

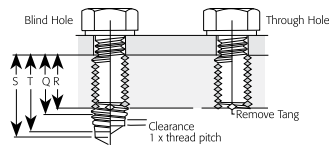
Recoil Metric Insert Part Number Call-Out and Dimensional Data

Thread Nominal	Recoil Spec - Free Running Free				Recoil Spec - Screw Locking Free				MA Spec				BASIC LENGTH OF INSERT NOMINAL DIAMETER OF SCREW "D"					
	Nominal Length	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 1.5 2 2.5 3							05022 05023 05024 05025 05026	Upon Request	0.079 0.118 0.157 0.197 0.236	2.0 3.0 4.0 5.0 6.0						
M2.2 x 0.45	1 1.5 2 2.5 3	05012 05013 05014 05015 05016			15012 15013 15014 15015 15016		3.0 2.8 2.95 9.75 12.0	05012MA 05013MA 05014MA 05015MA 05016MA	15012MA 15013MA 15014MA 15015MA 15016MA	0.087 0.13 0.173 0.217 0.26	2.2 3.3 4.4 5.5 6.6		3.125 5.375 7.625 9.875 12.125		2.20 3.30 4.40 5.50 6.60	1.75 2.85 3.95 5.05 6.15	4.23 5.33 6.43 7.53 8.63	3.98 4.88 5.98 7.08 8.18
M2.5 x 0.45	1 1.5 2 2.5 3	05252 05253 05254 05255 05256		3.40 3.10 3.20 11.45 14.05	15252 15253 15254 15255 15256		3.2 3.25 3.45 10.35 12.6	05252MA 05253MA 05254MA 05255MA 05256MA	15252MA 15253MA 15254MA 15255MA 15256MA	0.098 0.15 0.197 0.248 0.295	2.5 3.8 5.0 6.3 7.5		3.375 5.750 8.125 10.500 12.750		2.50 3.75 5.00 6.25 7.50	2.05 3.30 4.55 5.80 7.05	4.53 5.78 7.03 8.28 9.53	4.08 5.33 6.58 7.83 9.08
M3 x 0.5	1 1.5 2 2.5 3	05032 05033 05034 05035 05036			15032 15033 15034 15035 15036		3.6 3.80 3.95 11.22 13.72	05032MA 05033MA 05034MA 05035MA 05036MA	15032MA 15033MA 15034MA 15035MA 15036MA	0.118 0.177 0.236 0.295 0.354	3.0 4.5 6.0 7.5 9.0		3.750 6.375 8.875 11.375 13.875		3.00 4.50 6.00 7.50 9.00	2.50 4.00 5.50 7.00 8.50	5.25 6.75 8.25 9.75 11.25	4.75 6.25 7.75 9.25 10.75
M3.5 x 0.6	1 1.5 2 2.5 3	05352 05353 05354 05355 05356		4.00 4.30 4.46 12.15 14.85	15352 15353 15354 15355 15356		3.6 4.40 8.6 11.23 13.6	05352MA 05353MA 05354MA 05355MA 05356MA	15352MA 15353MA 15354MA 15355MA 15356MA	0.138 0.209 0.276 0.346 0.413	3.5 5.3 7.0 8.8 10.5		3.750 6.375 8.625 11.375 13.625		3.50 5.25 7.00 8.75 10.50	2.90 4.65 6.40 8.15 9.90	6.20 7.95 9.70 11.45 13.20	5.60 7.35 9.10 10.85 12.60
M4 x 0.7	1 1.5 2 2.5 3	05042 05043 05044 05045 05046		3.85 4.90 5.15 11.85 14.45	15042 15043 15044 15045 15046	AS PER "MA SPECIFICATION"		05042MA 05043MA 05044MA 05045MA 05046MA	15042MA 15043MA 15044MA 15045MA 15046MA	0.157 0.236 0.315 0.394 0.472	4.0 6.0 8.0 10.0 12.0		3.625 6.125 8.625 11.125 13.625		4.00 6.00 8.00 10.00 12.00	3.30 5.30 7.30 9.30 11.30	7.15 9.15 11.15 13.15 15.15	6.45 8.45 10.45 12.45 14.45
M5 x 0.8	1 1.5 2 2.5 3	05052 05053 05054 05055 05056		4.45 6.00 6.20 13.15 16.05	15052 15053 15054 15055 15056	AS PER "MA SPECIFICATION"		05052MA 05053MA 05054MA 05055MA 05056MA	15052MA 15053MA 15054MA 15055MA 15056MA	0.197 0.295 0.394 0.492 0.591	5.0 7.5 10.0 12.5 15.0		4.125 6.875 9.625 12.375 15.125		5.00 7.50 10.00 12.50 15.00	4.20 6.70 9.20 11.70 14.20	8.60 11.10 13.60 16.10 18.60	7.80 10.30 12.80 15.30 17.80
M6 x 1	1 1.5 2 2.5 3	05062 05063 05064 05065 05066		4.15 7.25 7.45 12.55 15.35	15062 15063 15064 15065 15066	AS PER "MA SPECIFICATION"		05062MA 05063MA 05064MA 05065MA 05066MA	15062MA 15063MA 15064MA 15065MA 15066MA	0.236 0.354 0.472 0.591 0.709	6.0 9.0 12.0 15.0 18.0		4.000 6.750 9.500 12.125 14.875		6.00 7.40 8.90 10.50 12.10	5.00 8.00 11.00 14.00 17.00	10.50 13.50 16.50 19.50 22.50	9.50 12.50 15.50 18.50 21.50
M7 x 1	1 1.5 2 2.5 3	05072 05073 05074 05075 05076		5.15 8.35 8.65 15.00 18.30	15072 15073 15074 15075 15076	AS PER "MA SPECIFICATION"		05072MA 05073MA 05074MA 05075MA 05076MA	15072MA 15073MA 15074MA 15075MA 15076MA	0.276 0.413 0.551 0.689 0.827	7.0 10.5 14.0 17.5 21.0		4.875 8.000 11.125 14.125 17.250		8.65 9.20 14.00 17.50 21.00	7.00 9.50 13.00 16.50 20.00	11.50 15.00 18.50 22.00 25.50	10.50 14.00 17.50 21.00 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.

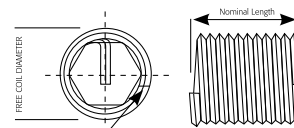
Fitted Insert:

- 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.



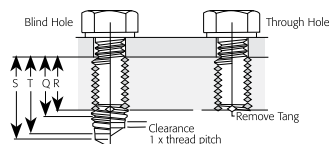
Recoil Metric Insert Part Number Call-Out and Dimensional Data

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	AS PER "MA SPECIFICATION"		05082MA	15082MA	0.394	10.0	4.500		8.00	6.75	13.63	12.38	
	1.5	05083	9.60	7.55	15083			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		Upon Request				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							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		Upon Request				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							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
	3	05096		18.95						1.063	27.0			27.00	25.75	32.63	31.38	
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					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.

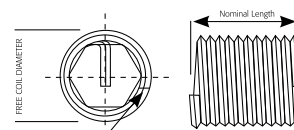
Fitted Insert:

- R = Maximum length of engaged portion of screw when tang is removed.
- 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.

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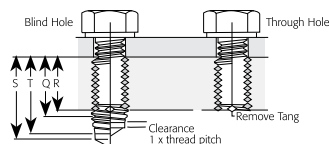
Recoil Metric Insert Part Number Call-Out and Dimensional Data

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
M11 x 1.25	1	07112		6.90									11.00	9.75	16.63	15.38
	1.5	07113	12.83	11.00					0.650	16.5			16.50	15.25	22.13	20.88
	2	07114	13.10	15.15	Upon Request				0.866	22.0			22.00	20.75	27.63	26.38
	2.5	07115		19.35					1.083	27.5			27.50	26.25	33.13	31.88
	3	07116		23.45					1.299	33.0			33.00	31.75	38.63	37.38
M11 x 1.5	1	05112		5.55					0.433	11.0			11.00	9.50	17.75	16.25
	1.5	05113	12.95	9.05					0.650	16.5			16.50	15.00	23.25	21.75
	2	05114	13.25	12.55	Upon Request				0.866	22.0			22.00	20.50	28.75	27.25
	2.5	05115		16.05					1.083	27.5			27.50	26.00	34.25	32.75
	3	05116		19.45					1.299	33.0			33.00	31.50	39.75	38.25
M12 x 1	1	08122-1.0		10.25					0.472	12.0			12.00	11.00	16.50	15.50
	1.5	08123-1.0	13.55	15.35					0.709	18.0			18.00	17.00	22.50	21.50
	2	08124-1.0	13.90	21.30	Upon Request				0.945	24.0			24.00	23.00	28.50	27.50
	2.5	08125-1.0							1.181	30.0			30.00	29.00	34.50	33.50
	3	08126-1.0							1.417	36.0			36.00	35.00	40.50	39.50
M12 x 1.25	1	08122		7.65	18122			18122MA	0.472	12.0	7.250		12.00	10.75	17.63	16.38
	1.5	08123	13.70	12.15	18123	AS PER "MA SPECIFICATION"		18123MA	0.709	18.0	11.625	14.30	18.00	16.75	23.63	22.38
	2	08124	14.05	16.65	18124		18124MA	0.945	24.0	15.875	15.00	24.00	22.75	29.63	27.38	
	2.5	08125		21.25	18125		18125MA	1.181	30.0	20.250		30.00	28.75	35.63	34.38	
	3	08126		25.75	18126		18126MA	1.417	36.0	24.500		36.00	34.75	41.63	40.38	
1	07122		5.85	17122				07122MA	0.472	12.0	6.000		12.00	10.50	18.75	17.25
M12 x 1.5	1.5	07123	14.00	9.50	17123	AS PER "MA SPECIFICATION"		07123MA	0.709	18.0	9.625	14.25	18.00	16.50	24.75	23.25
	2	07124	14.30	13.23	17124		07124MA	0.945	24.0	13.375	14.95	24.00	22.50	30.75	29.25	
	2.5	07125		16.85	17125		07125MA	1.181	30.0	17.000		30.00	28.50	36.75	32.25	
	3	07126		20.6	17126		07126MA	1.417	36.0	20.750		36.00	34.50	42.75	41.25	
M12 x 1.75	1				15122	AS PER "MA SPECIFICATION"		05122	0.472	12.0	5.000		12.00	10.25	19.88	18.13
	1.5				15123		05123	15123MA	0.709	18.0	8.250	14.30	18.00	16.25	25.88	24.13
	2				15124		05124	15124MA	0.945	24.0	11.500	15.00	24.00	22.25	31.88	30.13
	2.5				15125		05125	15125MA	1.181	30.0	14.625		30.00	28.25	37.88	36.13
	3				15126		05126	15126MA	1.417	36.0	17.875		36.00	34.25	43.88	42.13
M13 x 1.5	1	07132	15.20	6.65					0.512	13.0			13.00	11.50	19.75	18.25
	1.5	07133	15.53	10.75									19.50	18.00	26.25	24.75
	2	07134		14.95									26.00	24.50	32.75	31.25
M13 x 1.75	1	05132		5.50									13.00	11.25	20.88	19.13
	1.5	05133	15.35	9.05					0.768	19.5			19.50	17.75	27.38	25.63
	2	05134	15.75	12.60	Upon Request								26.00	24.25	33.88	32.13
	2.5	05135		16.1									32.50	30.75	40.38	38.63
	3	05136		19.65									39.00	37.25	46.88	45.13
M13 x 1.25	1	08132		8.35					0.512	13.0			13.00	11.75	18.63	17.38
	1.5	08133	14.70	13.25									19.50	18.25	25.13	23.88
	2	08134	15.05	18.25	Upon Request								26.00	24.75	31.63	30.38
	2.5	08135		23.15									32.50	31.25	38.13	36.88
	3	08136		28.15									39.00	37.75	44.63	43.38

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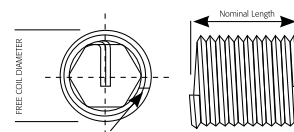
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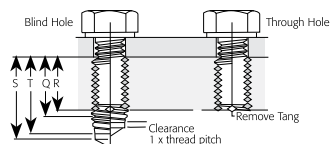


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M14 x 1.5	1	07142		7.35	17142		6.98	07142MA	17142MA	0.551	14.0	7.125	14.00	12.50	20.75	19.25	
	1.5	07143	16.15	11.75	17143	17.30	11.23	07143MA	17143MA	0.827	21.0	11.375	16.55	21.00	19.50	27.75	26.25
	2	07144	16.55	16.25	17144	17.60	15.48	07144MA	17144MA	1.102	28.0	15.625	17.25	28.00	26.50	34.75	33.25
	2.5	07145		20.65	17145		19.85	07145MA	17145MA	1.378	35.0	20.000		35.00	33.50	41.75	40.25
	3	07146		25.05	17146		24.10	07146MA	17146MA	1.654	42.0	24.250		42.00	40.50	48.75	47.25
M14 x 2	1				15142			05142	15142MA	0.551	14.0	5.125	14.00	12.00	23.00	21.00	
	1.5				15143			05143	15143MA	0.827	21.0	8.500	16.65	21.00	19.00	30.00	28.00
	2				15144	AS PER "MA SPECIFICATION"		05144	15144MA	1.102	28.0	11.750	17.35	28.00	26.00	37.00	35.00
	2.5				15145			05145	15145MA	1.378	35.0	15.000		35.00	33.00	44.00	42.00
	3				15146			05146	15146MA	1.654	42.0	18.375		42.00	40.00	51.00	49.00
M15 x 1.5	1	07152		7.95						0.591	15.0		15.00	13.50	21.75	20.25	
	1.5	07153	17.25	12.75						0.886	22.5		22.50	21.00	29.25	27.75	
	2	07154	17.65	17.45	Upon Request					1.181	30.0		30.00	28.50	36.75	35.25	
	2.5	07155		22.25						1.476	37.5		37.50	36.00	44.25	42.75	
	3	07156		26.95						1.772	45.0		45.00	43.50	51.75	50.25	
M15 x 2	1	05152		5.55						0.591	15.0		15.00	13.00	24.00	22.00	
	1.5	05153	17.70	9.15						0.886	22.5		22.50	20.50	31.50	29.50	
	2	05154	18.10	12.70	Upon Request					1.181	30.0		30.00	28.00	39.00	37.00	
	2.5	05155		16.30						1.476	37.5		37.50	35.50	46.50	44.50	
	3	05156		19.85						1.772	45.0		45.00	43.00	54.00	52.00	
M16 x 1.5	1	07162		8.65	17162		8.65	07162MA	17162MA	0.63	16.0	8.250	16.00	14.50	22.75	21.25	
	1.5	07163	18.20	13.75	17163	18.20	13.75	07163MA	17163MA	0.945	24.0	13.125	18.90	24.00	22.50	30.75	29.25
	2	07164	18.60	18.85	17164	18.60	18.85	07164MA	17164MA	1.26	32.0	18.000	19.60	32.00	30.50	38.75	37.25
	2.5	07165		23.85	17165		23.85	07165MA	17165MA	1.575	40.0	22.750		40.00	38.50	46.75	45.25
	3	07166		28.95	17166		28.95	07166MA	17166MA	1.89	48.0	27.625		48.00	46.50	54.75	53.25
M16 x 2	1	05162		6.10	15162			05162MA	15162MA	0.63	16.0	6.125	16.00	14.00	25.00	23.00	
	1.5	05163	18.35	9.60	15163			05163MA	15163MA	0.945	24.0	9.750	18.80	24.00	22.00	33.00	31.00
	2	05164	18.55	13.70	15164	AS PER "MA SPECIFICATION"		05164MA	15164MA	1.26	32.0	13.500	19.60	32.00	30.00	41.00	39.00
	2.5	05165		17.50	15165			05165MA	15165MA	1.575	40.0	17.250		40.00	38.00	49.00	47.00
	3	05166		21.15	15166			05166MA	15166MA	1.89	48.0	21.000		48.00	46.00	57.00	55.00
M18 x 1.5	1	08182		9.85	18182			08182MA	18182MA	0.709	18.0	9.500	18.00	16.50	24.75	23.25	
	1.5	08183	20.35	15.45	18183			08183MA	18183MA	1.063	27.0	15.000	21.05	27.00	25.50	33.75	32.25
	2	08184	20.75	21.05	18184	AS PER "MA SPECIFICATION"		08184MA	18184MA	1.417	36.0	20.375	21.75	36.00	34.50	42.75	41.25
	2.5	08185		26.75	18185			08185MA	18185MA	1.772	45.0	25.875		45.00	43.50	51.75	50.25
	3	08186		32.35	18186			08186MA	18186MA	2.126	54.0	31.375		54.00	52.50	60.75	59.25
M18 x 2	1	07182			17182				17182MA	0.709	18.0	7.000	18.00	16.00	27.00	25.00	
	1.5	07183	AS PER "MA SPECIFICATION"		17183	AS PER "MA SPECIFICATION"			17183MA	1.063	27.0	11.125	21.15	27.00	25.00	36.00	34.00
	2	07184			17184				17184MA	1.417	36.0	15.375	21.85	36.00	34.00	45.00	43.00
	2.5	07185			17185				17185MA	1.772	45.0	19.500		45.00	43.00	54.00	52.00
	3	07186			17186				17186MA	2.126	54.0	23.625		54.00	52.00	63.00	61.00
M18 x 2.5	1	05182			15182				15182MA	0.709	18.0	5.375	18.00	15.50	29.25	26.75	
	1.5	05183	AS PER "MA SPECIFICATION"		15183	AS PER "MA SPECIFICATION"			15183MA	1.063	27.0	8.875	21.30	27.00	24.50	38.25	35.75
	2	05184			15184			15184MA	1.417	36.0	12.250	22.00	36.00	33.50	47.25	44.75	
	2.5	05185			15185				15185MA	1.772	45.0	15.625		45.00	42.50	56.25	53.75
	3	05186			15186				15186MA	2.126	54.0	19.000		54.00	51.50	65.25	62.75

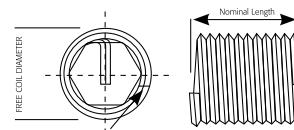
Drill Depth: The minimum drilling depth "S" allows for one pitch chip clearance between the tip of the tap and the bottom of the drilled hole. "S" minimum allows for tap clearance, the maximum amount of insert set-down and countersink. Where a spiral pointed tap is used, the drill depths shown should 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	Recoil Spec - Free Running Free				Recoil Spec - Screw Locking Free				MA Spec		BASIC LENGTH OF INSERT NOMINAL DIAMETER OF SCREW "D"						
	Nominal Length	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
M20 x 1.5	1	08202		11.25	18202			08202MA	18202MA	0.787	20.0	10.750	20.00	18.50	26.75	25.25	
	1.5	08203	22.08	17.65	18203	AS PER "MA SPECIFICATION"		08203MA	18203MA	1.181	30.0	16.875	23.15	30.00	28.50	36.75	35.25
	2	08204	22.50	23.95	18204			08204MA	18204MA	1.575	40.0	22.875	24.00	40.00	38.50	46.75	45.25
	2.5	08205		30.35	18205			08205MA	18205MA	1.969	50.0	28.875		50.00	48.50	56.75	55.25
	3	08206		36.75	18206			08206MA	18206MA	2.362	60.0	35.000		60.00	58.50	66.75	65.25
M20 x 2	1	07202		8.05	17202			07202MA	17202MA	0.787	20.0	7.875		20.00	18.00	29.00	27.00
	1.5	07203	22.97	12.75	17203	AS PER "MA SPECIFICATION"		07203MA	17203MA	1.181	30.0	12.500	23.20	30.00	28.00	39.00	37.00
	2	07204	23.40	17.45	17204			07204MA	17204MA	1.575	40.0	17.250	24.05	40.00	38.00	49.00	47.00
	2.5	07205		22.25	17205			07205MA	17205MA	1.969	50.0	21.875		50.00	48.00	59.00	57.00
	3	07206		26.95	17206			07206MA	17206MA	2.362	60.0	26.500		60.00	58.00	69.00	67.00
M20 x 2.5	1				15202			05202	15202MA	0.787	20.0	6.125		20.00	17.50	31.25	28.75
	1.5				15203	AS PER "MA SPECIFICATION"		05203	15203MA	1.181	30.0	9.875	23.55	30.00	27.50	41.25	38.75
	2				15204			05204	15204MA	1.575	40.0	13.625	24.40	40.00	37.50	51.25	48.75
	2.5				15205			05205	15205MA	1.969	50.0	17.375		50.00	47.50	61.25	58.75
	3				15206			05206	15206MA	2.362	60.0	21.125		60.00	57.50	71.25	68.75
M22 x 1.5	1	08222		12.55				08222MA	18222MA	0.866	22.0	11.875		22.00	20.50	28.75	27.25
	1.5	08223	23.90	19.75		AS PER "MA SPECIFICATION"		08223MA	18223MA	1.299	33.0	18.500	25.55	33.00	31.50	39.75	38.25
	2	08224	24.45	26.65				08224MA	18224MA	1.732	44.0	25.125	26.45	44.00	42.50	50.75	49.25
	2.5	08225		33.65				08225MA	18225MA	2.165	55.0	31.625		55.00	53.50	61.75	60.25
	3	08226		40.65				08226MA	18226MA	2.598	66.0	38.250		66.00	64.50	72.75	71.25
M22 x 2	1	07222		9.05	17222			07222MA	17222MA	0.787	20.0	8.750		22.00	20.00	31.00	29.00
	1.5	07223	25.00	14.25	17223	AS PER "MA SPECIFICATION"		07223MA	17223MA	1.181	30.0	13.750	25.60	33.00	31.00	42.00	40.00
	2	07224	25.40	19.45	17224			07224MA	17224MA	1.575	40.0	18.875	26.50	44.00	42.00	53.00	51.00
	2.5	07225		24.65	17225			07225MA	17225MA	1.969	50.0	23.875		55.00	53.00	64.00	62.00
	3	07226		30.15	17226			07226MA	17226MA	2.362	60.0	29.000		66.00	64.00	75.00	73.00
M22 x 2.5	1				15222			05222	15222MA	0.866	22.0	6.750		22.00	19.50	33.25	30.75
	1.5				15223			05223	15223MA	1.299	33.0	10.875	25.90	33.00	30.50	44.25	41.75
	2				15224			05224	15224MA	1.732	44.0	14.875	26.90	44.00	41.50	55.25	52.75
	2.5				15225			05225	15225MA	2.165	55.0	19.000		55.00	52.50	66.25	63.75
	3				15226			05226	15226MA	2.598	66.0	23.125		66.00	63.50	77.25	74.75
M24 x 1.5	1	08242		13.85	18242		13.85			0.945	24.0			24.00	22.50	30.75	29.25
	1.5	08243	26.10	21.55	18243	26.10	21.55			1.417	36.0			36.00	34.50	42.75	41.25
	2	08244	26.60	29.15	18244	26.60	29.15			1.89	48.0			48.00	46.50	54.75	53.25
	2.5	08245		36.85	18245		36.85			2.362	60.0			60.00	58.50	66.75	65.25
	3	08246		44.45	18246		44.45			2.835	72.0			72.00	70.50	78.75	77.25
M24 x 2	1	07242		9.95	17242			07242MA	17242MA	0.945	24.0	9.500		24.00	22.00	33.00	31.00
	1.5	07243	27.00	15.65	17243	AS PER "MA SPECIFICATION"		07243MA	17243MA	1.417	36.0	15.000	28.10	36.00	34.00	45.00	43.00
	2	07244	27.50	21.45	17244			07244MA	17244MA	1.89	48.0	20.375	29.10	48.00	46.00	57.00	55.00
	2.5	07245		27.15	17245			07245MA	17245MA	2.362	60.0	25.875		60.00	58.00	69.00	67.00
	3	07246		32.85	17246			07246MA	17246MA	2.835	72.0	31.250		72.00	70.00	81.00	79.00
M24 x 3	1				15242			05242	15242MA	0.945	24.0	6.125		24.00	21.00	37.50	34.50
	1.5				15243	AS PER "MA SPECIFICATION"		05243	15243MA	1.417	36.0	10.000	28.00	36.00	33.00	49.50	46.50
	2				15244			05244	15244MA	1.89	48.0	13.750	29.00	48.00	45.00	61.50	58.50
	2.5				15245			05245	15245MA	2.362	60.0	17.500		60.00	57.00	73.50	70.50
	3				15246			05246	15246MA	2.835	72.0	21.375		72.00	69.00	85.50	82.50

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.

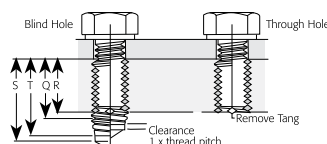
Fitted Insert:

R = Maximum length of engaged portion of screw when tang is removed.

Q = Minimum full tapped thread length.

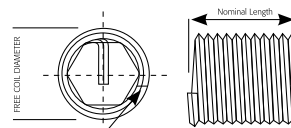
T = Minimum tapping depth - including 3 1/2 threads of plug tap.

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.



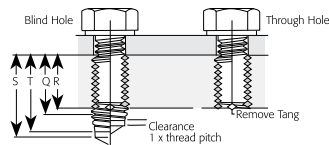
Recoil Metric Insert Part Number Call-Out and Dimensional Data

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
M26 x 1.5	1	08262		15.15					1.024	26.0			26.50	24.50	32.75	31.25
	1.5	08263	28.10	23.45					1.535	39.0			39.00	37.50	45.75	44.25
	2	08264	28.60	31.75	Upon Request				2.047	52.0			52.00	50.50	58.75	57.25
	2.5	08265		40.05					2.559	65.0			65.00	63.50	71.75	70.25
	3	08266		48.35					3.071	78.0			78.00	76.50	84.75	83.25
M27 x 1.5	1	08272		15.85					1.063	27.0						
	1.5	08273	29.10	24.45					1.594	40.5						
	2	08274	29.6	33.15	Upon Request				2.126	54.0						
	2.5	08275		41.8					2.657	67.5						
	3	08276		50.45					3.189	81.0						
M27 x 2	1	07272		11.08	17272		07272MA	17272MA	1.063	27.0	10.875		27.00	25.00	36.00	34.00
	1.5	07273	30.40	17.40	17273	AS PER "MA SPECIFICATION"	07273MA	17273MA	1.594	40.5	17.000	31.30	40.50	38.50	49.50	47.50
	2	07274	30.85	23.87	17274		07274MA	17274MA	2.126	54.0	23.250	32.30	54.00	52.00	63.00	61.00
	2.5	07275		30.2	17275		07275MA	17275MA	2.657	67.5	29.375		67.50	65.50	76.50	74.50
	3	07276		36.52	17276		07276MA	17276MA	3.189	81.0	35.500		81.00	79.00	90.00	88.00
M27 x 3	1				15272		AS PER "MA SPECIFICATION"	05272	15272MA	1.063	27.0	7.000		27.00	24.00	40.50
	1.5				15273	05273		15273MA	1.594	40.5	11.250	31.40	40.50	37.50	54.00	51.00
	2				15274	05274		15274MA	2.126	54.0	15.500	32.40	54.00	51.00	67.50	64.50
	2.5				15275	05275		15275MA	2.657	67.5	19.750		67.50	64.50	81.00	78.00
	3				15276	05276		15276MA	3.189	81.0	24.000		81.00	78.00	94.50	91.50
M30 x 1.5	1	08302		17.45					1.181	30.0						
	1.5	08303	32.50	26.95					1.772	45.0						
	2	08304	32.80	36.55	Upon Request				2.362	60.0						
	2.5	08305		46.05					2.953	75.0						
	3	08306		55.55					3.543	90.0						
M30 x 2	1	07302		12.48	17302	AS PER "MA SPECIFICATION"	07302MA	17302MA	1.181	30.0	12.250		30.00	28.00	39.00	37.00
	1.5	07303	33.55	19.58	17303		07303MA	17303MA	1.772	45.0	19.125	34.50	45.00	43.00	54.00	52.00
	2	07304	34.00	26.54	17304		07304MA	17304MA	2.362	60.0	25.875	35.70	60.00	58.00	69.00	67.00
	2.5	07305		33.62	17305		07305MA	17305MA	2.953	75.0	32.750		75.00	73.00	84.00	82.00
	3	07306		40.58	17306		07306MA	17306MA	3.543	90.0	39.500		90.00	88.00	99.00	97.00
M30 x 3	1	05302-3			15302-3	AS PER "MA SPECIFICATION"		15302-3MA	1.181	30.0	7.875		30.00	27.00	43.50	40.50
	1.5	05303-3			15303-3		15303-3MA	1.772	45.0	12.500	34.90	45.00	42.00	58.50	55.50	
	2	05304-3			15304-3		15304-3MA	2.362	60.0	17.125	36.10	60.00	57.00	73.50	70.50	
	2.5	05305-3			15305-3		15305-3MA	2.953	75.0	21.875		75.00	72.00	88.50	85.50	
	3	05306-3			15306-3		15306-3MA	3.543	90.0	26.500		90.00	87.00	103.50	100.50	
M30 x 3.5	1	05302		6.65	15302				1.181	30.0			30.00	26.50	45.75	42.25
	1.5	05303	34.85	10.75	15303				1.772	45.0			45.00	41.50	60.75	57.25
	2	05304	35.35	14.89	15304				2.362	60.0			60.00	56.50	75.75	72.25
	2.5	05305		18.95	15305				2.953	75.0			75.00	71.50	90.75	87.25
	3	05306		23.13	15306				3.543	90.0			90.00	86.50	105.75	102.25
M33 x 2	1	07332		13.93	17332	AS PER "MA SPECIFICATION"		17332MA	1.299	33.0	13.625		33.00	31.00	42.00	40.00
	1.5	07333	36.70	21.67	17333		17333MA	1.949	49.5	21.125	37.80	49.50	47.50	58.50	56.50	
	2	07334	37.15	39.42	17334		17334MA	2.598	66.0	28.625	39.20	66.00	64.00	75.00	73.00	
	2.5	07335		37.03	17335		17335MA	3.248	82.5	36.000		82.50	80.50	91.50	89.50	
	3	07336		44.78	17336		17336MA	3.898	99.0	43.500		99.00	97.00	108.00	106.00	

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.

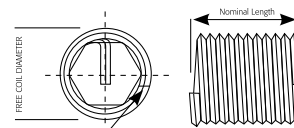
Fitted Insert:

- 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.



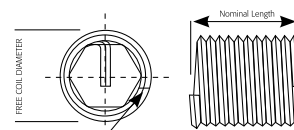
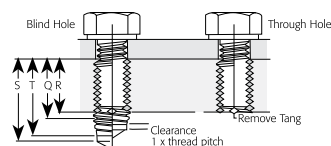
Recoil Metric Insert Part Number Call-Out and Dimensional Data

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	Insert Length mm	Number of Coils	Free Coil Dia Min./Max.	SCREW "D"			
		Q	R	S	T												
M33 x 3	1	07332-3		9.05	17332-3MA					1.299	33.00	8.750	33.00	30.00	46.50	43.50	
	1.5	07333-3	37.65	14.25	17333-3MA					1.949	49.50	13.875	38.10	49.50	46.50	63.00	60.00
	2	07334-3	38.00		17334-3MA					2.598	66.00	19.000	39.50	66.00	63.00	79.50	76.50
	2.5	07335-3			17335-3MA					3.248	82.50	24.125		82.50	79.50	96.00	93.00
	3	07336-3			17336-3MA					3.898	99.00	29.250		99.00	96.00	112.50	109.50
M33 x 3.5	1	05332		7.55	15332					1.299	33.0			33.00	29.50	48.75	45.25
	1.5	05333	38.20	11.95	15333					1.949	49.5			49.50	46.00	65.25	61.75
	2	05334	38.55	16.40	15334					2.598	66.0			66.00	62.50	81.75	78.25
	2.5	05335		21.15	15335					3.248	82.5			82.50	79.00	98.25	94.75
	3	05336		25.30	15336					3.898	99.0			99.00	95.50	114.75	111.25
M36 x 1.5	1	08362		22.15	18362					1.417	36.0			36.00	34.50	42.75	41.25
	1.5	08363	38.45	33.95	18363					2.126	54.0			54.00	52.50	60.75	59.25
	2	08364	38.95	45.75	18364					2.835	72.0			72.00	70.50	78.75	77.25
	2.5	08365		57.65	18365					3.543	90.0			90.00	88.50	96.75	95.25
	3	08366		69.45	18366					4.252	108.0			108.00	106.50	114.75	113.25
M36 x 2	1	07362-2		16.15	17362-2					1.417	36.0	15.000		36.00	34.00	45.00	43.00
	1.5	07363-2	39.52	25.05	17363-2	AS PER "MA SPECIFICATION"				2.126	54.0	23.250	41.00	54.00	52.00	63.00	61.00
	2	07364-2	40.05	33.75	17364-2					2.835	72.0	31.375	42.40	72.00	70.00	81.00	79.00
	2.5	07365-2		42.65	17365-2					3.543	90.0	39.500		90.00	88.00	99.00	97.00
	3	07366-2		51.45	17366-2					4.252	108.0	47.750		108.00	106.00	117.00	115.00
M36 x 3	1							07362		1.417	36.0	9.750		36.00	33.00	49.50	46.50
	1.5							07363		2.126	54.0	15.250	41.30	54.00	51.00	67.50	64.50
	2				Upon Request			07364		2.835	72.0	20.875	42.70	72.00	69.00	85.50	82.50
	2.5							07365		3.543	90.0	26.500		90.00	87.00	103.50	100.50
	3							07366		4.252	108.0	32.000		108.00	105.00	121.50	118.50
M36 x 4.0	1	05362		7.00	15362					1.417	36.0			36.00	32.00	54.00	50.00
	1.5	05363	41.90	11.35	15363					2.126	54.0			54.00	50.00	72.00	68.00
	2	05364	42.40	15.75	15364					2.835	72.0			72.00	68.00	90.00	86.00
	2.5	05365		20.05	15365					3.543	90.0			90.00	86.00	108.00	104.00
	3	05366		24.35	15366					4.252	108.0			108.00	104.00	126.00	122.00
M39 x 2	1	08392		16.95	18392				08392MA	1.535	39.0	16.375		39.00	37.00	48.00	46.00
	1.5	08393	42.40	26.25	18393	AS PER "MA SPECIFICATION"			08393MA	2.303	58.5	25.250	44.30	58.50	56.50	67.50	65.50
	2	08394	43.05	35.55	18394				08394MA	3.071	78.0	34.125	45.70	78.00	76.00	87.00	85.00
	2.5	08395		44.85	18395				08395MA	3.839	97.5	43.000		97.50	95.50	106.50	104.50
	3	08396		54.15	18396				08396MA	4.606	117.0	51.87		117.00	115.00	126.00	124.00
M39 x 3	1	07392		10.95	17392					1.535	39.0	10.750		39.00	36.00	52.50	49.50
	1.5	07393	43.87	17.15	17393	AS PER "MA SPECIFICATION"				2.303	58.5	16.750	44.40	58.50	55.50	72.00	69.00
	2	07394	44.30	23.35	17394			Upon Request		3.071	78.0	22.750	45.80	78.00	75.00	91.50	88.50
	2.5	07395		29.55	17395					3.839	97.5	28.875		97.50	94.50	111.00	108.00
	3	07396		35.75	17396					4.606	117.0	34.875		117.00	114.00	130.50	127.50
M39 x 4	1	05392		7.80	15392					1.535	39.0			39.00	35.00	57.00	53.00
	1.5	05393	45.05	12.50	15393					2.303	58.5			58.50	54.50	76.50	72.50
	2	05394	45.55	17.15	15394					3.071	78.0			78.00	74.00	96.00	92.00
	2.5	05395		21.85	15395					3.839	97.5			97.50	93.50	115.50	111.50
	3	05396		23.55	15396					4.606	117.0			117.00	113.00	135.00	131.00

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.

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.

- 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: Dimensions shown are for MA parts only.

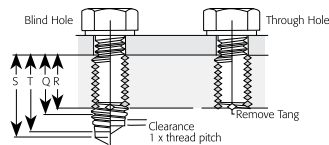
Recoil Metric Insert Part Number Call-Out and Dimensional Data

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
M42 x 2	1	08422		19.15					1.654	42.0			42.00	40.00	51.00	49.00
	1.5	08423	44.70	29.45					2.480	63.0			63.00	61.00	72.00	70.00
	2	08424	45.50	39.85	Upon Request				3.307	84.0			84.00	82.00	93.00	91.00
	2.5	08425		50.15									105.00	103.00	114.00	112.00
	3	08426		60.45									126.00	124.00	135.00	133.00
M42 x 3	1	07422		11.75					1.654	42.0			42.00	39.00	55.50	52.50
	1.5	07423	47.20	18.45					2.480	63.0			63.00	60.00	76.50	73.50
	2	07424	47.85	26.05	Upon Request				3.307	84.0			84.00	81.00	97.50	94.50
	2.5	07425		31.75									105.00	102.00	118.50	115.50
	3	07426		38.45									126.00	123.00	139.50	136.50
M42 x 4.5	1	05422		7.35					1.654	42.0			42.00	37.50	62.25	57.75
	1.5	05423	48.5	11.85					2.480	63.0			63.00	58.50	83.25	78.75
	2	05424	49.00	16.35	Upon Request				3.307	84.0			84.00	79.50	104.25	99.75
	2.5	05425		20.85									105.00	100.50	125.50	120.75
	3	05426		25.35									126.00	121.50	146.25	141.75
M42 x 4	1	05422-4		8.50					1.654	42.0			42.00	38.00	60.00	56.00
	1.5	05423-4	48.50	13.45					2.480	63.0			63.00	59.00	81.00	77.00
	2	05424-4	49.00	18.65	Upon Request				3.307	84.0			84.00	80.00	102.00	98.00
	2.5	05425-4		23.65									105.00	101.00	123.00	119.00
	3	05426-4		28.65									126.00	122.00	144.00	140.00
M45 x 3	1	07452		12.70									45.00	42.00	58.50	55.50
	1.5	07453	50.30	19.85					2.657	67.5			67.50	64.50	81.00	78.00
	2	07454	51.00	26.95	Upon Request								90.00	87.00	103.50	100.50
	2.5	07455		34.15									112.50	109.50	126.00	123.00
	3	07456		41.25									135.00	132.00	148.50	145.50
M48 x 3	1	07482		13.65									48.00	45.00	61.50	58.50
	1.5	07483	52.50	21.25					2.835	72.0			72.00	69.00	85.50	82.50
	2	07484	53.5	28.85	Upon Request								96.00	93.00	109.50	106.50
	2.5	07485		36.45									120.00	117.00	133.50	130.50
	3	07486		44.15									144.00	141.00	157.50	154.50
M48 x 5	1	05482											48.00	45.00	70.50	65.50
	1.5	05483	55.47	12.15					2.835	72.0			72.00	67.00	94.50	89.50
	2	05484	56.4	17.10	Upon Request								96.00	91.00	118.50	113.50
	2.5	05485											120.00	115.00	142.50	137.50
	3	05486											144.00	139.00	166.50	161.50
M48 x 4	1.5	05483-4	53.80	15.56	Upon Request				2.835	72.0			72.00	68.00	90.00	86.00
			54.30													
M52 x 5	1.5	05523	59.53	13.45	Upon Request				3.071	78.0			78.00	73.00	100.50	95.50
	2	05524	60.25	18.00									104.00	99.00	126.50	121.50
M52 x 3	1	07522	57.37	15.00	Upon Request				3.071	78.0						
	1.5	07523	57.90	23.20									78.00	75.00	91.50	88.50

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: 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.

