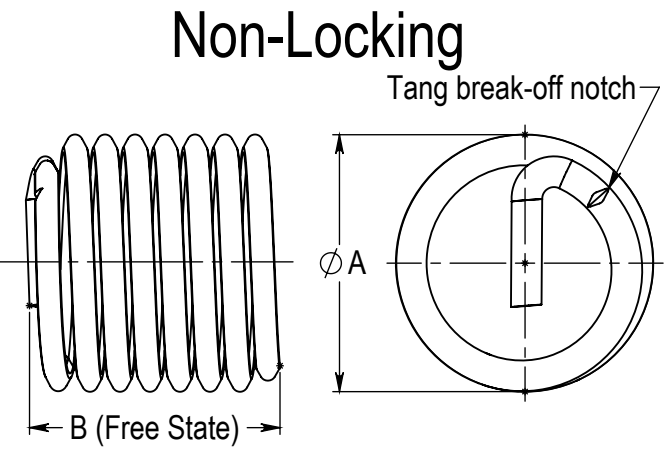
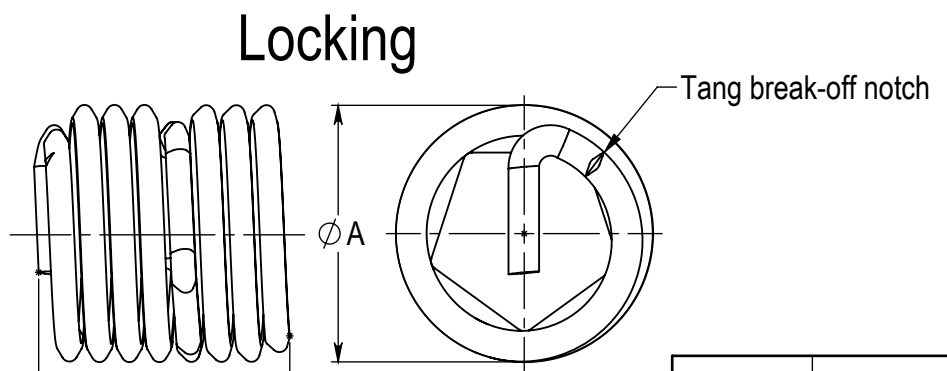


Revision	Revised By	Description	Date	Approval
New	GP	Initial Release	11-12-18	MO



TLF	-	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
3-56	TLF	TNF	03	B- Phosphor Bronze C- CRES Steel (304 Stainless Steel) ¹⁰ N- Nitronic 60® M- Nimonic 90® T- Inconel X-750	0.099	0.148	0.198	0.248	0.297	Blank- No Finish W- Dry Film Lubricant Y- Cadmium V- Silver Plating A- Passivation P- Xylan B- Blue Dye G- Green Dye	0.131	0.146	3-3/8	5-5/8	8	10-3/8	12-5/8			
4-48			04		0.112	0.168	0.224	0.280	0.336		0.147	0.162	3-3/8	5-5/8	7-7/8	10-1/4	12-1/2			
6-40			06		0.138	0.207	0.276	0.345	0.414		0.173	0.193	3-1/2	6	8-3/8	10-3/4	13-1/4			
8-36			2		0.164	0.246	0.328	0.410	0.492		0.204	0.224	3-7/8	6-1/2	9-1/8	11-5/8	14-1/4			
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	1.000	1.250	1.500		0.592	0.617	7-7/8	12-3/8	16-7/8	21-3/8	25-7/8			
9/16-18			9		0.562	0.844	1.125	1.406	1.688		0.666	0.691	8	12-1/2	17-1/8	21-3/4	26-1/4			
5/8-18			10		0.625	0.938	1.250	1.562	1.875		0.733	0.758	9	14-1/8	19-1/4	24-1/4	29-3/8			
3/4-16			12		0.750	1.125	1.500	1.875	2.250		0.876	0.901	9-3/4	15-1/8	20-5/8	26	31-1/2			
7/8-14			14		0.875	1.312	1.750	2.188	2.625		1.021	1.051	9-7/8	15-1/2	21-1/8	26-5/8	32-1/4			
1-12			16		1.000	1.500	2.000	2.500	3.000		1.169	1.199	9-5/8	15	20-1/2	26	31-1/2			
1-1/8-12			18		1.125	1.688	2.250	2.812	3.375		1.304	1.334	11-1/8	17-1/4	23-3/8	29-1/2	35-3/4			
1-1/4-12			20		1.250	1.875	2.500	3.125	3.750		1.439	1.469	12-1/2	19-3/8	26-1/4	33	39-7/8			
1-3/8-12			22		1.375	2.062	2.750	3.438	4.125		1.575	1.610	13-3/4	21-3/8	28-7/8	36-1/2	44			
1-1/2-12			24		1.500	2.250	3.000	3.750	4.500		1.710	1.745	15-1/4	23-1/2	31-5/8	39-7/8	48-1/8			

- Notes:
- For each threadsize, complete part number consists of combining columns 1-5 across each row.
 - 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.
 - The nominal length of the insert is a function of the nominal thread size ($1.5D \times 0.190 \text{ in} = 0.285 \text{ in}$).
 - The number of free coils is measured 90° from the tang. It is the total number of revolutions ± 0.25 coil.
 - Assembled length of insert is in accordance to NASM33537.
 - Locking torque specification conforms to NASM8846.
 - As applicable, inserts meet NASM21209, or NASM124651-NASM124850 specification.
 - When assembled in an STI thread, conforming to NASM33537 specification, the finished thread shall conform to FED-STD-H28/2, and shall accept external threads per MIL-S-7792 or AS8879.
 - For strip-feed packaged inserts, use "SF" at the end of the part number. Not available for all sizes and all plating options. Leave blank for bulk packaged inserts.
 - 304 Stainless Steel is the most popular wire material and meets AS7245 specification.

KATO Fastening Systems, Inc., 11864 Fishing Point Dr., Newport News, VA 23606, www.katofastening.com			
Drawing No.	KSTD-004	Description	KATO Tanged 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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