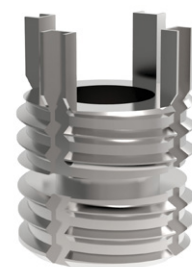
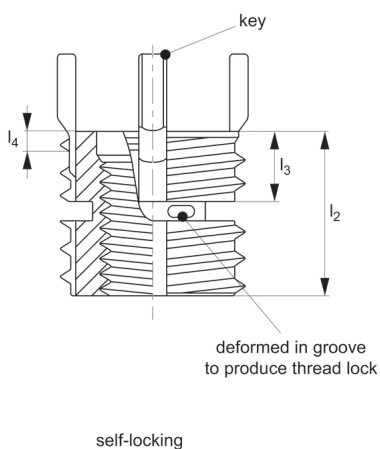




Threaded Insert MS/NAS - Thinwall - 303 stainless steel - self-locking - MS/NAS grade

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	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
TR1653.77321	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



Teknipart
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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
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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