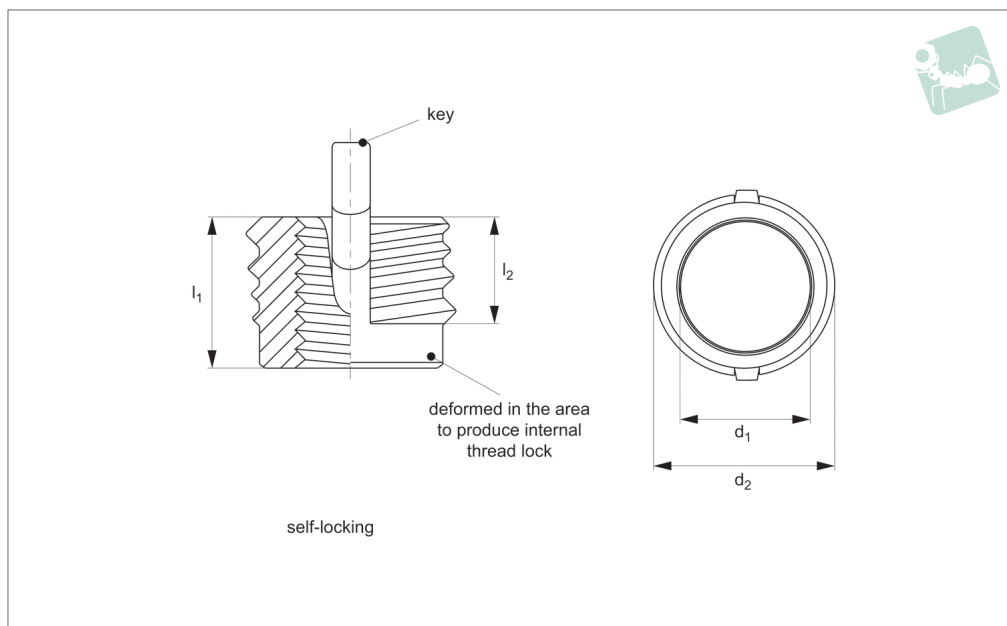




# Threaded Insert MS/NAS - Mini - Inch

4140 steel - self-locking - MS/NAS grade

Threaded  
Inserts Steel



**TR1661**

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 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)

| Order No.           | Type | d <sub>1</sub><br>class<br>3B | Thread<br>type d <sub>1</sub> | d <sub>2</sub><br>class 2A | Thread<br>type d <sub>2</sub> | l <sub>1</sub> | l <sub>2</sub> thread<br>length | Inst.<br>c'sink<br>hole size<br>+0.010 -<br>0.000 | Inst. tap<br>drill<br>size<br>+0.003<br> -0.001 | Inst.<br>thread<br>tap depth<br>min. | Inst.<br>thread<br>tap size<br>class 2B | Inst. tool<br>ref.<br>TR1700 | Removal<br>drill size | Removal<br>drill depth |
|---------------------|------|-------------------------------|-------------------------------|----------------------------|-------------------------------|----------------|---------------------------------|---|---|--------------------------------------|---|------------------------------|-----------------------|------------------------|
| <b>TR1661.81283</b> | SL   | 2-56                          | UNC                           | 8-32                       | UNC                           | ,120           | ,90                             | ,166  | ,134  | ,140                                 | 8-32                                    | .0830                        | #33                   | 1/16                   |
| <b>TR1661.81284</b> | SL   | 4-40                          | UNC                           | 10-32                      | UNF                           | ,170           | ,125                            | ,194  | ,161  | ,160                                 | 10-32                                   | .0840                        | #29                   | 3/32                   |
| <b>TR1661.81285</b> | SL   | 6-32                          | UNC                           | 12-28                      | UNF                           | ,170           | ,125                            | ,220  | ,187  | ,160                                 | 2-28                                    | .0850                        | #21                   | 3/32                   |
| <b>TR1661.81286</b> | SL   | 8-32                          | UNC                           | 1/4-28*                    | UNF                           | ,220           | ,175                            | ,255  | ,228  | ,210                                 | 1/4-28                                  | .0860                        | # 8                   | 1/8                    |



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