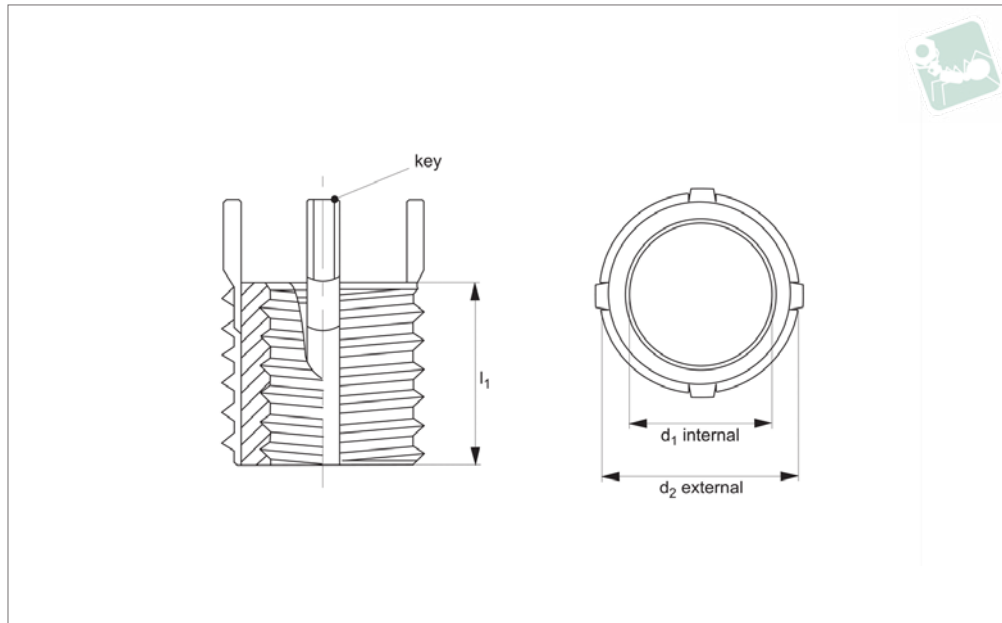
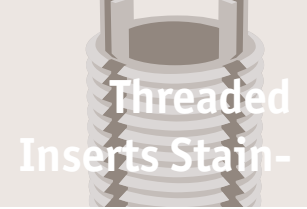




Threaded Insert - Metric

thinwall - stainless steel



TR1510

THREADED INSERTS STAINLESS

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 internal threads M 8 and over. Two locking keys on internal threads smaller than M 8.

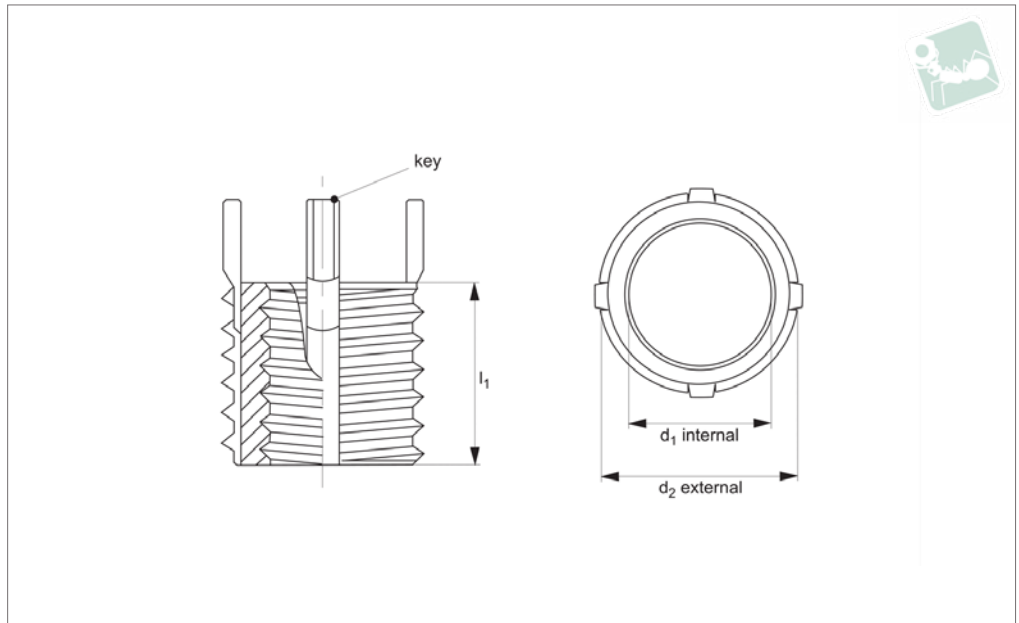
Installation (Inst.) drill size, countersink, thread tap and thread depth as specified in table.

Removal drill size and drill depth as speci-

Order No.	Int. d ₁ tol. 6H	Int. thread type d ₁	Ext. d ₂ tol. 6g	Ext. thread type d ₂	l ₁	Inst. tap drill size	Inst. tool ref. 22060	Inst. c'sink dia. ±0,25 ± 0,000	Inst. thread tap tol. 6H	Inst. thread depth min.	Removal drill size	Removal drill depth
TR1510.66351	M 5x0,80	Coarse	M 8x1,25	Coarse	8	6,9	.W0510	8,3	M 8x1,25	9,5	5,5	4,0
TR1510.66352	M 6x1,00	Coarse	M10x1,25	Fine	10	8,8	.W0520	10,3	M10x1,25	11,5	7,5	4,8
TR1510.66353	M 8x1,25	Coarse	M12x1,25	Fine	12	10,8	.W0530	12,3	M12x1,25	13,5	9,5	4,8
TR1510.66553	M 8x1,00	Fine	M12x1,25	Fine	12	10,8	.W0530	12,3	M12x1,25	13,5	9,5	4,8
TR1510.66355	M10x1,50	Coarse	M14x1,50	Fine	14	12,8	.W0550	14,3	M14x1,50	15,5	11,5	4,8
TR1510.66555	M10x1,25	Fine	M14x1,50	Fine	14	12,8	.W0550	14,3	M14x1,50	15,5	11,5	4,8
TR1510.66356	M12x1,75	Coarse	M16x1,50	Fine	16	14,2	.W0560	14,3	M16x1,50	17,5	13,5	4,8
TR1510.66556	M12x1,25	Fine	M16x1,50	Fine	16	14,8	.W0560	16,3	M16x1,50	17,5	13,5	4,8



TR1560



Material

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

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

Technical Notes

All dimensions in inches.

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 internal threads 5/

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

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

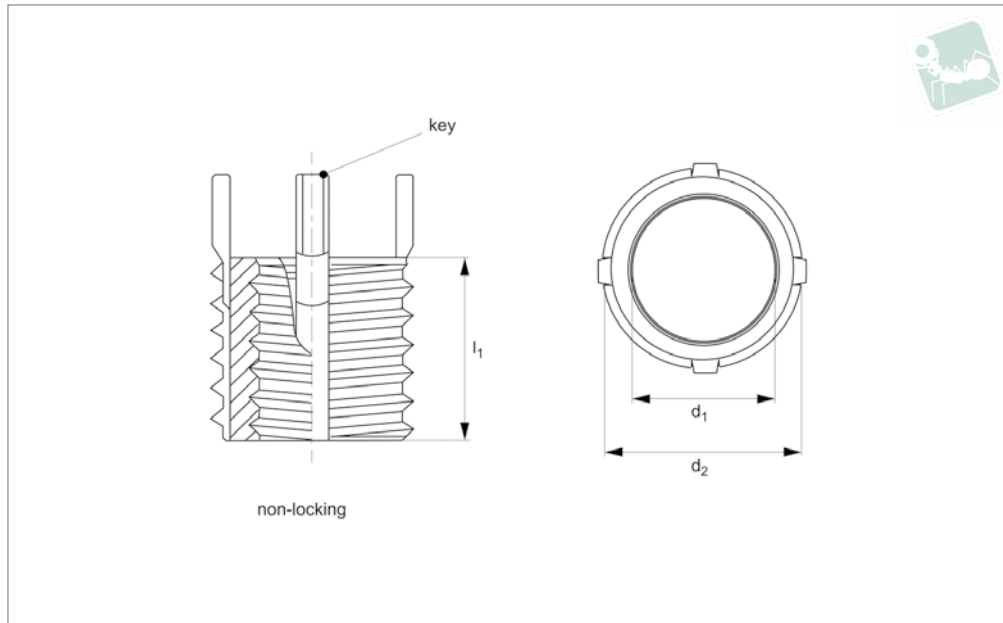
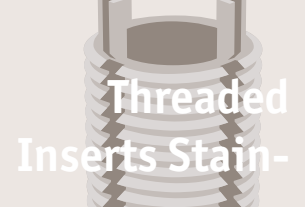
Removal drill size and drill depth as specified in table.

All dimensions in inches.

Order No.	Int. d ₁ tol. 2B	Int. thread type d ₁	Ext. d ₂ tol. 2A	Ext. thread type d ₂	l ₁	Inst. tap drill size	Inst. tool ref. 22054	Inst. c'sink dia. +0.010 -0.000	Inst. thread tap tol. 2B	Inst. thread depth min.	Removal drill size	Removal drill depth
TR1560.66321	10-24	UNC	5/16"-18	UNC	0,31	17/64"	.W0210	0,32	5/16"-18	0,37	7/32"	1/8"
TR1560.66521	10-32	UNF	5/16"-18	UNC	0,31	17/64"	.W0210	0,32	5/16"-18	0,37	7/32"	1/8"
TR1560.66322	1/4"-20	UNC	3/8"-16	UNC	0,37	21/64"	.W0220	0,38	3/8"-16	0,43	9/32"	3/16"
TR1560.66522	1/4"-28	UNF	3/8"-16	UNC	0,37	21/64"	.W0220	0,38	3/8"-16	0,43	9/32"	3/16"
TR1560.66323	5/16"-18	UNC	7/16"-14	UNC	0,43	25/64"	.W0230	0,44	7/16"-14	0,50	11/32"	3/16"
TR1560.66523	5/16"-24	UNF	7/16"-14	UNC	0,43	25/64"	.W0230	0,44	7/16"-14	0,50	11/32"	3/16"
TR1560.66324	3/8"-16	UNC	1/2"-13	UNC	0,50	29/64"	.W0240	0,51	1/2"-13	0,56	13/32"	3/16"
TR1560.66524	3/8"-16	UNF	1/2"-13	UNC	0,50	29/64"	.W0240	0,51	1/2"-13	0,56	13/32"	3/16"
TR1560.66325	7/16"-14	UNC	9/16"-12	UNC	0,56	33/64"	.W0250	0,57	9/16"-12	0,62	15/32"	3/16"
TR1560.66525	7/16"-20	UNF	9/16"-12	UNC	0,56	33/64"	.W0250	0,57	9/16"-12	0,62	15/32"	3/16"
TR1560.66326	1/2"-13	UNC	5/8"-11	UNC	0,62	37/64"	.W0260	0,63	5/8"-11	0,68	17/32"	3/16"
TR1560.66526	1/2"-20	UNF	5/8"-11	UNC	0,62	37/64"	.W0260	0,63	5/8"-11	0,68	17/32"	3/16"



Threaded Insert MS/NAS - Thinwall - 303 stainless steel - non-locking - MS/NAS grade



TR1602

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
NL = Non-Locking type.

Tips

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

Important Notes

Four locking keys on internal threads M 6 and over. Two locking keys on internal threads smaller than M 6.
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 type 5H	Thread d ₁	d ₂ tol. 4h type	Thread d ₂	Inst. tap drill size	l ₁	l ₄ c'bore depth	C'sink hole size +0.25 -0.00	Inst. thread tap tol. 6H	Inst. thread tap depth min.	Inst. tool ref. TR1712	Removal drill depth	Removal drill size
TR1602.76351	NL	M 5x0, 8	Coars e	M 8x1, 25	Coars e	6.90	8.0	1.27	8.25	M 8x1,25	9.5	.0510	4.00	5.50
TR1602.76551	NL	M 5x0, 5	Fine	M 8x1, 25	Coars e	6.90	8.0	1.27	8.25	M 8x1,25	9.5	.0510	4.00	5.50
TR1602.76352	NL	M 6x1, 0	Coars e	M10 x1,2 5	Fine	8.80	10.0	1.78	10.25	M10x1 ,25	11.5	.0520	4.75	7.50
TR1602.76552	NL	M 6x0, 75	Fine	M10 x1,2 5	Fine	8.80	10.0	1.78	10.25	M10x1 ,25	11.5	.0520	4.75	7.50
TR1602.76353	NL	M 8x1, 25	Coars e	M12 x1,2 5	Fine	10.80	12.0	1.78	12.25	M12.1, 25	13.5	.0530	4.75	9.50
TR1602.76553	NL	M 8x1, 0	Fine	M12 x1,2 5	Fine	10.80	12.0	1.78	12.25	M12.1, 25	13.5	.0530	4.75	9.50
TR1602.76355	NL	M10 x1,5	Coars e	M14 x1,5	Fine	12.80	14.0	2.29	14.25	M14x1 ,5	15.5	.0550	4.75	11.50
TR1602.76555	NL	M10 x1,2 5	Fine	M14 x1,5	Fine	12.80	14.0	2.29	14.25	M14x1 ,5	15.5	.0550	4.75	11.50

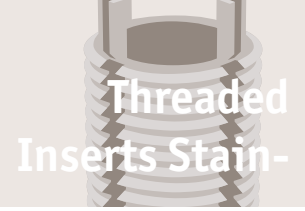


Order No.	Type	d ₁ tol. 4H 5H	Thread type d ₁	d ₂ tol. 4h	Thread type d ₂	Inst. tap drill size	l ₁	l ₄ c'bore depth	C'sink hole size +0.25 -0.00	Inst. thread tap tol. 6H	Inst. thread tap depth min.	Inst. tool ref. TR1712	Removal drill depth	Removal drill size
TR1602.76356	NL	M12 x1,7 5	Coars e	M16 x1,5	Fine	14.75	16.0	2.29	16.25	M16x1 ,5	17.5	.0560	4.75	13.50
TR1602.76556	NL	M12 x1,2 5	Fine	M16 x1,5	Fine	14.75	16.0	2.29	16.25	M16x1 ,5	17.5	.0560	4.75	13.50

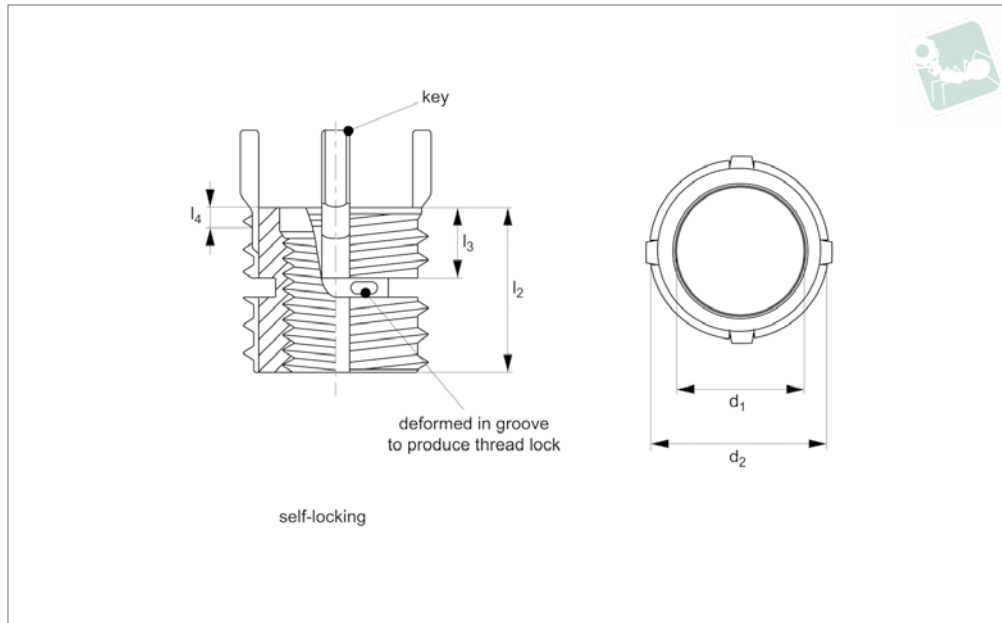
THREADED INSERTS STAINLESS



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



Threaded Inserts Stain-



TR1603

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 M 6 and over. Two locking keys on internal threads smaller than M 6.
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.

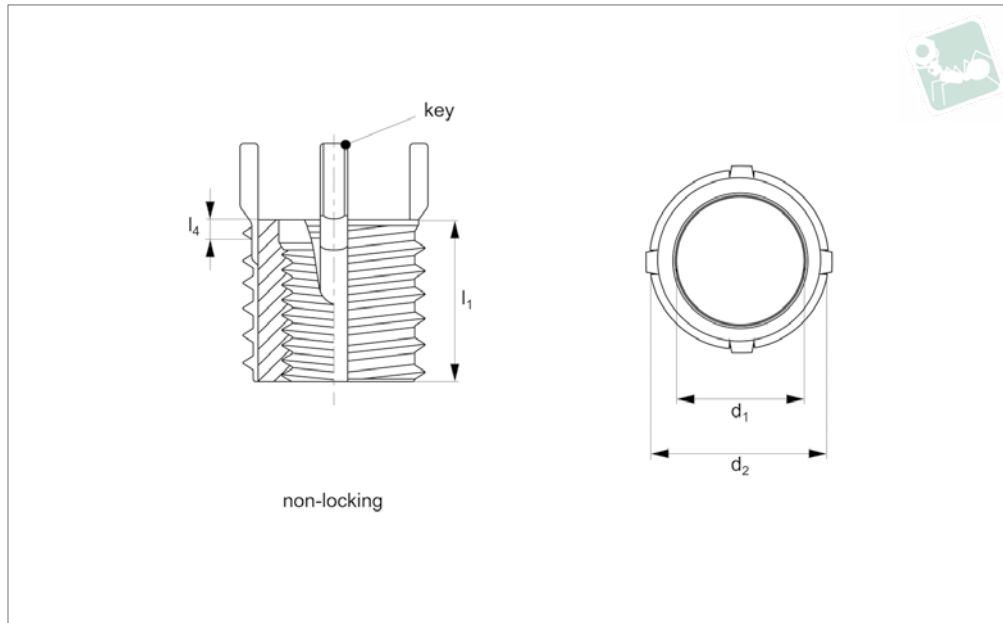
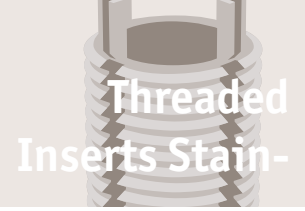
Order No.	Type	d ₁ Thread tol. 4H type 5H	d ₂ Thread tol. 4h type 5H	Inst. tap drill size	l ₁	l ₃ ±0.76	l ₄ c'bor e dept h	C'sink hole size +0.25 tol. 6H -0.00	Inst. thread tap tol. 6H	Inst. thread tap depth min.	Inst. tool ref. TR1712	Removal drill depth	Removal drill size
TR1603.77351	SL	M 5x0,8 Coars e	M 8x1,25 Coars e	6.90	8.0	3.73	1.27	8.25	M 8x1,25	9.5	.0510	4.00	5.50
TR1603.77551	SL	M 5x0,5 Fine	M 8x1,25 Coars e	6.90	8.0	3.73	1.27	8.25	M 8x1,25	9.5	.0510	4.00	5.50
TR1603.77352	SL	M 6x1,0 Coars e	M10 x1,25 Fine	8.80	10.0	6.02	1.78	10.25	M10x 1,25	11.5	.0520	4.75	7.50
TR1603.77552	SL	M 6x0,75 Fine	M10 x1,25 Fine	8.80	10.0	6.02	1.78	10.25	M10x 1,25	11.5	.0520	4.75	7.50
TR1603.77353	SL	M 8x1,25 Coars e	M12 x1,25 Fine	10.80	12.0	6.28	1.78	12.25	M12x 1,25	13.5	.0530	4.75	9.50
TR1603.77553	SL	M 8x1,0 Fine	M12 x1,25 Fine	10.80	12.0	6.28	1.78	12.25	M12x 1,25	13.5	.0530	4.75	9.50
TR1603.77355	SL	M10 x1,5 Coars e	M14 x1,5 Fine	12.80	14.0	6.46	2.29	14.25	M14x 1,5	15.5	.0550	4.75	11.50
TR1603.77555	SL	M10 x1,25 Fine	M14 x1,5 Fine	12.80	14.0	6.46	2.29	14.25	M14x 1,5	15.5	.0550	4.75	11.50



Order No.	Type	d ₁ tol. 4H 5H	Thread type d ₁	d ₂ tol. 4h	Thread type d ₂	Inst. tap drill size	l ₁	l ₃ ±0.76	l ₄ e	c'bor h	C'sink hole size +0.25 -0.00	Inst. thread tap tol. 6H	Inst. thread tap depth min.	Inst. tool ref. TR1712	Removal drill depth	Removal drill size
TR1603.77356	SL	M12 x1,7 5	Coars e	M16 x1,5	Fine	14.75	16.0	6.46	2.29	16.25	M16x1,5	17.5	.0560	4.75	13.50	
TR1603.77556	SL	M12 x1,2 5	Fine	M16 x1,5	Fine	14.75	16.0	6.46	2.29	16.25	M16x1,5	17.5	.0560	4.75	13.50	



Threaded Insert MS/NAS - Thinwall - 303 stainless steel - non-locking - MS/NAS grade



TR1652

THREADED INSERTS STAINLESS

Material

Inserts - 303 CRES.
Keys - 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 -
0,234 to 0,500 = +0,004/-0,001
0,500 and over = +0,005/-0,001
NL = Non-Locking type.

Tips

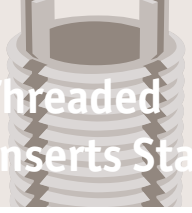
Order installation tool separately, as identified by „Inst. Tool ref.“ in table.

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: MIL-I-45914A (MS51830 & NAS1394)

Order No.	Type	d ₁ tol. 3B	Thread type d ₁	d ₂ (mod.) class 2A	Thread type d ₂	Inst. tap drill size	l ₁	l ₄ c'bor e dept h	C'sink hole size +0.01 0 - 0.000	Inst. thread tap depth min.	Inst. thread tap size tol. 2B	Inst. tool ref. TR1702	Removal drill depth	Removal drill size
TR1652.76321	NL	10-24	UNC	5/16-18	UNC	.397	.437	.07	.447	.50	7/16-14	.0210	3/16	11/32
TR1652.76521	NL	10-32	UNF	5/16-18	UNC	.397	.437	.07	.447	.50	7/16-14	.0211	3/16	11/32
TR1652.76322	NL	1/4-20	UNC	3/8-16	UNC	.272	.312	.07	.323	.37	5/16-18	.0220	5/32	7/32
TR1652.76522	NL	1/4-28	UNF	3/8-16	UNC	.272	.312	.07	.323	.37	5/16-18	.0221	5/32	7/32
TR1652.76323	NL	5/16-18	UNC	7/16-14	UNC	.332	.375	.07	.385	.43	3/8-16	.0230	3/16	9/32
TR1652.76523	NL	5/16-24	UNF	7/16-14	UNC	.332	.375	.07	.385	.43	3/8-16	.0231	3/16	9/32
TR1652.76324	NL	3/8-16	UNC	1/2-13	UNC	.453	.500	.07	.510	.56	1/2-13	.0240	3/16	13/32
TR1652.76524	NL	3/8-24	UNF	1/2-13	UNC	.453	.500	.07	.510	.56	1/2-13	.0241	3/16	13/32
TR1652.76325	NL	7/16-14	UNC	9/16-12	UNC	.516	.562	.07	.572	.62	9/16-12	.0250	3/16	15/32

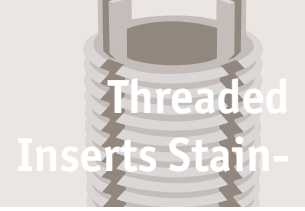


THREADED INSERTS STAINLESS

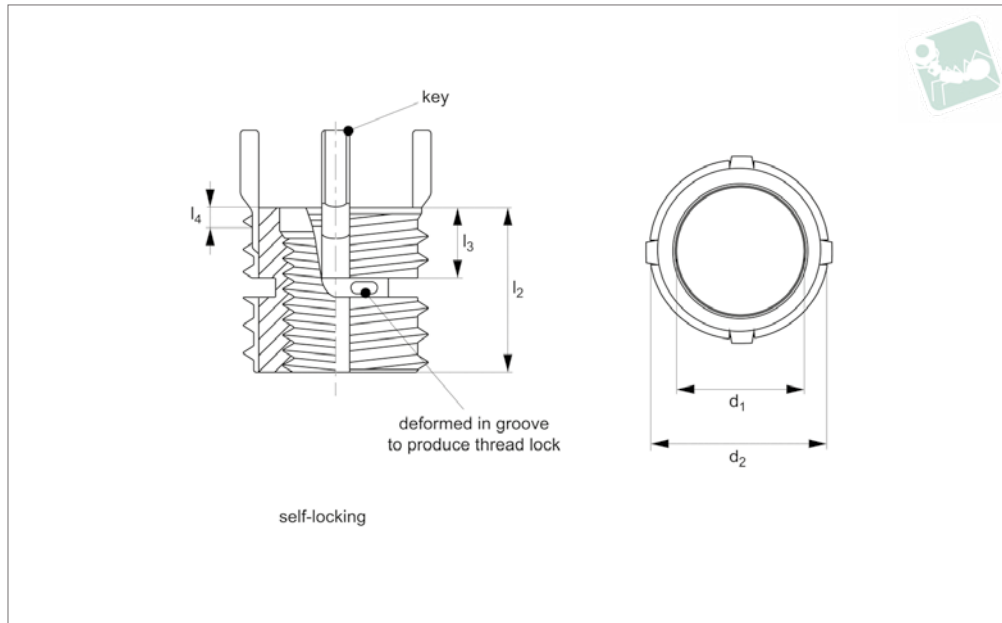
Order No.	Type	d ₁ tol. 3B	Thread type d ₁	d ₂ (mod.) class 2A	Thread type d ₂	Inst. tap drill size	l ₁	l ₄ c'bor e dept h	C'sink hole size +0.01 0 -0.000	Inst. thread tap depth min.	Inst. thread tap size tol. 2B	Inst. tool ref. TR1702	Removal drill depth	Removal drill size
TR1652.76525	NL	7/16-20	UNF	9/16-12	UNC	.516	.562	.07	.572	.62	9/16-12	.0251	3/16	15/32
TR1652.76326	NL	1/2-13	UNC	5/8-11	UNC	.578	.625	.07	.635	.68	5/8-11	.0260	3/16	17/32
TR1652.76526	NL	1/2-20	UNF	5/8-11	UNC	.578	.625	.07	.635	.68	5/8-11	.0261	3/16	17/32



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



Threaded
Inserts Stain-



TR1653

THREADED INSERTS STAINLESS

Material

Inserts - 303 CRES.
Keys - 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 -

0,234 to 0,500 = +0,004/-0,001
0,500 and over = +0,005/-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: MIL-I-45914A (MS51830 & NAS1394)

Order No.	Type	d ₁ tol. 3B	Thre ad type d ₁	d ₂ (mod.) class 2A	Thre ad type d ₂	Inst. tap drill size	l ₁	l ₃ ±0.30 c'bore	l ₄ depth	C'sink hole size +0.0 10 - 0.000	Inst. thread tap depth min.	Inst. thread tap size tol. 2B	Inst. tool ref. TR1702	Removal drill depth	Removal drill size
TR1653.77321	SL	10-24	UNC	5/16-18	UNC	.272	.312	.22	.07	.323	.37	5/16-18	.0210	5/32	7/32
TR1653.77521	SL	10-32	UNF	5/16-18	UNC	.272	.312	.22	.07	.323	.37	5/16-18	.0211	5/32	7/32
TR1653.77322	SL	1/4-20	UNC	3/8-16	UNC	.332	.375	.22	.07	.385	.43	3/8-16	.0220	3/16	9/32
TR1653.77522	SL	1/4-28	UNF	3/8-16	UNC	.332	.375	.22	.07	.385	.43	3/8-16	.0221	3/16	9/32
TR1653.77323	SL	5/16-18	UNC	7/16-14	UNC	.397	.437	.22	.07	.447	.50	7/16-14	.0230	3/16	11/32
TR1653.77523	SL	5/16-24	UNF	7/16-14	UNC	.397	.437	.22	.07	.447	.50	7/16-14	.0231	3/16	11/32
TR1653.77324	SL	3/8-16	UNC	1/2-13	UNC	.453	.500	.24	.07	.510	.56	1/2-13	.0240	3/16	13/32
TR1653.77524	SL	3/8-24	UNF	1/2-13	UNC	.453	.500	.24	.07	.510	.56	1/2-13	.0241	3/16	13/32
TR1653.77325	SL	7/16-14	UNC	9/16-12	UNC	.516	.562	.27	.07	.572	.62	9/16-12	.0250	3/16	15/32

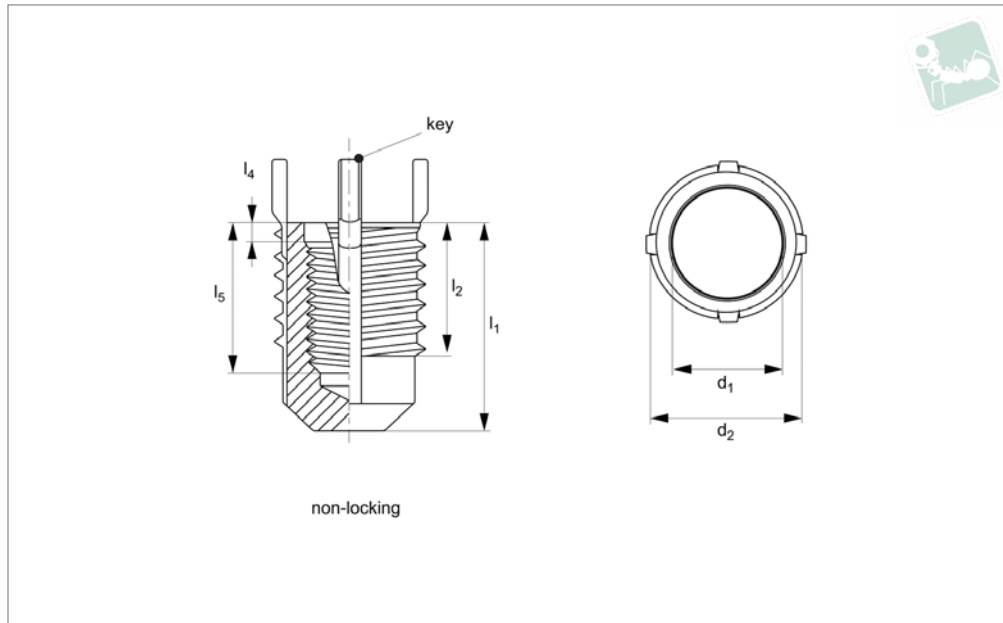
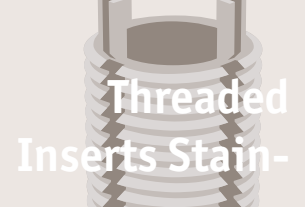


THREADED INSERTS STAINLESS

Order No.	Type	d ₁ tol. 3B	Thre ad type d ₁	d ₂ (mod.) class 2A	Thre ad type d ₂	Inst. tap drill size	l ₁	l ₃ ±0.30	l ₄ c'bore depth	C'sink hole size +0.0 10 - 0.000	Inst. thread tap depth min.	Inst. thread tap size tol. 2B	Inst. tool ref. TR1702	Removal drill depth	Removal drill size
TR1653.77525	SL	7/ 16- 20	UNF	9/16- 12	UNC	.516	.562	.27	.07	.572	.62	9/16-12	.0251	3/16	15/32
TR1653.77326	SL	1/2- 13	UNC	5/8- 11	UNC	.578	.625	.28	.07	.635	.68	5/8-11	.0260	3/16	17/32
TR1653.77526	SL	1/2- 20	UNF	5/8- 11	UNC	.578	.625	.28	.07	.635	.68	5/8-11	.0261	3/16	17/32



Blind Threaded Insert - Thinwall - 303 stainless steel - non-locking



TR1672

THREADED INSERTS STAINLESS

Material

Inserts - A303 CRES.
Keys - 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 -
0,234 to 0,500 = +0,004/-0,001
0,500 and over = +0,005/-0,001
NL = Non-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: MIL-I-45914A

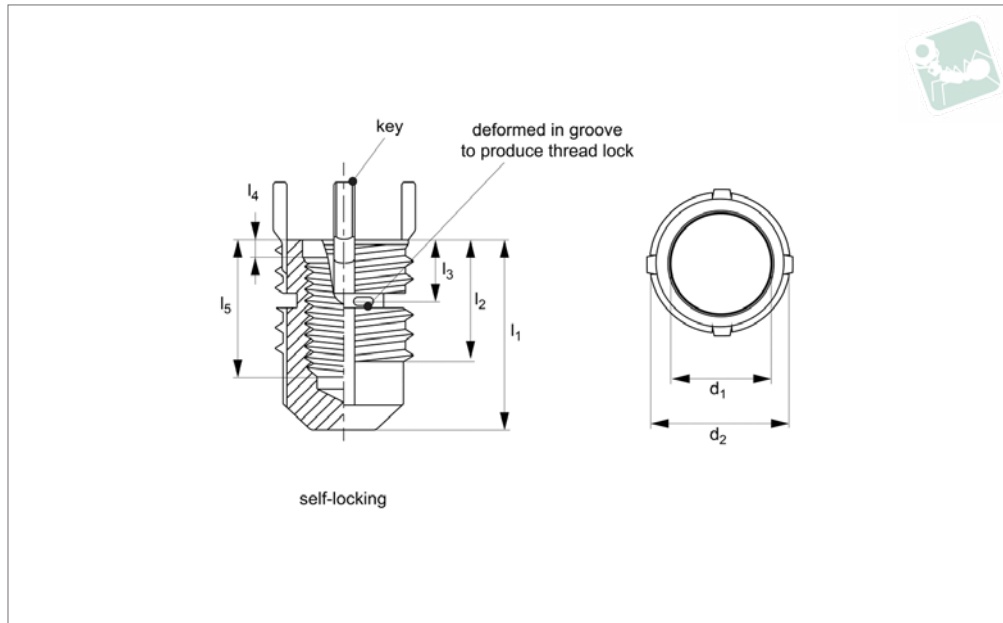
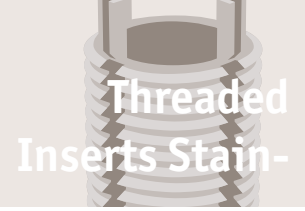
Order No.	Type	d ₁ tol. 3B	Thre ad type d ₁	d ₂ (mod.) class 2A	Thre ad type d ₂	Inst. tap drill size	l ₁	l ₂	l ₄ c'bore depth	l ₅	Inst. c'sink hole size +0.010 -0.000	Inst. thread tap depth min.	Inst. thread tap size class 2B	Inst. tool ref. TR1702	Removal drill depth	Remo val drill size
TR1672.83321	NL	10-24	UNC	5/16-18	UNC	.272	.50	.31	.07	.31	.323	.37	5/16-18	.0210	5/32	7/32
TR1672.83521	NL	10-32	UNF	5/16-18	UNC	.272	.50	.31	.07	.31	.323	.37	5/16-18	.0210	5/32	7/32
TR1672.83322	NL	1/4-20	UNC	3/8-16	UNC	.332	.62	.37	.07	.37	.385	.43	3/8-16	.0220	3/16	9/32
TR1672.83522	NL	1/4-28	UNF	3/8-16	UNC	.332	.62	.37	.07	.37	.385	.43	3/8-16	.0220	3/16	9/32
TR1672.83323	NL	5/16-18	UNC	7/16-14	UNC	.397	.75	.43	.07	.43	.447	.50	7/16-14	.0230	3/16	11/32
TR1672.83523	NL	5/16-18	UNF	7/16-14	UNC	.397	.75	.43	.07	.43	.447	.50	7/16-14	.0230	3/16	11/32
TR1672.83324	NL	3/8-16	UNC	1/2-13	UNC	.453	.81	.50	.07	.50	.510	.56	1/2-13	.0240	3/16	13/32
TR1672.83524	NL	3/8-24	UNF	1/2-13	UNC	.453	.81	.50	.07	.50	.510	.56	1/2-13	.0240	3/16	13/32
TR1672.83325	NL	7/16-14	UNC	9/16-12	UNC	.516	.87	.56	.07	.56	.572	.62	9/16-12	.0250	3/16	15/32



Order No.	Type	d ₁ tol. 3B	Thre ad type d ₁	d ₂ (mod.) class 2A	Thre ad type d ₂	Inst. tap drill size	l ₁	l ₂	l ₄ c'bore depth	l ₅	Inst. c'sink hole size +0.010 -0.000	Inst. thread tap depth min.	Inst. thread tap size class 2B	Inst. tool ref. TR1702	Removal drill depth	Remo val drill size
TR1672.83525	NL	7/ 16- 20	UNF	9/ 16- 12	UNC	.516	.87	.56	.07	.56	.572	.62	9/16-12	.0250	3/16	15/32
TR1672.83326	NL	1/2- 13	UNC	5/8- 11	UNC	.578	1.06	.62	.07	.62	.635	.68	5/8-11	.0260	3/16	17/32
TR1672.83526	NL	1/2- 20	UNF	5/8- 11	UNC	.578	1.06	.62	.07	.62	.635	.68	5/8-11	.0260	3/16	17/32



Blind Threaded Insert - Thinwall - 303 stainless steel - self-locking



TR1673

THREADED INSERTS STAINLESS

Material

Inserts - A303 CRES.
Keys - 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 -

0,234 to 0,500 = +0,004/-0,001
0,500 and over = +0,005/-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: MIL-I-45914A

Order No.	Type	d ₁ tol. 3B	Thre ad type d ₁	d ₂ (mod.) class 2A	Thre ad type d ₂	Inst. tap drill size	l ₁	l ₂	l ₃ ±0.0 30	l ₄ c'bore depth	l ₅	Inst. c'sink hole size +0.010 -0.000	Inst. thread tap depth min.	Inst. thread tap size class 2B	Inst. tool ref. TR1702	Removal drill depth	Rem oval drill size
TR1673.84321	SL	10-24	UNC	5/16-18	UNC	.272	.50	.31	.22	.07	.31	.323	.37	5/16-18	.0210	5/32	7/32
TR1673.84521	SL	10-32	UNF	5/16-18	UNC	.272	.50	.31	.22	.07	.31	.323	.37	5/16-18	.0210	5/32	7/32
TR1673.84322	SL	1/4-20	UNC	3/8-16	UNC	.332	.62	.37	.22	.07	.37	.385	.43	3/8-16	.0220	3/16	9/32
TR1673.84522	SL	1/4-28	UNF	3/8-16	UNC	.332	.62	.37	.22	.07	.37	.385	.43	3/8-16	.0220	3/16	9/32
TR1673.84323	SL	5/16-18	UNC	7/16-14	UNC	.397	.75	.43	.22	.07	.43	.447	.50	7/16-14	.0230	3/16	11/32
TR1673.84523	SL	5/16-18	UNF	7/16-14	UNC	.397	.75	.43	.22	.07	.43	.447	.50	7/16-14	.0230	3/16	11/32
TR1673.84324	SL	3/8-16	UNC	1/2-13	UNC	.453	.81	.50	.24	.07	.50	.510	.56	1/2-13	.0240	3/16	13/32
TR1673.84524	SL	3/8-24	UNF	1/2-13	UNC	.453	.81	.50	.24	.07	.50	.510	.56	1/2-13	.0240	3/16	13/32
TR1673.84325	SL	7/16-14	UNC	9/16-12	UNC	.516	.87	.56	.27	.07	.56	.572	.62	9/16-12	.0250	3/16	15/32



Order No.	Type	d ₁ tol. 3B	Thre ad type d ₁	d ₂ (mod.) class 2A	Thre ad type d ₂	Inst. tap drill size	l ₁	l ₂	l ₃ ±0.0 30	l ₄ c'bore depth	l ₅	Inst. c'sink hole size +0.010 -0.000	Inst. thread tap depth min.	Inst. thread tap size class 2B	Inst. tool ref. TR1702	Removal drill depth	Rem oval drill size
TR1673.84525	SL	7/ 16- 20	UNF	9/ 16- 12	UNC	.516	.87	.56	.27	.07	.56	.572	.62	9/16- 12	.0250	3/16	15/ 32
TR1673.84326	SL	1/2- 13	UNC	5/8- 11	UNC	.578	1.06	.62	.28	.07	.62	.635	.68	5/8-11	.0260	3/16	17/ 32
TR1673.84526	SL	1/2- 20	UNF	5/8- 11	UNC	.578	1.06	.62	.28	.07	.62	.635	.68	5/8-11	.0260	3/16	17/ 32