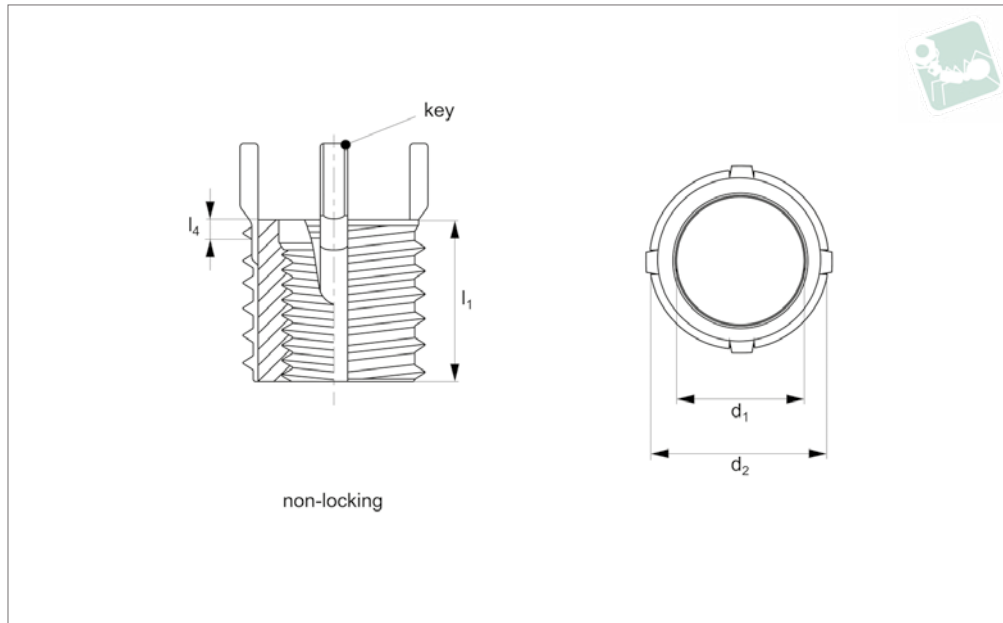
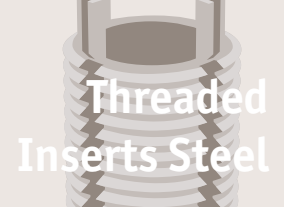




Threaded Insert MS/NAS - H Duty - 4140 steel - non-locking - MS/NAS grade



TR1610

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
NL = Non-Locking type.

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: NA0150

Order No.	Type	d ₁ tol. 4H 5H	Thread type d ₁	d ₂ tol. 4h	Thread type d ₂	l ₁	l ₄ c'bore depth	C'sink hole size +0.25 - 0.00	Inst. tap drill size	Inst. thread tap tol. 6H	Inst. thread tap depth min.	Inst. tool ref. TR1715	Removal drill size	Removal drill size
TR1610.80363	NL	M 4x0,7	Coarse	M 8x1,25	Coarse	8,0	1,27	8,25	6,90	M 8x1,25	9,5	.0630	5,50	5,50
TR1610.80364	NL	M 5x0,8	Coarse	M10x1,25	Fine	10,0	1,27	10,25	8,80	M10x1,25	12,5	.0640	7,50	7,50
TR1610.80365	NL	M 6x1,0	Coarse	M12x1,25	Fine	12,0	1,78	12,25	10,80	M12x1,25	14,5	.0650	9,50	9,50
TR1610.80366	NL	M 8x1,25	Coarse	M14x1,5	Fine	14,0	1,78	14,25	12,80	M14x1,5	16,5	.0660	11,50	11,50
TR1610.80566	NL	M 8x1,0	Fine	M14x1,5	Fine	14,0	1,78	14,25	12,80	M14x1,5	16,5	.0660	11,50	11,50
TR1610.80367	NL	M10x1,5	Coarse	M16x1,5	Fine	16,0	2,29	16,25	14,75	M16x1,5	18,5	.0670	13,50	13,50
TR1610.80567	NL	M10x1,25	Fine	M16x1,5	Fine	16,0	2,29	16,25	14,75	M16x1,5	18,5	.0670	13,50	13,50
TR1610.80369	NL	M12x1,75	Coarse	M18x1,5	Coarse	18,0	2,29	18,25	16,75	M18x1,5	20,5	.0690	15,50	15,50
TR1610.80569	NL	M12x1,25	Fine	M18x1,5	Coarse	18,0	2,29	18,25	16,75	M18x1,5	20,5	.0690	15,50	15,50
TR1610.80370	NL	M14x2,0	Coarse	M20x1,5	Fine	20,0	2,79	20,25	18,75	M20x1,5	22,5	.0700	17,50	17,50
TR1610.80570	NL	M14x1,5	Fine	M20x1,5	Fine	20,0	2,79	20,25	18,75	M20x1,5	22,5	.0700	17,50	17,50
TR1610.80371	NL	M16x2,0	Coarse	M22x1,5	Fine	22,0	2,79	22,25	20,50	M22x1,5	24,5	.0710	17,75	17,75
TR1610.80571	NL	M16x1,5	Fine	M22x1,5	Fine	22,0	2,79	22,25	20,50	M22x1,5	24,5	.0710	17,75	17,75
TR1610.80572	NL	M18x1,5	Coarse	M24x2,0	Fine	24,0	2,79	24,25	22,50	M 24x2,0	28,5	.0720	19,75	19,75
TR1610.80373	NL	M20x2,5	Coarse	M30x2,0	Fine	30,0	2,79	30,25	28,00	M30x2,0	34,5	.0730	25,75	25,75
TR1610.80573	NL	M20x1,5	Fine	M30x2,0	Fine	30,0	2,79	30,25	28,00	M30x2,0	34,5	.0730	25,75	25,75
TR1610.80574	NL	M22x1,5	Fine	M32x2,0	Non-Std	32,0	2,79	32,25	30,00	M32x2,0	36,5	.0740	27,75	27,75
TR1610.80375	NL	M24x3,0	Coarse	M33x2,0	Non-Std	33,0	3,81	33,25	31,00	M33x2,0	37,5	.0750	28,75	28,75
TR1610.80575	NL	M24x2,0	Fine	M33x2,0	Non-Std	33,0	3,81	33,25	31,00	M33x2,0	37,5	.0750	28,75	28,75