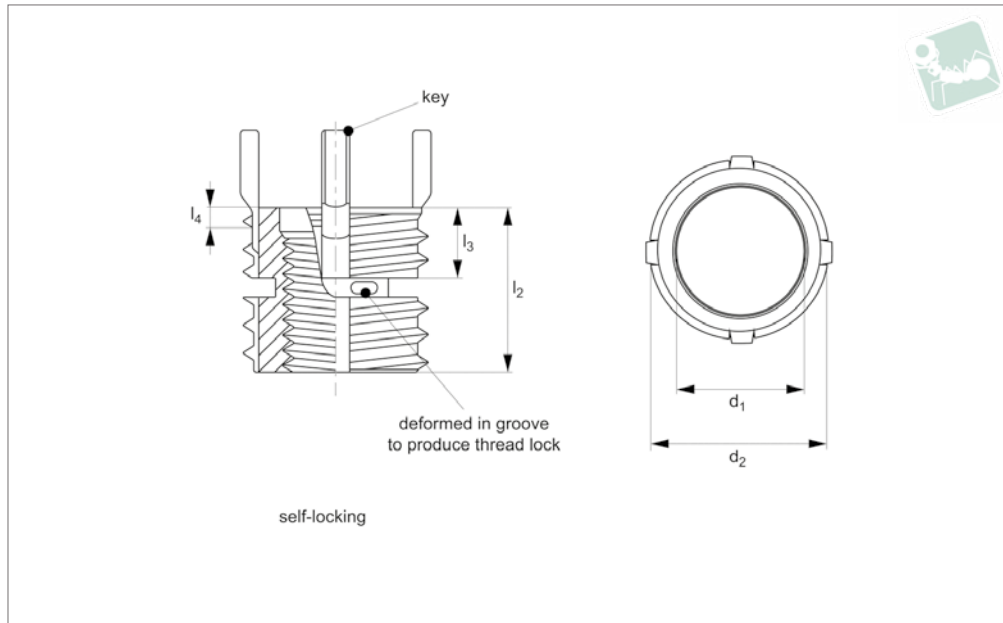
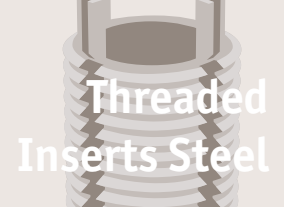




Threaded Insert MS/NAS - L Duty - 4140 steel - self-locking - MS/NAS grade



TR1609

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

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.
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
TR1609.81351	SL	M 5x0,8	Coarse	M 8x1,25	Coarse	6.90	8.0
TR1609.81551	SL	M 5x0,5	Fine	M 8x1,25	Coarse	6.90	8.0
TR1609.81352	SL	M 6x1,0	Coarse	M10x1,25	Fine	8.80	10.0
TR1609.81552	SL	M 6x0,75	Fine	M10x1,25	Fine	8.80	10.0
TR1609.81353	SL	M 8x1,25	Coarse	M12x1,25	Fine	10.80	12.0
TR1609.81553	SL	M 8x1,0	Fine	M12x1,25	Fine	10.80	12.0
TR1609.81355	SL	M10x1,5	Coarse	M14x1,5	Fine	12.80	14.0
TR1609.81555	SL	M10x1,25	Fine	M14x1,5	Fine	12.80	14.0
TR1609.81356	SL	M12x1,75	Coarse	M16x1,5	Fine	14.75	16.0
TR1609.81556	SL	M12x1,25	Fine	M16x1,5	Fine	14.75	16.0

Order No.	l ₃ ±0.76	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. T11712	Removal drill depth	Removal drill size
TR1609.81351	3.73	1.27	8.25	M 8x1,25	9.5	.0510	4.00	5.50
TR1609.81551	3.73	1.27	8.25	M 8x1,25	9.5	.0510	4.00	5.50
TR1609.81352	6.02	1.78	10.25	M10x1,25	11.5	.0520	4.75	7.50
TR1609.81552	6.02	1.78	10.25	M10x1,25	11.5	.0520	4.75	7.50
TR1609.81353	6.28	1.78	12.25	M12x1,25	13.5	.0530	4.75	9.50
TR1609.81553	6.28	1.78	12.25	M12x1,25	13.5	.0530	4.75	9.50
TR1609.81355	6.46	2.29	14.25	M14x1,5	15.5	.0550	4.75	11.50
TR1609.81555	6.46	2.29	14.25	M14x1,5	15.5	.0550	4.75	11.50
TR1609.81356	6.46	2.29	16.25	M16x1,5	17.5	.0560	4.75	13.50
TR1609.81556	6.46	2.29	16.25	M16x1,5	17.5	.0560	4.75	13.50