

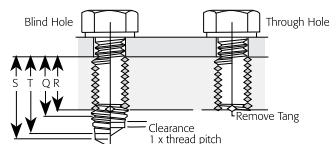
Recoil Inch Insert Part Number Call-Out and Dimensional Data

Thread Nominal UNC	Nominal Length Dia	Free Running Part Number	Screw Locking Part Number	Insert Length		Number of Coils	Free Coil Dia		BASIC LENGTH OF INSERT NOMINAL DIAMETER OF SCREW "D"			
				inches	mm		Min.	Max	Q	R	S	T
#2 - 56	1D	03522	13522	0.086	2.2	3.000			0.086	0.068	0.166	0.148
	1.5D	03523	13523	0.129	3.3	5.250	.110		0.129	0.111	0.209	0.191
	2D	03524	13524	0.172	4.4	7.375	.119		0.172	0.154	0.252	0.234
	2.5D	03525	13525	0.215	5.5	9.625			0.215	0.197	0.295	0.277
	3D	03526	13526	0.258	6.6	11.875			0.258	0.240	0.338	0.320
#3 - 48	1D	03532	13532	0.099	2.5	2.875			0.099	0.078	0.193	0.172
	1.5D	03533	13533	0.149	3.8	5.000	.128		0.148	0.127	0.242	0.221
	2D	03534	13534	0.198	5	7.250	.139		0.198	0.177	0.292	0.271
	2.5D	03535	13535	0.248	6.3	9.375			0.248	0.227	0.342	0.321
	3D	03536	13536	0.297	7.5	11.500			0.297	0.276	0.391	0.370
#4 - 40	1D	03542	13542	0.112	2.8	2.750			0.112	0.087	0.224	0.199
	1.5D	03543	13543	0.168	4.3	4.750	.144		0.168	0.143	0.28	0.255
	2D	03544	13544	0.224	5.7	6.750	.159		0.224	0.199	0.336	0.311
	2.5D	03545	13545	0.280	7.1	8.875			0.280	0.255	0.392	0.367
	3D	03546	13546	0.336	8.5	10.875			0.336	0.311	0.448	0.423
#5 - 40	1D	03552	13552	0.112	2.8	3.250			0.125	0.100	0.237	0.212
	1.5D	03553	13553	0.168	4.3	5.500	.158		0.187	0.162	0.300	0.275
	2D	03554	13554	0.224	5.7	7.750	.173		0.250	0.225	0.362	0.337
	2.5D	03555	13555	0.280	7.1	10.000			0.312	0.287	0.425	0.400
	3D	03556	13556	0.336	8.5	12.250			0.375	0.350	0.487	0.462
#6 - 32	1D	03562	13562	0.138	3.5	2.750			0.138	0.107	0.279	0.247
	1.5D	03563	13563	0.207	5.3	4.750	.178		0.207	0.176	0.348	0.316
	2D	03564	13564	0.276	7	6.875	.193		0.276	0.245	0.417	0.385
	2.5D	03565	13565	0.345	8.8	8.875			0.345	0.314	0.486	0.454
	3D	03566	13566	0.414	10.5	10.750			0.414	0.383	0.555	0.523
#8 - 32	1D	03582	13582	0.164	4.2	3.500			0.164	0.133	0.305	0.273
	1.5D	03583	13583	0.246	6.2	6.000	.205		0.246	0.215	0.387	0.355
	2D	03584	13584	0.328	8.3	8.375	.220		0.328	0.297	0.469	0.437
	2.5D	03585	13585	0.410	10.4	10.750			0.410	0.379	0.551	0.519
	3D	03586	13586	0.492	12.5	13.250			0.492	0.461	0.633	0.601
#10 - 24	1D	03602	13602	0.190	4.8	2.875			0.190	0.148	0.377	0.336
	1.5D	03603	13603	0.285	7.2	5.000	.244		0.285	0.243	0.472	0.431
	2D	03604	13604	0.380	9.7	7.125	.259		0.380	0.338	0.567	0.526
	2.5D	03605	13605	0.475	12.1	9.250			0.475	0.433	0.662	0.621
	3D	03606	13606	0.570	14.5	11.375			0.570	0.528	0.757	0.716
#12 - 24	1D	03622	13622	0.216	5.5	3.500			0.216	0.174	0.404	0.362
	1.5D	03623	13623	0.324	8.2	6.000	.270		0.324	0.282	0.512	0.470
	2D	03624	13624	0.432	11	8.375	.285		0.432	0.390	0.620	0.578
	2.5D	03625	13625	0.540	13.7	10.625			0.540	0.498	0.727	0.686
	3D	03626	13626	0.648	16.5	13.125			0.648	0.606	0.836	0.794
1/4-20	1D	03042	13042	0.250	6.4	3.375			0.250	0.200	0.475	0.425
	1.5D	03043	13043	0.375	9.5	5.750	.310		0.375	0.325	0.600	0.550
	2D	03044	13044	0.500	12.7	8.000	.330		0.500	0.450	0.725	0.675
	2.5D	03045	13045	0.625	15.9	10.375			0.625	0.575	0.850	0.800
	3D	03046	13046	0.750	19.1	12.750			0.750	0.700	0.975	0.925

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.

