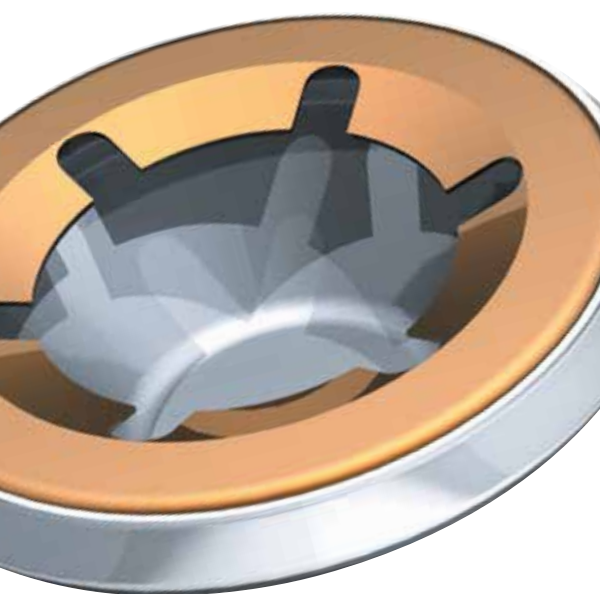




Starlock®

PUSH-ON FASTENERS

Plus Precision Pressings
and Clips in Spring Steel
and other materials.



ISO/TS 16949:2009 ■ ISO9001:2008 ■ ISO14001:2004

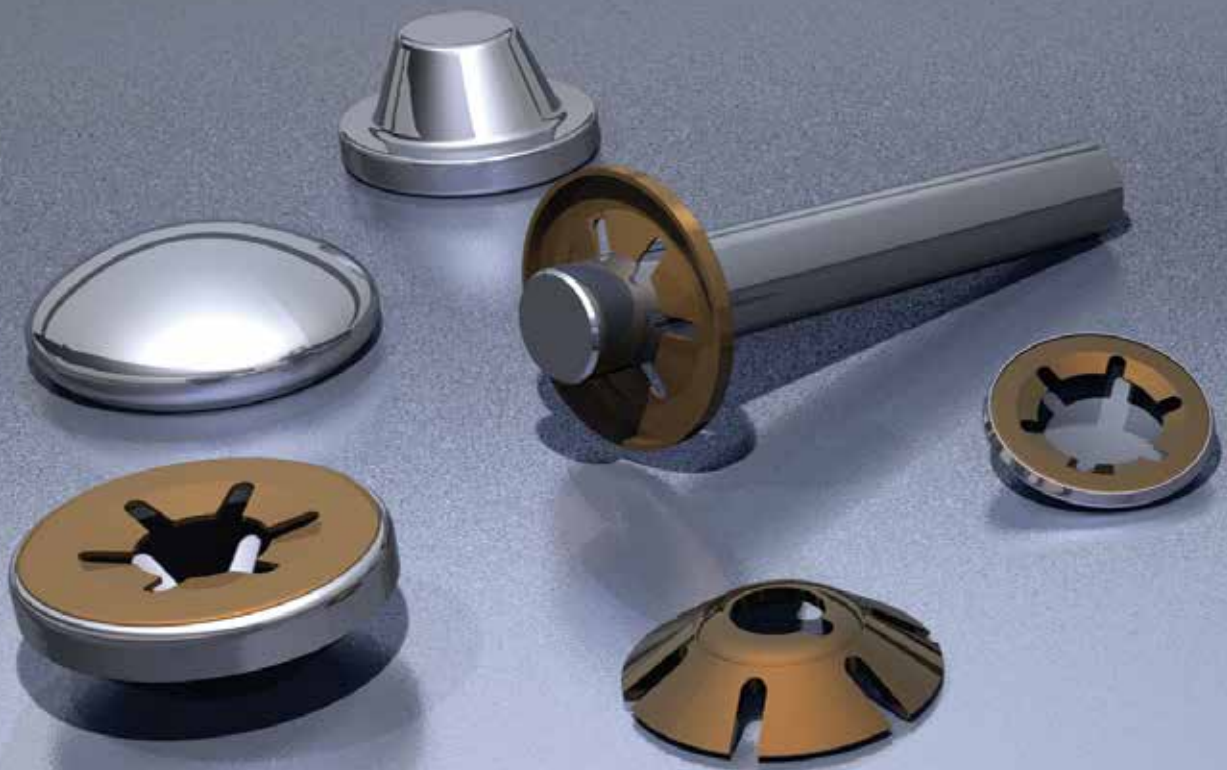
**REVISED &
UPDATED**

Baker & Finnemore is situated in Birmingham, ideally positioned at the hub of the national motorway network.

The company has over 160 years' experience in the design and manufacture of precision pressings in ferrous and non-ferrous

materials with particular emphasis on the spring quality type.

We have achieved a worldwide reputation for being able to supply quality products for inclusion in many applications for a wide range of industries.



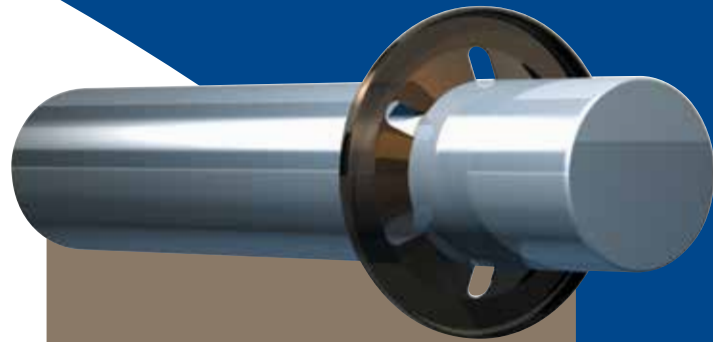
“

160 years' experience in the design and manufacture of precision pressings.

”

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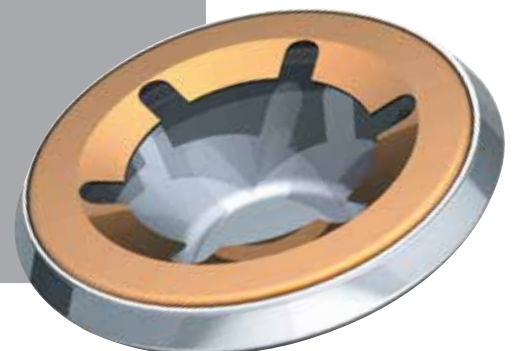
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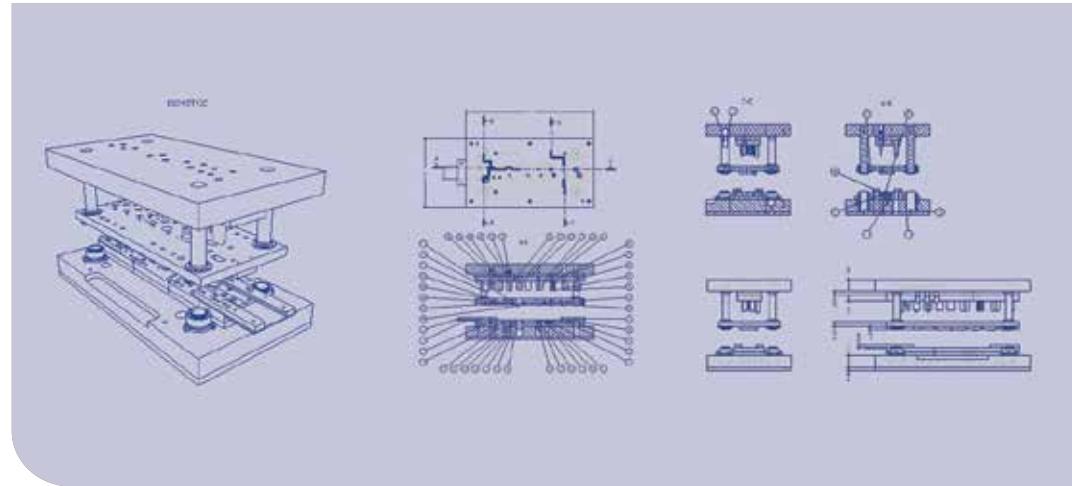
STARLOCK®

The Starlock® is designed for applications where a quick, permanent and efficient means of assembly is required to retain plain shafts of steel, non-ferrous and plastic materials. They eliminate costly threading and grooving operations, facilitate rapid assembly, and once fixed in position, are so secure that they cannot be removed without destruction.

Supplied in spring and stainless steel, in a variety of designs and finishes, both capped and uncapped, it's no surprise that the Starlock® has played a part in the design of many thousands of products, industrial and domestic.



We offer technical advice on component design using our expertise and CAD CAM technology



“

In addition, we are able to design, manufacture and supply a wide range of precision pressings.

”

DESIGN OF TOOLS

With use of the latest CAD CAM and 3D software technology our design and tooling development engineers ensure tooling that is cost effective whether it be for multi-stage progression power presses or multi-slide forming machines.



TOOLING MANUFACTURE

Tooling is manufactured in our own well-equipped toolroom, staffed by specialist toolmakers with state-of-the-art equipment to ensure excellent quality of products and first rate durability of tooling.

PRODUCTION FACILITIES

Our well-equipped Production Department includes high speed power presses with the capability of manufacturing components using presses with capacities up to 60 tonnes.



PRODUCTION CAPABILITY

Our comprehensive in-house facilities and wealth of expertise enable us to be very flexible in meeting customer requirements. In addition to our renowned range of Starlock® Push-on Fasteners, we are able to design, manufacture and supply a wide range of bespoke pressings and clips to meet specific orders/individual requirements.





“

Bak-Fin provides the customer with components that are of the best quality, engineered to the exact specifications required.

”

QUALITY

ISO/TS16949:2009 forms the backbone of our quality management system, thus ensuring that the manufacturing processes are strictly controlled. This complements Baker & Finnemore’s total commitment to customer satisfaction.

We are also accredited to ISO9001:2008 and ISO14001:2004.

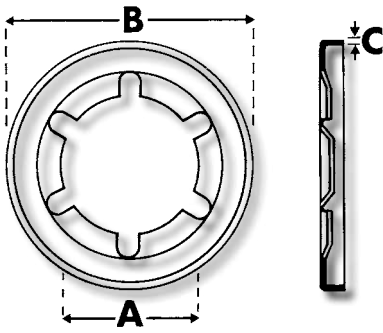
In addition, we have **fully automatic multi-slide strip forming Bihler and Finzer machines** for manufacturing components requiring complex shapes.

A wide range of materials can be used to manufacture precision components and

the high production speeds provide **low cost products and first class quality.**

Our in-house heat treatment plant provides essential control over heat treated spring quality items to ensure that customers’ requirements are completely satisfied.

For a round shaft



Starlock® Push-on Fasteners were designed for use where a quick, permanent and efficient means of assembly is required to retain plain shafts of steel, non-ferrous and plastic materials. They are not normally recommended for use on hard plated or hardened surfaces.

A Shaft Size	Part No. Uncapped	B Outside Diameter	C Material Thickness	Part No. Capped	Size of Cap	Type of Cap				Remarks
						Dome	Axle	Deep Axle	Nylon	
1.50mm	6499	6.35mm	0.2mm	6669	0	S				
1.50mm	8004	9.70mm	0.2mm	7204	1	S	S			Standard
1/16"	6488	.250"	.008"	6339	0	S				
1/16"	6218	.380"	.008"	6232	1	S	S			Standard
1.80mm	8054	9.70mm	0.2mm	8047	1	S	S			
2.00mm	6933	6.35mm	0.2mm	7154	0	S				
2.00mm	6489	9.70mm	0.2mm	6662	1	S	S			Standard
3/32"	6330	.250"	.008"	6333	0	S				
3/32"	5883	.380"	.008"	6221	1	S	S			Standard
2.50mm	7114	8.50mm	0.2mm							
.104"	6823	.380"	.008"	6892	1	S	S			
2.70mm	8171	18.40mm	0.2mm	8087	4	S	S			
3.00mm	8014	6.35mm	0.2mm	8046	0	S				
3.00mm	6490	9.70mm	0.2mm	6663	1	S	S			Standard
3.00mm	8131	11.50mm	0.2mm	8300	2	S	S	A		
3.00mm	7184	14.80mm	0.25mm							
3.00mm	8068	18.40mm	0.2mm	8078	4	S	S	A	N	
3.00mm	8066	28.15mm	0.2mm	8048	6	S				N
1/8"	7025	.250"	.008"	7161	0	S				
1/8"	5897	.380"	.008"	6222	1	S	S			Standard
3.50mm	8006	9.70mm	0.2mm	8032	1	S	S			
.144"	6833	.380"	.008"	6891	1	S	S			
5/32"	6707	.375"	.008"							
5/32"	5928	.450"	.008"	6223	2	S	S	A		Standard
4.00mm	6492	11.50mm	0.2mm	6665	2	S	S	A		Standard
4.00mm	7187	11.50mm	0.25mm							
4.00mm	8059	11.50mm	0.4mm	8045	2	S	S	A		Heavy Duty
4.00mm	8051	15.25mm	0.25mm	8083	3	S	S	A	N	
4.00mm	8064	18.40mm	0.3mm	8043	4	S	S	A	N	
4.00mm	8072	25.00mm	0.25mm	8079	5	S	S			N
4.50mm	7080	11.50mm	0.2mm	7206	2	S	S	A		
3/16"	8018	.380"	.008"	8081	1	S	S			
3/16"	5920	.450"	.008"	6224	2	S	S	A		Standard
3/16"	6500	.450"	.012"	7245	2	S	S	A		
3/16"	8058	.450"	.016"	8073	2	S	S	A		Heavy Duty
3/16"	7127	.600"	.010"	7201	3	S	S	A	N	
3/16"	6718	.725"	.012"	6680	4	S	S	A	N	



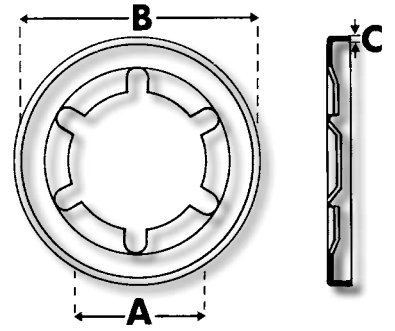
All dimensions shown are subject to engineering tolerances.

FOR CAPPED FASTENER DIMENSIONS, SEE PAGES 12 AND 13.

Starlocks are generally available in spring steel and many are also supplied in stainless steel.

Non-standard parts may be subject to a minimum order quantity.

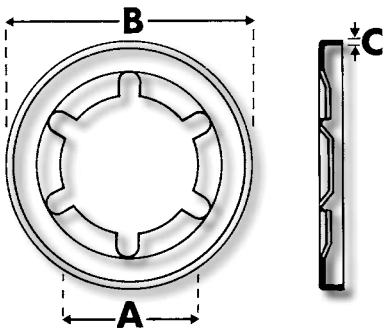
For a round shaft



A Shaft Size	Part No. Uncapped	B Outside Diameter	C Material Thickness	Part No. Capped	Size of Cap	Type of Cap				Remarks
						Dome	Axle	Deep Axle	Nylon	
5.00mm	8153	9.70mm	0.25mm	8312	1	S	S			
5.00mm	6491	11.50mm	0.2mm	6664	2	S	S	A		Standard
5.00mm	7129	11.50mm	0.3mm	8037	2	S	S	A		
5.00mm	8060	11.50mm	0.4mm	8074	2	S	S	A		Heavy Duty
5.00mm	7077	15.25mm	0.25mm	7250	3	S	S	A	N	
7/32"	6324	.450"	.008"	6235	2	S	S	A		Standard
7/32"	6934	.600"	.010"	7155	3	S	S	A	N	
7/32"	7108	.725"	.012"	8027	4	S	S	A	N	
6.00mm	7126	11.50mm	0.2mm	7205	2	S	S	A		
6.00mm	8024	11.50mm	0.3mm	8040	2	S	S	A		
6.00mm	8114	11.80mm	0.2mm							
6.00mm	7073	14.50mm	0.25mm							
6.00mm	6493	15.25mm	0.25mm	6666	3	S	S	A	N	Standard
6.00mm	7036	15.25mm	0.35mm	7160	3	S	S	A	N	
6.00mm	8061	15.25mm	0.4mm	8075	3	S	S	A	N	Heavy Duty
6.00mm	8002	18.40mm	0.3mm	8031	4	S	S	A	N	
1/4"	5873	.600"	.010"	6225	3	S	S	A	N	Standard
1/4"	7068	.600"	.014"	7244	3	S	S	A	N	
1/4"	8052	.600"	.016"	8041	3	S	S	A	N	Heavy Duty
1/4"	7029	.725"	.012"	7159	4	S	S	A	N	
1/4"	8010	.983"	.010"	8302	5	S	S		N	
1/4"	8181	.450"	.008"	8203	2	S	S	A		
6.75mm	7030	18.40mm	0.25mm	7158	4	S	S	A	N	
7.00mm	6703	15.25mm	0.25mm	6670	3	S	S	A	N	Standard
7.00mm	8149	15.25mm	0.4mm	8085	3	S	S	A	N	Heavy Duty
9/32"	6326	.600"	.010"	6236	3	S	S	A	N	Standard
9/32"	6937	.725"	.010"	7167	4	S	S	A	N	
9/32"	6938	.983"	.010"	7168	5	S	S		N	
9/32"	7136	1.437"	.010"	8028	7	S			N	
5/16"	5821	.600"	.010"	6226	3	S	S	A	N	Standard
5/16"	7037	.600"	.012"	7169	3	S	S	A	N	
5/16"	8063	.600"	.016"	8042	3	S	S	A	N	Heavy Duty
8.00mm	6704	15.25mm	0.25mm	6671	3	S	S	A	N	Standard
8.00mm	8062	15.25mm	0.4mm	8076	3	S	S	A	N	Heavy Duty
8.00mm	7192	18.40mm	0.3mm	7207	4	S	S	A	N	
8.00mm	7067	25.00mm	0.3mm	7243	5	S	S		N	
8.50mm	7101	15.25mm	0.25mm	8033	3	S	S	A	N	
11/32"	6332	.725"	.012"	6238	4	S	S	A	N	Standard
11/32"	7109	.983"	.012"	8029	5	S	S		N	
9.00mm	6708	18.40mm	0.3mm	6674	4	S	S	A	N	Standard
.365"	6213	.725"	.012"	6233	4	S	S	A	N	
3/8"	6020	.725"	.012"	6227	4	S	S	A	N	Standard

All dimensions shown are subject to engineering tolerances.
 FOR CAPPED FASTENER DIMENSIONS, SEE PAGES 12 AND 13.
 Non-standard parts may be subject to a minimum order quantity.

For a round shaft



A Shaft Size	Part No. Uncapped	B Outside Diameter	C Material Thickness	Part No. Capped	Size of Cap	Type of Cap				Remarks
						Dome	Axle	Deep Axle	Nylon	
3/8"	6931	1.625"	.020"	7153	9	S			N	
10.00mm	6496	18.40mm	0.3mm	6668	4	S	S	A	N	Standard
10.00mm	8130	18.40mm	0.4mm	8082	4	S	S	A	N	
10.00mm	7074	25.00mm	0.4mm	7249	5	S	S		N	
13/32"	6331	.725"	.012"	6239	4	S	S	A	N	Standard
13/32"	7110	.983"	.012"	7208	5	S	S		N	
11.00mm	6706	18.40mm	0.3mm	6673	4	S	S	A	N	Standard
7/16"	6494	.725"	.012"	6661	4	S	S	A	N	
7/16"	6216	.983"	.016"	6228	5	S	S		N	Standard
12.00mm	6713	25.00mm	0.4mm	6675	5	S	S		N	Standard
12.00mm	8179	28.15mm	0.4mm	8304	6	S				
1/2"	6143	.983"	.016"	6229	5	S	S		N	Standard
13.00mm	6829	25.00mm	0.4mm	6885	5	S	S		N	Standard
17/32"	6325	.983"	.016"	6237	5	S	S		N	Standard
14.00mm	7065	23.00mm	0.4mm							
14.00mm	7078	25.00mm	0.4mm	8034	5	S	S		N	
14.00mm	6825	28.15mm	0.4mm	6881	6	S			N	Standard
15.00mm	8193	25.00mm	0.4mm							
15.00mm	6714	28.15mm	0.4mm	6676	6	S			N	Standard
5/8"	6720	.983"	.008"	8077	5	S	S		N	
5/8"	6185	.983"	.016"	6231	5	S	S		N	Standard
16.00mm	6826	28.15mm	0.4mm	6882	6	S			N	Standard
17.00mm	6715	28.15mm	0.4mm	6677	6	S			N	Standard
18.00mm	8001	28.15mm	0.4mm	8035	6	S			N	
18.00mm	8125	31.00mm	0.3mm							
18.00mm	6827	36.50mm	0.4mm	6883	7	S			N	Standard
18.40mm	8110	28.15mm	0.4mm	8306	6	S				
19.00mm	6828	36.50mm	0.4mm	6884	7	S			N	Standard
3/4"	6323	1.437"	.008"	8307	7	S				
3/4"	6322	1.437"	.016"	6234	7	S			N	Standard
19.85mm	8069	28.15mm	0.4mm	8308	6	S				
20.00mm	6716	36.50mm	0.4mm	6678	7	S			N	Standard
20.00mm	8057	36.50mm	0.5mm	8309	7	S				
20.00mm	8109	41.28mm	0.4mm	8310	9	S				
20.00mm	8160	28.00mm	0.5mm							
21.00mm	6830	36.50mm	0.4mm	6886	7	S			N	Standard
22.00mm	6719	36.50mm	0.4mm	6889	7	S			N	Standard
22.00mm	8161	29.80mm	0.5mm							
7/8"	6328	1.500"	.018"	6335	8	S				Standard
23.00mm	6831	38.10mm	0.45mm	6887	8	S				Standard



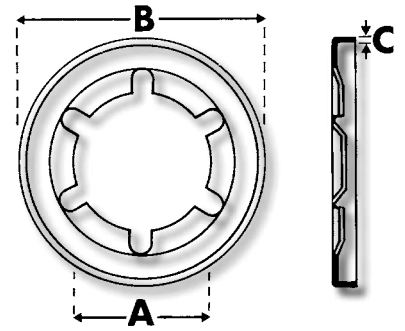
All dimensions shown are subject to engineering tolerances.

FOR CAPPED FASTENER DIMENSIONS, SEE PAGES 12 AND 13.

Starlocks are generally available in spring steel and many are also supplied in stainless steel.

Non-standard parts may be subject to a minimum order quantity.

For a round shaft



A Shaft Size	Part No. Uncapped	B Outside Diameter	C Material Thickness	Part No. Capped	Size of Cap	Type of Cap			Remarks
						Dome	Axle	Deep Axle	
24.00mm	7035	38.10mm	.045mm	7241	8	S			
24.00mm	6832	41.28mm	0.5mm	6888	9	S			N Standard
25.00mm	8103	38.10mm	0.3mm	8311	8	S			
25.00mm	6717	41.28mm	0.5mm	6679	9	S			N Standard
1"	8150	1.625"	.012"	8084	9	S			N
1"	6329	1.625"	.020"	6334	9	S			N Standard
27.00mm	7194	41.28mm	0.5mm	8036	9	S			N
1 1/8"	7061	1.625"	.020"	7248	9	S			N
30.00mm	8124	44.00mm	0.5mm						
30.00mm	8104	50.00mm	0.5mm						

All dimensions shown are subject to engineering tolerances.

FOR CAPPED FASTENER DIMENSIONS, SEE PAGES 12 AND 13.

Uncapped fasteners are available in:

- Blue and varnish finish for inch BV sizes
- Bronze and varnish finish for metric BV sizes
- Mechanical zinc plated DT finish
- Certain sizes of fasteners are available in stainless steel

Standard fasteners (capped & uncapped) are available in blue and varnish or bronze and varnish finishes.

S = stainless steel; A = zinc plated mild steel; N = nylon

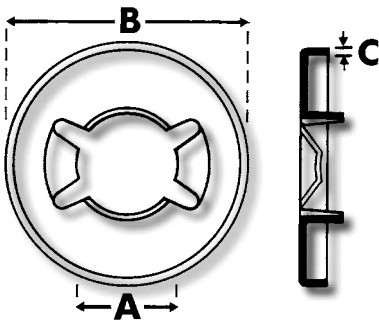
Non-standard parts may be subject to a minimum order quantity.



Starlocks are used in many aspects of the manufacturing industry

Self-aligning type

This development of the standard Starlock® Push-on Fastener is particularly useful for applications where the face of the fastener must be square to the axis of the shaft. This is achieved by the self-aligning legs on the fastener which also give increased resistance to non-axial loads, which may be transmitted from the adjacent part, i.e. wheel to axle assembly.



A Shaft Size	Part No. Uncapped	B Outside Diameter	C Material Thickness	Part No. Capped	Size of Cap	Type of Cap				Remarks
						Dome	Axle	Deep Axle	Nylon	
3/16"	7112	.450"	.010"	7253	2	S	S	A		
5.00mm	7121	11.50mm	0.25mm	7257	2	S	S	A		
6.00mm	7122	15.20mm	0.3mm	7258	3	S	S	A	N	
1/4"	7118	.600"	.012"	7254	3	S	S	A	N	
5/16"	7125	.600"	.012"	7255	3	S	S	A	N	
8.00mm	7123	15.20mm	0.3mm	7259	3	S	S	A	N	
3/8"	7119	.725"	.012"	7256	4	S	S	A	N	
10.00mm	7124	18.40mm	0.3mm	7260	4	S	S	A	N	
22.10mm	8185	29.80mm	0.4mm							



All dimensions shown are subject to engineering tolerances.

FOR CAPPED FASTENER DIMENSIONS, SEE PAGES 12 AND 13.

Uncapped fasteners are available in spring steel with the following finishes:

- Blue and varnish finish for inch BV sizes
- Bronze and varnish finish for metric BV sizes
- Mechanical zinc plated DT finish

Standard fasteners (capped & uncapped) are available in blue and varnish or bronze and varnish finishes.

S = stainless steel; A = zinc plated mild steel; N = nylon

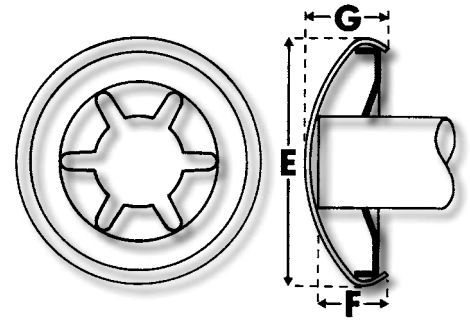
Non-standard parts may be subject to a minimum order quantity.



Starlocks are used in the manufacturing of garage door mechanisms

Dome capped type reference 0

Note: Please refer to “Uncapped” Starlock product to determine cap size (see pages 7–11).

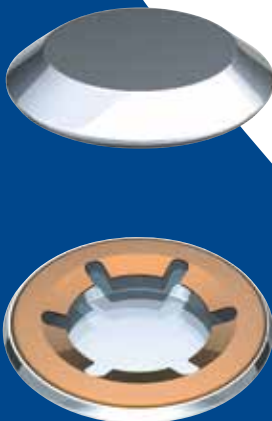
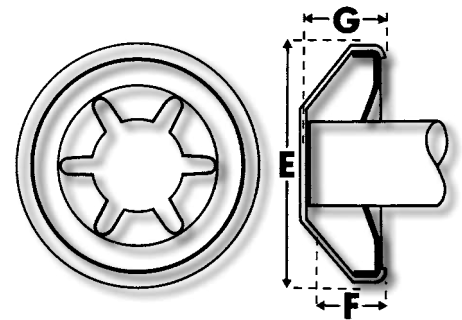


Size	E Outside Diameter	F Max. Depth of Penetration of Shaft	G Height	E Outside Diameter	F Max. Depth of Penetration of Shaft	G Height
0	.285	.055	.105	7.2	1.4	2.70
1	.420	.100	.120	10.67	2.54	3.05
2	.485	.120	.148	12.32	3.05	3.76
3	.640	.160	.200	16.32	4.06	5.08
4	.780	.177	.230	19.81	4.50	5.80
5	1.025	.236	.295	26.0	6.00	7.50
6	1.157	.276	.354	29.4	7.00	9.00
7	1.505	.343	.460	38.2	8.70	11.70
8	1.565	.375	.510	39.8	9.53	12.95
9	1.695	.375	.490	43.0	9.53	12.45
	INCHES			MILLIMETRES		

All dimensions shown are subject to engineering tolerances.
Non-standard parts may be subject to a minimum order quantity.

Axle capped type reference 3

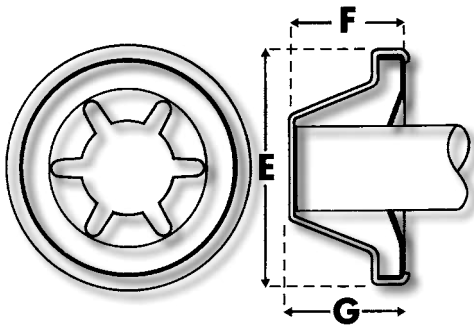
Note: Please refer to “Uncapped” Starlock product to determine cap size (see pages 7–11).



Size	E Outside Diameter	F Max. Depth of Penetration of Shaft	G Height	E Outside Diameter	F Max. Depth of Penetration of Shaft	G Height
1	.420	.135	.157	10.67	3.43	3.96
2	.490	.160	.175	12.45	4.06	4.45
3	.640	.180	.200	16.26	4.55	5.08
4	.785	.216	.235	19.82	5.50	5.97
5	1.028	.270	.285	26.11	6.86	7.24
	INCHES			MILLIMETRES		

All dimensions shown are subject to engineering tolerances.
Non-standard parts may be subject to a minimum order quantity.

Deep axle capped type reference 4

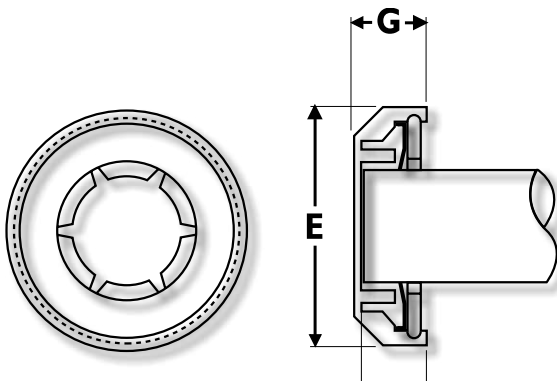


Note: Please refer to “Uncapped” Starlock product to determine cap size (see pages 7 –11).

Size	E Outside Diameter	F Max. Depth of Penetration of Shaft	G Height	E Outside Diameter	F Max. Depth of Penetration of Shaft	G Height
2	.485	.217	.224	12.32	5.50	5.69
3	.635	.264	.283	16.13	6.70	7.20
4	.777	.303	.320	19.74	7.70	8.13
	INCHES			MILLIMETRES		

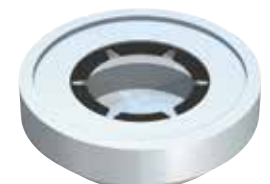


Nylon capped type reference 5



Note: Please refer to “Uncapped” Starlock product to determine cap size (see pages 7 –11).

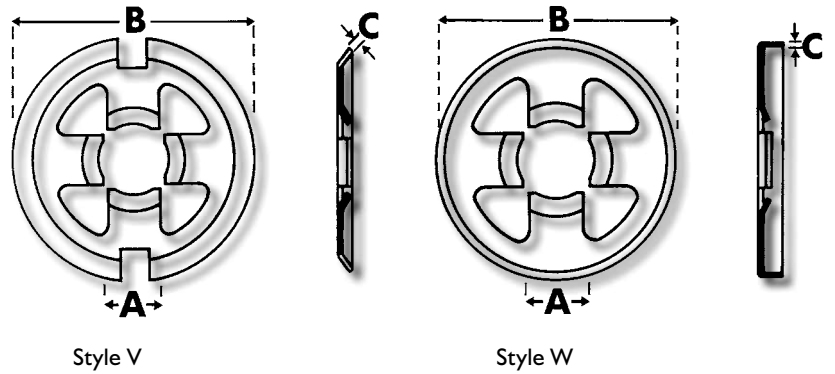
Size	E Outside Diameter	F Max. Depth of Penetration of Shaft	G Height	E Outside Diameter	F Max. Depth of Penetration of Shaft	G Height
3	.750	.216	.256	19.0	5.5	6.5
4	.905	.256	.296	23.0	6.5	7.5
5	1.180	.315	.354	30.0	8.0	9.0
6	1.300	.394	.433	33.0	10.0	11.0
7	1.614	.433	.472	41.0	11.0	12.0
9	1.810	.512	.551	46.0	13.0	14.0
	INCHES			MILLIMETRES		



All dimensions shown are subject to engineering tolerances.
Non-standard parts may be subject to a minimum order quantity.

For a square shaft

This application originated from door lock manufacturers. The unusual shape of the piercing is designed to give point contacts on the sides of the square shaft, and extra flexibility gives a wide range of fitting, i.e. part 7023 is suitable for shafts from .300" to .312" with two slots to assist in location on assembly.

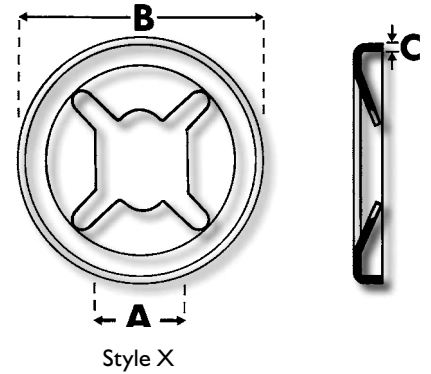


A	B	C		
Shaft Size A/FLATS	Part No.	Outside Diameter	Material Thickness	Remarks
.300"	6152	1.000"	.016"	Style W
.300"	7023	1.090"	.022"	Style V
3/8"	8067	1.093"	.022"	Style V

All dimensions shown are subject to engineering tolerances.
 These fasteners can be supplied in blue and varnish BV or in mechanical zinc plated DT finishes.
 Starlocks are generally available in spring steel and many are also supplied in stainless steel.
 Non-standard parts may be subject to a minimum order quantity.

For a square shaft

The 7mm square Starlock® 7066 features two retaining teeth and two flat legs pieced to the nominal shaft size for location purposes.



A	B	C	Type of Cap				Remarks			
			Dome	Axle	Deep Axle	Nylon				
Shaft Size	Part No. Uncapped	Outside Diameter	Material Thickness	Part No. Capped	Size of Cap					
7.00mm	7066	18.40mm	0.4mm	7252	4	S	S	A	N	Style X

All dimensions shown are subject to engineering tolerances.
 FOR CAPPED FASTENER DIMENSIONS, SEE PAGES 12 and 13.

These fasteners are available in:

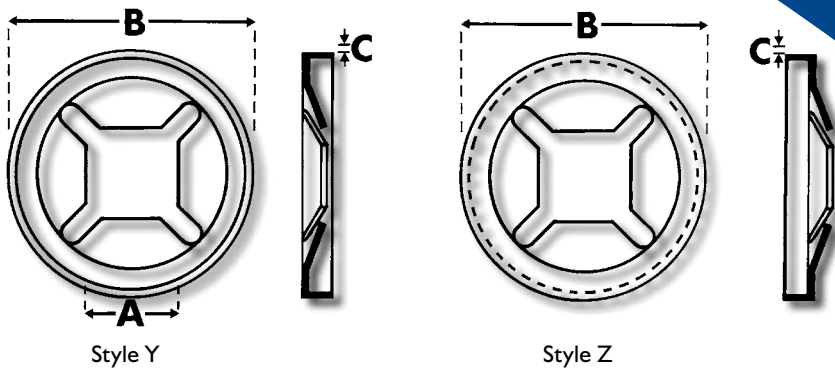
- Bronze and varnish BV finish
- Mechanical zinc plated DT finish

Starlocks are generally available in spring steel and many are also supplied in stainless steel.

S = stainless steel; A = zinc plated mild steel; N = nylon

Non-standard parts may be subject to a minimum order quantity.

For a square shaft



Shaft Size A/Flats	Part No. Uncapped	B Outside Diameter	C Material Thickness	Part No. Capped	Size of Cap	Type of Cap				Remarks
						Dome	Axle	Deep Axle	Nylon	
5.50mm	8070	15.25mm	0.25mm	8080	3	S	S	A	N	Style Y
8.00mm	7031	20.00mm	0.45mm							Style Y
3/8"	8017	.787"	.018"							Style Y
8.00mm	7120	20.00mm	0.45mm							Style Z
8.00mm	8183	20.00mm	0.25mm							Style Y



All dimensions shown are subject to engineering tolerances.

FOR CAPPED FASTENER DIMENSIONS, SEE PAGES 12 and 13.

Uncapped fasteners are available in:

- Blue and varnish finish for inch BV sizes
- Bronze and varnish finish for metric BV sizes
- Mechanical zinc plated DT finish

S = stainless steel; A = zinc plated mild steel; N = nylon

Starlocks are generally available in spring steel and many are also supplied in stainless steel.

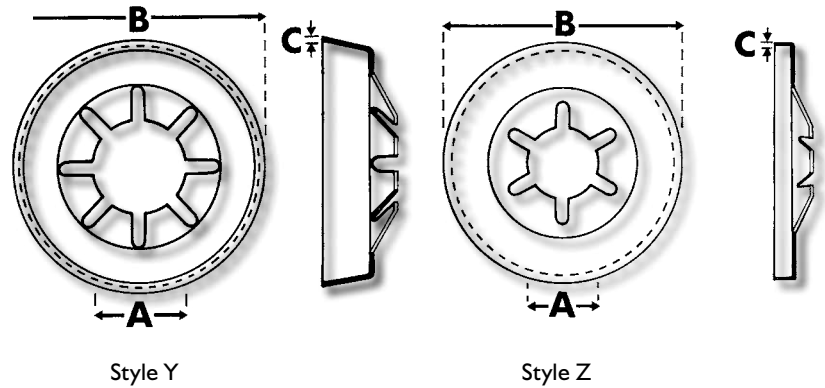
Non-standard parts may be subject to a minimum order quantity.



Starlocks are used in the
manufacture of garden equipment

Reversed type

A special Starlock® used where the form is reversed and the edge of the flange turned downwards, whilst retaining Starlock's rigid strength. It can serve a dual purpose on assembly, i.e. housing for a compression spring.

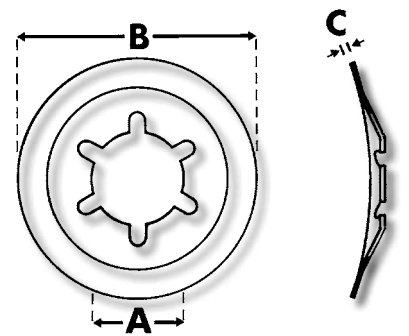


A	B	C		
Shaft Size	Part No. Uncapped	Outside Diameter	Material Thickness	Style
3/16"	7062	.495"	.015"	Y
7/32"	7182	.600"	.010"	Z
1/4"	7181	.725"	.012"	Z
12.00mm	8162	25.00mm	0.4mm	Z
5/8"	8115	1.368"	.028"	Y

All dimensions shown are subject to engineering tolerances.
 These fasteners can be supplied in blue and varnish BV or in mechanical zinc plated DT finishes.
 Starlocks are generally available in spring steel and many are also supplied in stainless steel.
 Non-standard parts may be subject to a minimum order quantity.

Bowed type

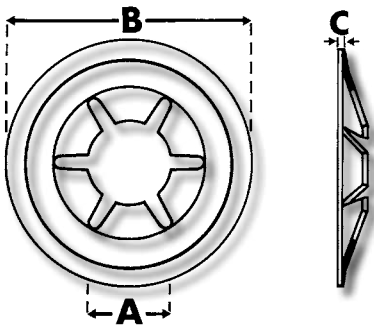
This was developed for applications where tension is required in the finished assembly. When the wave is fully compressed, all movement and rattle is eliminated.



A	B	C		
Shaft Size	Part No. Uncapped	Outside Diameter	Material Thickness	
.144"	8108	.380"	.008"	
3/16"	7022	.500"	.012"	

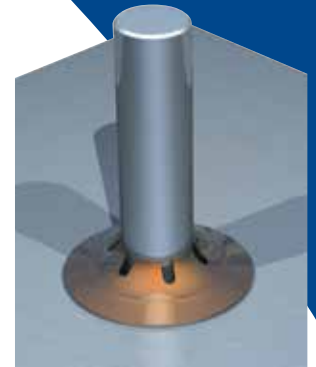
All dimensions shown are subject to engineering tolerances.
 These fasteners can be supplied in blue and varnish BV or in mechanical zinc plated DT finishes.
 Starlocks are generally available in spring steel and many are also supplied in stainless steel.
 Non-standard parts may be subject to a minimum order quantity.

Belleville type



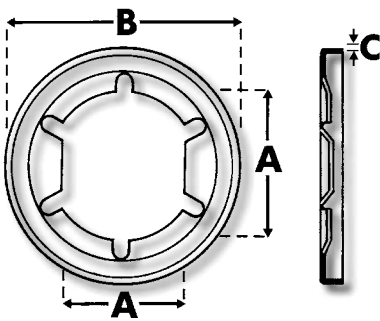
This fastener was developed when tension is required and the tension is formed when the fastener is pressed flat.

A	Part No.	B	C
Shaft Size		Outside Diameter	Material Thickness
3.00mm	8168	9.70mm	0.2mm
1/8"	6987	.315"	.012"
1/8"	6709	.500"	.012"
3.50mm	7130	12.70mm	0.25mm
4.00mm	6986	11.10mm	0.3mm
3/16"	6498	.500"	.012"



All dimensions shown are subject to engineering tolerances.
 These fasteners can be supplied in blue and varnish finish for imperial BV sizes, in bronze and varnish finish for metric BV sizes or in mechanical zinc plated DT finishes.
 Starlocks are generally available in spring steel and many are also supplied in stainless steel.
 Non-standard parts may be subject to a minimum order quantity.

Double D type



The Double D Starlock® is designed to fit on a round shaft, which has two parallel flats. A popular application is in door handle fittings.

A	Part No.	B	C
Shaft Size		Outside Diameter	Material Thickness
.620" (.496A/F)	6930	.983"	.016"

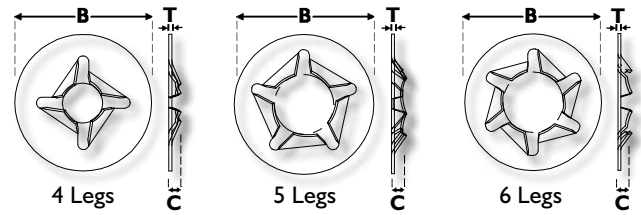
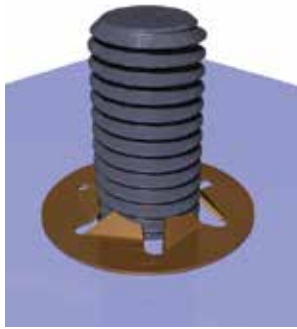
All dimensions shown are subject to engineering tolerances.
 These fasteners can be supplied in blue and varnish BV or in mechanical zinc plated DT finishes.
 Starlocks are generally available in spring steel and many are also supplied in stainless steel.
 Non-standard parts may be subject to a minimum order quantity.



Bolt retainer type

These retainers are designed to push on to a screw or bolt in order to simply retain it whilst in transit prior to final assembly operations.

The teeth on the fastener fold flat when the mating panel is presented and screwed down with minimal thickness added to the assembly. Recent regulations regarding movable guards and the retention of their retaining bolts is a good example of an application where this product can be used.



A		B	C	T	
To Suit	Part No.	Outside Diameter	Height	Material Thickness	Legs
M4	8237	10.00mm	1.6mm	0.3mm	4
M5	8238	10.00mm	1.6mm	0.3mm	4
M6	8239	12.50mm	2.0mm	0.3mm	5
M8	8240	16.00mm	2.3mm	0.4mm	6
M10	8241	19.75mm	2.6mm	0.4mm	6
M12	8242	21.40mm	2.6mm	0.4mm	6

All dimensions shown are subject to engineering tolerances.

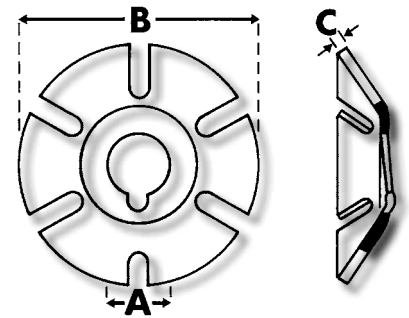
These fasteners are supplied in bronze and varnish BV finish as standard, other finishes may be subject to a minimum quantity.

Inlock washers

The Inlock fastener is an effective means of anchoring a thread stud into a tube.

The method employed for assembly is to screw two or more inlocks on to a stud and then to press this assembly into the tube leaving a threaded portion protruding.

The number of inlocks used is dependent upon the load requirements, but a minimum of two, suitably spaced, must be used to align the stud with the bore of the tube.



A			B	C	
Screw Size	Part No.	Tube Size	Outside Diameter	Material Thickness	Remarks
M4	8200	5/8 O/D x 18g	.538"	.012"	helix plug washer
3/16"	7084	3/4 O/D x 18g	.670"	.016"	helix plug washer
3/16"	7090	1 O/D x 16g	.900"	.016"	helix plug washer
1/4"	7091	3/4 O/D x 18g	.670"	.016"	helix plug washer
1/4"	7081	7/8 O/D x 16g	.786"	.016"	helix plug washer
1/4"	7083	7/8 O/D x 18g	.805"	.016"	helix plug washer
1/4" plain shaft	7097	3/4 O/D x 18g	.663"	.012"	plain plug washer
1/4" plain shaft	7085	7/8 O/D x 18g	.850"	.012"	plain plug washer
6.00mm	7099	1 O/D x 16g	22.90mm	0.4mm	helix plug washer
5/16"	7082	7/8 O/D x 16g	.786"	.016"	helix plug washer
5/16" plain shaft	7092	5/8 O/D x 18g	.538"	.012"	plain plug washer
5/16" plain shaft	7096	3/4 O/D x 18g	.663"	.012"	plain plug washer

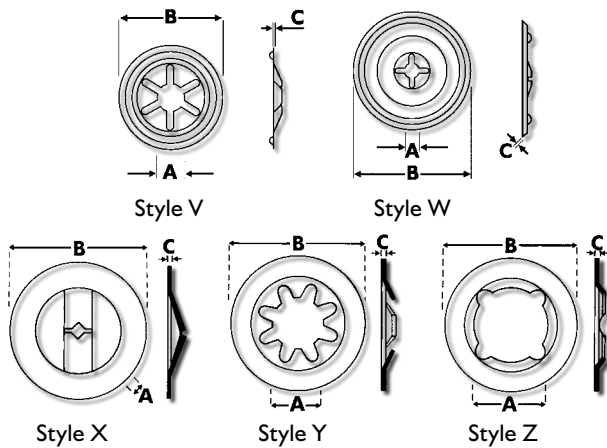
All dimensions shown are subject to engineering tolerances.

These fasteners can be supplied in blue and varnish BV or in mechanical zinc plated DT finishes.

Starlocks are generally available in spring steel and many are also supplied in stainless steel.

Non-standard parts may be subject to a minimum order quantity.

Flangeless type



Where a greater degree of flexibility is required compared with a standard Starlock® Push-on Fastener, or where there is insufficient room for the flange, a flangeless fastener can be used. With certain fasteners assembly is possible without the use of a tool. This is a particularly attractive feature in the soft toy industry for the mounting of items such as eyes and noses. The ribbed style is used to hold insulation in place as the large diameter eliminates damage.



A Shaft Size	Part No.	B Outside Diameter	C Material Thickness	Style
2.00mm	7115	20.00mm	0.4mm	X
3.00mm	8168	9.70mm	0.2mm	Y
3.00mm	8121	36.55mm	0.25mm	W
4.00mm	8120	16.00mm	0.35mm	Y
3/16"	7039	.394"	.008"	Y
3/16"	8122	1.483"	.010"	W
.190"	7128	.650"	.010"	Y
.190"	7188	.875"	.008"	Y
5.00mm	8105	9.60mm	0.25mm	Y
7/32"	7223	.600"	.010"	Y
6.00mm	8106	10.50mm	0.4mm	Y
6.00mm	8123	36.55mm	0.4mm	W
6.10mm	8173	22.23mm	0.2mm	Y
1/4"	6834	.472"	.014"	Y
1/4"	7225	.812"	.008"	V
7.00mm	8050	12.00mm	0.35mm	Y
9/32"	8055	.472"	.014"	Y
9/32"	8020	.812"	.008"	V
9/32"	7226	1.093"	.012"	V
5/16"	6835	.570"	.010"	Y
5/16"	7183	.740"	.016"	Y
11/32"	7224	1.093"	.008"	Y
10.00mm	8071	27.76mm	0.3mm	Y
13/32"	8011	1.093"	.012"	Y
.417"	7076	1.000"	.028"	Y
7/16"	7106	.800"	.024"	Z
7/16"	8012	1.093"	.012"	Y
13.00mm	8134	21.00mm	0.4mm	Z
13.00mm	8013	27.76mm	0.3mm	Y
14.00mm	8148	22.25mm	0.6mm	Y
14.00mm	7107	24.10mm	0.6mm	Z
9/16"	7221	.950"	.024"	Z

All dimensions shown are subject to engineering tolerances.

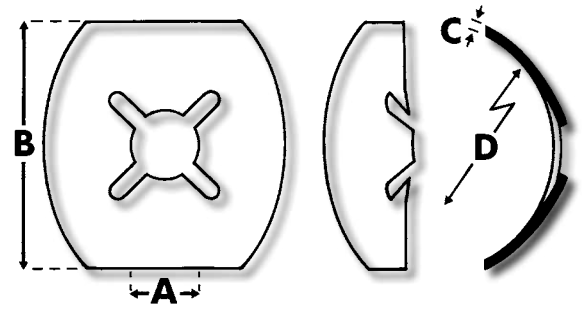
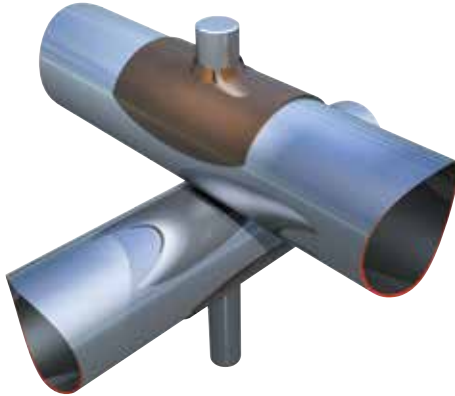
These fasteners can be supplied in blue and varnish finish for imperial BV sizes, in bronze and varnish finish for metric BV sizes or in mechanical zinc plated DT finishes.

Starlocks are generally available in spring steel and many are also supplied in stainless steel.

Non-standard parts may be subject to a minimum order quantity.

Tube clip type

This Starlock® was designed to eliminate the use of rivets in the manufacture of tubular furniture and similar applications. It will be noted that the radius of the form is slightly less than the outside diameter of the tube, so that when the Starlock® is assembled it fits snugly to the contour of the tube and the assembly is under a degree of tension.



A Shaft Size	Part No.	B Length	C Material Thickness	D Tube size
1/8"	8015	5/8"	.016"	1/2"
5/32"	7132	5/8"	.016"	5/8" + 3/4"
3/16"	7117	5/8"	.016"	1/2"
3/16"	7111	5/8"	.016"	5/8" + 3/4"
3/16"	8098	7/8"	.016"	3/4"
3/16"	8112	5/8"	.016"	3/4"
1/4"	8107	5/8"	.016"	5/8" + 3/4"
1/4"	8127	5/8"	.016"	3/4"

All dimensions shown are subject to engineering tolerances.

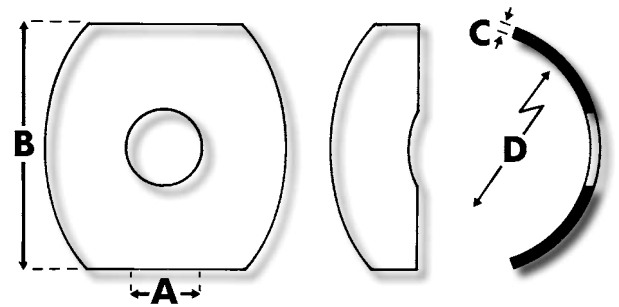
These fasteners can be supplied in blue and varnish BV or in mechanical zinc plated DT finishes.

Starlocks are generally available in spring steel and many are also supplied in stainless steel.

Non-standard parts may be subject to a minimum order quantity.

Tube washer

For applications where it is not necessary to grip the stud, a plain hole tube washer is available.



A Shaft Size	Part No.	B Length	C Material Thickness	D Tube size
1/8"	7615	5/8"	.016"	5/8" + 3/4"
3/16"	7707	5/8"	.016"	5/8" + 3/4"
5.00mm	7495	5/8"	0.4mm	3/4"

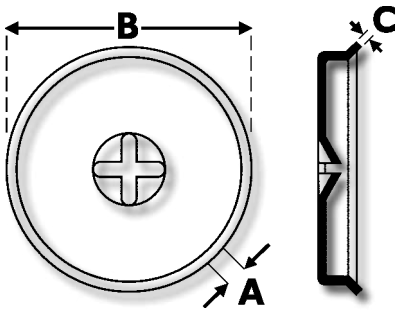
All dimensions shown are subject to engineering tolerances.

These washers can be supplied in blue and varnish finish for inch BV sizes, in bronze and varnish finish for metric BV sizes or in mechanical zinc plated DT finishes.

Starlocks are generally available in spring steel and many are also supplied in stainless steel.

Non-standard parts may be subject to a minimum order quantity.

Pin retainer type



This retainer is used particularly to secure upholstery buttons to furniture and another use is found in the clothing industry to hold badges and buttons in place.

A Shaft Size	Part No.	B Outside Diameter	C Material Thickness
.048mm	7069	.469 - 11.9mm	.008mm
.048mm	8100	.599 - 15.21mm	.010mm
.048mm	7070	.633 - 16.1mm	.008mm
.048mm	7072	.773 - 19.6mm	.008mm
.048mm	8133	.992 - 25.2mm	.012mm

All dimensions shown are subject to engineering tolerances.

These retainers can be supplied in electrolytical zinc plated and clear passivated A finish, or in mechanical zinc plated DT finish.

Only available in spring steel.



Starlocks are used in the automotive industry.

Assembly tools and sample boxes

Hand assembly tools are available for the majority of Starlocks. When ordering please indicate the Starlock® part number and either capped or uncapped.



SAMPLE BOXES

We are now able to offer a new low-cost compact sample box with a selection of plain and dome capped Starlocks in both metric and inch sizes.

If you need a specific size of Starlock® please ask our sales department and if the parts are available we will be pleased to customise the box accordingly.

Available for immediate dispatch.

METRIC SAMPLE BOXES

With or without stainless cover cap

3mm	6mm
4mm	7mm
5mm	8mm

INCH SAMPLE BOXES

With or without stainless cover cap

1/16"	1/4"
1/8"	5/16"
3/16"	3/8"

Design and development kit



As an aid to the Design and Development Engineer, we offer various kits containing Starlock® Push-on Fasteners. These design and development kits are an invaluable aid when assessing potential areas for Starlock® applications.

The four kits contain a variety of popular sizes of capped or uncapped Starlock® Push-On Fasteners in either metric or imperial sizes, together with an assembly tool and interchanging fixing heads.

The content of this publication is for general information only. It is the user's responsibility to determine suitability of any product for the application intended and reference should be made to our Technical Department if clarification is required. In the interests of technical development we reserve the right to change specification, design and materials without notice.

Baker & Finne more products are sold subject to our terms and conditions of business, which can be found on our website www.bakfin.com. For further technical information please contact our Sales team for assistance. **Tel +44 (0) 121 236 2347.**





Starlock®

PUSH-ON FASTENERS

THE COMPANY

Baker & Finmore is situated in central Birmingham's Jewellery Quarter, ideally positioned at the hub of the UK's national motorway network. Since being established in 1850, the company, now widely known as 'Bak Fin', has come a long way from its origins as a producer of high quality dip-type fountain pen nibs. From these beginnings the company has progressed to supplying many different industries with components that could either be pressed or strip-formed from steel, and is today best known as the manufacturer of the world famous Starlock® Push-on Fastener.

Bak Fin now has over 160 years' experience in the design and manufacture of precision pressings in ferrous and non-ferrous materials with particular emphasis on the spring quality type. We have achieved a worldwide reputation for being able to supply quality products for inclusion in many applications for a wide range of industries.

It's the success of the Starlock® that has earned Bak Fin its reputation today as the UK's premier manufacturer of push-on fasteners, and although we produce high volumes of customised precision pressings, the Starlock® Push-on Fastener range forms the lion's share of output, with 500 million Starlocks manufactured annually, destined for use in around 50 countries across every continent.

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