue passivated steel : 302.100.050.110

材料	表面硬化钢，镀锌，蓝色钝化	物品编号（第四组数字）110
Materials	Case-hardened steel, Zinc plated, blue passivated	Article no. (fourth group of digits)...110
	表面硬化钢，镀锌镍，透明钝化	物品编号（第四组数字）143
	Case-hardened steel, Zinc-nickel plated, transparent passivated	Article no. (fourth group of digits)...143
	表面硬化钢，镀锌，黄铬酸盐处理	物品编号（第四组数字）160
	Case-hardened steel , Zinc plated , yellow chromated	Article no. (fourth group of digits)...160
	不锈钢 14301 (304)	物品编号（第四组数字）400
	Stainless steel 14301	Article no. (fourth group of digits)...400
	不锈钢 14305 (303)	物品编号（第四组数字）500
	Stainless steel 14305	Article no. (fourth group of digits)...500
	不锈钢 14401 (316F)	物品编号（第四组数字）600
	Stainless steel 14401	Article no. (fourth group of digits)...600
	钛 3.7035	物品编号（第四组数字）700
	Ti 3.7035	Article no. (fourth group of digits)...700
	黄铜	物品编号（第四组数字）800
	Brass	Article no. (fourth group of digits)...800

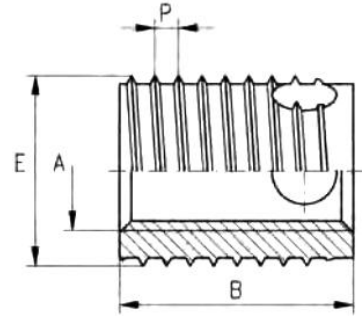
公差
 Tolerance ISO 2768-m

螺纹
 Thread 内螺纹 A: 符合 ISO 6H / Internal thread A: as per ISO 6H
 外螺纹 E: 按 FH 标准/ External thread E: as per FH standard

	自攻螺套 Threaded insert self-tapping	结构类型 Works Standard 307 0 and 308 0
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应用：
 飞航 FH 带切割孔的自攻螺套，用于在较高剪切强度的材料中承担具有高承载能力的无磨损、抗振动的螺纹连接。

Application:
 Threaded insert Ensatsb with cutting bores is a self-tapping fastener for the creation of wear-free, vibration resistant screw joints with high loading capacity in materials with higher shearing strength.



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物品编号 Article number	内螺纹 Internal thread	外螺纹 External thread		长度 Length	预钻孔指导值 Guideline values for receiving hole diameter	盲孔最小钻孔深度 Minimum borehole depth for blind holes
	A	E	P	B	L	T
307 000 030 ...	M 3	5	0.6	4	4.7 to 4.8	6
308 000 030 ...	M 3	5	0.6	6	4.7 to 4.8	8
307 000 035 ...	M 3.5	6	0.8	5	5.6 to 5.7	7
308 000 035 ...	M 3.5	6	0.8	8	5.6 to 5.7	10
307 000 040 ...	M 4	6.5	0.8	6	6.1 to 6.2	8
308 000 040 ...	M 4	6.5	0.8	8	6.1 to 6.2	10
307 000 050 ...	M 5	8	1	7	7.6 to 7.7	9
308 000 050 ...	M 5	8	1	10	7.6 to 7.7	13
307 000 060 ...	M 6	10	1.25	8	9.5 to 9.6	10
308 000 060 ...	M 6	10	1.25	12	9.5 to 9.6	15
307 000 080 ...	M 8	12	1.5	9	11.3 to 11.5	11
308 000 080 ...	M 8	12	1.5	14	11.3 to 11.5	17
307 000 100 ...	M10	14	1.5	10	13.3 to 13.5	13
308 000 100 ...	M10	14	1.5	18	13.3 to 13.5	22
307 000 120 ...	M12	16	1.75	12	15.2 to 15.4	15
308 000 120 ...	M12	16	1.75	22	15.2 to 15.4	26
307 000 140 ...	M14	18	2	14	17.2 to 17.4	17
308 000 140 ...	M14	18	2	24	17.2 to 17.4	28
307 000 160 ...	M16	20	2	14	19.2 to 19.4	17
308 000 160 ...	M16	20	2	24	19.2 to 19.4	28
307 000 180 ...	M18	22	2	18	21.2 to 21.4	21
308 000 180 ...	M18	22	2	24	21.2 to 21.4	28
308 000 200 ...	M20	26	2	27	25.2 to 25.4	31
308 000 220 ...	M22	26	2	30	25.2 to 25.4	34
308 000 240 ...	M24	30	2	30	29.2 to 29.4	34

物品编号的示例 符合工程标准 307 0 的自攻螺套，内螺纹 A=M5，表面硬化、镀锌和蓝色钝化钢：
 Example for finding the article number 307. 000. 050. 110
 Self-tapping threaded insert FH to Works Standard 307 0 with internal thread A=M5 made of case-hardened, zinc plated and blue passivated steel: 307.000.050.110

材料	表面硬化钢，镀锌，蓝色钝化 Case-hardened steel, Zinc plated, blue passivated	物品编号（第四组数字）110
Materials	表面硬化钢，镀锌镍，透明钝化 Case-hardened steel, Zinc-nickel plated, transparent passivated	物品编号（第四组数字）143
	表面硬化钢，镀锌，黄铬酸盐处理 Case-hardened steel, Zinc plated, yellow chromated	物品编号（第四组数字）160
	不锈钢 14301（304） Stainless steel 14301	物品编号（第四组数字）400
	不锈钢 14305（303） Stainless steel 14305	物品编号（第四组数字）500
	不锈钢 14401（316F） Stainless steel 14401	物品编号（第四组数字）600
	钛 3.7035 Ti 3.7035	物品编号（第四组数字）700
	黄铜 Brass	物品编号（第四组数字）800

公差 ISO 2768-m
 Tolerance

螺纹 内螺纹 A：符合 ISO 6H / Internal thread A: as per ISO 6H
 Thread 外螺纹 E：按 FH 标准 / External thread E: as per FH standard

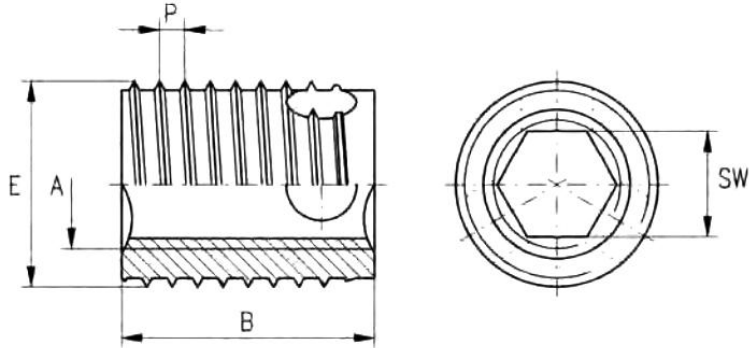
	带六角套筒自攻螺套 Threaded insert self-tapping with hexagonal socket	结构类型 Works Standard 307 2 and 308 2
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应用:
 飞航 FH 带切割孔的自攻螺套, 用于在高剪切强度材料中承担具有高承载能力的无磨损、抗振动的螺纹连接。

Application:
 The threaded insert FH with cutting bores is a self-tapping fastener for the creation of wear-free, vibration resistant screw joints with high loading capacity in materials with higher shearing strength.

六角套筒:
 FH 通过六角套筒插入, 从而缩短安装时间。优点: 更简单只需要顺时针旋转的驱动工具和机器。FH 可在循环使用前顺利提取。

Hexagonal socket:
 The FH is inserted via the hexagonal socket, permitting the achievement of short installation time.
 Other benefits: More simple driving tools and machines which require only clockwise rotation.
 The FH can be extracted without problems before the recycling process.



mm

物品编号	内螺纹	外螺纹		长度	六角尺寸	预钻孔指导值	盲孔最小钻孔深度
Article number	Internal thread	External thread		Length	Hexagonal socket	Guideline values for receiving hole diameter	Minimum borehole depth for blind holes
	A	E	P	B	SW+0.1	L	T
307 200 040 ...	M 4	6.5	0.8	6	3.2	6.1 to 6.2	8
307 200 040 ...	M 4	6.5	0.8	8	3.2	6.1 to 6.2	10
307 200 050 ...	M 5	8	1	7	4.1	7.6 to 7.7	9
308 200 050 ...	M 5	8	1	10	4.1	7.6 to 7.7	13
307 200 060 ...	M 6	10	1.25	8	4.9	9.5 to 9.6	10
308 200 060 ...	M 6	10	1.25	12	4.9	9.5 to 9.6	15
307 200 080 ...	M 8	12	1.5	9	6.6	11.3 to 11.5	11
308 200 080 ...	M 8	12	1.5	14	6.6	11.3 to 11.5	17
307 200 100 ...	M10	14	1.5	10	8.3	13.3 to 13.5	13
308 200 100 ...	M10	14	1.5	18	8.3	13.3 to 13.5	22
307 200 120 ...	M12	16	1.75	12	10.1	15.2 to 15.4	15
308 200 120 ...	M12	16	1.75	22	10.1	15.2 to 15.4	26

物品编号的示例 带内六角套筒, 符合工程标准 307 2 的自攻螺套, 内螺纹 A=M5, 表面硬化、镀锌和蓝色钝化钢: 307. 200. 050. 110
Example for finding the article number Self-tapping threaded insert with hexagonal socket FH-SL to Works Standard 307 2 with internal thread A = M5 made of case-hardened , zinc plated and blue passivated steel : 307.200.050.110

材料 Materials	表面硬化钢, 镀锌, 蓝色钝化	物品编号 (第四组数字)110
	Case-hardened steel, Zinc plated, blue passivated	Article no. (fourth group of digits)... ..110
	表面硬化钢, 镀锌镍, 透明钝化	物品编号 (第四组数字)143
	Case-hardened steel, Zinc-nickel plated, transparent passivated	Article no. (fourth group of digits)... ..143
	表面硬化钢, 镀锌, 黄铬酸盐处理	物品编号 (第四组数字)160
	Case-hardened steel , Zinc plated , yellow chromated	Article no. (fourth group of digits)... ..160
	不锈钢 14301 (304)	物品编号 (第四组数字)400
	Stainless steel 14301	Article no. (fourth group of digits)... ..400
	不锈钢 14305 (303)	物品编号 (第四组数字)500
	Stainless steel 14305	Article no. (fourth group of digits)... ..500
不锈钢 14401 (316F)	物品编号 (第四组数字)600	
Stainless steel 14401	Article no. (fourth group of digits)... ..600	
钛 3.7035	物品编号 (第四组数字)700	
Ti 3.7035	Article no. (fourth group of digits)... ..700	
黄铜	物品编号 (第四组数字)800	
Brass	Article no. (fourth group of digits)... ..800	

公差 ISO 2768-m
Tolerance

螺纹 内螺纹 A: 符合 ISO 6H / Internal thread A: as per ISO 6H
Thread 外螺纹 E: 按 FH 标准/ External thread E: as per FH standard



带凸肩的自攻螺套
Threaded insert
self-tapping
shouldered

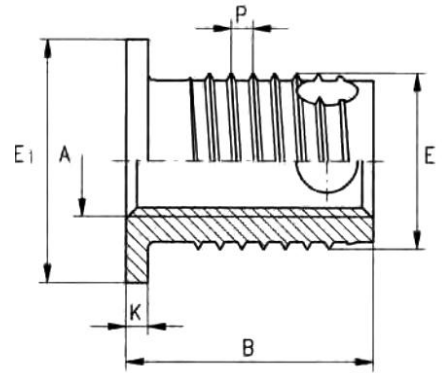
结构类型
Works Standard
307 1 and 308 1

应用：
飞航 FH 自攻螺套 307 1 和 308 1 是基于自攻螺套 307 0 和 308 0 的自攻紧固件。用于在高剪切强度材料中创建具有高承载能力的耐磨、抗振动螺纹接头。

Application:

The Threaded insert 307 1 and 308 1 based on the part geometry of the threaded insert 307 0 and 308 0. self-tapping fastener for the creation of wear-free, vibration resistant screw joints with high loading capacity in materials with higher shearing strength.

当同时紧固多个零件时，头部用作触点的支撑；当对头部施加应力时，拉力显著增加。
The head serves as a support for electrical contacts when fastening several parts simultaneously; when stress is applied against the head, the pull-through force is significantly increased.



mm

物品编号 Article number	内螺纹 Internal thread	外螺纹 External thread		头部直径 Head diameter	头部高度 Head height	长度 Length	预钻孔 指导值 Guideline values for receiving hole diameter	盲孔最小 钻孔深度 Minimum borehole depth for blind holes
	A	E	P	E1	K	B	L	T
307 100 050 ...	M 5	8	1	11	1	8	7.6 to 7.7	9
308 100 050 ...	M 5	8	1	11	1	11	7.6 to 7.7	13
307 100 060 ...	M 6	10	1.25	13	1.5	9.5	9.5 to 9.6	10
308 100 060 ...	M 6	10	1.25	13	1.5	13.5	9.5 to 9.6	15
307 100 080 ...	M 8	12	1.5	15	1.5	10.5	11.3 to 11.5	11
308 100 080 ...	M 8	12	1.5	15	1.5	15.5	11.3 to 11.5	17
307 100 100 ...	M10	14	1.5	17	1.5	11.5	13.3 to 13.5	13
308 100 100 ...	M10	14	1.5	17	1.5	19.5	13.3 to 13.5	22

物品编号的示例
Example for finding
the article number

带凸肩，符合工程标准 307 1 的自攻螺套，内螺纹 A=M5，表面硬化、镀锌和蓝色钝化钢：307.100.050.110
Self-tapping threaded insert FH-SK to Works Standard 307 1 with internal thread A = M5 made of case-hardened , zinc plated and blue passivated steel : 307.100.050.110

材料

- 表面硬化钢，镀锌，蓝色钝化
- Case-hardened steel, Zinc plated, blue passivated
- 表面硬化钢，镀锌镍，透明钝化
- Case-hardened steel, Zinc-nickel plated, transparent passivated
- 表面硬化钢，镀锌，黄铬酸盐处理
- Case-hardened steel , Zinc plated , yellow chromated
- 不锈钢 14301 (304)
- Stainless steel 14301
- 不锈钢 14305 (303)
- Stainless steel 14305
- 不锈钢 14401 (316F)
- Stainless steel 14401
- 钛 3.7035
- Ti 3.7035
- 黄铜
- Brass

- 物品编号 (第四组数字)110
- Article no. (fourth group of digits)... ..110
- 物品编号 (第四组数字)143
- Article no. (fourth group of digits)... ..143
- 物品编号 (第四组数字)160
- Article no. (fourth group of digits)... ..160
- 物品编号 (第四组数字)400
- Article no. (fourth group of digits)... ..400
- 物品编号 (第四组数字)500
- Article no. (fourth group of digits)... ..500
- 物品编号 (第四组数字)600
- Article no. (fourth group of digits)... ..600
- 物品编号 (第四组数字)700
- Article no. (fourth group of digits)... ..700
- 物品编号 (第四组数字)800
- Article no. (fourth group of digits)... ..800

公差

ISO 2768-m

Tolerance

螺纹

内螺纹 A: 符合 ISO 6H / Internal thread A: as per ISO 6H

Thread

外螺纹 E: 按 FH 标准/ External thread E: as per FH standard

	带屑屑储存孔自攻螺套 Threaded insert self-tapping with chip reservoirs	结构类型 Works Standard 337 0 and 338 0
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应用:

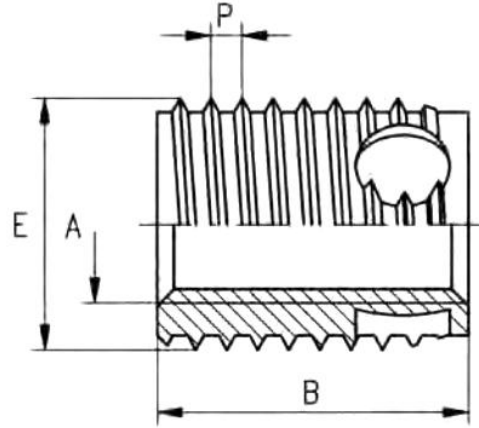
飞航 FH 带屑屑储存孔的自攻螺套，主要是针对以下应用：通过自攻过程产生的屑屑会产生有害影响，并可能在安装的组件（例如电子设备）的后续操作过程中造成严重损坏或故障。分布在周围的三个切削孔形成切屑储存层。在安装过程中产生的屑屑储存在这些储存孔中，不会落入关键设备部件中。

Application:

This special insert was developed primarily for applications in which chips created by the self-tapping process exert a detrimental effect and could cause serious damage or failure during subsequent operation of the installed assembly—for example in electronic equipment.

The three cutting bores distributed around the periphery are formed as chip reservoirs.

The coarse chips created during the installation process are stored in these reservoirs and cannot drop into sensitive equipment components.



mm

物品编号 Article number	内螺纹 Internal thread		外螺纹 External thread		长度 Length	预钻孔指导值 Guideline values for receiving hole diameter	盲孔最小钻孔深度 Minimum borehole depth for blind holes
	A	E	P	B			
337 000 030 ...	M 3	5	0.6	4	4.7 to 4.8	6	
338 000 030 ...	M 3	5	0.6	6	4.7 to 4.8	8	
337 000 035 ...	M 3.5	6	0.8	5	5.6 to 5.7	7	
338 000 035 ...	M 3.5	6	0.8	8	5.6 to 5.7	10	
337 000 040 ...	M 4	6.5	0.8	6	6.1 to 6.2	8	
338 000 040 ...	M 4	6.5	0.8	8	6.1 to 6.2	10	
337 000 050 ...	M 5	8	1	7	7.6 to 7.7	9	
338 000 050 ...	M 5	8	1	10	7.6 to 7.7	13	
337 000 060 ...	M 6	10	1.25	8	9.5 to 9.6	10	
338 000 060 ...	M 6	10	1.25	12	9.5 to 9.6	15	
337 000 080 ...	M 8	12	1.5	9	11.4 to 11.5	11	
338 000 080 ...	M 8	12	1.5	14	11.4 to 11.5	17	
337 000 100 ...	M10	14	1.5	10	13.4 to 13.5	13	
338 000 100 ...	M10	14	1.5	18	13.4 to 13.5	22	
337 000 120 ...	M12	16	1.75	12	15.3 to 15.4	15	
338 000 120 ...	M12	16	1.75	22	15.3 to 15.4	26	
337 000 140 ...	M14	18	2	14	17.3 to 17.4	17	
338 000 140 ...	M14	18	2	24	17.3 to 17.4	28	
337 000 160 ...	M16	20	2	14	19.3 to 19.4	17	
338 000 160 ...	M16	20	2	24	19.3 to 19.4	28	

物品编号的示例
Example for finding
the article number

符合工程标准 337 0 的自攻螺套，内螺纹 A=M5，表面硬化、镀锌和蓝色钝化钢：
337. 000. 050. 110
Self-tapping threaded insert FH to Works Standard 337 0 with internal thread A=M5
made of case-hardened, zinc plated and blue passivated steel: 337.000.050.110

材料
Materials

- 表面硬化钢，镀锌，蓝色钝化
Case-hardened steel, Zinc plated, blue passivated
- 表面硬化钢，镀锌镍，透明钝化
Case-hardened steel, Zinc-nickel plated, transparent passivated
- 表面硬化钢，镀锌，黄铬酸盐处理
Case-hardened steel, Zinc plated, yellow chromated
- 不锈钢 14301 (304)
Stainless steel 14301
- 不锈钢 14305 (303)
Stainless steel 14305
- 不锈钢 14305
Stainless steel 14305
- 不锈钢 14401 (316F)
Stainless steel 14401
- 黄铜
Brass

- 物品编号 (第四组数字)110
Article no. (fourth group of digits)... ..110
- 物品编号 (第四组数字)143
Article no. (fourth group of digits)... ..143
- 物品编号 (第四组数字)160
Article no. (fourth group of digits)... ..160
- 物品编号 (第四组数字)400
Article no. (fourth group of digits)... ..400
- 物品编号 (第四组数字)500
Article no. (fourth group of digits)... ..500
- 物品编号 (第四组数字)600
Article no. (fourth group of digits)... ..600
- 物品编号 (第四组数字)800
Article no. (fourth group of digits)... ..800

公差
Tolerance

ISO 2768-m

螺纹

内螺纹 A: 符合 ISO 6H / Internal thread A: as per ISO 6H

Thread

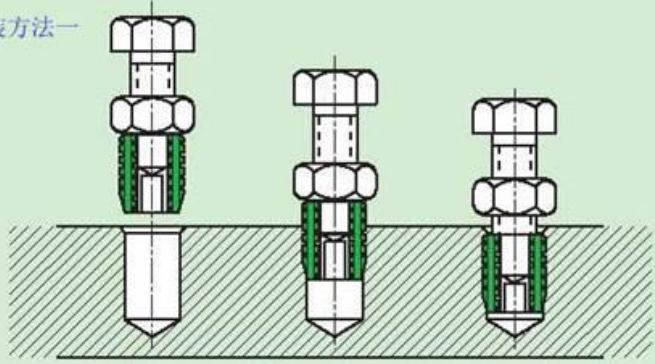
外螺纹 E: 按 FH 标准 / External thread E: as per FH standard

■方法 1 / Method 1

当安装数量较少时，可采取简易安装方法，具体就是采取对应规格螺栓+螺母的方法，如右图示，将自攻螺套固定在对号型号的螺丝上，用同型号螺母进行固定，使三者成为一个整体，用扳手把螺套拧入底孔，后把螺丝退出即可。

It is suitable for small number of installations, as shown in the figure on the right.

安装方法一

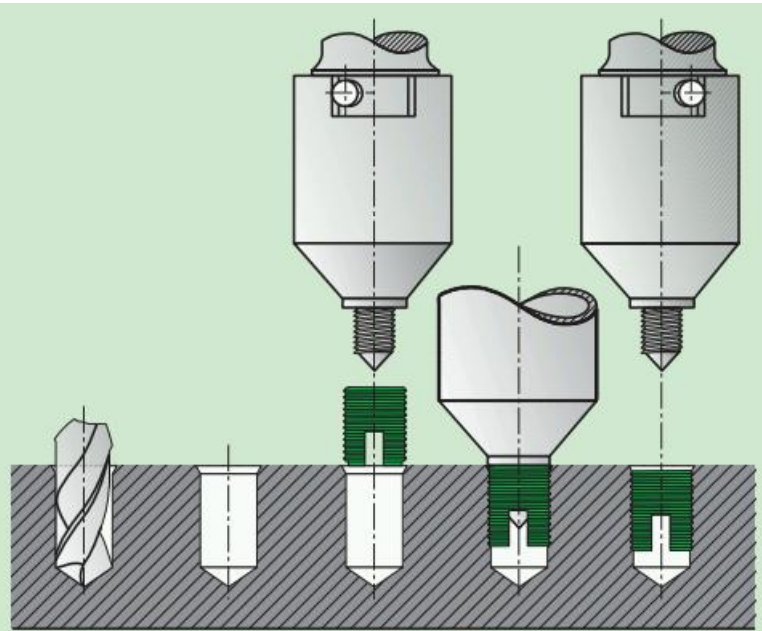
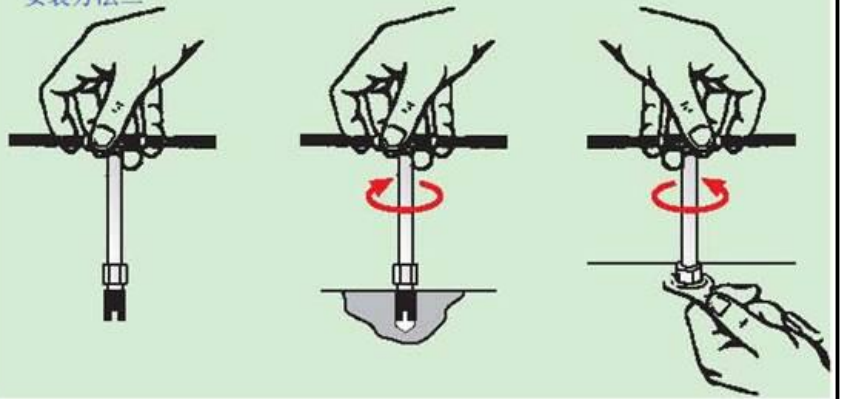


■方法 2 / Method 2

当安装数量较多时，可用专用螺套安装工具，具体操作方法参照右图。图中工具尾端为一六角头，可连手动攻牙扳手，也可接电动或气动工具。

It is suitable for batch installation, as shown in the right figure.

安装方法二



安装孔推荐尺寸 / Recommended size of mounting hole

工件孔径 (mm)		302 系列标准值				307/308 系列标准值				
工件材料	轻质合金 Rm 表示拉伸强度	Rm<250								
		Rm<300				Rm<300				
				Rm<350			Rm<350			
	低碳钢, 青铜			Rm>350				Rm>350		
	铸铁 HB 表示布氏硬度	<150HB				<150HB				
		<200HB				<200HB				
			>200HB				>200HB			
自攻螺套内螺纹	M2/M2.5	N/A	4.1	4.2	4.3	-	-	-	-	
	M3	#4	4.6	4.7	4.8	4.6	4.7	4.8		
	M3.5	#6	5.4	5.5	5.6	5.7	5.5	5.6	5.7	
	M4	#8	5.9	6	6.1	6.2	6	6.1	6.2	
	M5	#10	7.2	7.3	7.5	7.6	7.4	7.5	7.6	7.7
	M6(a)	-	8.2	8.3	8.5	8.6	-	-	-	-
	M6	1/4"	8.8	9	9.2	9.4	9.3	9.4	9.5	9.6
	N8	5/16"	10.8	11	11.2	11.4	11.1	11.2	11.3	11.5
	M10	3/8"	12.8	13	13.2	13.4	13.1	13.2	13.3	13.5
	M12	7/16"	14.8	15	15.2	15.4	15	15.1	15.2	15.4
	M14	1/2"	16.8	17	17.2	17.4	17	17.1	17.2	17.4
M16	5/8"	18.8	19	19.2	19.4	19	19.1	19.2	19.4	
自攻螺套外螺纹嵌入比例		60%	50%	40%	30%	80%	70%	60%	50%	