

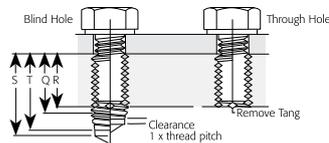
Recoil Metric Insert Part Number Call-Out and Dimensional Data

Thread Nominal	Nominal Length	Recoil Spec - Free Running Free			Recoil Spec - Screw Locking Free			MA Spec		BASIC LENGTH OF INSERT NOMINAL DIAMETER OF SCREW "D"							
		Part Number	Coil Dia Min./Max.	Number of Coils	Part Number	Coil Dia Min./Max.	Number of Coils	Free Running Part Number	Screw Locking Part Number	Insert Length inch	mm	Number of Coils	Free Coil Dia Min./Max.	Q	R	S	T
M2 x 0.4	1							05022		0.079	2.0			2.00	1.60	3.80	3.40
	1.5							05023		0.118	3.0	5.5	2.5	3.00	2.60	4.80	4.40
	2							05024	Upon Request	0.157	4.0	7.75	2.7	4.00	3.60	5.80	5.40
	2.5							05025		0.197	5.0	10.125		5.00	4.60	6.80	6.40
	3							05026		0.236	6.0	12.375		6.00	5.60	7.80	7.40
M2.2 x 0.45	1	05012			15012		3.0	05012MA	15012MA	0.087	2.2	3.125		2.20	1.75	4.23	3.98
	1.5	05013			15013	2.8	5.25	05013MA	15013MA	0.13	3.3	5.375	2.80	3.30	2.85	5.33	4.88
	2	05014			15014	2.95	7.55	05014MA	15014MA	0.173	4.4	7.625	3.00	4.40	3.95	6.43	5.98
	2.5	05015			15015		9.75	05015MA	15015MA	0.217	5.5	9.875		5.50	5.05	7.53	7.08
	3	05016			15016		12.0	05016MA	15016MA	0.26	6.6	12.125		6.60	6.15	8.63	8.18
M2.5 x 0.45	1	05252		3.40	15252		3.2	05252MA	15252MA	0.098	2.5	3.375		2.50	2.05	4.53	4.08
	1.5	05253	3.10	6.20	15253	3.25	5.6	05253MA	15253MA	0.15	3.8	5.750	3.20	3.75	3.30	5.78	5.33
	2	05254	3.20	8.95	15254	3.45	8.0	05254MA	15254MA	0.197	5.0	8.125	3.70	5.00	4.55	7.03	6.58
	2.5	05255		11.45	15255		10.35	05255MA	15255MA	0.248	6.3	10.500		6.25	5.80	8.28	7.83
	3	05256		14.05	15256		12.6	05256MA	15256MA	0.295	7.5	12.750		7.50	7.05	9.53	9.08
M3 x 0.5	1	05032			15032		3.6	05032MA	15032MA	0.118	3.0	3.750		3.00	2.50	5.25	4.75
	1.5	05033	3.65	6.95	15033	3.80	6.22	05033MA	15033MA	0.177	4.5	6.375	3.80	4.50	4.00	6.75	6.25
	2	05034	3.80	9.75	15034	3.95	8.73	05034MA	15034MA	0.236	6.0	8.875	4.35	6.00	5.50	8.25	7.75
	2.5	05035		12.55	15035		11.22	05035MA	15035MA	0.295	7.5	11.375		7.50	7.00	9.75	9.25
	3	05036		15.35	15036		13.72	05036MA	15036MA	0.354	9.0	13.875		9.00	8.50	11.25	10.75
M3.5 x 0.6	1	05352		4.00	15352		3.6	05352MA	15352MA	0.138	3.5	3.750		3.50	2.90	6.20	5.60
	1.5	05353	4.30	6.75	15353	4.40	6.23	05353MA	15353MA	0.209	5.3	6.375	4.40	5.25	4.65	7.95	7.35
	2	05354	4.46	9.45	15354	4.55	8.6	05354MA	15354MA	0.276	7.0	8.625	4.95	7.00	6.40	9.70	9.10
	2.5	05355		12.15	15355		11.23	05355MA	15355MA	0.346	8.8	11.375		8.75	8.15	11.45	10.85
	3	05356		14.85	15356		13.6	05356MA	15356MA	0.413	10.5	13.625		10.50	9.90	13.20	12.60
M4 x 0.7	1	05042		3.85	15042			05042MA	15042MA	0.157	4.0	3.625		4.00	3.30	7.15	6.45
	1.5	05043	4.90	6.55	15043			05043MA	15043MA	0.236	6.0	6.125	5.05	6.00	5.30	9.15	8.45
	2	05044	5.15	9.15	15044			05044MA	15044MA	0.315	8.0	8.625	5.60	8.00	7.30	11.15	10.45
	2.5	05045		11.85	15045			05045MA	15045MA	0.394	10.0	11.125		10.00	9.30	13.15	12.45
	3	05046		14.45	15046			05046MA	15046MA	0.472	12.0	13.625		12.00	11.30	15.15	14.45
M5 x 0.8	1	05052		4.45	15052			05052MA	15052MA	0.197	5.0	4.125		5.00	4.20	8.60	7.80
	1.5	05053	6.00	7.35	15053			05053MA	15053MA	0.295	7.5	6.875	6.25	7.50	6.70	11.10	10.30
	2	05054	6.20	10.25	15054			05054MA	15054MA	0.394	10.0	9.625	6.80	10.00	9.20	13.60	12.80
	2.5	05055		13.15	15055			05055MA	15055MA	0.492	12.5	12.375		12.50	11.70	16.10	15.30
	3	05056		16.05	15056			05056MA	15056MA	0.591	15.0	15.125		15.00	14.20	18.60	17.80
M6 x 1	1	05062		4.15	15062			05062MA	15062MA	0.236	6.0	4.000		6.00	5.00	10.50	9.50
	1.5	05063	7.25	6.95	15063			05063MA	15063MA	0.354	9.0	6.750	7.40	9.00	8.00	13.50	12.50
	2	05064	7.45	9.75	15064			05064MA	15064MA	0.472	12.0	9.500	7.95	12.00	11.00	16.50	15.50
	2.5	05065		12.55	15065			05065MA	15065MA	0.591	15.0	12.125		15.00	14.00	19.50	18.50
	3	05066		15.35	15066			05066MA	15066MA	0.709	18.0	14.875		18.00	17.00	22.50	21.50
M7 x 1	1	05072		5.15	15072			05072MA	15072MA	0.276	7.0	4.875	8.65	7.00	6.00	11.50	10.50
	1.5	05073	8.35	8.45	15073			05073MA	15073MA	0.413	10.5	8.000	9.20	10.50	9.50	15.00	14.00
	2	05074	8.65	11.70	15074			05074MA	15074MA	0.551	14.0	11.125		14.00	13.00	18.50	17.50
	2.5	05075		15.00	15075			05075MA	15075MA	0.689	17.5	14.125		17.50	16.50	22.00	21.00
	3	05076		18.30	15076			05076MA	15076MA	0.827	21.0	17.250		21.00	20.00	25.50	24.50

Drill Depth: The minimum drilling depth "S" allows for one pitch chip clearance between the tip of the tap and the bottom of the drilled hole. "S" minimum allows for tap clearance, the maximum amount of insert set-down and countersink. Where a spiral pointed tap is used, the drill depths shown should be increased to allow for chip clearance.

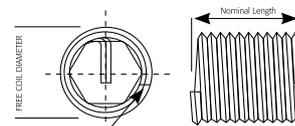
Fitted Insert:

- R = Maximum length of engaged portion of screw when tang is removed.
- Q = Minimum full tapped thread length.
- T = Minimum tapping depth - including 3 1/2 threads of plug tap.
- S = Minimum drill depth - excluding point.



Note: Recoil metric inserts are made to Din locking torque requirements. Military specification MA parts need to be specifically ordered by adding MA to the standard part number above.

Note: Dimensions shown are for MA parts only.



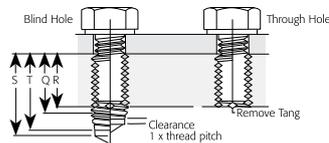
Recoil Metric Insert Part Number Call-Out and Dimensional Data

Thread Nominal	Nominal Length	Recoil Spec - Free Running Free				Recoil Spec - Screw Locking Free				MA Spec		BASIC LENGTH OF INSERT NOMINAL DIAMETER OF SCREW "D"					
		Part Number	Coil Dia Min./Max.	Number of Coils	Part Number	Coil Dia Min./Max.	Number of Coils	Free Running Part Number	Screw Locking Part Number	Insert Length inch	mm	Number of Coils	Free Coil Dia Min./Max.	Q	R	S	T
M8 x 0.75	1	08082		8.60	18082				18082	0.315	8	7.85	8.00	7.25	11.38	10.63	
	1.5	08083	9.00	13.75	18083				18083	0.472	12	12.6	12.00	11.25	15.38	14.63	
	2	08084	9.18	18.75									16.00	15.25	19.38	18.63	
M8 x 1	1	07082		6.15	17082			07082MA	17082	0.315	8.0	5.875	8.00	7.00	12.50	11.50	
	1.5	07083	9.40	9.85	17083	AS PER "MA SPECIFICATION"		07083MA	17083	0.472	12.0	9.375	9.70	12.00	11.00	16.50	15.50
	2	07084	9.65	13.65	17084		07084MA	17084	0.63	16.0	13.000	10.25	16.00	15.00	20.50	19.50	
	2.5	07085		17.45	17085		07085MA	17085	0.787	20.0	16.500		20.00	19.00	24.50	23.50	
	3	07086		21.15	17086		07086MA	17086	0.945	24.0	20.125		24.00	23.00	28.50	27.50	
M8 x 1.25	1	05082		4.55	15082			05082MA	15082MA	0.394	10.0	4.500	8.00	6.75	13.63	12.38	
	1.5	05083	9.60	7.55	15083	AS PER "MA SPECIFICATION"		05083MA	15083MA	0.472	12.0	7.375	9.80	12.00	10.75	17.63	16.38
	2	05084	9.80	10.55	15084		05084MA	15084MA	0.63	16.0	10.250	10.35	16.00	14.75	21.63	20.38	
	2.5	05085		13.55	15085		05085MA	15085MA	0.787	20.0	13.250		20.00	18.75	25.63	24.38	
3	05086		16.55	15086	05086MA		15086MA	0.945	24.0	16.125		24.00	22.75	29.63	28.38		
M9 x 1	1	07092		7.05						0.354	9.0		9.00	8.00	13.50	12.50	
	1.5	07093	10.41	11.35						0.531	13.5		13.50	12.50	18.00	17.00	
	2	07094	10.65	15.65	Upon Request					0.709	18.0		18.00	17.00	22.50	21.50	
	2.5	07095		19.85						0.886	22.5		22.50	21.50	27.00	26.00	
	3	07096		24.15						1.063	27.0		27.00	26.00	31.50	30.50	
M9 x 1.25	1	05092		5.35						0.354	9.0		9.00	7.75	14.63	13.38	
	1.5	05093	10.68	8.75						0.531	13.5		13.50	12.25	19.13	17.88	
	2	05094	10.92	12.15	Upon Request					0.709	18.0		18.00	16.75	23.63	22.38	
	2.5	05095		15.55						0.886	22.5		22.50	21.25	28.13	26.88	
M10 x 1	1	08102		8.05			08102MA	18102MA	0.394	10.0	7.625	10.00	9.00	14.50	13.50		
	1.5	08103	11.34	12.75			08103MA	18103MA	0.591	15.0	12.00	11.95	15.00	14.00	19.50	18.50	
	2	08104	11.63	17.55			08104MA	18104MA	0.787	20.0	16.50	12.5	20.00	19.00	24.50	23.50	
	2.5	08105		22.25			08105MA	18105MA	0.984	25.0	21.00		25.00	24.00	29.50	28.50	
	3	08106		26.95			08106MA	18106MA	1.181	30.0	25.50		30.00	29.00	34.50	33.50	
M10 x 1.25	1	07102		6.05	17102			07102MA	17102MA	0.394	10.0	5.875	10.00	8.75	15.63	14.38	
	1.5	07103	11.80	9.85	17103			07103MA	17103MA	0.591	15.0	9.500	12.10	15.00	13.75	20.63	19.38
	2	07104	12.10	13.55	17104			07104MA	17104MA	0.787	20.0	13.125	12.65	20.00	18.75	25.63	24.38
	2.5	07105		17.35	17105			07105MA	17105MA	0.984	25.0	16.750		25.00	23.75	30.63	29.38
	3	07106		21.15	17106			07106MA	17106MA	1.181	30.0	20.375		30.00	28.75	35.63	34.38
M10 x 1.5	1				15102			05102	15102MA	0.394	10.0	4.875	10.00	8.50	16.75	15.25	
	1.5				15103			05103	15103MA	0.591	15.0	8.000	11.95	15.00	13.50	21.75	20.25
	2				15104			05104	15104MA	0.787	20.0	11.125	12.50	20.00	18.50	26.75	25.25
	2.5				15105			05105	15105MA	0.984	25.0	14.250		25.00	23.50	31.75	30.25
	3				15106			05106	15106MA	1.181	30.0	17.375		30.00	28.50	36.75	35.25
M11 x 1	1	08112		8.95						0.433	11.0		11.00	12.00	15.50	14.50	
	1.5	08113	12.40	14.15						0.866	22.0		16.50	15.50	21.00	20.00	
	2	08114	12.70	19.35	Upon Request					1.083	27.5		22.00	21.00	26.50	25.50	
	2.5	08115		24.55						1.299	33.0		27.50	26.50	32.00	31.00	
3	08116		29.75						0.433	11.0		33.00	32.00	37.50	36.50		

Drill Depth: The minimum drilling depth "S" allows for one pitch chip clearance between the tip of the tap and the bottom of the drilled hole. "S" minimum allows for tap clearance, the maximum amount of insert set-down and countersink. Where a spiral pointed tap is used, the drill depths shown should be increased to allow for chip clearance.

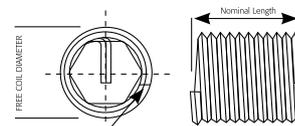
Fitted Insert:

- R = Maximum length of engaged portion of screw when tang is removed.
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Note: Dimensions shown are for MA parts only.



Threaded Inserts / Tools for Inserts

Tangless Inserts / Self-Tapping Inserts

Slotted

When large quantities are needed, box package sales is more economical. P274

Threaded Inserts

HLTS (Coarse)
HLSS (Fine)

Material: SUS304

Part Number	Type	*M	* (L) After Insertion	Pitch	Tap Pilot Hole Dia. (Reference)	Unit Price	Volume Discount Rate
3	HLTS	3	4.5	6	0.5	3.11~3.20	10-19
4	HLTS	4	6	8	0.7	4.16~4.29	20-49
5	HLTS	5	7.5	10	0.8	5.18~5.33	50-100
6	HLTS	6	9	12	1.0	6.22~6.40	
8	HLTS	8	12	16	1.25	8.28~8.48	
10	HLTS	10	15	20	1.5	10.33~10.56	
12	HLTS	12	18	24	1.75	12.38~12.64	
16	HLTS	16	24	32	2.0	16.44~16.73	

Taps for Threaded Inserts

Coarse	Fine	Finish
HLTX	HLSX	Coarse Tapping
HLTY	HLSY	Medium Tapping
HLTZ	HLSZ	Finish Tapping

(M3-5)
(M6 or More)

Material: SKH Hardness: G1 ~ 64HRC

Part Number	Type	*M	* (L) After Insertion	Pitch	Tap Pilot Hole Dia. (Reference)	Unit Price	Volume Discount Rate
8	HLSS	8	16	24	1.0	8.28~8.48	10-19
10	HLSS	10	15	20	1.0	10.33~10.56	20-49
12	HLSS	12	18	24	1.25	12.38~12.64	50-100
12	HLSS	12	24	1.5			

Threaded Insert Installation Tools

HLTP

Material: SKH Hardness: G1 ~ 64HRC

Taps for Threaded Inserts

Part Number	Type	No.	Applicable Threaded Insert M	L	D	K	Unit Price	Volume Discount Rate
3	HLTX	3	3	55	5	4	1~9 pc(s)	10-20
4	HLTX	4	4	61	5.5	4.5		
5	HLTX	5	5	67	6	5		
6	HLTX	6	6	65	6.2	5		
8	HLTX	8	8	75	7	5.5		
10	HLTX	10	10	82	8.5	6.5		
12	HLTX	12	12	88	10.5	8		
16	HLTX	16	16	105	14	11		

Threaded Insert Tang Break-Off Tools

HLTB

Material: SCM435 Surface Treatment: Black Oxide

Threaded Insert Installation Tools

Part Number	Type	No.	Pitch	L	D	K	Unit Price	Volume Discount Rate
8	HLSX	8	1.0	75	7	5.5	1~9 pc(s)	10-20
10	HLSY	10	1.0	82	8.5	6.5		
12	HLSZ	12	1.25	88	10.5	8		

Threaded Insert Removal Tools

HLTN (No.1)
HLTN (No.2-3)

Material: S45C Surface Treatment: Black Oxide

Tang Break-Off Tools

Part Number	Type	No.	Applicable Threaded Insert M	L	A	Unit Price	Volume Discount Rate
3	HLTP	3	3	80		1~9 pc(s)	10-20
4	HLTP	4	4	150			
5	HLTP	5	5				
6	HLTP	6	6	165	103		
8	HLTP	8	8	175			
10	HLTP	10	10	180			
12	HLTP	12	12	200	124		
16	HLTP	16	16	210			

Threaded Insert Removal Tools

Part Number	Type	No.	Applicable Threaded Insert M	L	A	Unit Price	Volume Discount Rate
3	HLTN	3	3	6	1.8	1~9 pc(s)	10-20
4	HLTN	4	4	9	2.6		
5	HLTN	5	5	10	3.5		
6	HLTN	6	6	10	4.2		
8	HLTN	8	8	12	5.5		
10	HLTN	10	10	110	14	7.5	
12	HLTN	12	12	115	16	8.5	
16	HLTN	16	16	114	20	12	

Threaded Insert Removal Tools

Part Number	Type	No.	Applicable Threaded Insert M	L	A	Unit Price	Volume Discount Rate
1	HLTN	1	3-4-5	92	60	1~9 pc(s)	10-20
2	HLTN	2	6-8-10	109	75		
3	HLTN	3	12-16	117	100		

Ordering Example: Part Number - L - Pitch
HLTS3 - 4.5
HLTX5 - 15 - 1.25
HLSS10 - 8 - 1.0

How to Handle Threaded Inserts

(Fig. 1) (Fig. 2) (Fig. 3) (Fig. 4)

1. Drill a pilot hole in the workpiece within the appropriate limit of tap pilot hole diameters shown in the above table. (Hole Depth > Length after Insertion + 2.5xP (Pitch))
2. Tap with "Taps for Threaded Inserts" (Coarse, Medium, Finish Tapping in that order), and completely remove metal chips.
3. Insert Threaded Inserts to tip of sleeve of the Insert Tool (with tang on the tip side), and clip on the tang at the mandrel slot (Fig. 1). Turn the handle and insert Threaded Insert into the guide of thread part on the tool tip. Set it so that the threaded insert does not protrude more than the sleeve tip (leaving 1 or 2 pitches).
4. Turn the handle to install Threaded Inserts by positioning the insert tool perpendicular to the work (Fig. 2). Check the insertion condition from the opening of the sleeve tip. Remove the tool from the work when insertion is complete. *Inserting while pressing the handle hard in the insertion direction causes damages such as skipped threads. Always turn the handle lightly in the horizontal direction. Do not reverse the rotation during the insertion as that will cause damages.
5. After the insertion is complete, insert the tang break-off tool, and break off the tang from the notch by striking the head sharply with a hammer (Fig. 3).
6. When removing Threaded Inserts, press an Insert Removal Tool onto the insert, and slowly turn counterclockwise to remove it (Fig. 4). When reinserting the Threaded Insert into the removed hole, use special tap again before inserting.

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Tangless Inserts

TLTS (SUS304)

Material: SUS304

Part Number	Type	*M	* (L) After Insertion	Tap Pilot Hole Dia. (Reference)	Unit Price	Volume Discount Rate
2.5	TLTS	2.5	3.8	5	2.60~2.65	1~49 pc(s)
3	TLTS	3	4.5	6	3.12~3.20	50~100
4	TLTS	4	6	8	4.17~4.30	
5	TLTS	5	7.5	10	5.16~5.33	
6	TLTS	6	9	12	6.25~6.42	
8	TLTS	8	12	16	8.31~8.52	
10	TLTS	10	15	20	10.37~10.62	

Tangless Insert Hand Taps

TLTK (Set of a plug tap and a bottom tap)

Material: HSSV Hardness: G3 ~ 68HRC

Hand Taps for Tangless Inserts

Part Number	Type	No.	Applicable Threaded Insert M	L	D	K	Unit Price	Volume Discount Rate
2.5	TLTK	2.5	2.5	46	4	3.2	1~3 pc(s)	4 pcs.
3	TLTK	3	3	52	4	3.2		
4	TLTK	4	4	60	5.5	4.5		
5	TLTK	5	5	62	6	4.5		
6	TLTK	6	6	70	6.2	5		
8	TLTK	8	8	75	7	5.5		
10	TLTK	10	10	82	8.5	6.5		

Tangless Insert Insertions / Removal Tools

TLTP TLTN

Material: HSSV Hardness: G3 ~ 68HRC

Insertions / Removal Tools

Part Number	Type	No.	D	L	Unit Price	Volume Discount Rate
2.5	TLTP	2.5	6.0	69.0	1~3 pc(s)	4 pcs.
3	TLTP	3	6.8	68.5		
4	TLTP	4	9.0	75.8		
5	TLTP	5	9.7	78.6		
6	TLTP	6	11.0	78.1		
8	TLTP	8	13.0	98.4		
10	TLTP	10	15.5	104.4		

Self-Tapping Inserts Slotted

ENT, ENT5, ENT10, ENT15, ENT20, ENT25, ENT30, ENT35, ENT40, ENT45, ENT50, ENT55, ENT60, ENT65, ENT70, ENT75, ENT80, ENT85, ENT90, ENT95, ENT100, ENT110, ENT120, ENT130, ENT140, ENT150, ENT160, ENT170, ENT180, ENT190, ENT200, ENT210, ENT220, ENT230, ENT240, ENT250, ENT260, ENT270, ENT280, ENT290, ENT300, ENT310, ENT320, ENT330, ENT340, ENT350, ENT360, ENT370, ENT380, ENT390, ENT400, ENT410, ENT420, ENT430, ENT440, ENT450, ENT460, ENT470, ENT480, ENT490, ENT500, ENT510, ENT520, ENT530, ENT540, ENT550, ENT560, ENT570, ENT580, ENT590, ENT600, ENT610, ENT620, ENT630, ENT640, ENT650, ENT660, ENT670, ENT680, ENT690, ENT700, ENT710, ENT720, ENT730, ENT740, ENT750, ENT760, ENT770, ENT780, ENT790, ENT800, ENT810, ENT820, ENT830, ENT840, ENT850, ENT860, ENT870, ENT880, ENT890, ENT900, ENT910, ENT920, ENT930, ENT940, ENT950, ENT960, ENT970, ENT980, ENT990, ENT1000, ENT1010, ENT1020, ENT1030, ENT1040, ENT1050, ENT1060, ENT1070, ENT1080, ENT1090, ENT1100, ENT1110, ENT1120, ENT1130, ENT1140, ENT1150, 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