



Good2KnowCard - ONSERT® Key-facts

BÖLLHOFF

Joining technology: Fast and process reliable bonding of fasteners

Designs:



Materials:

Stud base

- PAPACM 12

Insert body

- PAPACM 12

ONSERT® base

- PAPACM 12

ONSERT®

- PAPACM 12

ONSERT®

- PAPACM 12

Threads

- Steel (ZiNi)
(M5 / M6)
- A286 (passivated)
(0.1900.32)
- others on request

Threads

- EN AW 6061 - T6 with
X5CrNi18-10 HC (1.4301)
(0.1900.32)
- others on request

ONSERT® clip

- PEI
- PA
- others on request

Adhesive*:

- 1 C Acrylate (modified)
- compliant with RoHs directive 2015/83/EU
- 6 month shelf life (0-25°C)
- fast cure type - full strength in seconds
- compliant with FAR 25 and ANSI UL 94 V0

Advantages:

- fast curing and immediate strength
- no visual impact on sensitive surfaces
- applicable where thermal processes can not be used
- one component adhesive - no adhesive mixing
- manual and automated equipment available

Restrictions:

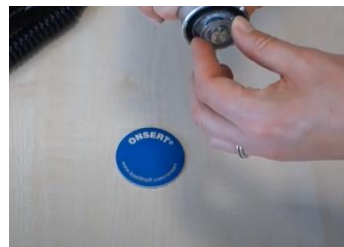
- permanent surrounding temperature < 90°
- mechanical properties dependant on surface quality
- For metals: AL, Steel after Ecoat and paint
- For plastics: Epoxy based composites, PC, PA
- For glass; With or without paint

Manual bonding process

apply adhesive



set fastener inside the tool



place tool onto the substrate



remove tool and assemble



* not all characteristics in all combinations available





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Parameters :

- Fastener: ONSERT® cable holder
- Article code: 48409100002
- Over molding: PAPACM 12
- Thread material: -
- Surface: -

product type



- Adhesive: 48391004150
- amount: 0,25 g

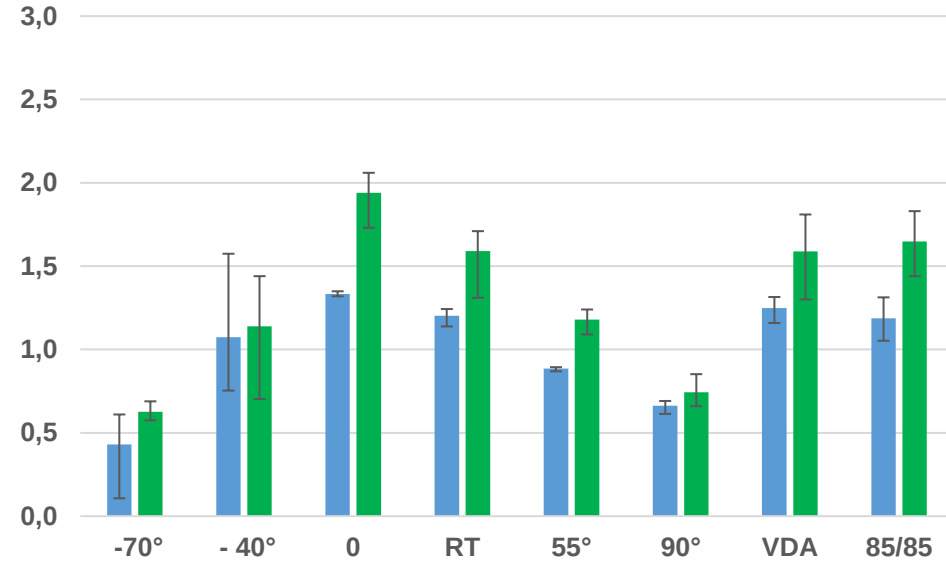
- tooling: portable mini
- 8 sec. 90%

typical failure mode;
part failure at 23°C



- Substrat: Honeycomb
- Surface: cleaned
- Thickness: 10,2 mm

Pull Off and shear performance [kN]:



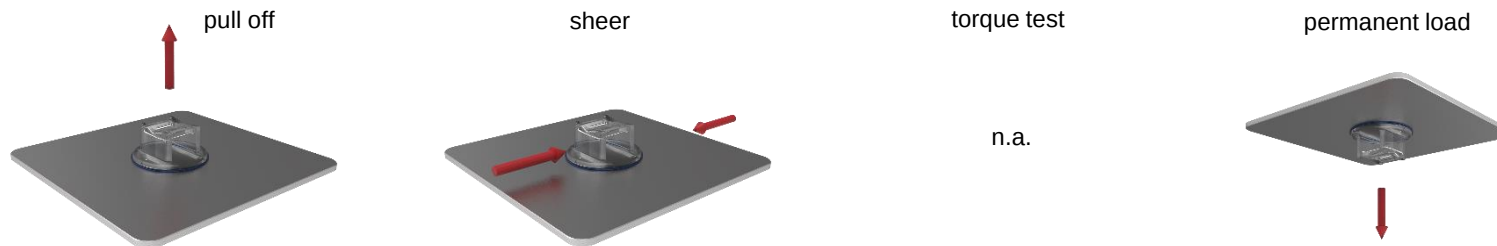
properties to be confirmed under
customer specific conditions

Further characteristics:*

- Salt spray tests: -
- static load: -
- torque out: -

- Dynamic testing acc. RTCA-DO 160F Ch. 8
- Dynamic testing acc. RTCA-DO 160F Ch. 7
- Nose wheel Imbalance tests acc. ABD 0100.1.2
- Fluid susceptibility acc. DO 160 G Sec 11.4 (materials)
- Flammability in acc. FAR 25 - 60 sec. vert. (materials)

Test visualisation:



* not all characteristics in
all combinations available