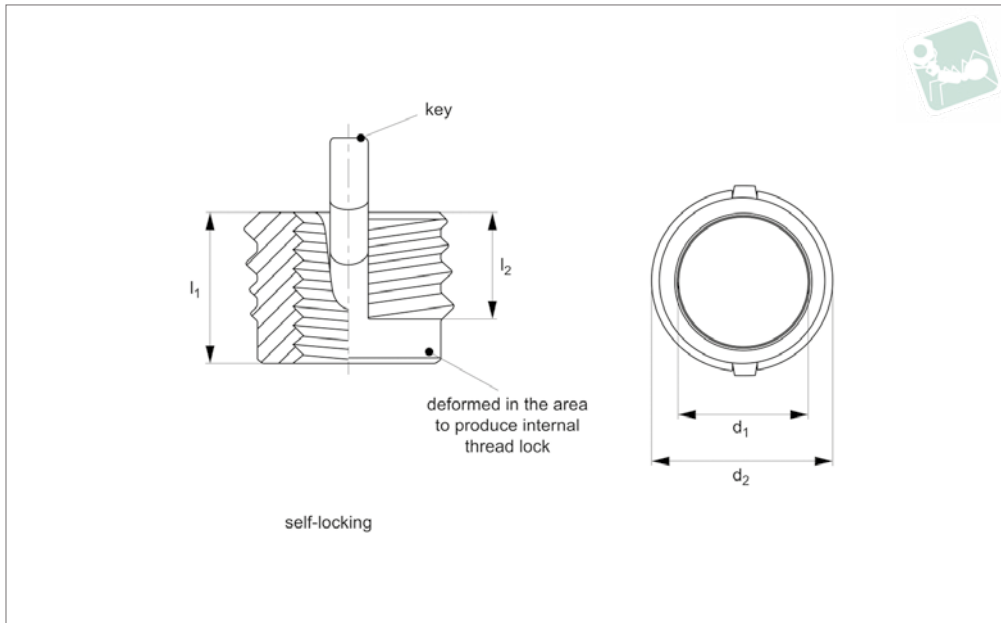
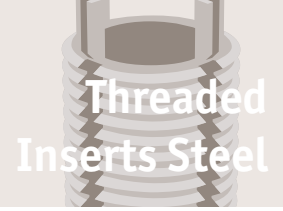




# Threaded Insert MS/NAS - Mini - 4140 steel - self-locking - MS/NAS grade



**TR1607**

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 M6 and over. Two locking keys on internal threads smaller than M6.  
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 <sub>1</sub> tol. 4H 6H	Thread type d <sub>1</sub>	d <sub>2</sub> tol. 4h	Thread type d <sub>2</sub>	l <sub>1</sub>	l <sub>2</sub>	Inst. c'sink hole size +0.25 - 0.00	Inst. tap drill size +0.080  -0.025	Inst. thread tap tol. 6H	Inst. thread tap depth min.	Inst. tool ref. TR1710	Removal drill size	Removal drill depth
<b>TR1607.81382</b>	SL	M 2x0,4	Coarse	M 4x0,7	Coarse	3,00	2,20	4,1	3,4	M 4x0,7	4,0	.0820	2,8	2,00
<b>TR1607.81383</b>	SL	M2,5x0,45	Coarse	M4,5x0,75	Coarse	3,81	2,70	4,6	3,9	M4,5x0,75	5,0	.0830	3,0	2,00
<b>TR1607.81384</b>	SL	M 3x0,5	Coarse	M 5x0,8	Coarse	4,25	3,10	5,1	4,4	M 5x0,8	5,5	.0840	3,5	2,25
<b>TR1607.81386</b>	SL	M 4x0,7	Coarse	M 6x0,75	Fine	5,25	4,11	6,1	5,5	M 6x0,75	6,5	.0860	4,6	2,50