How to use heat threaded inserts

Step 1: Install the correct insert tip

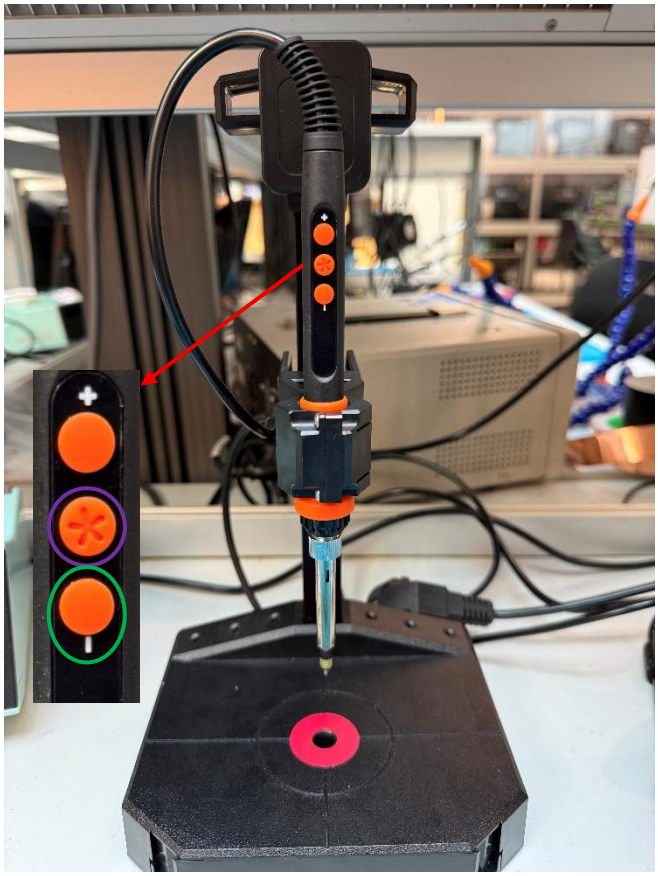


Open the small drawer at the base of the press tool and select the correct tip for your specific insert size. Screw the guide into the end of the soldering iron.

*(⚠️ **Important:** Make sure the tool is completely cold before changing the insert guide!*

It is highly recommended to turn on the fume extractor while inserting heat-threaded inserts!*)*

Step 2: Turn on the press tool:



Press and hold the button marked with a **Star** for 5 seconds to turn the tool on.

Step 3: Set the temperature:

Press and hold the **Minus (–)** button to adjust the temperature. Set it to the following value based on your material:

- **PLA:** 200°C
- **PETG:** 240°C
- **ABS & ASA:** 260°C
- **PAHT-CF:** 290°C

Once you reach the desired temperature, press the **Star** button to confirm your setting.

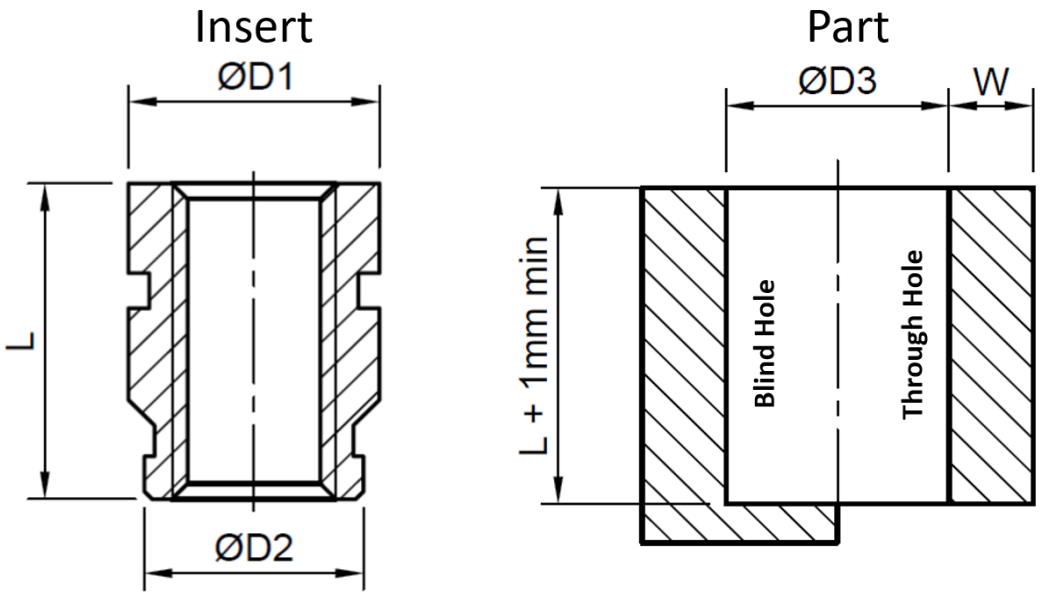
Step 4: Press in the insert:

Place the insert on top of the hole in your 3D print. Gently push the tool down onto the insert. Wait a few seconds for the heat to transfer to the insert and melt the surrounding plastic. Let the heat do the work, and stop pushing as soon as the top of the insert is flush with the surface of the print.

Troubleshooting Guide

Issue	Likely Cause	Solution
Insert goes in crooked	Part shifted during pressing	Hold the part firmly against the base or use a clamp. Trust the vertical guide of the press.
Plastic bubbles or smokes	Temperature is too high	Lower the temperature on your iron by 10-15°C.
Plastic bulges around the insert	Pressing too fast or hole too small	Let the heat do the work instead of pushing. Verify your 3D model hole dimensions.
Insert pulls out easily	Temperature too low	Increase the temperature slightly so the plastic properly flows around the knurling of the insert.

Dimensions & Design Recommendations



Type	*Length* **L**	*Insert Diameter* **D1**	*Installation Hole Diameter Tip* **D2**	**D3**	*Min Wall Thickness* **W**
M3	5.7	4.6	3.9	4.0	1.6
M4	8.1	6.3	5.5	5.6	2.1
M5	9.5	7.1	6.3	6.4	2.6
1/4“-20	12.7	8.7	7.9	8.0	3.3
M3 Short	3.0	4.6	3.9	4.0	1.6
M4 Short	4.0	6.3	5.5	5.6	2.1
M5 Short	5.8	7.1	6.3	6.4	2.6