

B series insert hole diameters

1. HOLE DIAMETERS (STANDARD)

Table 1 shows the revised range of standard hole diameters for block inserts, available in 0.5mm increments.

Table 1

	B140	B700
TWO HOLE DIAMETER	3.0 - 6.5mm	3.5 - 6.5mm
ONE HOLE DIAMETER	3.0 - 12.0mm	3.5 - 14.0mm
HOLE DEPTH	150mm	150mm

For two-hole inserts, you can choose any combination of sizes within the range, in 0.5mm increments, up to the maximum size for both holes for example, two holes of \varnothing 6.5mm for the B700. If either of the hole diameters need to be larger than the maximum shown in Table 1, the pitch needs to be changed, see 2.2.

2. ADDITIONAL INFORMATION (FOR TWO HOLE INSERTS)

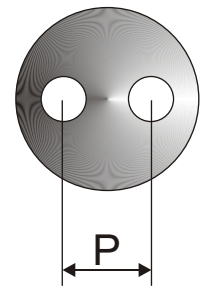
Table 2 for two-hole inserts shows:

2.1 The standard pitch (P = distance between hole centres) for the two-hole inserts as shown in Table 1.

2.2 For special inserts, which require hole diameters larger than the two hole-range shown in Table 1, we have to use a non-standard pitch. In these cases, the sum of the two-hole diameters determines what is possible. Table 2 shows the maximum sum possible for two diameters.

Table 2

	B140	B700
STANDARD PITCH (P)	7.5mm	8.5mm
SUM OF DIAMETERS (MAX)	13mm	14mm



3. ADDITIONAL INFORMATION (ALL INSERTS)

The following data for all drilled holes shows:

3.1 The tolerance on the insert diameters.

3.2 Hole straightness: The axis of the insert hole, lies within a circle of diameter as given in Table 3.

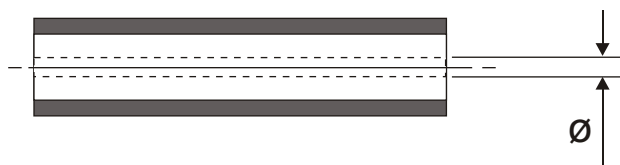


Table 3

SIZE	DIAMETER TOLERANCE	STRAIGHTNESS
<3mm	± 0.05 mm	$\varnothing 1$ mm
3 - 6.0mm	± 0.07 mm	$\varnothing 0.5$ mm
>6 - 10mm	± 0.1 mm	$\varnothing 0.3$ mm
>10mm	± 0.13 mm	$\varnothing 0.2$ mm

4. PLEASE NOTE THE FOLLOWING GENERAL INFORMATION

- 4.1 Hole diameters smaller than the minimum shown in Table 1, are possible down to 1mm, but with a reduced depth. The maximum depth possible = 30 x diameter. For example, for a 1.5mm hole the maximum depth is 45mm.
- 4.2 To calculate the hole size to match your probe, add 0.5mm to the probe diameter and select the nearest standard hole size. A hole size no greater than 0.5mm larger than your probe size is recommended.
- 4.3 [B140](#) inserts are anodised after drilling, but note that holes with diameters smaller than the values in Table 1 above may not be completely anodised inside.
- 4.4 All inserts are supplied with a 3mm cross hole, 5mm from the top, for use with the insert removal tool.

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