

# Anchor® – serrated rivet bushing ...

The Anchor® rivet bushing is a threaded insert made of steel or rustproof material, brass or light alloy with a counter-bored and serrated shank.

Anchor® is riveted into thin-walled moulded parts with pre-punched receiving holes. During this process, the riveted serrations of the shank cut into the side wall, creating an absolutely secure fastening.

The special shape of the shank and the countersinking at the bottom protect the thread from damage during installation. In almost all application cases, overload testing indicated that Anchor® remains firmly seated even if the thread is completely overtightened.



## Fields of application

Anchor® rivet nuts can be applied universally. They provide a multitude of constructive solutions for robust screw fittings. Anchor® is used in almost all fields of the metal processing industry, for example in the automotive, railway and electrical fields.

## Product features

- Anchor® is torque-resistant and capable of loads applied from both sides.
- Anchor® can be used in surface-treated, ready-plated parts, so eliminating the need for time-consuming cleaning of internal threads and reworking damage at the surface.
- When turning in the screw, it is impossible for the Anchor® to be forced out of the hole. This saves incalculable time losses.
- Anchor® sits with a precise centric fit without the use of templates or other positioning devices.
- Anchor® is also suitable for application in high-quality materials.

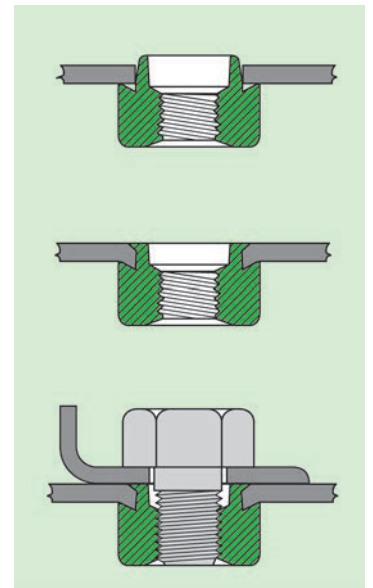


Fig. 2

## Specifications

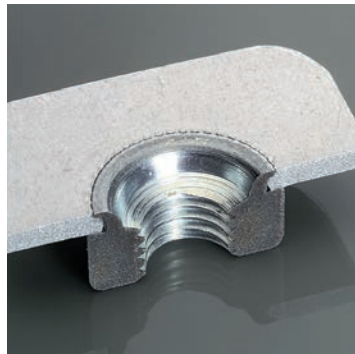
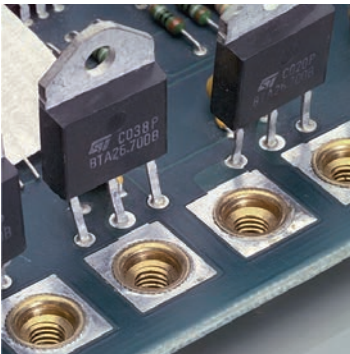
Works Standard sheets 701 to 758, page 7 – 9

### On request:

Anchor® with TufLok® screw lock in the female thread. The captive plastic coating serves as a security against the screw working loose.

Anchor® with sealing agent precote 5 on the support surface.





**Special request**

- Space and weight-saving design

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- Thread closed on one side

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- Distanced fixture

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- Support or bearing function

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- Flush finish to the surface of the metals

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- Loading on both sides

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- Can also be processed in FRP

**We recommend**

- Anchor®-Mini with small outer dimensions (Works Standard 721 to 738)

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- Anchor®-Blind with blind thread (Works Standard 741 to 758)

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- Anchor® in special lengths

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- Anchor® without internal thread (special version)

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- No bead required in the component material.

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- Anchor® can be loaded from both sides, it is practically impossible for it to be levered out.

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- Delamination is largely avoided in fibre-reinforced plastic (FRP).





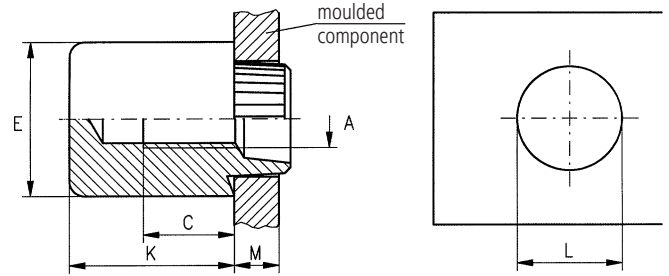
**Rivet Bushing**  
serrated

**Anchor®-Blind**  
Works Standard  
741 0 to 758 0

**Application**

Anchor®-Blind is a rivet bushing with a threaded blind hole (sealed thread) for captive, torqueresistant screw connections in thin-walled workpieces. (0,5 to 5 mm thickness)

the Anchor® is suitable for thin-walled moulded parts made of  
 – steel,  
 – light alloy,  
 – NF metal and  
 – plastic.



Dimensions in mm

Article no. of the first group of digits	for sheet metal thickness M	Article no. of the second and third group of digits	Internal thread A	External diameter E	Nut height K	Recommended hole diameter L +0,1	Thread depth min. C
741 ... ..	0,5 to 0,6 1)	... 000 030 ...	M 3	8,0	8,5	6,0	3,0
742 ... ..	0,7 1)	... 000 035 ...	M 3,5	9,5	9,0	7,0	4,0
743 ... ..	0,8 1)	... 000 040 ...	M 4	9,5	9,0	7,0	4,0
744 ... ..	0,9 to 1,0 1)	... 000 050 ...	M 5	11,0	10,0	8,4	5,0
745 ... ..	1,1 to 1,3 1)	... 000 060 ...	M 6	12,5	10,5	9,7	5,5
746 ... ..	1,4 to 1,6 1)	... 000 080 ...	M 8	16,0	12,0	13,2	5,5
747 ... ..	1,7 to 1,9 2)	... 000 100 ...	M 10	19,0	13,5	15,5	6,0
748 ... ..	2,0 to 2,2 2)	... 000 120 ...	M 12	25,4	19,0	19,6	7,0
749 ... ..	2,3 to 2,5 2)						
750 ... ..	2,6 to 2,8 2)						
751 ... ..	2,9 to 3,1 2)						
752 ... ..	3,2 to 3,4 2)						
753 ... ..	3,5 to 3,7 2)						
754 ... ..	3,8 to 4,0 2)						
755 ... ..	4,1 to 4,3 2)						
756 ... ..	4,4 to 4,6 2)						
757 ... ..	4,7 to 4,9 2)						
758 ... ..	5,0 2)						

- 1) Shoulder 20° undercut
- 2) Surfaced shoulder

**Exemple for finding the article number**

Anchor®-Blind serrated rivet bushing with female thread M5; steel, galvanized, blue passivated for sheet thickness 2 mm (sheet steel) Anchor®-Blind 748 000 050. 110 \*)

**Materials**

- Steel, unrefined
- Steel, zinc plated, blue passivated
- Stahl, zinc-nickel plated, transparent passivated
- Stainless steel 1.4305
- Light alloy
- Brass

- Article no. (fourth group of digits) ... .. 100
- Article no. (fourth group of digits) ... .. 110
- Article no. (fourth group of digits) ... .. 143
- Article no. (fourth group of digits) ... .. 500
- Article no. (fourth group of digits) ... .. 700
- Article no. (fourth group of digits) ... .. 800

**Other materials and designs (e.g. nut height, shank lengths of deviating sheet metal thicknesses) on request.**

**Tolerances**

ISO 2768-m

**Thread**

Internal thread A: as per ISO 6H

**\*) Remark**

**For applications in high-strength steel sheet or stainless steel sheet, or when using the stainless steel rivet nut, we recommend – for flush riveting – the rivet nut of the next smallest shank length: 747 000 050.100 (sheet thickness: 2 mm stainless steel sheet or high-strength steel sheet).**