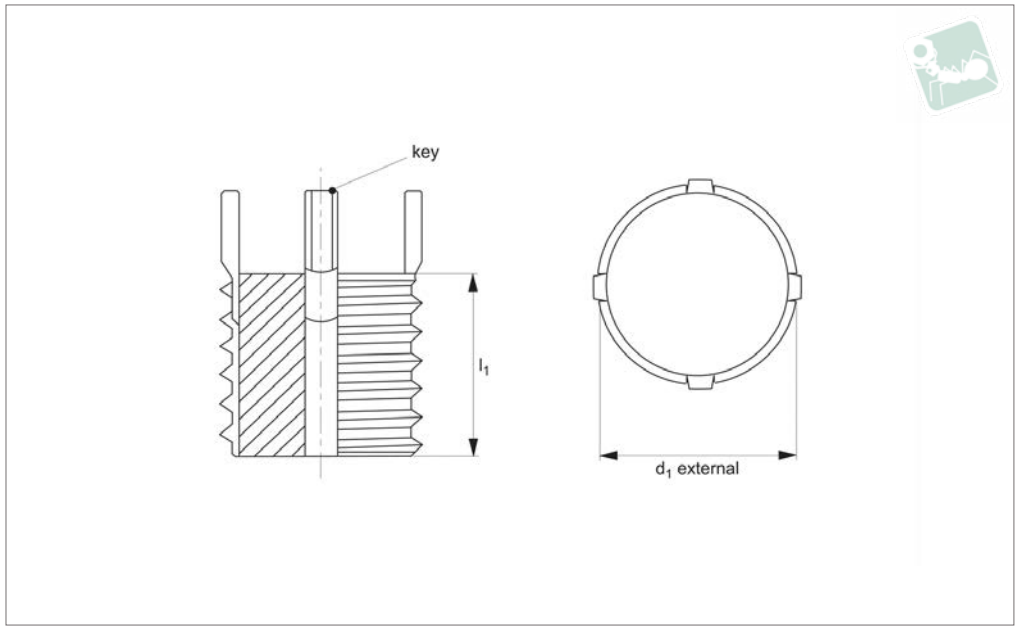


TR1690

Material
Inserts: stainless steel (AISI 303) or equivalent. Passivated.
Keys: stainless steel (302 CRES) or equivalent. Passivated.

Technical Notes
General tolerances:
± 0,25 unless specified.
Tap drill hole tolerances:
6,9 to 10,8 = +0,10/-0,025.
12,8 and over = +0,13/-0,025.

Tips
Order installation tool separately, as identified by „Inst. tool ref." in table.

Important Notes
Four locking keys on external threads M12 and over. Two locking keys on external threads smaller than M12.
Installation (Inst.) drill size, countersink, thread tap and thread depth as specified in table.
Removal drill size and drill depth as specified in table.
External metric thread allows you to machine your internal thread.

Order No.	d_1	Thread type d_1	l_1	Inst. tool ref. 22052	Inst. tap drill size	Inst. c'sink dia.	Inst. thread tap	Inst. thread tap depth	Removal drill size	Removal drill depth
TR1690.66421	M 8x1,25	Coarse	8	.W0210	6.9	8.3	M 8x1,25	9.5	5.50	4.0
TR1690.66422	M10x 1,25	Fine	10	.W0220	8.8	10.3	M10x1,25	12.5	7.50	4.8
TR1690.66423	M12x 1,25	Fine	12	.W0230	10.8	12.3	M12x1,25	14.5	9.50	4.8
TR1690.66424	M14x 1,50	Fine	14	.W0240	12.8	14.3	M14x1,50	16.5	11.50	4.8
TR1690.66425	M16x 1,50	Fine	16	.W0250	14.8	16.3	M16x1,50	18.5	13.50	4.8
TR1690.66426	M18x 1,50	Fine	18	.W0260	16.8	18.3	M18x1,50	20.5	15.50	4.8
TR1690.66427	M20x 1,50	Fine	20	.W0270	18.8	20.3	M20x1,50	22.5	17.50	4.8
TR1690.66428	M22x 1,50	Fine	22	.W0280	20.5	22.3	M22x1,50	24.5	17.75	6.4
TR1690.66429	M24x 1,50	Fine	24	.W0290	22.5	24.3	M24x1,50	26.5	19.75	6.4
TR1690.66430	M30x 2,00	Non-Std	30	.W0300	28.0	30.3	M30x2,00	34.5	25.75	6.4
TR1690.66431	M32x 2,00	Non-Std	32	.W0310	30.0	32.3	M32x2,00	36.5	27.75	6.4
TR1690.66432	M33x 2,00	Non-Std	33	.W0320	31.0	33.3	M33x2,00	37.5	28.75	6.4

Threaded Inserts

Threaded inserts are used to quickly repair stripped, damaged or worn out threads with new stronger threads, or are used in original equipment to guarantee stronger thread connections.

Wixroyd inserts are easy to install and remove, without the need for special drills, taps or pre-winder tools. The 'locking keys' on threaded inserts are easily driven down into the thread of the surrounding base material – locking the insert securely in place.

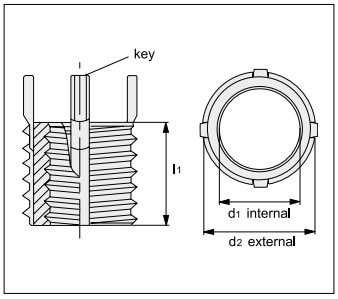
Carbon steel inserts

Stainless steel inserts

Solid inserts

Key Features

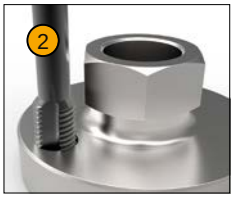
- Solid, one-piece construction providing high pull-out strengths.
- Locking "keys" provide a positive mechanical lock against rotation of the insert.
- Easy installation and removal.
- Installation with standard drills and taps.
- No pre-winder tools required.
- No tangs to break off and account for in the assembly.
- For use in a wide variety of materials.
- Both metric and imperial sizes available in coarse and fine pitches.

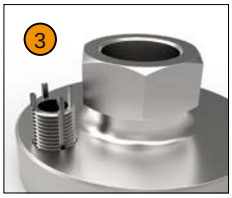


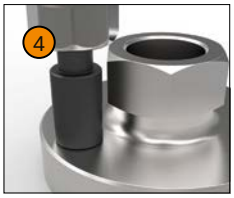
Installation and Removal

Installation

1. Select desired threaded insert, and from the product data table identify the installation drill and tap sizes (note the drill is slightly oversized deliberately). Drill with standard tap drill as per product data table, and countersink with standard 82-100° countersink.
2. Tap new threads with standard tap – as specified in product data table.
3. Screw in the insert until it is 0.25 to 0.75mm (0.010 to 0.030 inch) below the surface.
4. Drive locking keys down with several hammer taps on the installation tool – see product data table for correct tool.
5. Insert is installed.







Removal

Wixroyd threaded inserts, can be removed (if required) without damage to the surrounding material.

1. Refer to product data tables to identify the drill size and drill depth required for removal. Drill out the material between the insert keys and the internal thread to specified depth.
2. Bend the locking keys inward and break off.
3. Remove the old insert using a screw extractor.
4. Install a replacement insert into the original tapped hole.

ov-W22000-AP0084.1-TTR1510-W22046-A-TTR1696-a-Inh - Updated - 26-10-2022

Stainless Steel

22000 - Thinwall - Metric
Use installation tool no. 22060.

22002 - Heavy Duty - Metric.
Use installation tool no. 22062.

22012 - Heavy Duty - Metric - Inch.
Use installation tool no. 22064.

22020, 22022, 22024 - Inch - Thinwall - Heavy Duty - Extra Heavy Duty.
Use installation tool no. 22054-58.

Carbon Steel

22004 - Thinwall - Metric
Use installation tool no. 22060.

22006 - Heavy Duty - Metric
Use installation tool no. 22062.

22010 - Heavy Duty - Metric - Inch.
Use installation tool no. 22064.

22030 - 22034 - Inch - Thinwall - Heavy Duty - Extra Heavy Duty
Use installation tool no. 22054, 20058.

Solid

22040 - Metric - Carbon
Use installation tool no. 22052.

22042 - Metric - Stainless Steel
Use installation tool no. 22052.

22044 - Inch - Carbon
Use installation tool no. 22050.

22046 - Inch - Stainless Steel
Use installation tool no. 22050.

Installation Tools

22050 for 22044 & 22046

22052 for 22040 & 22042

22054, 22058 for 22020, 22024, 22030, 22034,

22060 for 22000 & 22004

22062 for 22002 & 22006

22064 for 22010 & 22012