

Specific Use - Blind End Keylocking Threaded Inserts



Material: Inserts - 303 CRES
Keys - 302 CRES

Finish: Passivated

Tolerances: $\pm .010$ inch unless specified otherwise.

Internal Threads: Per SAE AS8879

Dimensions: All dimensions below are in inches

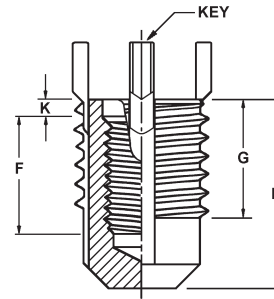
Keys: Inserts with an internal thread size of 5/16 and larger are furnished with 4 locking keys. Smaller sizes have 2 locking keys.

Material Identification Mark: None

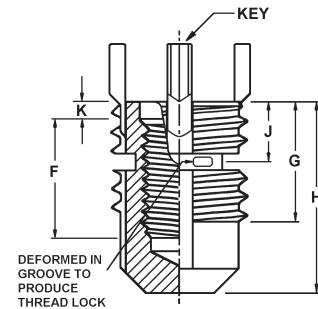
Lubrication: Dry Film Lube on Self-Locking Inserts only

Performance: MIL-I-45914A

Non-Locking



Self-Locking



Miniature - Inch

PART NUMBER*		INSERT							INSTALLATION					REMOVAL	
Non-Lock	Self-Lock	Internal Thread Class 3B	External Thread Class 2A	F Int Thd (min)	G Ext Thd	H Lgth	J $\pm .030$	K C'Bore Depth	Install Tool Part No.*	Tap Drill Size ¹	C'Sink Dia. $+.010$ $-.000$	Thread Tap		Drill	
												Size Class 2B	Min. Depth	Size	Depth
83290	84290	2 - 56	8 - 32	.13	.18	.24	.10	C'Sink	72552	.134	.166	8 - 32	.24	#33	1/16
83291	84291	4 - 40	10 - 32	.17	.22	.31	.12	C'Sink	72554	.161	.194	10 - 32	.28	#29	3/32
83292	84292	6 - 32	12 - 28	.21	.22	.39	.12	C'Sink	72556	.187	.220	12 - 28	.28	#21	3/32
83294	84294	8 - 32	1/4 - 28 [†]	.25	.24	.43	.13	C'Sink	72558	.228	.255	1/4 - 28	.30	#8	3/32

* To complete the abbreviated Insert part numbers in the table above use the prefix "218-0". Install Tools use "217-0".

[†] Modified Minor Diameter

¹ Tap Drill Hole Tolerance: .130 to .233 = $+.003/-0.001$

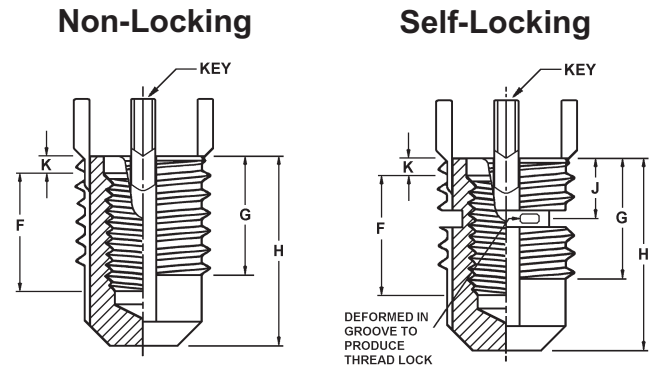
Lightweight - Inch

PART NUMBER*		INSERT							INSTALLATION					REMOVAL	
Non-Lock	Self-Lock	Internal Thread Class 3B	External Thread (Mod.) Class 2A	F Int Thd (min)	G Ext Thd	H Lgth	J $\pm .030$	K C'Bore Depth	Install Tool Part No.*	Tap Drill Size ¹	C'Sink Dia. $+.010$ $-.000$	Thread Tap		Drill	
												Size Class 2B	Min. Depth	Size	Depth
83321	84321	10 - 24	5/16 - 18	.31	.31	.50	.22	.07	72568	.272	.323	5/16 - 18	.37	7/32	5/32
83521	84521	10 - 32													
83322	84322	1/4 - 20	3/8 - 16	.37	.37	.62	.22	.07	72570	.332	.385	3/8 - 16	.43	9/32	3/16
83522	84522	1/4 - 28													
83323	84323	5/16 - 18	7/16 - 14	.43	.43	.75	.22	.07	72572	.397	.447	7/16 - 14	.50	11/32	3/16
83523	84523	5/16 - 24													
83324	84324	3/8 - 16	1/2 - 13	.50	.50	.81	.24	.07	72574	.453	.510	1/2 - 13	.56	13/32	3/16
83524	84524	3/8 - 24													
83325	84325	7/16 - 14	9/16 - 12	.56	.56	.87	.27	.07	72576	.516	.572	9/16 - 12	.62	15/32	3/16
83525	84525	7/16 - 20													
83326	84326	1/2 - 13	5/8 - 11	.62	.62	1.06	.28	.07	72578	.578	.635	5/8 - 11	.68	17/32	3/16
83526	84526	1/2 - 20													

* To complete the abbreviated Insert part numbers in the table above use the prefix "218-0". Install Tools use "217-0".

¹ Tap Drill Hole Tolerance: .234 to .500 = $+.004/-0.001$
Over .500 = $+.005/-0.001$

Material: Inserts - 303 CRES
 Keys - 302 CRES
 Finish: Passivated
 Tolerances: ±.010 inch unless specified otherwise.
 Internal Threads: Per SAE AS8879
 Dimensions: All dimensions below are in inches
 Keys: Inserts with an internal thread size of 5/16 and larger are furnished with 4 locking keys. Smaller sizes have 2 locking keys.
 Material Identification Mark: None
 Lubrication: Dry Film Lube on Self-Locking Inserts only
 Performance: MIL-I-45914A



Heavy Duty - Inch

PART NUMBER*		INSERT							INSTALLATION				REMOVAL		
Non-Lock	Self-Lock	Internal Thread Class 3B	External Thread (Mod.) Class 2A	F Int. Thd (min)	G Ext Thd	H Lgth	J ±.030	K C'Bore Depth	Install Tool Part No.*	Tap Drill Size ¹	C'Sink Dia. +.010 -0.000	Thread Tap		Drill	
												Size Class 2B	Min. Depth	Size	Depth
83300	84300	8 - 32	5/16 - 18	.31	.31	.50	.22	.04	72590	.272	.323	5/16 - 18	.37	7/32	1/8
83301	84301	10 - 24	3/8 - 16	.31	.31	.56	.22	.07	72591	.332	.385	3/8 - 16	.37	9/32	1/8
83501	84501	10 - 32													
83302	84302	1/4 - 20	7/16 - 14	.37	.37	.62	.22	.07	72593	.397	.447	7/16 - 14	.43	11/32	3/16
83502	84502	1/4 - 28													
83303	84303	5/16 - 18	1/2 - 13	.43	.43	.75	.22	.07	72595	.453	.510	1/2 - 13	.50	13/32	3/16
83503	84503	5/16 - 24													
83304	84304	3/8 - 16	9/16 - 12	.50	.50	.81	.25	.07	72597	.516	.572	9/16 - 12	.56	15/32	3/16
83504	84504	3/8 - 24													
83305	84305	7/16 - 14	5/8 - 11	.62	.62	1.00	.28	.10	72599	.578	.635	5/8 - 11	.68	17/32	3/16
83505	84505	7/16 - 20													
83306	84306	1/2 - 13	11/16 - 11 NS	.68	.68	1.06	.28	.10	72601	.641	.700	11/16 - 11 NS	.75	19/32	3/16
83506	84506	1/2 - 20													
83307	84307	9/16 - 12	13/16 - 16	.81	.81	1.25	.32	.10	72603	.766	.822	13/16-16	.94	23/32	3/16
83507	84507	9/16 - 18													
83308	84308	5/8 - 11	7/8-14	.87	.87	1.31	.33	.10	72605	.828	.885	7/8 - 14	1.00	25/32	3/16
83508	84508	5/8 - 18													
83309	84309	3/4 - 10	1-1/8 - 12	1.25	1.25	1.75	.49	.10	72607	1.062	1.145	1-1/8 - 12	1.44	31/32	5/16
83509	84509	3/4 - 16													
83310	84310	7/8 - 9	1-1/4 - 12	1.37	1.37	1.94	.49	.10	72609	1.187	1.270	1-1/4 - 12	1.56	1-3/32	5/16
83510	84510	7/8 - 14													
83311	84311	1" - 8	1-3/8 - 12	1.50	1.50	2.12	.55	.10	72611	1.312	1.395	1-3/8 - 12	1.68	1-7/32	5/16
83511	84511	1" - 12													

* To complete the abbreviated Insert part numbers in the table above use the prefix "218-0". Install Tools use "217-0".

¹ Tap Drill Hole Tolerance: .234 to .500 = +.004/-0.001
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