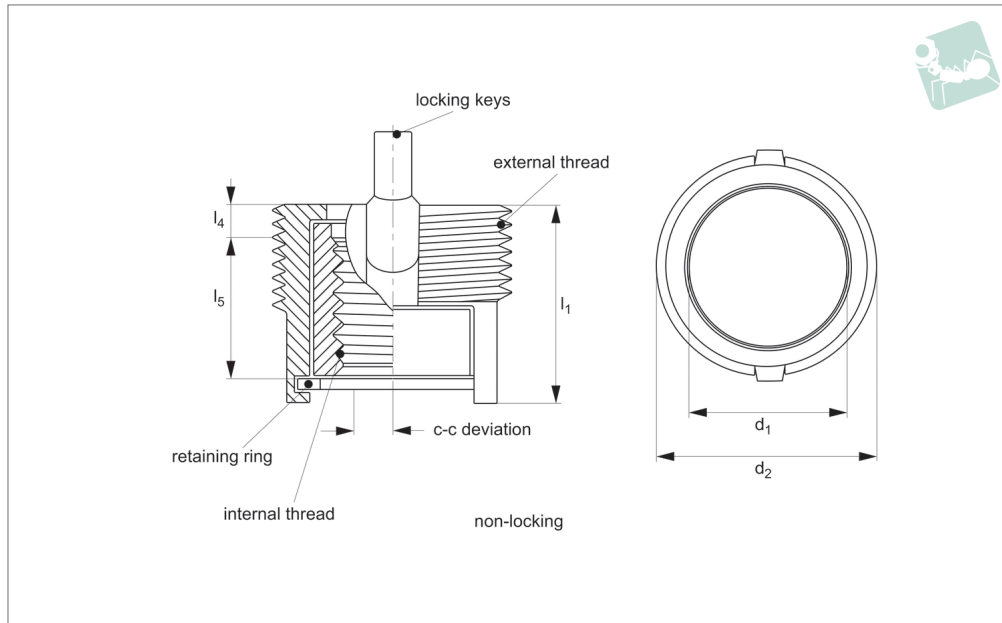
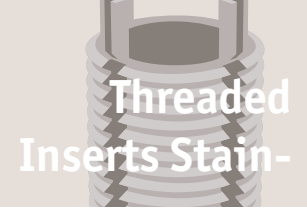




Floating Threaded Insert - Mini - Inch

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.

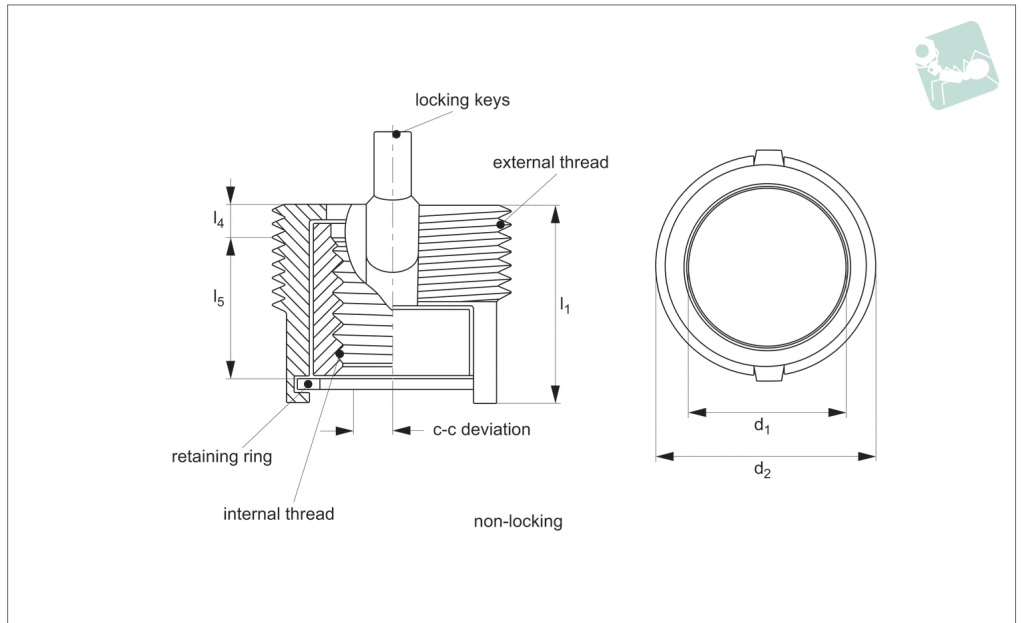
Important Notes

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 | Thre ad type d ₁ | l ₁ ±0.0 15 | d ₂ tol. 2A | Thre ad type d ₂ | l ₄ | l ₅ | c-c float min. | Inst. c'sink dia. +0.0 10 - 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

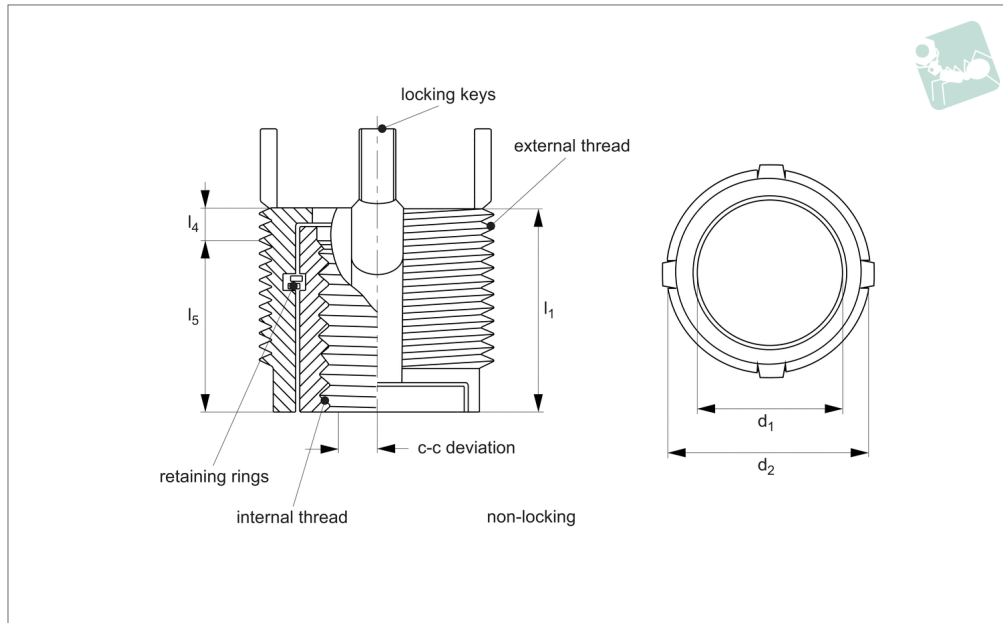
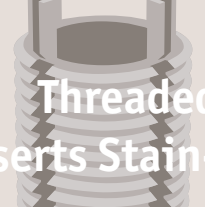
Four locking keys on internal threads 5/16 and over. Two locking keys on internal threads smaller than 5/16.
 Installation (Inst.) drill size, counter sink, thread tap and thread depth as specified in table.
 Removal (Rem.) drill size and drill depth as specified in table.
 Perform to standards

| Order No. | Type | d ₁ tol. 3B | Thre ad type d ₁ | l ₁ ±0.0 15 | d ₂ tol. 2A | Thre ad type d ₂ | l ₄ | l ₅ | c-c float min. | Inst. c'sink dia. +0.0 10 -0.000 | Inst. drill size | Inst. tap 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

Threaded
Inserts Stain-



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 | Thre ad type d ₁ | l ₁ ±0.0 15 | d ₂ (mod.) class 2A | Thre ad type d ₂ | l ₄ | l ₅ | c-c float min. | Inst. c'sink dia. +0.0 10 - 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 |
|--------------|------|---------------------------|-----------------------------------|------------------------------|---|-----------------------------------|----------------|----------------|----------------------|---|-------------------------|-----------------------------------|--------------------------------------|---------------------------|-----------------------|------------------------|
| 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 |

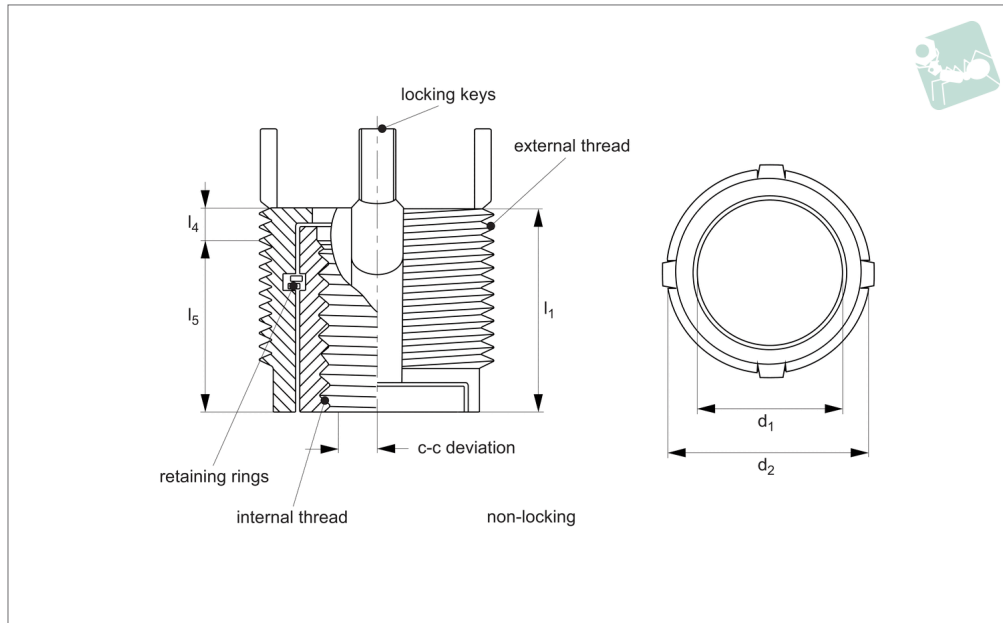
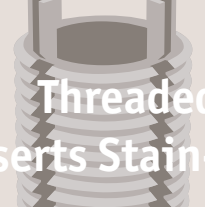


| Order No. | Type | d ₁ tol. 3B | Thre ad type d ₁ | l ₁ ±0.0 15 | d ₂ (mod.) class 2A | Thre ad type d ₂ | l ₄ | l ₅ | c-c float min. | Inst. c'sink dia. +0.0 10 - 0.000 | Inst. tap drill size | Inst. thread tap depth min. | Inst. thread tap size class 2B | Inst. tool ref. TR1725 | Removal drill size | Removal drill depth |
|---------------------|------|---------------------------|--------------------------------------|------------------------------|---|--------------------------------------|----------------|----------------|----------------------|--|-------------------------|-----------------------------------|---|---------------------------|-----------------------|------------------------|
| 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 | 1.02 0 | ,937 | ,65 | 1-12 | .0060 | 27/32 | 5/16 |
| TR1685.89406 | NL | 1/2- 20 | UNF | ,73 | 1-12 | UNF | ,23 | ,50 | ,040 | 1.02 0 | ,937 | ,65 | 1-12 | .0060 | 27/32 | 5/16 |



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

Threaded
Inserts Stain-



TR1686

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

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 | Thre ad type d ₁ | l ₁ ±0.0 15 | d ₂ (mod.) class 2A | Thre ad type d ₂ | l ₄ | l ₅ | c-c float min. | Inst. c'sink dia. +0.0 10 - 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 |



| Order No. | Type | d ₁ tol. 3B | Thre ad type d ₁ | l ₁ ±0.0 15 | d ₂ (mod.) class 2A | Thre ad type d ₂ | l ₄ | l ₅ | c-c float min. | Inst. c'sink dia. +0.0 10 - 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 |
|---------------------|------|---------------------------|--------------------------------------|------------------------------|---|--------------------------------------|----------------|----------------|----------------------|--|-------------------------|-----------------------------------|---|---------------------------|-----------------------|------------------------|
| TR1686.89605 | 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 | 1.02 0 | ,937 | ,65 | 1-12 | .0060 | 27/32 | 5/16 |
| TR1686.89606 | SL | 1/2- 20 | UNF | ,73 | 1-12 | UNF | ,23 | ,50 | ,040 | 1.02 0 | ,937 | ,65 | 1-12 | .0060 | 27/32 | 5/16 |