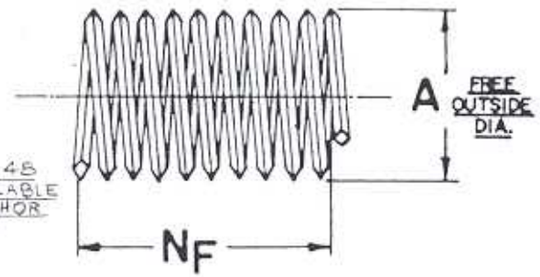
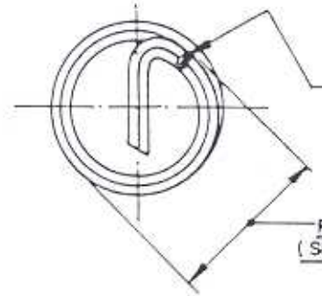
| DATE | RELEASE | REV. LTR. | ALTERATIONS | DRAWN | ENGINEER | APPR'D |
|---|---|---|---|---|---|---|
| 8-13-65 | 6234 | Z | REV. NOTE 1 EXAMPLE PART NO. | FAS | RR | WBR |
| 9-3-87 | 7557 | AA | REVISED & REDRAWN | KJC | ARC | WBR |
| 3-16-88 | 7691 | AB | UPDATED | KJC | ARC | RGH |




10 2-56 & 3-48 NOT AVAILABLE IN PHOSPHOR BRONZE



NOTCH (TO FACILITATE TANG REMOVAL) DESIGNATED BY LETTER "N" IN PART NO. (UNNOTCHED INSERTS ARE SPECIALS)

REDUCED COIL (SEE NOTE 3)

MATERIAL CODE

| MATERIAL | CODE LETTER |
|---|---|
| STAINLESS STEEL (AMS 7245) | C |
| PHOSPHOR BRONZE (AMS 7247) | B |
| CAD PLATING WITH CHROMATE TREATMENT, YELLOW TO BRONZE COLOR (QQ-P-416) | Y |
| INCONEL X (AMS 7246) | T |
| SILVER PLATING (AMS 2410) | V |
| DRY FILM LUBRICANT | W |

9. WHEN INSTALLED IN TAPPED HOLES PER MS 33537 THESE INSERTS WILL PRODUCE THREADED HOLES WHICH CONFORM TO FED-STD-H28 THEY WILL ACCEPT HARDWARE WITH THREADS PER MIL-S-8879.

8. COUNT NUMBER OF COILS 90° FROM TANG.
7. UNSPECIFIED DIMENSIONS ARE MANUFACTURER'S STANDARDS.
6. WIRE SECTION CONFORMS TO 60° UNIFIED AND AMERICAN NATIONAL THREAD FORM.
5. INSERT WHEN INSTALLED IN HELI-COIL® TAPPED HOLE WILL ACCEPT STD. GO GAGE OF SAME CLASS OF FIT AS TAPPED HOLE AND REJECT STD. NOT GO GAGE.
4. INSERT OF NOMINAL LENGTH ("Q" ABOVE) OTHER THAN TABULATED ARE SPECIAL.
3. THERE IS NO REDUCED COIL ON SIZES 1/4 AND SMALLER, WITH THE EXCEPTION OF #2-56 & #3-48 SIZES.
2. NOMINAL LENGTH "Q" IS EQUAL TO MINIMUM FULL THREAD LENGTH. STANDARD LENGTHS ARE MULTIPLES OF THE NOMINAL DIAMETER. ASSEMBLED LENGTH OF INSERT EQUALS NOMINAL LENGTH MINUS 1/2 PITCH.
1. COMPLETE INSERT PART NO. IS COMPOSED OF INSERT PART NO., MATERIAL CODE, NOTCH DESIGNATION, PLATING CODE (IF REQUIRED) AND NOMINAL LENGTH ("Q").
EXAMPLE: 1185-4CNV500 EQUALS 1/4-20 INSERT, STAINLESS STEEL, NOTCHED WITH SILVER PLATE AND .500 NOMINAL LENGTH.

| NOMINAL THREAD SIZE | INSERT PART NO. (SEE NOTE 1) | Q NOMINAL LENGTH (SEE NOTES 1 & 2) | | | | | A | | NF FREE NUMBER OF COILS ± 1/4 COIL (SEE NOTE 8) | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | 1 DIA. | 1 1/2 DIA. | 2 DIA. | 2 1/2 DIA. | 3 DIA. | MIN. | MAX. | 1 DIA. | 1 1/2 DIA. | 2 DIA. | 2 1/2 DIA. | 3 DIA. |
| 4-40 | 1185-04 | 0.112 | 0.168 | 0.224 | 0.280 | 0.336 | .144 | .159 | 2 3/4 | 4 3/4 | 6 3/4 | 8 7/8 | 10 7/8 |
| 5-40 | 1185-05 | 0.125 | 0.188 | 0.250 | 0.312 | 0.375 | .158 | .173 | 3 1/4 | 5 1/2 | 7 3/4 | 10 | 12 1/4 |
| 6-32 | 1185-06 | 0.138 | 0.207 | 0.276 | 0.345 | 0.414 | .178 | .193 | 2 3/4 | 4 3/4 | 6 7/8 | 8 7/8 | 10 7/8 |
| 8-32 | 1185-2 | 0.164 | 0.246 | 0.328 | 0.410 | 0.492 | .205 | .220 | 3 1/2 | 6 | 8 3/8 | 10 3/4 | 13 1/4 |
| 10-24 | 1185-3 | 0.190 | 0.285 | 0.380 | 0.475 | 0.570 | .244 | .259 | 2 7/8 | 5 | 7 1/8 | 9 1/4 | 11 3/8 |
| 12-24 | 1185-1 | 0.216 | 0.324 | 0.432 | 0.540 | 0.648 | .270 | .285 | 3 1/2 | 6 | 8 3/8 | 10 5/8 | 13 1/8 |
| 1/4-20 | 1185-4 | 0.250 | 0.375 | 0.500 | 0.625 | 0.750 | .310 | .330 | 3 3/8 | 5 3/4 | 8 | 10 3/8 | 12 3/4 |
| 5/16-18 | 1185-5 | 0.312 | 0.469 | 0.625 | 0.781 | 0.938 | .380 | .400 | 4 | 6 5/8 | 9 1/4 | 11 7/8 | 14 5/8 |
| 3/8-16 | 1185-6 | 0.375 | 0.562 | 0.750 | 0.938 | 1.125 | .452 | .472 | 4 3/8 | 7 1/4 | 10 | 12 7/8 | 15 3/4 |
| 7/16-14 | 1185-7 | 0.438 | 0.656 | 0.875 | 1.094 | 1.312 | .526 | .551 | 4 1/2 | 7 3/8 | 10 1/4 | 13 1/8 | 16 1/8 |
| 1/2-13 | 1185-8 | 0.500 | 0.750 | 1.000 | 1.250 | 1.500 | .597 | .622 | 4 7/8 | 7 7/8 | 11 | 14 1/8 | 17 1/8 |
| 1/2-12 | 1185-81 | 0.500 | 0.750 | 1.000 | 1.250 | 1.500 | .604 | .629 | 4 1/4 | 7 1/8 | 9 7/8 | 12 3/4 | 15 5/8 |
| 9/16-12 | 1185-9 | 0.562 | 0.844 | 1.125 | 1.406 | 1.688 | .669 | .694 | 5 1/8 | 8 1/4 | 11 1/2 | 14 3/4 | 17 7/8 |
| 5/8-11 | 1185-10 | 0.625 | 0.938 | 1.250 | 1.562 | 1.875 | .742 | .767 | 5 1/4 | 8 1/2 | 11 3/4 | 15 | 18 3/8 |
| 3/4-10 | 1185-12 | 0.750 | 1.125 | 1.500 | 1.875 | 2.250 | .881 | .906 | 5 7/8 | 9 3/8 | 13 | 16 1/2 | 20 1/8 |
| 7/8-9 | 1185-14 | 0.875 | 1.312 | 1.750 | 2.188 | 2.625 | 1.022 | 1.052 | 6 1/4 | 10 | 13 3/4 | 17 1/2 | 21 1/4 |
| 1-8 | 1185-16 | 1.000 | 1.500 | 2.000 | 2.500 | 3.000 | 1.166 | 1.196 | 6 3/8 | 10 1/8 | 14 | 17 3/4 | 21 5/8 |
| 1 1/8-7 | 1185-18 | 1.125 | 1.688 | 2.250 | 2.812 | 3.375 | 1.315 | 1.355 | 6 1/8 | 9 7/8 | 13 5/8 | 17 1/2 | 21 1/4 |
| 1 1/4-7 | 1185-20 | 1.250 | 1.875 | 2.500 | 3.125 | 3.750 | 1.443 | 1.483 | 7 | 11 1/4 | 15 3/8 | 19 1/2 | 23 3/4 |
| 1 3/8-6 | 1185-22 | 1.375 | 2.062 | 2.750 | 3.438 | 4.125 | 1.598 | 1.643 | 6 1/2 | 10 1/2 | 14 3/8 | 18 3/8 | 22 1/4 |
| 1 1/2-6 | 1185-24 | 1.500 | 2.250 | 3.000 | 3.750 | 4.500 | 1.727 | 1.772 | 7 1/4 | 11 1/2 | 15 7/8 | 20 1/8 | 24 1/2 |
| 10 #2-56 | 1185-02 | .088 | .129 | .172 | .215 | .258 | .110 | .118 | 3 | 5 1/4 | 7 3/8 | 9 5/8 | 11 7/8 |
| #3-48 | 1185-03 | .099 | .144 | .198 | .248 | .297 | .128 | .139 | 2 7/8 | 5 | 7 1/4 | 9 3/8 | 11 1/2 |

® REG. U.S. PAT. OFF.

| | | | | |
|---|---|---|---|---|
| HEAT TREATMENT — | DRAWN | KJC | 9-3-87 | MATERIAL: SEE MATERIAL CODE |
| FINISH — | CHECKED | ARC | 1-27-88 | NAME: INSERT, HELI-COIL® SCREW THREAD INSERT (STI) COARSE THREAD SERIES |
| | APPROVED | | | |
| | APPROVED | | | |
| E.O. 13185-DA / REL. 16595 | SCALE — | | | HeliCoil — 1185-OR |