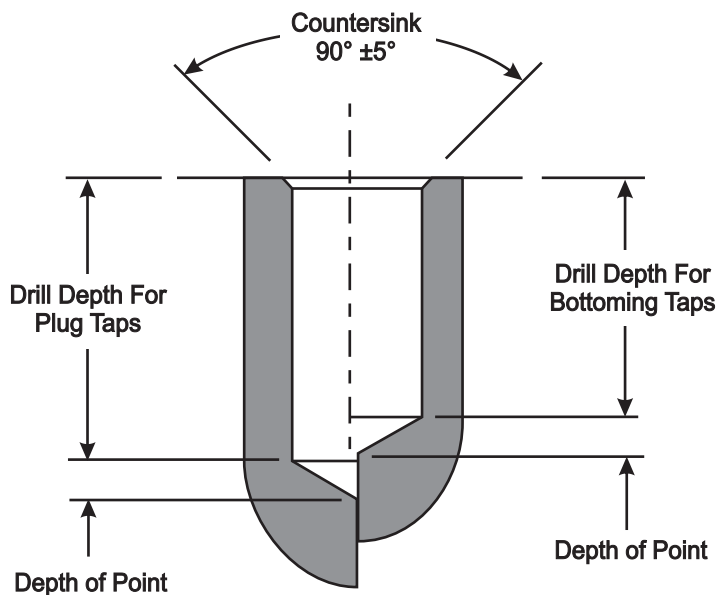


Keensert

DASH NO	MINIMUM SUGGESTED BOSS DIAM	NOMINAL INTERNAL THREAD SIZE	SUGGESTED DRILL SIZE	DEPTH OF POINT	MIN DRILLING DEPTH		COUNTERSINK DIAMETER	INSERT'S EXTERNAL THREAD	MIN TAP FULL THD DEPTH	LENGTH OF INSERT	LENGTH TO LOCKING THREAD
					Plug Taps	Bottoming Taps					
101	.328	2(.086)-56	#29(.136)	.041	.28	.22	.166	.164-32UNC-2A	.14	.120	.090
102	.380	4(.112)-40	#20(.161)	.048	.30	.24	.194	.190-32UNF-2A	.16	.170	.125
103	.432	6(.138)-32	3/16(.1875)	.057	.32	.25	.220	.216-28UNF-2A	.16	.170	.125
104	.500	8(.164)-32	#1(.228)	.067	.37	.30	.255	.250-28UNF-2A	.21	.220	.175
105	.625	10(.190)-24	1(.272)	.082	.62	.51	.322	.3125-18UNC-2A	.37	.312	.220
106	.750	1/4(.250)-20	Q(.332)	.100	.71	.59	.385	.375-16UNC-2A	.43	.375	.220
107	.875	5/16(-.3125)-18	X(.397)	.120	.82	.68	.447	.4375-14UNC-2A	.50	.437	.220
108	1.000	3/8(.375)-16	29/64(.4531)	.136	.91	.76	.510	.500-13UNC-2A	.56	.500	.240
109	1.125	7/16(.4375)-14	33/64(.5156)	.155	1.00	.83	.572	.5625-12UNC-2A	.62	.562	.270
110	1.250	1/2(.500)-13	37/64(.5781)	.173	1.09	.91	.635	.625-11UNC-2A	.68	.625	.280

Note: Total drill depth equals depth of point plus drill depth.

Note: Installation of inserts shall be in accordance with DR8660.



Selection of MS Part Number

MS51830-XXXL

- Material: Dash indicates CRES type 303 or 303SE
- Add "CA" in place of dash for CRES, type A286
- Add "A" in place of dash for Alloy Steel, grade 4140 or 8740
- Basic MS sheet number
- L indicates locking
- Dash # from Table

