

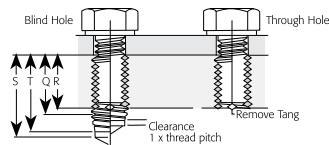
Recoil Metric Insert Part Number Call-Out and Dimensional Data

Thread Nominal	Nominal Length	Recoil Spec - Free Running Free			Recoil Spec - Screw Locking Free			MA Spec		BASIC LENGTH OF INSERT NOMINAL DIAMETER OF SCREW "D"							
		Part Number	Coil Dia Min./Max.	Number of Coils	Part Number	Coil Dia Min./Max.	Number of Coils	Free Running Part Number	Screw Locking Part Number	Insert Length inch	mm	Number of Coils	Free Coil Dia Min./Max.	Q	R	S	T
M8 x 0.75	1	08082		8.60	18082				18082	0.315	8	7.85		8.00	7.25	11.38	10.63
	1.5	08083	9.00	13.75	18083				18083	0.472	12	12.6		12.00	11.25	15.38	14.63
	2	08084	9.18	18.75										16.00	15.25	19.38	18.63
M8 x 1	1	07082		6.15	17082			07082MA	17082	0.315	8.0	5.875		8.00	7.00	12.50	11.50
	1.5	07083	9.40	9.85	17083	AS PER "MA SPECIFICATION"		07083MA	17083	0.472	12.0	9.375	9.70	12.00	11.00	16.50	15.50
	2	07084	9.65	13.65	17084			07084MA	17084	0.63	16.0	13.000	10.25	16.00	15.00	20.50	19.50
	2.5	07085		17.45	17085			07085MA	17085	0.787	20.0	16.500		20.00	19.00	24.50	23.50
	3	07086		21.15	17086			07086MA	17086	0.945	24.0	20.125		24.00	23.00	28.50	27.50
M8 x 1.25	1	05082		4.55	15082			05082MA	15082MA	0.394	10.0	4.500		8.00	6.75	13.63	12.38
	1.5	05083	9.60	7.55	15083	AS PER "MA SPECIFICATION"		05083MA	15083MA	0.472	12.0	7.375	9.80	12.00	10.75	17.63	16.38
	2	05084	9.80	10.55	15084			05084MA	15084MA	0.63	16.0	10.250	10.35	16.00	14.75	21.63	20.38
	2.5	05085		13.55	15085			05085MA	15085MA	0.787	20.0	13.250		20.00	18.75	25.63	24.38
3	05086		16.55	15086			05086MA	15086MA	0.945	24.0	16.125		24.00	22.75	29.63	28.38	
M9 x 1	1	07092		7.05						0.354	9.0			9.00	8.00	13.50	12.50
	1.5	07093	10.41	11.35						0.531	13.5			13.50	12.50	18.00	17.00
	2	07094	10.65	15.65	Upon Request					0.709	18.0			18.00	17.00	22.50	21.50
	2.5	07095		19.85						0.886	22.5			22.50	21.50	27.00	26.00
	3	07096		24.15						1.063	27.0			27.00	26.00	31.50	30.50
M9 x 1.25	1	05092		5.35						0.354	9.0			9.00	7.75	14.63	13.38
	1.5	05093	10.68	8.75						0.531	13.5			13.50	12.25	19.13	17.88
	2	05094	10.92	12.15	Upon Request					0.709	18.0			18.00	16.75	23.63	22.38
	2.5	05095		15.55						0.886	22.5			22.50	21.25	28.13	26.88
M10 x 1	1	08102		8.05				08102MA	18102MA	0.394	10.0	7.625		10.00	9.00	14.50	13.50
	1.5	08103	11.34	12.75				08103MA	18103MA	0.591	15.0	12.00	11.95	15.00	14.00	19.50	18.50
	2	08104	11.63	17.55				08104MA	18104MA	0.787	20.0	16.50	12.5	20.00	19.00	24.50	23.50
	2.5	08105		22.25				08105MA	18105MA	0.984	25.0	21.00		25.00	24.00	29.50	28.50
	3	08106		26.95				08106MA	18106MA	1.181	30.0	25.50		30.00	29.00	34.50	33.50
M10 x 1.25	1	07102		6.05	17102			07102MA	17102MA	0.394	10.0	5.875		10.00	8.75	15.63	14.38
	1.5	07103	11.80	9.85	17103			07103MA	17103MA	0.591	15.0	9.500	12.10	15.00	13.75	20.63	19.38
	2	07104	12.10	13.55	17104			07104MA	17104MA	0.787	20.0	13.125	12.65	20.00	18.75	25.63	24.38
	2.5	07105		17.35	17105			07105MA	17105MA	0.984	25.0	16.750		25.00	23.75	30.63	29.38
	3	07106		21.15	17106			07106MA	17106MA	1.181	30.0	20.375		30.00	28.75	35.63	34.38
M10 x 1.5	1				15102			05102	15102MA	0.394	10.0	4.875		10.00	8.50	16.75	15.25
	1.5				15103			05103	15103MA	0.591	15.0	8.000	11.95	15.00	13.50	21.75	20.25
	2				15104			05104	15104MA	0.787	20.0	11.125	12.50	20.00	18.50	26.75	25.25
	2.5				15105			05105	15105MA	0.984	25.0	14.250		25.00	23.50	31.75	30.25
	3				15106			05106	15106MA	1.181	30.0	17.375		30.00	28.50	36.75	35.25
M11 x 1	1	08112		8.95						0.433	11.0			11.00	12.00	15.50	14.50
	1.5	08113	12.40	14.15						0.866	22.0			16.50	15.50	21.00	20.00
	2	08114	12.70	19.35	Upon Request					1.083	27.5			22.00	21.00	26.50	25.50
	2.5	08115		24.55						1.299	33.0			27.50	26.50	32.00	31.00
3	08116		29.75						0.433	11.0			33.00	32.00	37.50	36.50	

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.

