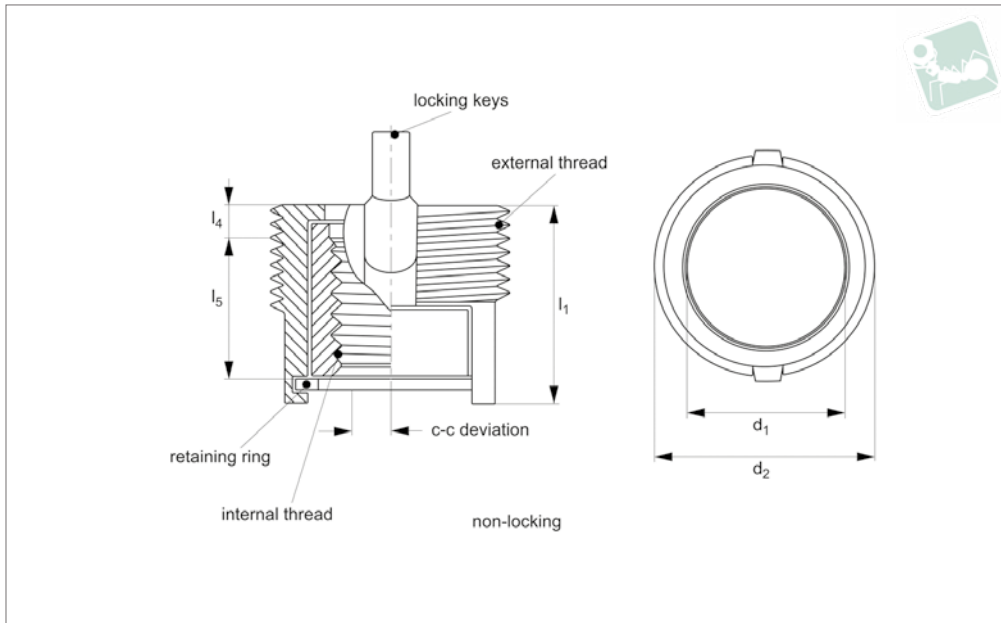
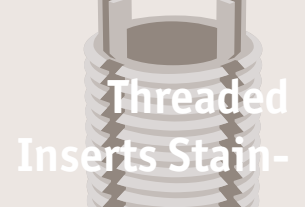




Floating Threaded Insert - Mini - Inch

303 stainless steel - non-locking



TR1680

THREADED INSERTS STAINLESS

Material

Inserts - 303 CRES.
 Keys and retaining ring - 302 CRES.
 Passivated. Dry film lubrication on self-locking inserts only.

Technical Notes

All dimensions in inches.
 Internal threads: to SAE AS8879.
 General tolerances -

+/- 0,010 unless specified.
 Tap drill hole tolerances -
 0,130 to 0,233 = +0,003/-0,001
NL = Non-thread locking type.

Tips

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

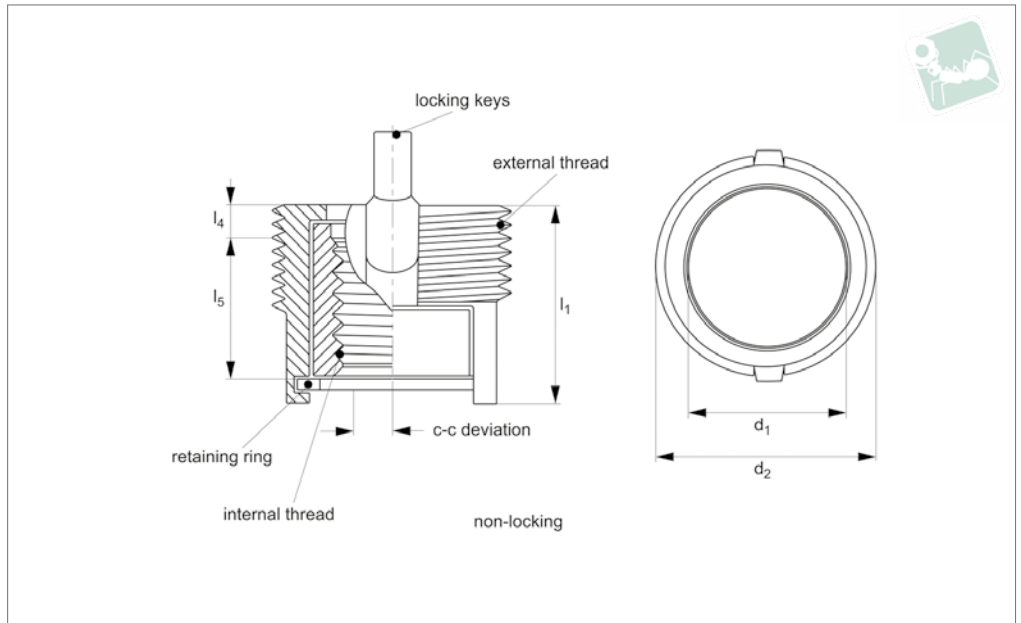
Important Notes

Four locking keys on internal threads 5/16 and over. Two locking keys on internal threads smaller than 5/16.
 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. 3B	Thread type d ₁	l ₁ ±0.01 5	d ₂ tol. 2A	Thread type d ₂	l ₄	l ₅	c-c float min.	Inst. c'sink dia. +0.01 0 - 0.000	Inst. tap drill size	Inst. thread tap depth min.	Inst. thread tap size class 2B	Inst. tool ref. TR1720	Removal drill size	Removal drill depth
TR1680.87283	NL	2-56	UNC	,19	1/4-28	UNF	,05	,10	,015	,250	,228	,12	1/4-28	.0830	#8	3/32
TR1680.87284	NL	4-40	UNC	,32	5/16-24	UNF	,07	,21	,020	,323	,272	,31	5/16-24	.0840	7/32	1/8
TR1680.87285	NL	6-32	UNC	,36	3/8-24	UNF	,08	,22	,030	,385	,332	,38	3/8-24	.0850	9/32	1/8
TR1680.87286	NL	8-32	UNC	,36	3/8-24	UNF	,08	,22	,030	,385	,332	,38	3/8-24	.0860	9/32	1/8



TR1681



Material

Inserts - 303 CRES.
Keys and retaining ring - 302 CRES.
Passivated. Dry film lubrication on self-locking inserts only.

Technical Notes

All dimensions in inches.
Internal threads: to SAE AS8879.
General tolerances -
+/- 0,010 unless specified.

Tap drill hole tolerances -

0,130 to 0,233 = +0,003/-0,001
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.

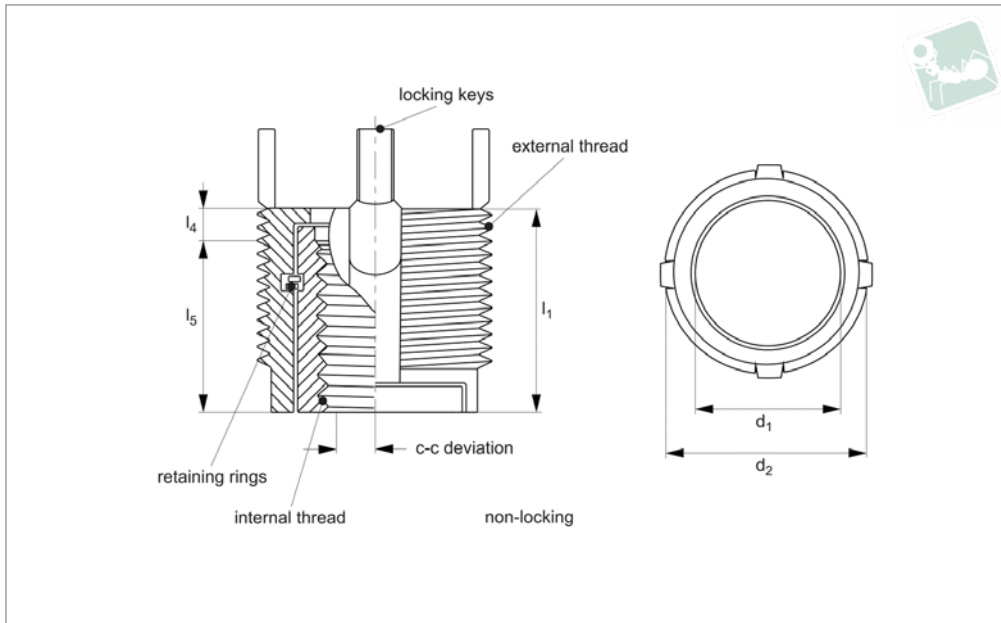
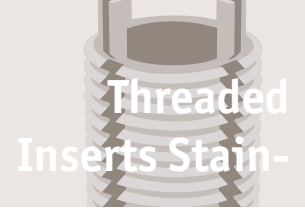
Important Notes

Four locking keys on internal threads 5/16 and over. Two locking keys on internal threads smaller than 5/16.
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.
Perform to standards

Order No.	Type	d ₁ Thread tol. 3B type	d ₁ Thread type	l ₁ ±0,01 5	d ₂ tol. 2A	Thread type	d ₂	l ₄	l ₅	c-c float min.	Inst. c'sink dia. +0,01 0 -0,000	Inst. tap drill size	Inst. thread tap depth min.	Inst. thread tap size class 2B	Inst. tool ref. TR1720	Removal drill size	Removal drill depth
TR1681.87583	SL	2-56	UNC	,19	1/4-28	UNF	,05	,10	,015	,250	,228	,12	1/4-28	.0830	#8	3/32	
TR1681.87584	SL	4-40	UNC	,32	5/16-24	UNF	,07	,21	,020	,323	,272	,31	5/16-24	.0840	7/32	1/8	
TR1681.87585	SL	6-32	UNC	,36	3/8-24	UNF	,08	,22	,030	,385	,332	,38	3/8-24	.0850	9/32	1/8	
TR1681.87586	SL	8-32	UNC	,36	3/8-24	UNF	,08	,22	,030	,385	,332	,38	3/8-24	.0860	9/32	1/8	



Floating Threaded Insert - H Duty - 4140 steel - non-locking



TR1685

THREADED INSERTS STAINLESS

Material

Inserts - 4140 alloy steel (160 KSI Min).
Keys - 302 CRES.
Cadmium plate (QQ-P-416 Type II, Cl. 2).
Dry film lubrication on self-locking inserts only.

Technical Notes

All dimensions in inches.
Internal threads: to SAE AS8879.
General tolerances -

+/- 0,010 unless specified.
Tap drill hole tolerances -
0,130 to 0,233 = +0,003/-0,001
NL = Non-thread locking type.

Tips

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

Important Notes

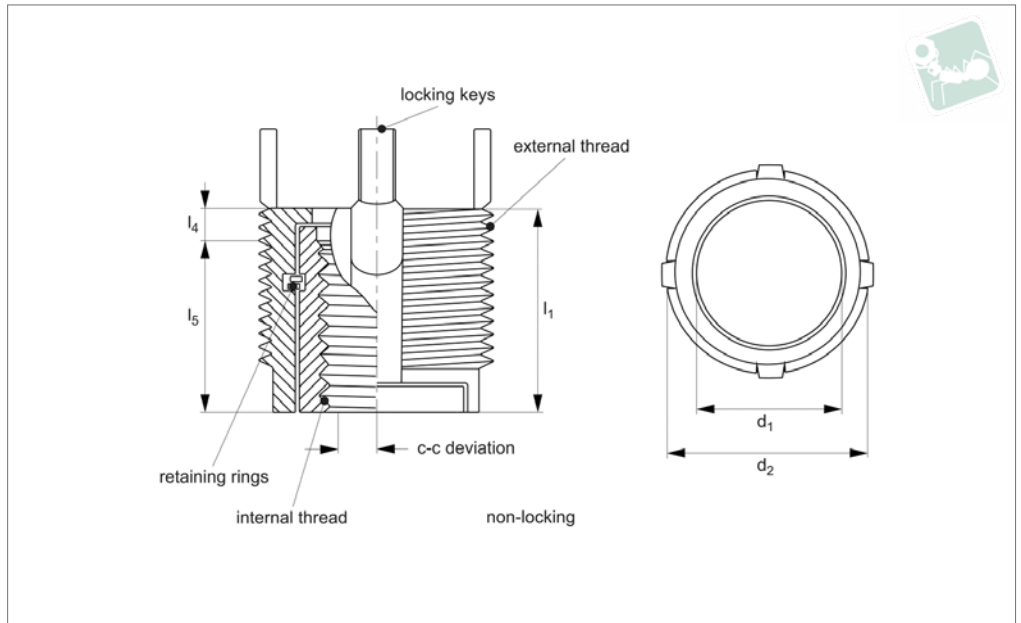
Four locking keys on internal threads 5/16

and over. Two locking keys on internal threads smaller than 5/16.
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.
Perform to standards:

Order No.	Type	d ₁ tol. 3B	Thread type d ₁ ±0.0 15	l ₁	d ₂ (mod.) class 2A	Thread type d ₂	l ₄	l ₅	c-c float min.	Inst. c'sink dia. +0.010 - 0.000	Inst. tap drill size	Inst. thread tap depth min.	Inst. tap size class 2B	Inst. tool ref. TR1725	Removal drill size	Removal drill depth
TR1685.89301	NL	10-24	UNC	,40	7/16-20	UNC	,15	,25	,040	,447	,406	,39	7/16-20	.0010	11/32	5/32
TR1685.89401	NL	10-32	UNF	,40	7/16-20	UNC	,15	,25	,040	,447	,406	,39	7/16-20	.0010	11/32	5/32
TR1685.89302	NL	1/4-20	UNC	,40	1/2-20	UNF	,15	,25	,040	,510	,486	,39	1/2-20	.0020	13/32	5/32
TR1685.89402	NL	1/4-28	UNF	,40	1/2-20	UNF	,15	,25	,040	,510	,486	,39	1/2-20	.0020	13/32	5/32
TR1685.89303	NL	5/16-18	UNC	,53	5/8-18	UNF	,13	,39	,040	,635	,578	,50	5/8-18	.0030	17/32	3/16
TR1685.89403	NL	5/16-24	UNF	,53	5/8-18	UNF	,13	,39	,040	,635	,578	,50	5/8-18	.0030	17/32	3/16
TR1685.89304	NL	3/8-16	UNC	,65	3/4-16	UNF	,20	,45	,040	,760	,703	,62	3/4-16	.0040	21/32	3/16
TR1685.89404	NL	3/8-24	UNF	,65	3/4-16	UNF	,20	,45	,040	,760	,703	,62	3/4-16	.0040	21/32	3/16
TR1685.89305	NL	7/16-14	UNC	,67	7/8-14	UNF	,20	,45	,040	,885	,828	,62	7/8-14	.0050	25/32	3/16
TR1685.89405	NL	7/16-20	UNF	,67	7/8-14	UNF	,20	,45	,040	,885	,828	,62	7/8-14	.0050	25/32	3/16
TR1685.89306	NL	1/2-13	UNC	,73	1-12	UNF	,23	,50	,040	1,020	,937	,65	1-12	.0060	27/32	5/16
TR1685.89406	NL	1/2-20	UNF	,73	1-12	UNF	,23	,50	,040	1,020	,937	,65	1-12	.0060	27/32	5/16



TR1686



Material

Inserts - 4140 alloy steel (160 KSI Min).
 Keys - 302 CRES.
 Cadmium plate (QQ-P-416 Type II, Cl. 2).
 Dry film lubrication on self-locking inserts only.

Technical Notes

All dimensions in inches.
 Internal threads: to SAE AS8879.
 General tolerances -

+/- 0,010 unless specified.

Tap drill hole tolerances -
 0,130 to 0,233 = +0,003/-0,001

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 5/16 and over. Two locking keys on internal threads smaller than 5/16.

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.

Perform to standards:

Order No.	Type	d ₁ tol. 3B	Thread type d ₁	l ₁ ±0,015	d ₂ (mod.) class 2A	Thread type d ₂	l ₄	l ₅	c-c float min.	Inst. c'sink dia. +0,010 -0,000	Inst. tap drill size	Inst. thread tap depth min.	Inst. thread tap size class 2B	Inst. tool ref. TR1725	Removal drill size	Removal drill depth
TR1686.89501	SL	10-24	UNC	,40	7/16-20	UNC	,15	,25	,040	,447	,406	,39	7/16-20	.0010	11/32	5/32
TR1686.89601	SL	10-32	UNF	,40	7/16-20	UNC	,15	,25	,040	,447	,406	,39	7/16-20	.0010	11/32	5/32
TR1686.89502	SL	1/4-20	UNC	,40	1/2-20	UNF	,15	,25	,040	,510	,486	,39	1/2-20	.0020	13/32	5/32
TR1686.89602	SL	1/4-28	UNF	,40	1/2-20	UNF	,15	,25	,040	,510	,486	,39	1/2-20	.0020	13/32	5/32
TR1686.89503	SL	5/16-18	UNC	,53	5/8-18	UNF	,13	,39	,040	,635	,578	,50	5/8-18	.0030	17/32	3/16
TR1686.89603	SL	5/16-24	UNF	,53	5/8-18	UNF	,13	,39	,040	,635	,578	,50	5/8-18	.0030	17/32	3/16
TR1686.89504	SL	3/8-16	UNC	,65	3/4-16	UNF	,20	,45	,040	,760	,703	,62	3/4-16	.0040	21/32	3/16
TR1686.89604	SL	3/8-24	UNF	,65	3/4-16	UNF	,20	,45	,040	,760	,703	,62	3/4-16	.0040	21/32	3/16
TR1686.89505	SL	7/16-14	UNC	,67	7/8-14	UNF	,20	,45	,040	,885	,828	,62	7/8-14	.0050	25/32	3/16
TR1686.89605	SL	7/16-20	UNF	,67	7/8-14	UNF	,20	,45	,040	,885	,828	,62	7/8-14	.0050	25/32	3/16
TR1686.89506	SL	1/2-13	UNC	,73	1-12	UNF	,23	,50	,040	1,020	,937	,65	1-12	.0060	27/32	5/16
TR1686.89606	SL	1/2-20	UNF	,73	1-12	UNF	,23	,50	,040	1,020	,937	,65	1-12	.0060	27/32	5/16