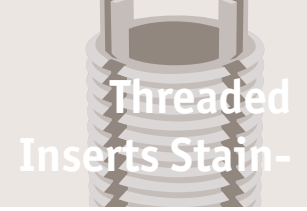
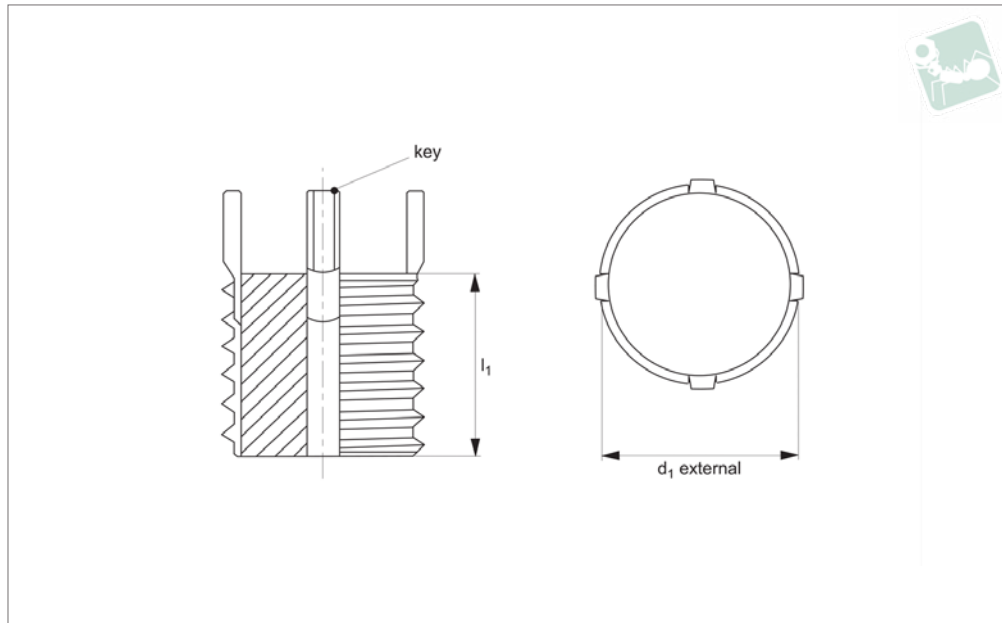




# Threaded Insert - Solid - Metric stainless steel



Threaded  
Inserts Stain-



**TR1690**

THREADED INSERTS STAINLESS

## Material

Inserts: stainless steel (AISI 303) or equivalent. Passivated.

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

## Technical Notes

### General tolerances:

$\pm 0,25$  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.

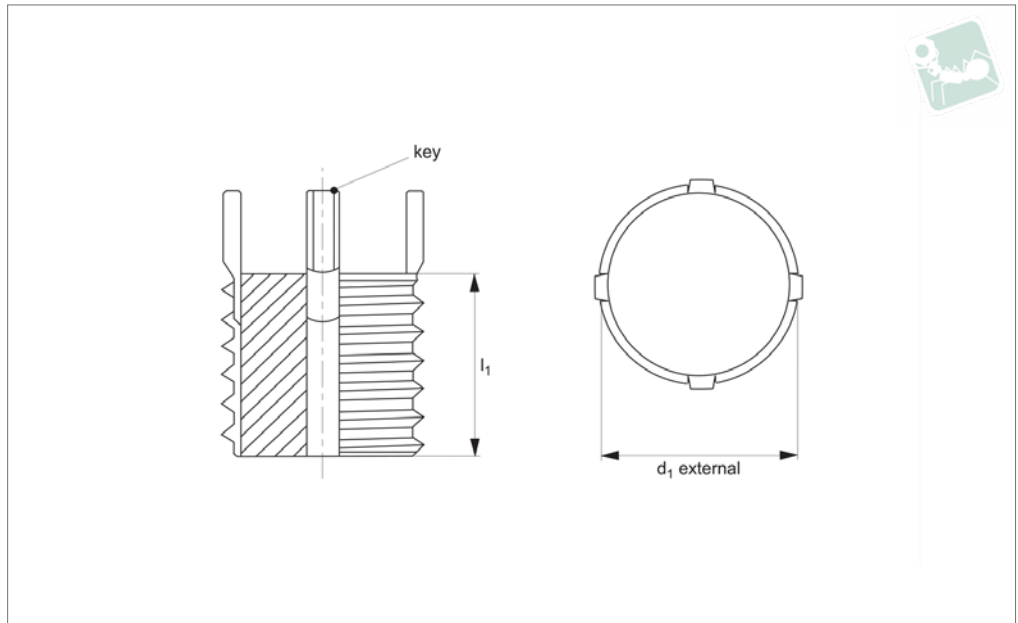
Removal drill size and drill depth as specified in table.

External metric thread allows you to machine your internal thread.

Order No.	d <sub>1</sub>	Thread type d <sub>1</sub>	l <sub>1</sub>	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	M10x1,25	Fine	10	.W0220	8.8	10.3	M10x1,25	12.5	7.50	4.8
TR1690.66423	M12x1,25	Fine	12	.W0230	10.8	12.3	M12x1,25	14.5	9.50	4.8
TR1690.66424	M14x1,50	Fine	14	.W0240	12.8	14.3	M14x1,50	16.5	11.50	4.8
TR1690.66425	M16x1,50	Fine	16	.W0250	14.8	16.3	M16x1,50	18.5	13.50	4.8
TR1690.66426	M18x1,50	Fine	18	.W0260	16.8	18.3	M18x1,50	20.5	15.50	4.8
TR1690.66427	M20x1,50	Fine	20	.W0270	18.8	20.3	M20x1,50	22.5	17.50	4.8
TR1690.66428	M22x1,50	Fine	22	.W0280	20.5	22.3	M22x1,50	24.5	17.75	6.4
TR1690.66429	M24x1,50	Fine	24	.W0290	22.5	24.3	M24x1,50	26.5	19.75	6.4
TR1690.66430	M30x2,00	Non-Std	30	.W0300	28.0	30.3	M30x2,00	34.5	25.75	6.4
TR1690.66431	M32x2,00	Non-Std	32	.W0310	30.0	32.3	M32x2,00	36.5	27.75	6.4
TR1690.66432	M33x2,00	Non-Std	33	.W0320	31.0	33.3	M33x2,00	37.5	28.75	6.4



## TR1696



### Material

Inserts: stainless steel (AISI 303) or equivalent. Passivated.

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.

\*Unified special pitch 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
TR1696.66401	5/16"-18	UNC	0,31	.W0010	0,272	0,32	5/16"-18	0,37	7/32"	1/8"
TR1696.66402	3/8"-16	UNC	0,31	.W0020	0,332	0,38	3/8"-16	0,37	9/32"	1/8"
TR1696.66403	7/16"-14	UNC	0,37	.W0030	0,397	0,44	7/16"-14	0,43	11/32"	3/16"
TR1696.66404	1/2"-13	UNC	0,43	.W0040	0,453	0,51	1/2"-13	0,50	13/32"	3/16"
TR1696.66405	9/16"-12	UNC	0,50	.W0050	0,516	0,57	9/16"-12	0,56	15/32"	3/16"
TR1696.66406	5/8"-11	UNC	0,62	.W0060	0,578	0,63	5/8"-11	0,68	17/32"	3/16"
TR1696.66413	11/16"-11*	UNS	0,68	.W0065	0,641	0,70	11/16"-11*	0,75	19/32"	3/16"
TR1696.66407	3/4"-16	UNF	0,68	.W0070	0,703	0,76	3/4"-16	0,75	21/32"	3/16"
TR1696.66414	13/16"-16	UNF	0,81	.W0075	0,766	0,82	13/16"-16	0,94	23/32"	3/16"
TR1696.66408	7/8"-14	UNF	0,87	.W0080	0,828	0,88	7/8"-14	1,00	25/32"	5/16"
TR1696.66409	1"-12	UNF	0,87	.W0090	0,937	1,02	1"-12	1,00	27/32"	5/16"
TR1696.66410	1-1/8"-12	UNF	1,12	.W0100	1,062	1,14	1-1/8"-12	1,31	31/32"	5/16"
TR1696.66411	1-1/4"-12	UNF	1,25	.W0110	1,187	1,27	1-1/4"-12	1,44	1-3/32"	5/16"
TR1696.66412	1-3/8"-12	UNF	1,37	.W0120	1,312	1,39	1-3/8"-12	1,56	1-7/32"	5/16"