

FED. SUPPLY CLASS

5340

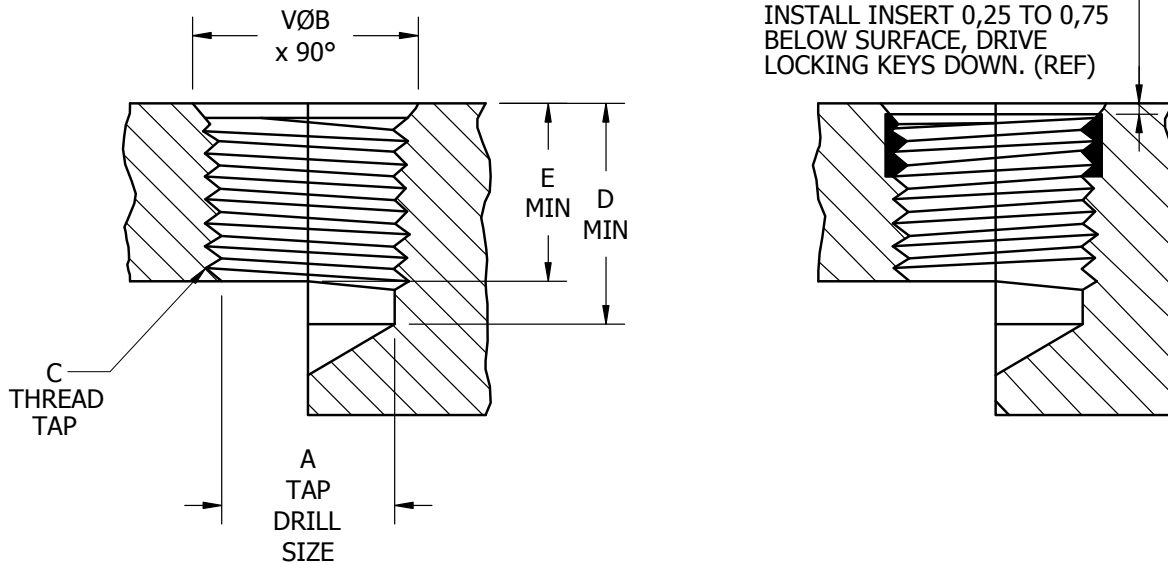


FIGURE 1 – INSERT INSTALLATION

TABLE I – INSTALLATION DATA FOR MINIATURE INSERTS

DASH NUMBER	ØA TAP DRILL /3/	ØB CSK +0,25 -0,00	C THREAD TAP 6H	BLIND HOLE	
				D TAP DRILL DEPTH	E TAP DEPTH
016	2,95	3,6	M3,5 x 0,35	5,54	3,54
020	3,40	4,1	M4 x 0,7	6,00	4,00
025	3,90	4,6	M4,5 x 0,75	6,80	5,00
030	4,40	5,1	M5 x 0,8	7,25	5,50
035	5,50	6,1	M6 x 0,75	7,30	6,50
040	5,50	6,1	M6 x 0,75	8,25	6,50

TABLE II – INSTALLATION DATA FOR LIGHTWEIGHT INSERTS

DASH NUMBER	ØA TAP DRILL /3/	ØB CSK +0,25 -0,00	C THREAD TAP 6H	BLIND HOLE	
				D TAP DRILL DEPTH	E TAP DEPTH
050	6,90	8,25	M8 x 1,25	13,25	9,5
060	8,80	10,25	M10 x 1,25	15,25	11,5
070	10,10	11,25	M11 x 1,0	16,25	12,5
080	10,80	12,25	M12 x 1,25	17,25	13,5
100	12,80	14,25	M14 x 1,5	19,25	15,5
120	14,75	16,25	M16 x 1,5	21,25	17,5

1 COMPLETELY REVISED

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 1
		CLASSIFICATION DESIGN STANDARD
PROCUREMENT SPECIFICATION NONE	TITLE INSERT, SCREW THREAD, KEY LOCKED, INSTALLATION AND REMOVAL PROCEDURE, METRIC	DA0145 SHEET 1 OF 4

TABLE III – INSTALLATION DATA FOR HEAVY DUTY INSERTS

DASH NUMBER	ØA TAP DRILL /3/	ØB CSK +0,25 –0,00	C THREAD TAP 6H	BLIND HOLE	
				D TAP DRILL DEPTH	E TAP DEPTH
040	6,90	8,25	M8 x 1,25	13,25	9,5
050	8,80	10,25	M10 x 1,25	16,25	12,5
060	10,80	12,25	M12 x 1,25	18,25	14,5
070	10,80	12,25	M12 x 1,0	18,25	14,5
080	12,80	14,25	M14 x 1,5	21,00	16,5
100	14,75	16,25	M16 x 1,5	23,00	18,5
120	16,75	18,25	M18 x 1,5	25,00	20,5
140	18,75	20,25	M20 x 1,5	27,00	22,5
160	20,50	22,25	M22 x 1,5	29,00	24,5
180	22,50	24,25	M24 x 2,0	34,50	28,5
200	28,00	30,25	M30 x 2,0	40,50	34,5
220	30,00	32,25	M32 x 2,0	42,50	36,5
240	31,00	33,25	M33 x 2,0	43,50	37,5

NOTES:

- (1) DIMENSIONS IN MILLIMETERS.
- (2) TAPPED THREAD SHALL CONFORM TO THE REQUIREMENTS OF FED-STD-H28/21.
- /3/ TAP DRILL DIAMETER TOLERANCES SHALL BE AS FOLLOWS:
 - A. FOR Ø2,95 THRU Ø5,50, TOLERANCE IS + 0,080/–0,025.
 - B. FOR Ø6,90 THRU Ø10,80, TOLERANCE IS + 0,100/–0,025.
 - C. FOR Ø12,80 AND OVER, TOLERANCE IS + 0,130/–0,025.
- (4) BROACHING OF KEY SLOTS MAY BE REQUIRED PRIOR TO INSERT INSTALLATION WHEN PARENT MATERIAL IS HARDER THAN 150HB.
- (5) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (6) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- (7) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.
- (8) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

① COMPLETELY REVISED

REVISION

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Documents
SHEET 2

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