

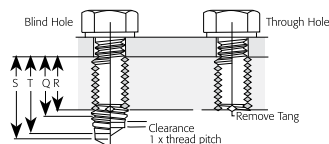
# Recoil Inch Insert Part Number Call-Out and Dimensional Data

Thread Nominal UNF	Nominal Length Dia	Part Number	Recoil Spec		MS spec				BASIC LENGTH OF INSERT						
			Free Running Free Coil Dia Min/Max	Number of coils	Free running Part Number	Screw Locking Part Number	Insert Length Inches	mm	Number of coils	FreeCoil Dia Min/Max	NOMINAL DIAMETER OF SCREW 'D'				
										Q	R	S	T		
#8 - 36	1D	04582	5.14 - 5.28	3.85	04582MS	14582	0.164	4.2	3.875	.204	0.164	0.136	0.289	0.261	
	1.5D	04583		6.85	04583MS	14583	0.246	6.2	6.500		0.246	0.218	0.371	0.343	
	2D	04584		9.35	04584MS	14584	0.328	8.3	9.125		.224	0.328	0.300	0.453	0.425
	2.5D	04585		11.95	04585MS		0.410	10.4	11.625			0.410	0.382	0.535	0.507
	3D	04586		14.65	04586MS		0.492	12.5	14.250			0.492	0.464	0.617	0.589
#10 - 32	1D	04602	5.85 - 6.00	4.25	04602MS	14602	0.190	4.8	4.125	.236	0.190	0.159	0.331	0.299	
	1.5D	04603		7.05	04603MS	14603	0.285	7.2	6.875		.256	0.285	0.254	0.426	0.394
	2D	04604		9.95	04604MS	14604	0.380	9.7	9.500			0.380	0.349	0.521	0.489
	2.5D	04605		12.25	04605MS	14605	0.475	12.1	12.000			0.475	0.444	0.616	0.584
	3D	04606		15.65	04606MS	14606	0.570	14.5	14.875			0.570	0.539	0.711	0.679
#12 - 28	1D				04622MS		0.216	5.5	4.25	.265	5.49	4.58	9.57	8.66	
	1.5D				04623MS		0.324	8.2	7.30		8.23	7.32	12.31	11.40	
	2D				04624MS	Upon Req.	0.432	11	9.85		.275	10.97	10.07	15.05	14.15
	2.5D						0.540	13.7							
	3D						0.648	16.5							
1/4-28	1D	04042	7.60-7.80	5.05	04042MS	14042	0.250	6.4	5.000	.306	0.250	0.214	0.411	0.375	
	1.5D	04043		8.45	04043MS	14043	0.375	9.5	8.250		.326	0.375	0.339	0.536	0.500
	2D	04044		11.65	04044MS	14044	0.500	12.7	11.375			0.500	0.464	0.661	0.625
	2.5D	04045		14.95	04045MS	14045	0.625	15.9	14.500			0.625	0.589	0.786	0.750
	3D	04046		18.15	04046MS	14046	0.750	19.1	17.625			0.750	0.714	0.911	0.875
5/16-24	1D	04052	9.45-9.65	5.55	04052MS	14052	0.313	8	5.500	.380	0.312	0.271	0.500	0.458	
	1.5D	04053		9.05	04053MS	14053	0.470	11.9	8.875		.400	0.469	0.428	0.656	0.615
	2D	04054		12.55	04054MS	14054	0.626	15.9	12.250			0.625	0.583	0.812	0.771
	2.5D	04055		16.15	04055MS	14055	0.783	19.9	15.625			0.781	0.740	0.969	0.927
	3D	04056		19.65	04056MS	14056	0.939	23.9	19.000			0.937	0.896	1.125	1.083
3/8-24	1D	04062	11.00-11.20	7.05	04062MS	14062	0.375	9.5	6.875	.448	0.375	0.333	0.562	0.521	
	1.5D	04063		11.25	04063MS	14063	0.563	14.3	11.000		.468	0.562	0.521	0.750	0.708
	2D	04064		15.45	04064MS	14064	0.750	19.1	15.000			0.750	0.708	0.937	0.896
	2.5D	04065		19.75	04065MS	14065	0.938	23.8	19.125			0.937	0.896	1.125	1.083
	3D	04066		23.95	04066MS	14066	1.125	28.6	23.125			1.125	1.083	1.312	1.271
7/16-20	1D	04072	12.96-13.20	6.85	04072MS	14072	0.438	11.1	6.625	.524	0.437	0.387	0.662	0.612	
	1.5D	04073		11.05	04073MS	14073	0.657	16.7	10.625		.549	0.656	0.606	0.881	0.831
	2D	04074		15.25	04074MS	14074	0.876	22.3	14.625			0.875	0.825	1.100	1.050
	2.5D	04075		19.75	04075MS	14075	1.095	27.8	18.500			1.094	1.044	1.319	1.269
	3D	04076		23.45	04076MS	14076	1.314	33.4	22.500			1.312	1.262	1.537	1.488
1/2-20	1D	04082	14.60-14.90	8.05	04082MS	14082	0.500	12.7	7.875	.592	0.500	0.450	0.725	0.675	
	1.5D	04083		12.75	04083MS	14083	0.750	19.1	12.375		.617	0.750	0.700	0.975	0.925
	2D	04084		17.45	04084MS	14084	1.000	25.4	16.875			1.000	0.950	1.225	1.175
	2.5D	04085		22.05	04085MS	14085	1.250	31.8	21.375			1.250	1.200	1.475	1.425
	3D	04086		26.75	04086MS	14086	1.500	38.1	25.875			1.500	1.450	1.725	1.675
9/16-18	1D	04092	16.38-16.68	8.15	04092MS	14092	0.563	14.3	8.000	.666	0.562	0.507	0.812	0.757	
	1.5D	04093		12.85	04093MS	14093	0.845	21.5	12.500		.691	0.844	0.788	1.094	1.038
	2D	04094		17.65	04094MS	14094	1.126	28.6	17.125			1.125	1.068	1.375	1.319
	2.5D	04095		22.45	04095MS	14095	1.408	35.8	21.750			1.406	1.351	1.656	1.601
	3D	04096		27.15	04096MS	14096	1.689	42.9	26.250			1.687	1.632	1.937	1.882

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.

