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KATO Fastening Systems Tangless Specification
(UNC, UNF and Metric Series)

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SPEC NUMBER
KSTD-001

DESCRIPTION
KATO TANGLESS COILTHREAD SPECIFICATION
NON-LOCKING/LOCKING - UNC, UNF, AND METRIC SERIES.

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REV
A

DATE
082312

REVISIONS

REVISED BY	REV	DESCRIPTION	DATE	APPROVED
M. Oana	New	Initial Release	80112	E.S.
M. Oana	A	Added M2 Non-Locking dimensions & note 11	82312	E.S.



SPEC NUMBER
KSTD-001

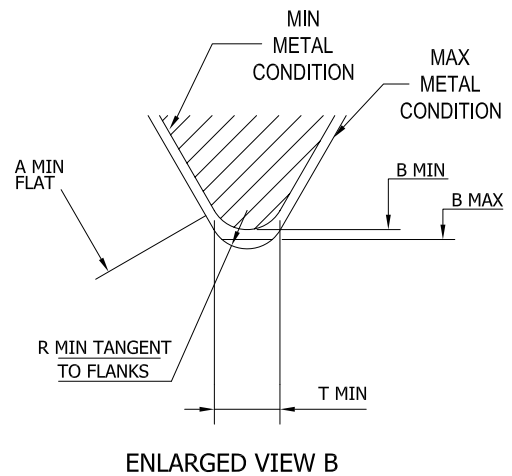
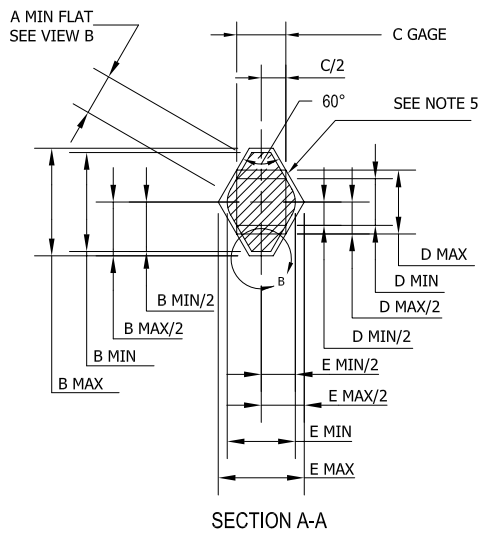
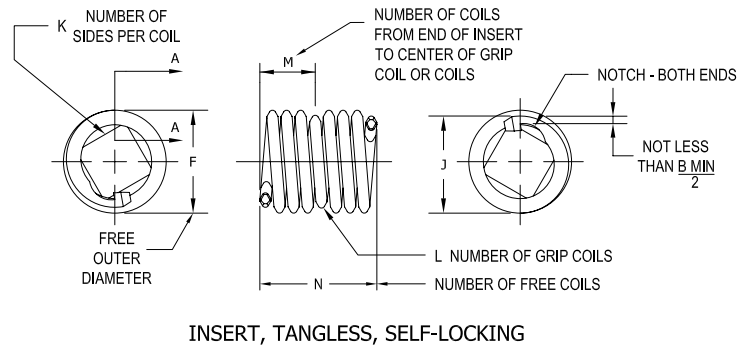
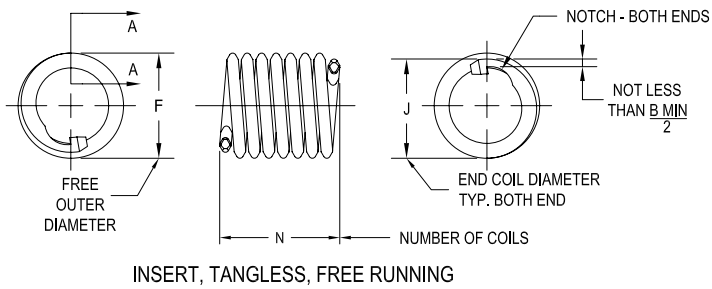
DESCRIPTION
KATO TANGLESS COILTHREAD SPECIFICATION
NON-LOCKING/LOCKING - UNC, UNF, AND METRIC SERIES.

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Section 1: Wire Profile and Insert Specification (UNC, UNF)



NOMINAL THREAD SIZE	A MIN	B		C GAGE	D		E		ØF		ØJ MIN	K	L	R MIN	T MIN
		MIN	MAX		MIN	MAX	MIN	MAX	MIN	MAX					
2 (.0860)-56	0.0027	0.0163	0.0193	0.00893	0.0112	0.0116	0.0126	0.0156	0.110	0.119	0.107	4	1	0.0032	0.0056
4 (.1120)-40	0.0068	0.0241	0.0271	0.0125	0.01584	0.01624	0.0189	0.0219	0.144	0.159	0.141	4	1	0.0045	0.0078
6 (.1380)-32	0.0076	0.0295	0.0338	0.01563	0.01985	0.02030	0.0233	0.0273	0.178	0.193	0.174	4	1	0.0056	0.0098
8 (.1640)-32	0.0076	0.0295	0.0338	0.01563	0.01985	0.02030	0.0233	0.0273	0.205	0.220	0.200	4	1	0.0056	0.0098
10 (.1900)-24	0.0120	0.0410	0.0449	0.02083	0.02656	0.02706	0.0305	0.0365	0.244	0.259	0.237	4	1	0.0075	0.0130
10 (.1900)-32	0.0076	0.0295	0.0338	0.01563	0.01985	0.02030	0.0233	0.0273	0.236	0.256	0.226	5	1	0.0056	0.0098
1/4 (.2500)-20	0.0164	0.0500	0.0540	0.02500	0.03198	0.03248	0.0378	0.0438	0.310	0.330	0.307	5	1	0.0090	0.0156
1/4 (.2500)-28	0.0085	0.0347	0.0387	0.01786	0.02270	0.02320	0.0253	0.0313	0.306	0.326	0.291	5	1	0.0064	0.0112
5/16 (.3125)-18	0.0176	0.0560	0.0600	0.02778	0.03558	0.03608	0.0416	0.0486	0.380	0.400	0.377	5	1	0.0100	0.0174
5/16 (.3125)-24	0.0120	0.0410	0.0449	0.02083	0.02656	0.02706	0.0305	0.0365	0.380	0.400	0.362	6	2	0.0075	0.0130
3/8 (.3750)-16	0.0215	0.0636	0.0677	0.03125	0.04009	0.04059	0.0477	0.0547	0.452	0.472	0.448	6	1	0.0113	0.0195
3/8 (.3750)-24	0.0120	0.0410	0.0449	0.02083	0.02656	0.02706	0.0305	0.0365	0.448	0.468	0.424	6	2	0.0075	0.0130

Section 2: KATO PART NUMBERS (UNC, UNF)

2
1
TLC
2
-
06
3
C
4
-
207
5
W
6
SF
7

Insert Type ¹ (Tangless/Tanged)	Insert Style ²	Size Designation ³	Material ⁴	Nominal Length ⁵	Finish ⁶	Packaging ⁷
Blank - Tanged CoilThread	TLC - Thread Locking Coarse	See Chart Below	B - Phosphor Bronze	See Chart Below	Blank - No Finish	Blank - Bulk
2 - Prefix for Tangless CoilThread II	TNC - Thread Non-Locking Coarse		C - CRES Steel (304 Stainless Steel per AS7245)		W - Dry Film Lubricant per AS5272	SF - Strip Feed
	TLF - Thread Locking Fine		N - Nitronic 60® (UNS S21800)		Y - Cadmium Plating per ASM-QQ-P-416	
	TNF - Thread Non-Locking Fine		T - Inconel X-750		G - Green	
	TLM - Tangless Locking Metric		J - Nimonic 90® (BS HR 503)		B - Blue	
	TNM - Tangless Non-Locking Metric				V - Silver Plating per AMS2411	

1.0 DIA NOMINAL LENGTH								
NOMINAL THREAD SIZE	KATO Part Number		NAS PART NUMBER (REF.)		REF. LENGTH (SEE NOTE 1)	WEIGHT LB/100	M ±1 COIL	N ±.25 COIL (SEE NOTE 2 & 8)
	Free-Running	Self-Locking	Free-Running	Self-Locking				
2 (.0860)-56	2TNC-02C-0086	2TLC-02C-0086	NAS1130-02-10	NAS1130-02L10	0.086	0.0051	1.500	3.000
4 (.1120)-40	2TNC-04C-0112	2TLC-04C-0112	NAS1130-04-10	NAS1130-04L10	0.112	0.0121	1.375	2.750
6 (.1380)-32	2TNC-06C-0138	2TLC-06C-0138	NAS1130-06-10	NAS1130-06L10	0.138	0.0243		
8 (.1640)-32	2TNC-2C-0164	2TLC-2C-0164	NAS1130-08-10	NAS1130-08L10	0.164	0.0355	1.750	3.500
10 (.1900)-24	2TNC-3C-0190	2TLC-3C-0190	NAS1130-3C-10	NAS1130-3CL10	0.190	0.0573	1.4375	2.875
10 (.1900)-32	2TNF-3C-0190	2TLF-3C-0190	NAS1130-3-10	NAS1130-3L10		0.0474	2.0625	4.125
1/4 (.2500)-20	2TNC-4C-0250	2TLC-4C-0250	NAS1130-4-10	NAS1130-4L10	0.250	0.145	1.6875	3.375
1/4 (.2500)-28	2TNF-4C-0250	2TLF-4C-0250	NAS1130-4F-10	NAS1130-4FL10		0.109	2.500	5.000
5/16 (.3125)-18	2TNC-5C-0312	2TLC-5C-0312	NAS1130-5C-10	NAS1130-5CL10	0.3125	0.232	2.000	4.000
5/16 (.3125)-24	2TNF-5C-0312	2TLF-5C-0312	NAS1130-5F-10	NAS1130-5FL10		0.180	2.750	5.500
3/8 (.3750)-16	2TNC-6C-0375	2TLC-6C-0375	NAS1130-6C-10	NAS1130-6CL10	0.375	0.391	2.1875	4.375
3/8 (.3750)-24	2TNF-6C-0375	2TLF-6C-0375	NAS1130-6F-10	NAS1130-6FL10		0.259	3.4375	6.875

1.5 DIA NOMINAL LENGTH								
NOMINAL THREAD SIZE	KATO Part Number		NAS PART NUMBER (REF.)		REF. LENGTH (SEE NOTE 1)	WEIGHT LB/100	M ±1 COIL	N ±.25 COIL (SEE NOTE 2 & 8)
	Free-Running	Self-Locking	Free-Running	Self-Locking				
2 (.0860)-56	2TNC-02C-0129	2TLC-02C-0129	NAS1130-02-15	NAS1130-02L15	0.129	0.0084	2.625	5.250
4 (.1120)-40	2TNC-04C-0168	2TLC-04C-0168	NAS1130-04-15	NAS1130-04L15	0.168	0.0196	2.375	4.750
6 (.1380)-32	2TNC-06C-0207	2TLC-06C-0207	NAS1130-06-15	NAS1130-06L15	0.207	0.0384		
8 (.1640)-32	2TNC-2C-0246	2TLC-2C-0246	NAS1130-08-15	NAS1130-08L15	0.246	0.0556	3.000	6.000
10 (.1900)-24	2TNC-3C-0285	2TLC-3C-0285	NAS1130-3C-15	NAS1130-3CL15	0.285	0.0899	2.500	5.000
10 (.1900)-32	2TNF-3C-0285	2TLF-3C-0285	NAS1130-3-15	NAS1130-3L15		0.0784	3.4375	6.875
1/4 (.2500)-20	2TNC-4C-0375	2TLC-4C-0375	NAS1130-4-15	NAS1130-4L15	0.375	0.196	2.875	5.750
1/4 (.2500)-28	2TNF-4C-0375	2TLF-4C-0375	NAS1130-4F-15	NAS1130-4FL15		0.155	4.125	8.250
5/16 (.3125)-18	2TNC-5C-0469	2TLC-5C-0469	NAS1130-5C-15	NAS1130-5CL15	0.469	0.369	3.3125	6.625
5/16 (.3125)-24	2TNF-5C-0469	2TLF-5C-0469	NAS1130-5F-15	NAS1130-5FL15		0.284	4.4375	8.875
3/8 (.3750)-16	2TNC-6C-0562	2TLC-6C-0562	NAS1130-6C-15	NAS1130-6CL15	0.562	0.625	3.625	7.250
3/8 (.3750)-24	2TNF-6C-0562	2TLF-6C-0562	NAS1130-6F-15	NAS1130-6FL15		0.420	5.500	11.000

Section 2: KATO PART NUMBERS (UNC, UNF cont.)

2 DIA NOMINAL LENGTH								
NOMINAL THREAD SIZE	KATO Part Number		NAS PART NUMBER (REF.)		REF. LENGTH (SEE NOTE 1)	WEIGHT LB/100	M ±1 COIL	N ±.25 COIL (SEE NOTE 2 & 8)
	Free-Running	Self-Locking	Free-Running	Self-Locking				
2 (.0860)-56	2TNC-02C-0172	2TLC-02C-0172	NAS1130-02-20	NAS1130-02L20	0.172	0.0117	3.6875	7.375
4 (.1120)-40	2TNC-04C-0224	2TLC-04C-0224	NAS1130-04-20	NAS1130-04L20	0.224	0.0272	3.375	6.750
6 (.1380)-32	2TNC-06C-0276	2TLC-06C-0276	NAS1130-06-20	NAS1130-06L20	0.276	0.0525	3.4375	6.875
8 (.1640)-32	2TNC-2C-0328	2TLC-2C-0328	NAS1130-08-20	NAS1130-08L20	0.328	0.0776	4.1875	8.375
10 (.1900)-24	2TNC-3C-0380	2TLC-3C-0380	NAS1130-3C-20	NAS1130-3CL20	0.380	0.133	3.5625	7.125
10 (.1900)-32	2TNF-3C-0380	2TLF-3C-0380	NAS1130-3-20	NAS1130-3L20		0.112	4.750	9.500
1/4 (.2500)-20	2TNC-4C-0500	2TLC-4C-0500	NAS1130-4-20	NAS1130-4L20	0.500	0.308	4.000	8.000
1/4 (.2500)-28	2TNF-4C-0500	2TLF-4C-0500	NAS1130-4F-20	NAS1130-4FL20		0.212	5.6875	11.375
5/16 (.3125)-18	2TNC-5C-0625	2TLC-5C-0625	NAS1130-5C-20	NAS1130-5CL20	0.625	0.510	4.625	9.250
5/16 (.3125)-24	2TNF-5C-0625	2TLF-5C-0625	NAS1130-5F-20	NAS1130-5FL20		0.397	6.125	12.250
3/8 (.3750)-16	2TNC-6C-0750	2TLC-6C-0750	NAS1130-6C-20	NAS1130-6CL20	0.750	0.862	5.000	10.000
3/8 (.3750)-24	2TNF-6C-0750	2TLF-6C-0750	NAS1130-6F-20	NAS1130-6FL20		0.553	7.500	15.000

2.5 DIA NOMINAL LENGTH								
NOMINAL THREAD SIZE	KATO Part Number		NAS PART NUMBER (REF.)		REF. LENGTH (SEE NOTE 1)	WEIGHT LB/100	M ±1 COIL	N ±.25 COIL (SEE NOTE 2 & 8)
	Free-Running	Self-Locking	Free-Running	Self-Locking				
2 (.0860)-56	2TNC-02C-0215	2TLC-02C-0215	NAS1130-02-25	NAS1130-02L25	0.215	0.015	4.8125	9.625
4 (.1120)-40	2TNC-04C-0280	2TLC-04C-0280	NAS1130-04-25	NAS1130-04L25	0.280	0.0348	4.4375	8.875
6 (.1380)-32	2TNC-06C-0345	2TLC-06C-0345	NAS1130-06-25	NAS1130-06L25	0.345	0.0666		
8 (.1640)-32	2TNC-2C-0410	2TLC-2C-0410	NAS1130-08-25	NAS1130-08L25	0.410	0.1008	5.375	10.750
10 (.1900)-24	2TNC-3C-0475	2TLC-3C-0475	NAS1130-3C-25	NAS1130-3CL25	0.475	0.172	4.625	9.250
10 (.1900)-32	2TNF-3C-0475	2TLF-3C-0475	NAS1130-3-25	NAS1130-3L25		0.140	6.000	12.000
1/4 (.2500)-20	2TNC-4C-0625	2TLC-4C-0625	NAS1130-4-25	NAS1130-4L25	0.625	0.385	5.1875	10.375
1/4 (.2500)-28	2TNF-4C-0625	2TLF-4C-0625	NAS1130-4F-25	NAS1130-4FL25		0.276	7.250	14.500
5/16 (.3125)-18	2TNC-5C-0781	2TLC-5C-0781	NAS1130-5C-25	NAS1130-5CL25	0.781	0.658	5.9375	11.875
5/16 (.3125)-24	2TNF-5C-0781	2TLF-5C-0781	NAS1130-5F-25	NAS1130-5FL25		0.490	7.8125	15.625
3/8 (.3750)-16	2TNC-6C-0938	2TLC-6C-0938	NAS1130-6C-25	NAS1130-6CL25	0.938	1.064	6.4375	12.875
3/8 (.3750)-24	2TNF-6C-0938	2TLF-6C-0938	NAS1130-6F-25	NAS1130-6FL25		0.709	9.5625	19.125

3 DIA NOMINAL LENGTH								
NOMINAL THREAD SIZE	KATO Part Number		NAS PART NUMBER (REF.)		REF. LENGTH (SEE NOTE 1)	WEIGHT LB/100	M ±1 COIL	N ±.25 COIL (SEE NOTE 2 & 8)
	Free-Running	Self-Locking	Free-Running	Self-Locking				
2 (.0860)-56	2TNC-02C-0258	2TLC-02C-0258	NAS1130-02-30	NAS1130-02L30	0.258	0.0183	5.9375	11.875
4 (.1120)-40	2TNC-04C-0336	2TLC-04C-0336	NAS1130-04-30	NAS1130-04L30	0.336	0.0423	5.4375	10.875
6 (.1380)-32	2TNC-06C-0414	2TLC-06C-0414	NAS1130-06-30	NAS1130-06L30	0.414	0.0807	5.375	10.750
8 (.1640)-32	2TNC-2C-0492	2TLC-2C-0492	NAS1130-08-30	NAS1130-08L30	0.492	0.125	6.625	13.250
10 (.1900)-24	2TNC-3C-0570	2TLC-3C-0570	NAS1130-3C-30	NAS1130-3CL30	0.570	0.219	5.6875	11.375
10 (.1900)-32	2TNF-3C-0570	2TLF-3C-0570	NAS1130-3-30	NAS1130-3L30		0.170	7.4375	14.875
1/4 (.2500)-20	2TNC-4C-0750	2TLC-4C-0750	NAS1130-4-30	NAS1130-4L30	0.750	0.490	6.375	12.750
1/4 (.2500)-28	2TNF-4C-0750	2TLF-4C-0750	NAS1130-4F-30	NAS1130-4FL30		0.338	8.8125	17.625
5/16 (.3125)-18	2TNC-5C-0938	2TLC-5C-0938	NAS1130-5C-30	NAS1130-5CL30	0.938	0.806	7.3125	14.625
5/16 (.3125)-24	2TNF-5C-0938	2TLF-5C-0938	NAS1130-5F-30	NAS1130-5FL30		0.602	9.500	19.000
3/8 (.3750)-16	2TNC-6C-1125	2TLC-6C-1125	NAS1130-6C-30	NAS1130-6CL30	1.125	1.316	7.875	15.750
3/8 (.3750)-24	2TNF-6C-1125	2TLF-6C-1125	NAS1130-6F-30	NAS1130-6FL30		0.862	11.5625	23.125



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Tangless Specification

Metric Series



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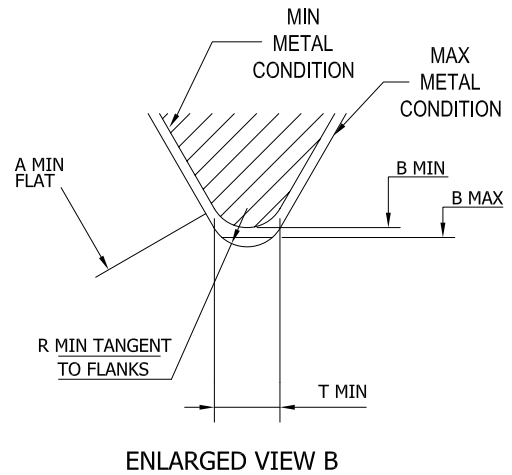
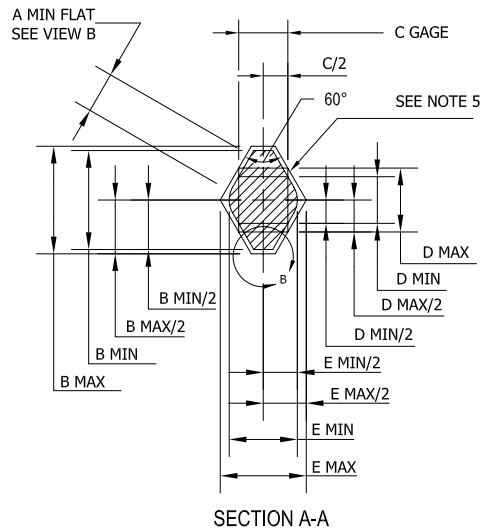
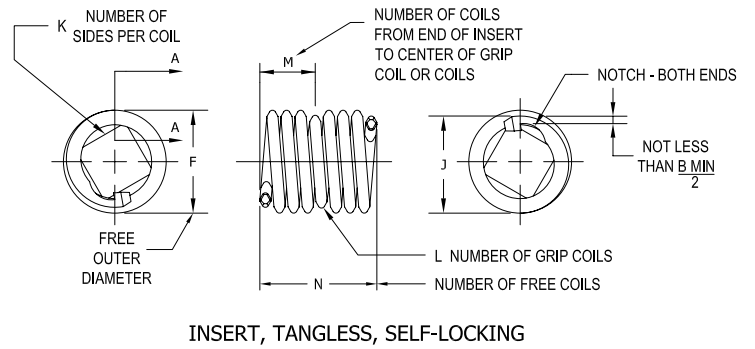
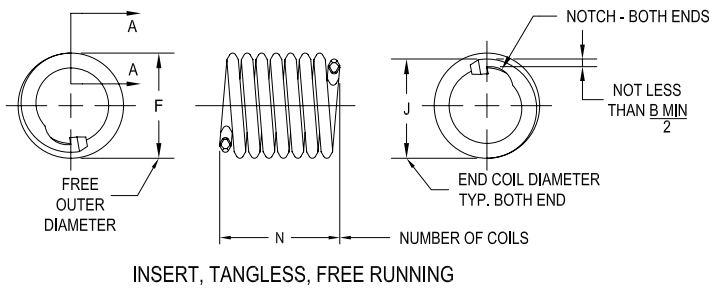
DESCRIPTION
KATO TANGLESS COILTHREAD SPECIFICATION NON-LOCKING/LOCKING - UNC, UNF, AND METRIC SERIES.

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Section 3: Wire Profile and Insert Specification (Metric Series)



NOMINAL THREAD SIZE	A MIN	B		C GAGE	D		E		ØF		ØJ MIN	K		L MAX	R RAD MIN	T MIN
		MIN	MAX		MIN	MAX	MIN	MAX	MIN	MAX						
M2x0.4	0.07	0.395	0.425	0.200	0.2520	0.2600	0.300	0.350	2.50	2.79	2.44	-	-	-	0.072	0.125
M2.5x0.45	0.08	0.437	0.487	0.225	0.2820	0.2920	0.318	0.394	3.20	3.70	3.03	4	5	2	0.081	0.141
M3x0.5	0.11	0.482	0.541	0.250	0.3145	0.3250	0.362	0.438	3.80	4.35	3.59	4	5	2	0.090	0.156
M4x0.7	0.16	0.683	0.758	0.350	0.4445	0.4550	0.510	0.612	5.05	5.60	4.82	4	5	2	0.126	0.219
M5x0.8	0.21	0.775	0.866	0.400	0.5085	0.5200	0.598	0.700	6.20	6.80	5.93	4	5	2	0.144	0.250
M6x1	0.27	0.975	1.083	0.500	0.6370	0.6500	0.748	0.875	7.40	7.95	7.16	4	5	2	0.180	0.312
M8x1.25	0.42	1.251	1.353	0.625	0.7990	0.8120	0.967	1.094	9.80	10.35	9.43	5	6	2	0.226	0.391
M10x1.5	0.51	1.522	1.624	0.750	0.9615	0.9740	1.160	1.312	11.95	12.50	11.71	5	6	2	0.271	0.469
M12x1.75	0.65	1.792	1.894	0.875	1.1240	1.1370	1.379	1.531	14.30	15.00	13.99	5	6	2	0.316	0.547

Section 4: KATO PART NUMBERS (Metric)

1.0 DIA NOMINAL LENGTH								
NOMINAL THREAD SIZE	KATO Part Number		NAS PART NUMBER (REF.)		NOMINAL LENGTH	WEIGHT kg/100	M ±1 COIL	N ±.25 COIL
	Free-Running	Self-Locking	Free-Running	Self-Locking				
M2x0.4	2TNM-2x.4C-2	-----	-----	-----	2	-----	-----	3.250
M2.5x0.45	2TNM-2.5x.45C-2.5	2TLM-2.5x.45C-2.5	NA0276M2A-10	NA0276M2AL10	2.5	0.003	1.688	3.375
M3x0.5	2TNM-3x.5C-3	2TLM-3x.5C-3	NA0276M3-10	NA0276M3L10	3	0.006	1.875	3.750
M4x0.7	2TNM-4x.7C-4	2TLM-4x.7C-4	NA0276M4-10	NA0276M4L10	4	0.014	1.813	3.625
M5x0.8	2TNM-5x.8C-5	2TLM-5x.8C-5	NA0276M5-10	NA0276M5L10	5	0.025	2.063	4.125
M6x1	2TNM-6x1C-6	2TLM-6x1C-6	NA0276M6-10	NA0276M6L10	6	0.044	2.000	4.000
M8x1.25	2TNM-8x1.25C-8	2TLM-8x1.25C-8	NA0276M8-10	NA0276M8L10	8	0.100	2.250	4.500
M10x1.5	2TNM-10x1.5C-10	2TLM-10x1.5C-10	NA0276M10-10	NA0276M10L10	10	0.188	2.438	4.875
M12x1.75	2TNM-12x1.75C-12	2TLM-12x1.75C-12	NA0276M12-10	NA0276M12L10	12	0.318	2.500	5.000

1.5 DIA NOMINAL LENGTH								
NOMINAL THREAD SIZE	KATO Part Number		NAS PART NUMBER (REF.)		NOMINAL LENGTH	WEIGHT kg/100	M ±1 COIL	N ±.25 COIL
	Free-Running	Self-Locking	Free-Running	Self-Locking				
M2x0.4	2TNM-2x.4C-3	-----	-----	-----	3	-----	-----	5.625
M2.5x0.45	2TNM-2.5x.45C-3.8	2TLM-2.5x.45C-3.8	NA0276M2A-15	NA0276M2AL15	3.75	0.006	2.875	5.750
M3x0.5	2TNM-3x.5C-4.5	2TLM-3x.5C-4.5	NA0276M3-15	NA0276M3L15	4.5	0.009	3.188	6.375
M4x0.7	2TNM-4x.7C-6	2TLM-4x.7C-6	NA0276M4-15	NA0276M4L15	6	0.022	3.063	6.125
M5x0.8	2TNM-5x.8C-7.5	2TLM-5x.8C-7.5	NA0276M5-15	NA0276M5L15	7.5	0.040	3.438	6.875
M6x1	2TNM-6x1C-9	2TLM-6x1C-9	NA0276M6-15	NA0276M6L15	9	0.072	3.375	6.750
M8x1.25	2TNM-8x1.25C-12	2TLM-8x1.25C-12	NA0276M8-15	NA0276M8L15	12	0.160	3.688	7.375
M10x1.5	2TNM-10x1.5C-15	2TLM-10x1.5C-15	NA0276M10-15	NA0276M10L15	15	0.302	4.000	8.000
M12x1.75	2TNM-12x1.75C-18	2TLM-12x1.75C-18	NA0276M12-15	NA0276M12L15	18	0.509	4.125	8.250

2 DIA NOMINAL LENGTH								
NOMINAL THREAD SIZE	KATO Part Number		NAS PART NUMBER (REF.)		NOMINAL LENGTH	WEIGHT kg/100	M ±1 COIL	N ±.25 COIL
	Free-Running	Self-Locking	Free-Running	Self-Locking				
M2x0.4	2TNM-2x.4C-4	-----	-----	-----	4	-----	-----	8.000
M2.5x0.45	2TNM-2.5x.45C-5	2TLM-2.5x.45C-5	NA0276M2A-20	NA0276M2AL20	5	0.008	4.063	8.125
M3x0.5	2TNM-3x.5C-6	2TLM-3x.5C-6	NA0276M3-20	NA0276M3L20	6	0.012	4.438	8.875
M4x0.7	2TNM-4x.7C-8	2TLM-4x.7C-8	NA0276M4-20	NA0276M4L20	8	0.031	4.313	8.625
M5x0.8	2TNM-5x.8C-10	2TLM-5x.8C-10	NA0276M5-20	NA0276M5L20	10	0.055	4.813	9.625
M6x1	2TNM-6x1C-12	2TLM-6x1C-12	NA0276M6-20	NA0276M6L20	12	0.099	4.750	9.500
M8x1.25	2TNM-8x1.25C-16	2TLM-8x1.25C-16	NA0276M8-20	NA0276M8L20	16	0.221	5.125	10.250
M10x1.5	2TNM-10x1.5C-20	2TLM-10x1.5C-10	NA0276M10-20	NA0276M10L20	20	0.416	5.563	11.125
M12x1.75	2TNM-12x1.75C-24	2TLM-12x1.75C-12	NA0276M12-20	NA0276M12L20	24	0.700	5.750	11.500



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Section 4: KATO PART NUMBERS (Metric cont.)

2.5 DIA NOMINAL LENGTH								
NOMINAL THREAD SIZE	KATO Part Number		NAS PART NUMBER (REF.)		NOMINAL LENGTH	WEIGHT kg/100	M ±1 COIL	N ±.25 COIL
	Free-Running	Self-Locking	Free-Running	Self-Locking				
M2x0.4	2TNM-2x.4C-5	-----	-----	-----	5	-----	-----	10.250
M2.5x0.45	2TNM-2.5x.45C-6.3	2TLM-2.5x.45C-6.3	NA0276M2A-25	NA0276M2AL25	6.25	0.010	5.250	10.500
M3x0.5	2TNM-3x.5C-7.5	2TLM-3x.5C-7.5	NA0276M3-25	NA0276M3L25	7.5	0.016	5.688	11.375
M4x0.7	2TNM-4x.7C-10	2TLM-4x.7C-10	NA0276M4-25	NA0276M4L25	10	0.039	5.563	11.125
M5x0.8	2TNM-5x.8C-12.5	2TLM-5x.8C-12.5	NA0276M5-25	NA0276M5L25	12.5	0.070	6.188	12.375
M6x1	2TNM-6x1C-15	2TLM-6x1C-15	NA0276M6-25	NA0276M6L25	15	0.126	6.063	12.125
M8x1.25	2TNM-8x1.25C-20	2TLM-8x1.25C-20	NA0276M8-25	NA0276M8L25	20	0.281	6.625	13.250
M10x1.5	2TNM-10x1.5C-25	2TLM-10x1.5C-25	NA0276M10-25	NA0276M10L25	25	0.530	7.125	14.250
M12x1.75	2TNM-12x1.75C-30	2TLM-12x1.75C-30	NA0276M12-25	NA0276M12L25	30	0.890	7.313	14.625

3 DIA NOMINAL LENGTH								
NOMINAL THREAD SIZE	KATO Part Number		NAS PART NUMBER (REF.)		NOMINAL LENGTH	WEIGHT kg/100	M ±1 COIL	N ±.25 COIL
	Free-Running	Self-Locking	Free-Running	Self-Locking				
M2x0.4	2TNM-2x.4C-6	-----	-----	-----	6	-----	-----	12.500
M2.5x0.45	2TNM-2.5x.45C-7.5	2TLM-2.5x.45C-7.5	NA0276M2A-30	NA0276M2AL30	7.5	0.012	6.375	12.750
M3x0.5	2TNM-3x.5C-9	2TLM-3x.5C-9	NA0276M3-30	NA0276M3L30	9	0.019	6.938	13.875
M4x0.7	2TNM-4x.7C-12	2TLM-4x.7C-12	NA0276M4-30	NA0276M4L30	12	0.048	6.813	13.625
M5x0.8	2TNM-5x.8C-15	2TLM-5x.8C-15	NA0276M5-30	NA0276M5L30	15	0.085	7.563	15.125
M6x1	2TNM-6x1C-18	2TLM-6x1C-18	NA0276M6-30	NA0276M6L30	18	0.153	7.438	14.875
M8x1.25	2TNM-8x1.25C-24	2TLM-8x1.25C-24	NA0276M8-30	NA0276M8L30	24	0.342	8.063	16.125
M10x1.5	2TNM-10x1.5C-30	2TLM-10x1.5C-30	NA0276M10-30	NA0276M10L30	30	0.643	8.688	17.375
M12x1.75	2TNM-12x1.75C-36	2TLM-12x1.75C-36	NA0276M12-30	NA0276M12L30	36	1.081	8.938	17.875

Section 5: MATERIAL, FINISH, AND NOTES (UNC, UNF AND METRIC)

MATERIAL:

- CRES-TYPE 304 (UNS S30400) PER AS7245
- NITRONIC 60 - UNS S21800
- NIMONIC 90 - BS HR 503
- INCONEL X - UNS N07750

FINISH:

- DRY FILM LUBRICANT IN ACCORDANCE WITH AS5272, TYPE I. WHEN ORDERING DRY FILM LUBRICANT USING THE NAS1130 AND/OR NA0276 SPECIFICATION ADD A "D" AT THE END OF THE PART NUMBER.
- CADMIUM PLATED IN ACCORDANCE WITH AMS-QQ-P- 416, TYPE II, THICKNESS SHALL BE A MAXIMUM OF 0.0001. AS A MINIMUM, ALL SURFACES SHALL SHOW VISUAL EVIDENCE OF CADMIUM PLATING. WHEN ORDERING CADMIUM PLATED INSERTS USING THE NAS1130 AND/OR NA0276 SPECIFICATION ADD A "P" AT THE END OF THE PART NUMBER.
- SILVER PLATING NICKEL STRIKE IN ACCORDANCE WITH AMS 2410J (PURCHASE DOCUMENTS SHOULD SPECIFY THICKNESS).

NOTES:

1. NOMINAL LENGTH EQUALS MINIMUM THROUGH HOLE LENGTH WITHOUT COUNTERSINK AND WITH INSERT LOCATED 1/4 TO 1/2 THREAD PITCH BELOW TOP SURFACE.
2. THE NUMBER OF FREE COILS OF THE INSERT IS COUNTED FROM NOTCH TO NOTCH.
3. FOR UNC, UNF, THE INSERT, WHEN ASSEMBLED IN A TAPPED HOLE AS SPECIFIED IN NASM33537, SHALL PRODUCE A FINISHED THREAD MEETING THE REQUIREMENTS OF FED-STD-H28/2 AND SHALL ACCEPT



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Section 5: MATERIAL, FINISH AND NOTES (UNC, UNF AND METRIC)

EXTERNAL THREADED PARTS WHICH CONFORM TO MIL-S-7742 OR AS8879. THE EXCEPTIONS TO NASM33537 INCLUDE: INSTALLATION IS PERFORMED WITH THE NOTCH AT EITHER END OF THE INSERT INSTEAD OF A TANG, AND CONSEQUENTLY, A TANG DOES NOT HAVE TO BE REMOVED AFTER INSTALLATION. ON NASM33537 A TANGLESS INSERT IS THE EQUIVALENT TO THE TANGED INSERT WITH THE TANG REMOVED AFTER INSTALLATION.

4. FOR METRIC SIZES, THE INSERTS, WHEN ASSEMBLED INTO THREADED HOLES CONFORMING TO MA1567, SHALL FORM THREADS CONFORMING TO ASME B1.13M, EXCEPT FOR THE LOCKING FEATURE, WHERE PRESENT, WHICH SHALL CONFORM TO THE RELEVANT INSERT SPECIFICATION. THE ASSEMBLED INSERTS (BOTH TYPES) SHALL ACCEPT AND FUNCTION WITH PARTS EXTERNALLY THREADED TO MA1370, ASME B1.13M AND ASME B1.21M.
5. SURFACE ROUGHNESS: 32 MICRO-INCHES Ra PER ASME B46.1 (0.8 MICRO-METER). SURFACE TEXTURE SYMBOLS SHALL BE IN ACCORDANCE WITH ASME Y14.36M.
6. DIMENSIONS ARE IN INCHES (MILLIMETERS FOR METRIC INSERTS) AND APPLY AFTER FINISH AND PRIOR TO THE APPLICATION OF LUBRICATION UNLESS OTHERWISE SPECIFIED.
7. INSERT COLOR IDENTIFICATION:
 - NO FINISH, FREE RUNNING.....NONE
 - NO FINISH, LOCKING.....RED (DYE)
 - DRY FILM LUBRICATED, FREE RUNNING.....DARK GRAY
 - DRY FILM LUBRICATED, LOCKING.....DARK GRAY
 - CADIUM PLATED, FREE RUNNING.....IRIDESCENT BRONZE OR YELLOW (CHROMATE)
 - CADIUM PLATED, LOCKING.....OLIVE DRAB (CHROMATE)ADDITIONAL COLORS:
 - WHEN OTHER VISUAL IDENTIFICATION IS REQUIRED, BLUE OR GREEN DYE CAN BE USE AS A SUBSTITUTE. THIS APPLIES TO PLAIN AND LOCKING INSERTS AND ARE NOT CERTIFIED TO THE NAS OR NA SPECIFICATION.
8. THE ASSEMBLED LENGTH OF THE INSERT IS SPECIFIED ON NASM33537 (MA1567 METRIC).
9. TOLERANCES UNLESS OTHERWISE SPECIFIED: DECIMALS ± 0.010 , ANGLES ± 5 DEGREES (DECIMALS ± 0.25 mm, ANGLES ± 5 DEGREES).
10. DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.1982 (Y14.5M.1994 METRIC).
11. INSERTS CAN BE USED WITH UNJ (MJ FOR METRIC) INTERNAL AND EXTERNAL THREADS.



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