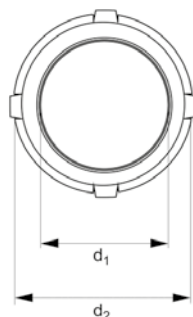
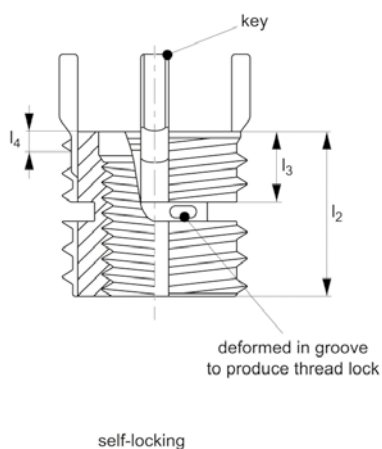




Threaded Insert MS/NAS - H Duty - 303 stainless steel - self-locking - MS/NAS grade

Threaded
Inserts Stain-



TR1605

THREADED INSERTS STAINLESS

Material

Inserts - 303 CRES.

Keys - 302 CRES.

Passivated. Dry film lubrication on self-locking inserts only.

Technical Notes

All dimensions in millimetres.

Internal threads: to Fed. Std. H28/21, MJ

Form

General tolerances -

+/- 0,25mm, unless specified.

Tap drill hole tolerances -

6,9 to 10,8 = +0,100/-0,025

12,8 and over = +0,130/-0,025

SL = Self-Locking type, deliberate deformity in thread produces self-affect once installed (see technical diagram).

Tips

Order installation tool separately, as identified by „Inst. Tool ref.“ in table.

Important Notes

Four locking keys on internal threads M6 and over. Two locking keys on internal threads smaller than M6.

Installation (Inst.) drill size, counter sink, thread tap and thread depth as specified in table.

Removal (Rem.) drill size and drill depth as specified in table.

Order No.	Type	d ₁ tol. 4H 5H	Thread type d ₁	d ₂ tol. 4H 5H	Thread type d ₂	l ₁	l ₃ ±0.76	l ₄ e	c'bor h	C'bore hole dia. +0.25 - 0.00	Inst. tap drill size	Inst. thread tap tol. 6H	Inst. thread tap depth min.	Inst. tool ref. TR1715	Removal drill size	Removal drill depth
TR1605.77363	SL	M 4x0, 7	Coars e	M 8x1, 25	Coars e	8.0	5.00	1.27	8.25	6.90	M 8x1,2 5	9.5	.0630	5.50	4.00	
TR1605.77364	SL	M 5x0, 8	Coars e	M10 x1,2 5	Fine	10.0	5.50	1.27	10.25	8.80	M10x 1,25	12.5	.0640	7.50	4.75	
TR1605.77365	SL	M 6x1, 0	Coars e	M12 x1,2 5	Fine	12.0	6.46	1.78	12.25	10.80	M 2x1,2 5	14.5	.0650	9.50	4.75	
TR1605.77366	SL	M 8x1, 25	Coars e	M14 x1,5	Fine	14.0	6.46	1.78	14.25	12.80	M14x 1,5	16.5	.0660	11.50	4.75	
TR1605.77566	SL	M 8x1, 0	Fine	M14 x1,5	Fine	14.0	6.46	1.78	14.25	12.80	M14x 1,5	16.5	.0660	11.50	4.75	
TR1605.77367	SL	M10 x1,5	Coars e	M16 x1,5	Fine	16.0	6.46	2.29	16.25	14.75	M16x 1,5	18.5	.0670	13.50	4.75	
TR1605.77567	SL	M10 x1,2 5	Fine	M16 x1,5	Fine	16.0	6.46	2.29	16.25	14.75	M16x 1,5	18.5	.0670	13.50	4.75	
TR1605.77369	SL	M12 x1,7 5	Coars e	M18 x1,5	Fine	18.0	7.23	2.29	18.25	16.75	M18x 1,5	20.5	.0690	15.50	4.75	



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Order No.	Type	d ₁ tol. 4H 5H	Thread type d ₁	d ₂ tol. 4h	Thread type d ₂	l ₁	l ₃ ±0.76	l ₄ e	c'bor dept h	C'bore hole dia. +0.25 - 0.00	Inst. tap drill size	Inst. thread tap tol. 6H	Inst. thread tap depth min.	Inst. tool ref. TR1715	Removal drill size	Removal drill depth
TR1605.77569	SL	M12 x1,2 5	Fine	M18 x1,5	Fine	18.0	7.23	2.29	18.25	16.75	M18x 1,5		20.5	.0690	15.50	4.75
TR1605.77370	SL	M14 x2,0	Coars e	M20 x1,5	Fine	20.0	7.73	2.79	20.25	18.75	M20x 1,5		22.5	.0700	17.50	4.75
TR1605.77570	SL	M14 x1,5	Fine	M20 x1,5	Fine	20.0	7.73	2.79	20.25	18.75	M20x 1,5		22.5	.0700	17.50	4.75
TR1605.77371	SL	M16 x2,0	Coars e	M22 x1,5	Fine	22.0	8.50	2.79	22.25	20.50	M22x 1,5		24.5	.0710	17.75	6.35
TR1605.77571	SL	M16 x1,5	Fine	M22 x1,5	Fine	22.0	8.50	2.79	22.25	20.50	M22x 1,5		24.5	.0710	17.75	6.35
TR1605.77572	SL	M18 x1,5	Fine	M24 x2,0	Fine	24.0	9.25	2.79	24.25	22.50	M24x 2,0		28.5	.0720	19.75	6.35
TR1605.77373	SL	M20 x2,5	Coars e	M30 x2,0	Fine	30.0	12.5 1	2.79	30.25	28.00	M30x 2,0		34.5	.0730	25.75	6.35
TR1605.77573	SL	M20 x1,5	Fine	M30 x2,0	Fine	30.0	12.5 1	2.79	30.25	28.00	M30x 2,0		34.5	.0730	25.75	6.35
TR1605.77574	SL	M22 x1,5	Fine	M32 x2,0	Non- Std	32.0	12.5 1	2.79	32.25	30.00	M32x 2,0		36.5	.0740	27.75	6.35
TR1605.77375	SL	M24 x3,0	Coars e	M33 x2,0	Non- Std	33.0	13.9 7	3.81	33.25	31.00	M33x 2,0		37.5	.0750	28.75	6.35
TR1605.77575	SL	M24 x2,0	Fine	M33 x2,0	Non- Std	33.0	13.9 7	3.81	33.25	31.00	M33x 2,0		37.5	.0750	28.75	6.35