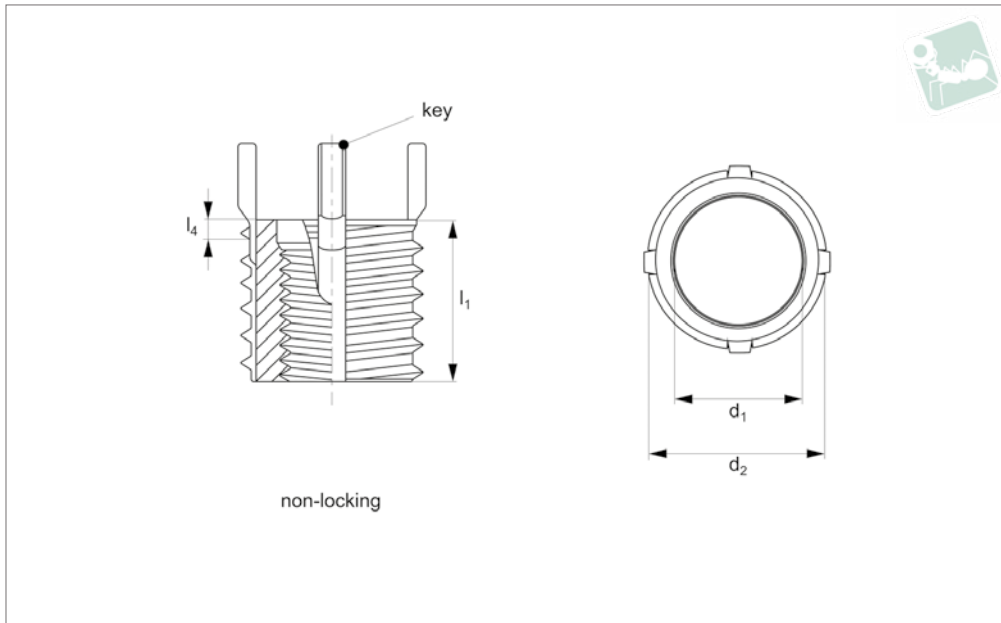
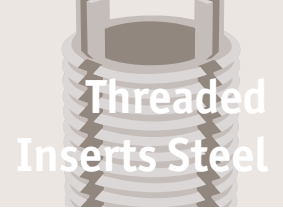




# Threaded Insert MS/NAS - Extra H

4140 steel - non-locking - MS/NAS grade



## TR1666

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 lubricatoin 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  
**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 1/4

and over. Two locking keys on internal threads smaller than 1/4.  
 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 (MS51832)

Order No.	Type	d <sub>1</sub> class 3B	Thread type d <sub>1</sub>	d <sub>2</sub> (mod.) class 2A	Thread type d <sub>2</sub>	l <sub>1</sub>	l <sub>4</sub>	Inst. c'bore depth	Inst. c'sink hole size +0.010 - 0.000	Inst. tap drill size	Inst. thread tap depth min.	Inst. thread tap size class 2B	Inst. tool ref. TR1706	Removal drill size	Removal drill depth
TR1666.80333	NL	10-24	UNC	7/16-14	UNC	,312	,07	,447	,397	,37	,37	7/16-14	.0330	11/32	3/16
TR1666.80533	NL	10-32	UNF	7/16-14	UNC	,312	,07	,447	,397	,37	,37	7/16-14	.0331	11/32	3/16
TR1666.80334	NL	1/4-20	UNC	1/2-13	UNC	,375	,07	,510	,453	,44	,44	1/2-13	.0340	13/32	3/16
TR1666.80534	NL	1/4-28	UNF	1/2-13	UNC	,375	,07	,510	,453	,44	,44	1/2-13	.0341	13/32	3/16
TR1666.80335	NL	5/16-18	UNC	9/16-12	UNC	,437	,07	,572	,516	,50	,50	9/16-12	.0350	15/32	3/16
TR1666.80535	NL	5/16-24	UNF	9/16-12	UNC	,437	,07	,572	,516	,50	,50	9/16-12	.0351	15/32	3/16
TR1666.80336	NL	3/8-16	UNC	5/8-11	UNC	,500	,07	,635	,578	,56	,56	5/8-11	.0360	17/32	3/16
TR1666.80536	NL	3/8-24	UNF	5/8-11	UNC	,500	,07	,635	,578	,56	,56	5/8-11	.0361	17/32	3/16
TR1666.80337	NL	7/16-14	UNC	11/16-11NS	UNS	,625	,10	,700	,641	,68	,68	11/16-11NS	.0370	19/32	3/16
TR1666.80537	NL	7/16-20	UNF	11/16-11NS	UNS	,625	,10	,700	,641	,68	,68	11/16-11NS	.0371	19/32	3/16
TR1666.80338	NL	1/2-13	UNC	13/16-16	UN	,688	,10	,822	,766	,75	,75	13/16-16	.0380	23/32	3/16
TR1666.80538	NL	1/2-20	UNF	13/16-16	UN	,688	,10	,822	,766	,75	,75	13/16-16	.0381	23/32	3/16
TR1666.80339	NL	9/16-12	UNC	7/8-14	UNF	,812	,10	,885	,828	,94	,94	7/8-14	.0390	25/32	3/16
TR1666.80539	NL	9/16-18	UNF	7/8-14	UNF	,812	,10	,885	,828	,94	,94	7/8-14	.0391	25/32	3/16
TR1666.80340	NL	5/8-11	UNC	1"-12	UNF	,875	,10	1,020	,937	1,00	1,00	1"-12	.0400	27/32	3/16
TR1666.80540	NL	5/8-18	UNF	1"-12	UNF	,875	,10	1,020	,937	1,00	1,00	1"-12	.0401	27/32	5/16
TR1666.80341	NL	3/4-10	UNC	1-1/4-12	UNF	1,125	,10	1,270	1,187	1,31	1,31	1-1/4-12	.0410	1-3/32	5/16
TR1666.80541	NL	3/4-16	UNF	1-1/4-12	UNF	1,125	,10	1,270	1,187	1,31	1,31	1-1/4-12	.0411	1-3/32	5/16
TR1666.80342	NL	7/8-9	UNC	1-3/8-12	UNF	1,250	,10	1,395	1,312	1,44	1,44	1-3/8-12	.0420	1-7/32	5/16
TR1666.80542	NL	7/8-14	UNF	1-3/8-12	UNF	1,250	,10	1,395	1,312	1,44	1,44	1-3/8-12	.0421	1-7/32	5/16
TR1666.80343	NL	1-8	UNC	1-1/2-12	UNF	1,375	,10	1,520	1,437	1,56	1,56	1-1/2-12	.0430	1-11/32	5/16
TR1666.80543	NL	1-12	UNF	1-1/2-12	UNF	1,375	,10	1,520	1,437	1,56	1,56	1-1/2-12	.0431	1-11/32	5/16