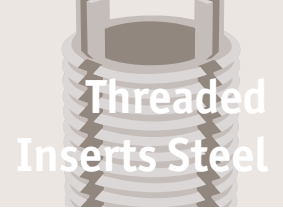


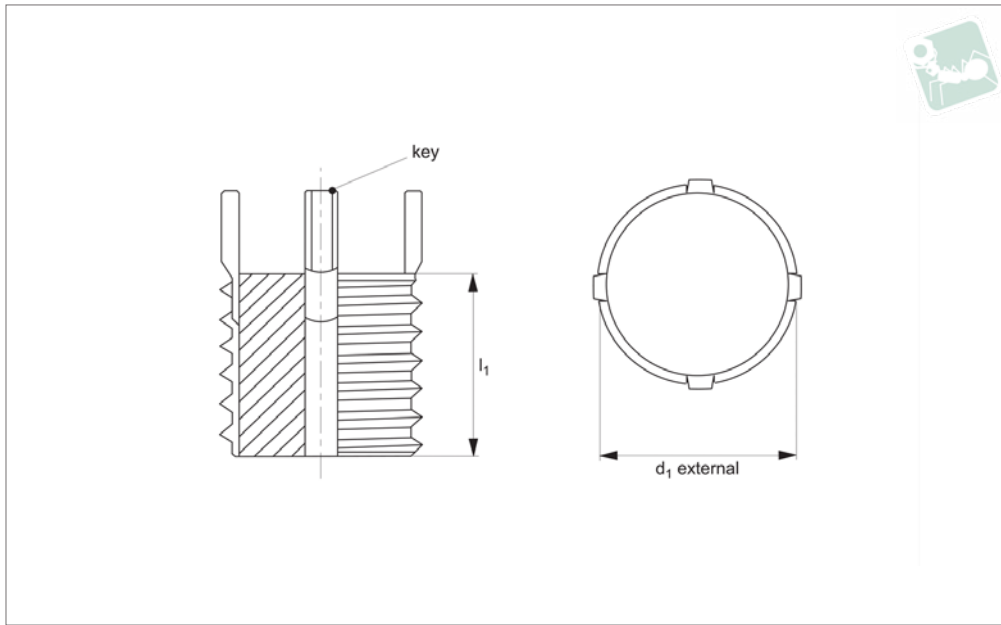


# Threaded Insert - Solid - Metric

carbon steel



**TR1692**



THREADED INSERTS STEEL

**Material**

Inserts: carbon steel (C1215) or equivalent. Zinc phosphate.

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.

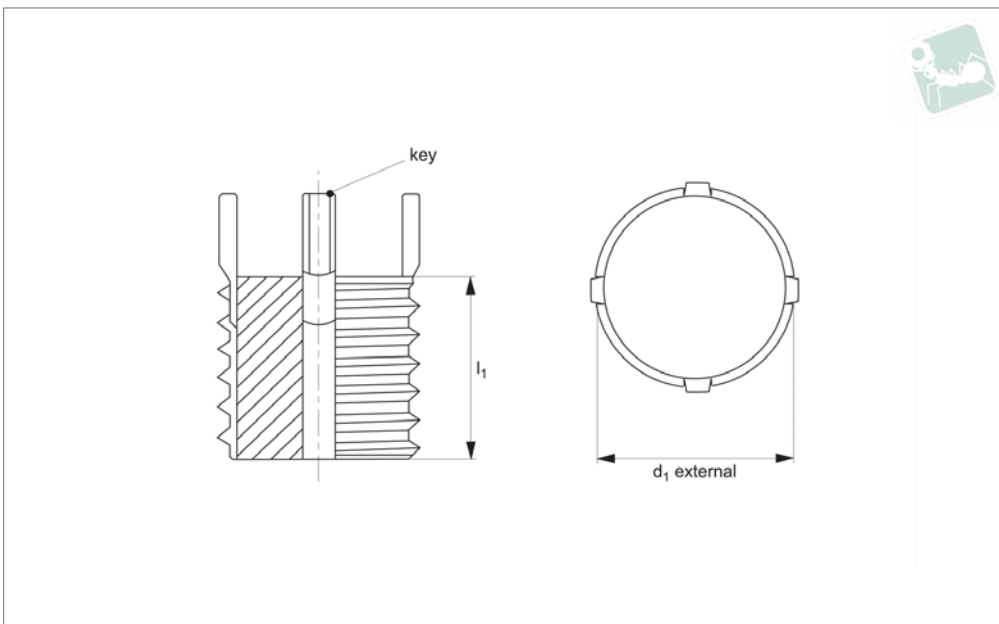
Removal drill size and drill depth as specified in table.

External metric thread allows you to machine your internal thread.

Order No.	d <sub>1</sub> tol. 6g	Thread type d <sub>1</sub>	l <sub>1</sub>	Inst. tool ref. 22052	Inst. tap drill size	Inst. c'sink dia. +0.25 -0.00	Inst. thread tap tol. 6H	Inst. thread tap depth min.	Removal drill size	Removal drill depth
TR1692.66021	M 8x1,25	Coarse	8	.W0210	6,90	8,3	M 8x1,25	9,5	5,5	4,0
TR1692.66022	M10x1,25	Fine	10	.W0220	8,80	10,3	M10x1,25	12,5	7,5	4,8
TR1692.66023	M12x1,25	Fine	12	.W0230	10,80	12,3	M12x1,25	14,5	9,5	4,8
TR1692.66024	M14x1,50	Fine	14	.W0240	12,80	14,3	M14x1,50	16,5	11,5	4,8
TR1692.66025	M16x1,50	Fine	16	.W0250	14,75	16,3	M16x1,50	18,5	13,5	4,8
TR1692.66026	M18x1,50	Fine	18	.W0260	16,75	18,3	M18x1,50	20,5	15,5	4,8
TR1692.66027	M20x1,50	Fine	20	.W0270	18,75	20,3	M20x1,50	22,5	17,5	4,8
TR1692.66028	M22x1,50	Fine	22	.W0280	20,50	22,3	M22x1,50	24,5	17,8	6,4
TR1692.66029	M24x1,50	Fine	24	.W0290	22,50	24,3	M24x1,50	26,5	19,8	6,4
TR1692.66030	M30x2,00	Fine	30	.W0300	28,00	30,3	M30x2,00	34,5	25,8	6,4
TR1692.66031	M32x2,00	Non-Std	32	.W0310	30,00	32,3	M32x2,00	36,5	27,8	6,4
TR1692.66032	M33x2,00	Non-Std	33	.W0320	31,00	33,3	M33x2,00	37,5	28,8	6,4



## TR1698



### Material

Inserts: carbon steel (C1215) or equivalent. Zinc phosphate.

Keys: stainless steel (302 CRES) or equivalent. Passivated.

### Technical Notes

#### General tolerances:

± 0,010" unless specified.

#### Tap drill hole tolerances:

0,234 to 0,500 = +0,004/-0,001".  
0,500 and over = +0,005/-0,001".

### Tips

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

### Important Notes

Four locking keys on external threads 7/16" and over. Two locking keys on

external threads smaller than 7/16".

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 inch thread allows you to machine your internal thread.

**All dimensions in inches.**

Order No.	d <sub>1</sub> (mod.) tol. 2A	Thread type d <sub>1</sub>	l <sub>1</sub>	Inst. tool ref. 22050	Inst. tap drill size	Inst. c'sink dia. +0.010 - 0.000	Inst. thread tap tol. 2B	Inst. thread tap depth min.	Removal drill size	Removal drill depth
TR1698.66001	5/16"-18	UNC	0,31	.W0010	0,27	0,32	5/16"-18	0,37	7/32"	1/8"
TR1698.66002	3/8"-16	UNC	0,31	.W0020	0,33	0,38	3/8"-16	0,37	9/32"	1/8"
TR1698.66003	7/16"-14	UNC	0,37	.W0030	0,40	0,44	7/16"-14	0,43	11/32"	3/16"
TR1698.66004	1/2"-13	UNC	0,43	.W0040	0,45	0,51	1/2"-13	0,50	13/32"	3/16"
TR1698.66005	9/16"-12	UNC	0,50	.W0050	0,52	0,57	9/16"-12	0,56	15/32"	3/16"
TR1698.66006	5/8"-11	UNC	0,62	.W0060	0,58	0,63	5/8"-11	0,68	17/32"	3/16"
TR1698.66007	3/4"-16	UNF	0,68	.W0070	0,70	0,76	3/4"-16	0,75	21/32"	3/16"
TR1698.66008	7/8"-14	UNF	0,87	.W0080	0,83	0,88	7/8"-14	1,00	25/32"	5/16"
TR1698.66009	1"-12	UNF	0,87	.W0090	0,94	1,02	1"-12	1,00	27/32"	5/16"
TR1698.66010	1-1/8"-12	UNF	1,12	.W0100	1,06	1,14	1-1/8"-12	1,31	31/32"	5/16"
TR1698.66011	1-1/4"-12	UNF	1,25	.W0110	1,19	1,27	1-1/4"-12	1,44	1-3/32"	5/16"
TR1698.66012	1-3/8"-12	UNF	1,37	.W0120	1,31	1,39	1-3/8"-12	1,56	1-7/32"	5/16"