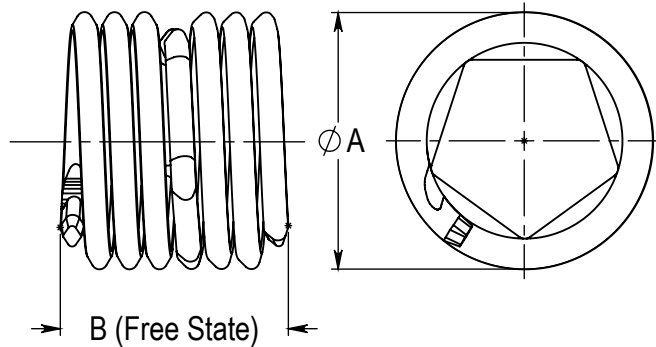
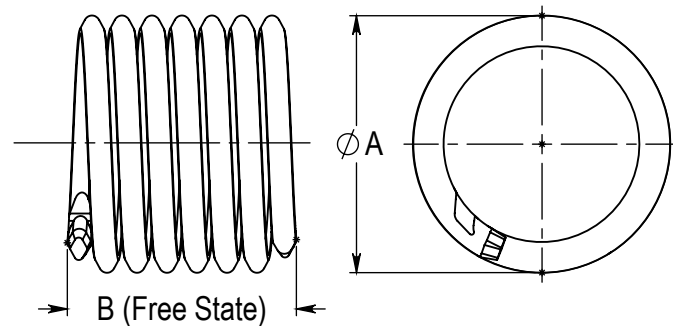


|          |            |                 |          |          |
|----------|------------|-----------------|----------|----------|
| Revision | Revised By | Description     | Date     | Approval |
| New      | GP         | Initial Release | 11-12-18 | MO       |

## Locking



## Non-Locking




|      |   |   |   |   |      |   |            |
|------|---|---|---|---|------|---|------------|
| 2TLF | - | 3 | C | - | 0285 | W | SF         |
| 1    |   | 2 | 3 |   | 4    | 5 | see note 9 |

| Nominal Thread Size | 1            |             | 2    | 3   | 4              |       |       |       |       | 5   | Free Outer Diameter (A) |       | Number of Coils (B, see note 4) |        |        |        |        |
|---------------------|--------------|-------------|------|---|----------------|-------|-------|-------|-------|---|-------------------------|-------|---------------------------------|--------|--------|--------|--------|
|                     | Insert Style |             | Size | Material  | Nominal Length |       |       |       |       | Finish  | Min                     | Max   | 1D                              | 1.5D   | 2D     | 2.5D   | 3D     |
|                     | Locking      | Non-Locking |      |   | 1D             | 1.5D  | 2D    | 2.5D  | 3D    |   |                         |       |                                 |        |        |        |        |
| 0-80 <sup>11</sup>  | 2TLF         | 2TNF        | 00   | B- Phosphor Bronze<br>C- CRES Steel<br>(304 Stainless Steel) <sup>10</sup><br>N- Nitronic 60®<br>M- Nimonic 90®<br>T- Inconel X-750 | 0.060          | 0.090 | 0.120 | ---   | ---   | Blank- No Finish<br>W- Dry Film Lubricant<br>Y- Cadmium<br>V- Silver Plating<br>A- Passivation<br>P- Xylan<br>B- Blue Dye<br>G- Green Dye | ---                     | ---   | 3                               | 5-1/2  | 7-3/8  | ---    | ---    |
| 10-32               |              |             | 3    |   | 0.190          | 0.285 | 0.380 | 0.475 | 0.570 |   | 0.236                   | 0.256 | 4-1/8                           | 6-7/8  | 9-1/2  | 12-1/4 | 14-7/8 |
| 1/4-28              |              |             | 4    |   | 0.250          | 0.375 | 0.500 | 0.625 | 0.750 |   | 0.306                   | 0.326 | 5                               | 8-1/4  | 11-3/8 | 14-1/2 | 17-5/8 |
| 5/16-24             |              |             | 5    |   | 0.312          | 0.469 | 0.625 | 0.781 | 0.938 |   | 0.380                   | 0.400 | 5-1/2                           | 8-7/8  | 12-1/4 | 15-5/8 | 19     |
| 3/8-24              |              |             | 6    |   | 0.375          | 0.562 | 0.750 | 0.938 | 1.125 |   | 0.448                   | 0.468 | 6-7/8                           | 11     | 15     | 19-1/8 | 23-1/8 |
| 7/16-20             |              |             | 7    |   | 0.438          | 0.656 | 0.875 | 1.094 | 1.312 |   | 0.524                   | 0.549 | 6-5/8                           | 10-5/8 | 14-5/8 | 18-1/2 | 22-1/2 |
| 1/2-20              |              |             | 8    |   | 0.500          | 0.750 | 1.00  | 1.250 | 1.500 |   | 0.592                   | 0.617 | 7-7/8                           | 12-3/8 | 16-7/8 | 21-3/8 | 25-7/8 |

Notes:

1. For each threadsize, complete part number consists of combining columns 1-5 across each row.
2. The nominal length is a calculated number and cannot be used to measure the insert in the free state. It is the actual installed length of the insert plus 0.5 pitch ( $L_n = L_a + 0.5P$ ), see column 4.
3. The nominal length of the insert is a function of the nominal thread size (1.5D x .190 in = .285 in).
4. The number of free coils is measured from notch to notch. It is the total number of revolutions  $\pm 0.25$  coil.
5. Assembled length of insert is in accordance to NASM33537.
6. Locking torque specification conforms to NASM8846.
7. Inserts meet NAS130 specification.
8. When assembled in an STI thread, conforming to NASM33537 specification, the finished thread shall conform to FED-STD-H28/21 and shall accept external threads per MIL-S-7742 or AS8879.
9. For strip-feed packaged inserts, use "SF" at the end of the part number. Not available for all plating options. Leave blank for bulk packaged inserts.
10. 304 Stainless Steel is the most popular wire material and meets AS7245 specification.
11. Non-Locking only.

|   |          |             |  |
|---|----------|-------------|--|
| KATO Fastening Systems, Inc., 11864 Fishing Point Dr., Newport News, VA 23606, <a href="http://www.katofastening.com">www.katofastening.com</a> |          |             |  |
| Drawing No.   | KSTD-008 | Description | KATO Tangless UNF Standard, Locking & Non-Locking Screw Thread Inserts (STI) |
| Revision  | New      | Drawn By    | G. Patterson   |
| Date  | 11-12-18 | Approved By | M. Oana  |



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