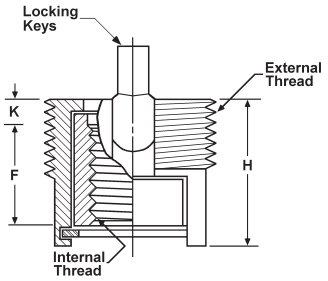
Specific Use - Floating Keylocking Threaded Inserts

Material: Inserts - 303 CRES
Keys and Retaining Ring - 302 CRES
Finish: Passivated
Tolerances: ±.010 inch unless specified otherwise
Internal Threads: Per SAE AS8879
Dimensions: All dimensions below are in inches
Keys: Miniature Inserts are furnished with 2 locking keys
Material Identification Mark: None
Lubrication: Dry Film Lube on Self-Locking Inserts only



Miniature - Inch

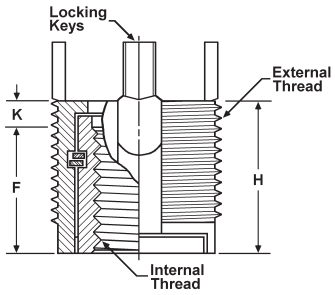
PART NUMBER*		INSERT						INSTALLATION					REMOVAL	
Non-Lock	Self-Lock	Internal Thread Class 3B	External Thread Class 2A	**F** Internal Thd Lgth	**H** Lgth ±015	**K** Dist. to 1st Thd (Approx)	Min. C - C Float	Install Tool Part No.*	Tap Drill Size[1]	C'Sink Dia. +.010 -.000	Thread Tap Size Class 2B	Thread Tap Min. Depth	Drill Size	Drill Depth
87283	87583	2 - 56	1/4 - 28†	.10	.19	.05	.015	82931	.228	.250	1/4 - 28	.12	#8	3/32
87284	87584	4 - 40	5/16 - 24	.21	.32	.07	.020	82932	.272	.323	5/16 - 24	.31	7/32	1/8
87285	87585	6 - 32	3/8 - 24	.22	.36	.08	.030	82933	.332	.385	3/8 - 24	.38	9/32	1/8
87286	87586	8 - 32	3/8 - 24	.22	.36	.08	.030	82934	.332	.385	3/8 - 24	.38	9/32	1/8

* To complete the abbreviated part numbers in the table above use the prefix "218-0"

† Modified Minor Diameter

[1] Tap Drill Hole Tolerance: .130 to .233 = +.003/-.001
.234 to .500 = +.004/-.001

Material: Inserts - 4140 Alloy Steel (160 KSI Min)
Keys and Retaining Rings - 302 CRES
Finish: Cadmium Plate (QQ-P-416 Type II, Cl. 2)
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: Two lines on top of Insert
Lubrication: Dry Film Lube on Self-Locking Inserts only



Heavy Duty - Inch

PART NUMBER*		INSERT						INSTALLATION					REMOVAL	
Non-Lock	Self-Lock	Internal Thread Class 3B	External Thread (Mod.) Class 2A	**F** Internal Thd Lgth	**H** Lgth ±015	**K** Dist. to 1st Thd. (Approx)	Min. C - C Float	Install Tool Part No.*	Tap Drill Size[1]	C'Sink Dia. +.010 -.000	Thread Tap Size Class 2B	Thread Tap Min. Depth	Drill Size	Drill Depth
89301	89501	10 - 24	7/16 - 20	.25	.40	.15	.040	82941	.406	.447	7/16 - 20	.39	11/32	5/32
89401	89601	10 - 32												
89302	89502	1/4 - 20	1/2 - 20	.25	.40	.15	.040	82942	.468	.510	1/2 - 20	.39	13/32	5/32
89402	89602	1/4 - 28												
89303	89503	5/16 - 18	5/8 - 18	.39	.53	.13	.040	82943	.578	.635	5/8 - 18	.50	17/32	3/16
89403	89603	5/16 - 24												
89304	89504	3/8 - 16	3/4 - 16	.45	.65	.20	.040	82944	.703	.760	3/4 - 16	.62	21/32	3/16
89404	89604	3/8 - 24												
89305	89505	7/16 - 14	7/8 - 14	.45	.67	.20	.040	82945	.828	.885	7/8 - 14	.62	25/32	3/16
89405	89605	7/16 - 20												
89306	89506	1/2 - 13	1" - 12	.50	.73	.23	.040	82946	.937	1.020	1" - 12	.65	27/32	5/16
89406	89606	1/2 - 20												

* To complete the abbreviated part numbers in the table above use the prefix "218-0"

[1] Tap Drill Hole Tolerance: .234 to .500 = +.004/-.001
Over .500 = +.005/-.001