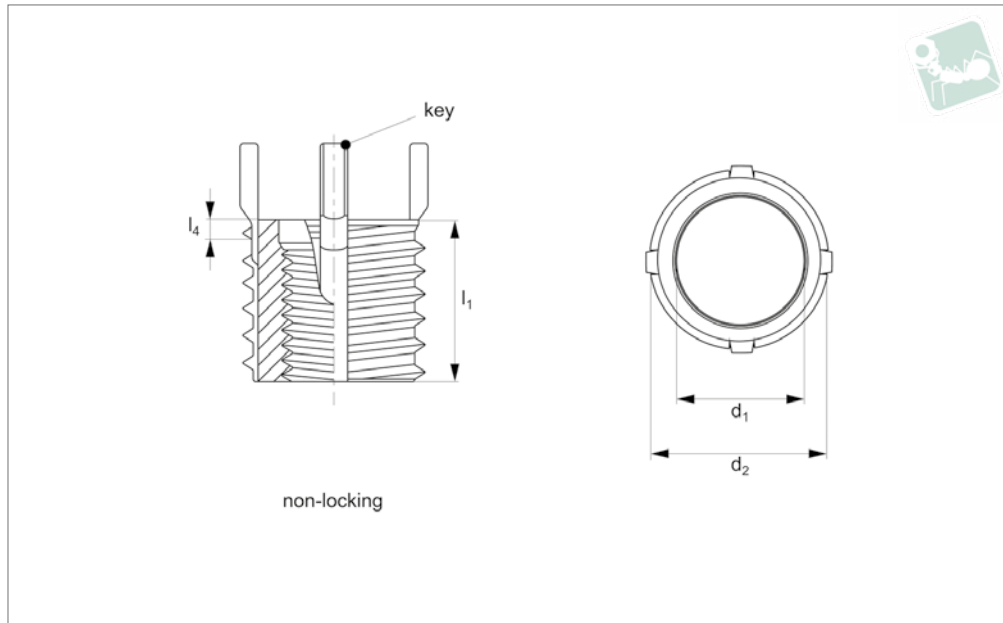
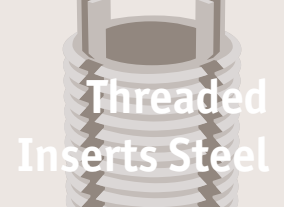




Threaded Insert MS/NAS - L Duty - 4140 steel - non-locking - MS/NAS grade



TR1608

THREADED INSERTS STEEL

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 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.
Perform to standards: NA0148

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. TI1712	Removal drill depth	Removal drill size
TR1608.80351	NL	M 5x0,8	Coarse	M 8x1,25	Coarse	6,90	8,0	1,27	8,25	M 8x1,25	9,5	.0510	4,00	5,50
TR1608.80551	NL	M 5x0,5	Fine	M 8x1,25	Coarse	6,90	8,0	1,27	8,25	M 8x1,25	9,5	.0510	4,00	5,50
TR1608.80352	NL	M 6x1,0	Coarse	M10x1,25	Fine	8,80	10,0	1,78	10,25	M10x1,25	11,5	.0520	4,75	7,50
TR1608.80552	NL	M 6x0,75	Fine	M10x1,25	Fine	8,80	10,0	1,78	10,25	M10x1,25	11,5	.0520	4,75	7,50
TR1608.80353	NL	M 8x1,25	Coarse	M12x1,25	Fine	10,80	12,0	1,78	12,25	M12x1,25	13,5	.0530	4,75	9,50
TR1608.80553	NL	M 8x1,0	Fine	M12x1,25	Fine	10,80	12,0	1,78	12,25	M12x1,25	13,5	.0530	4,75	9,50
TR1608.80355	NL	M10x1,5	Coarse	M14x1,5	Fine	12,80	14,0	2,29	14,25	M14x1,5	15,5	.0550	4,75	11,50
TR1608.80555	NL	M10x1,25	Fine	M14x1,5	Fine	12,80	14,0	2,29	14,25	M14x1,5	15,5	.0550	4,75	11,50
TR1608.80356	NL	M12x1,75	Coarse	M16x1,5	Fine	14,75	16,0	2,29	16,25	M16x1,5	17,5	.0560	4,75	13,50
TR1608.80556	NL	M12x1,25	Fine	M16x1,5	Fine	14,75	16,0	2,29	16,25	M16x1,5	17,5	.0560	4,75	13,50