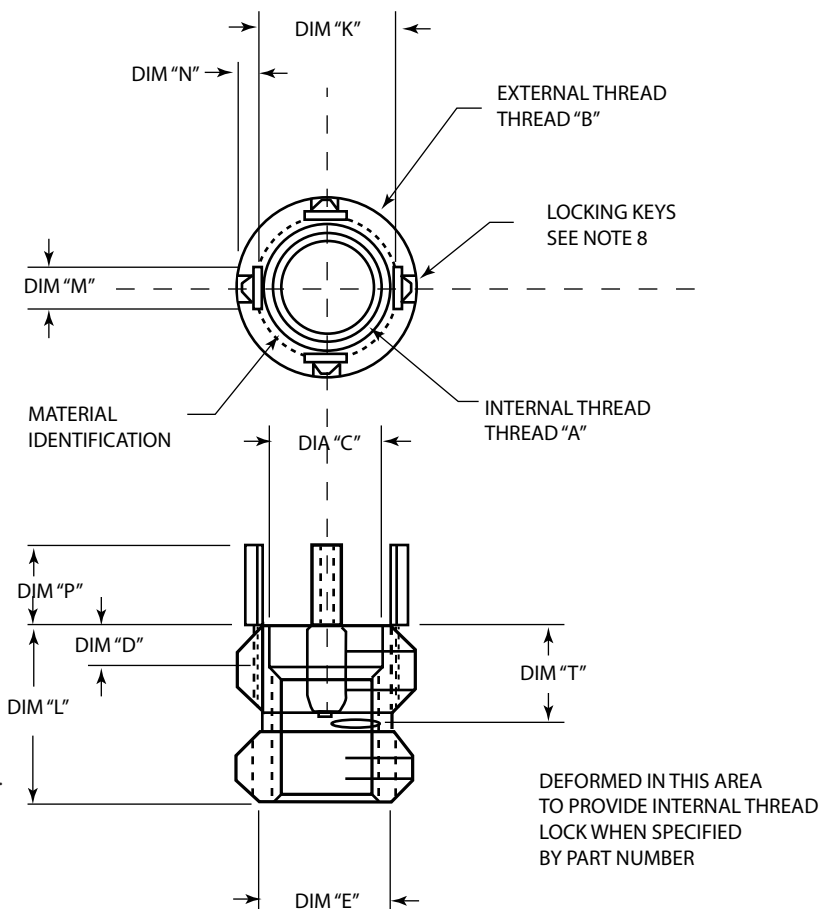




Example of Part Number

RA 2014 - 2201-NSL M SP

- D** For Lube Per Note 6 On Free Running Inserts
- SP** Add SP For Silver Plate Per QQ-S-365
- M** Add M For Military Key
- NSL** Add Dash For Non Standard Lengths In 1/16 in.
- 2201** Dash From Table I or II
- 2014** Basic Drawing Number



NOTES:

- 1) ONE DASH MARK ON TOP OF INSERT IDENTIFIES MATERIAL.
- 2) MATERIAL INSERT - A-286 HEAT AND CORROSION RESISTANT STEEL PER AMS 5731 OR AMS 5737 (140 K.S.I. MINIMUM).
- 3) HEAT TREAT: INSERT - A-286 MANUFACTURED FROM AMS 5731 SHALL BE AGE HARDENED PER AMS 5737 (140 K.S.I. MINIMUM).
- 4) LOCKING KEYS: 420 CORROSION RESISTANT STEEL PER QQ-S-763 (CHEMISTRY ONLY)
ADD M TO PART NUMBER FOR MILITARY KEY MADE FROM 302 SS
HEAT TREATED TO A MINIMUM ROCKWELL HARDNESS OF (RC50).
- 5) SURFACE TREATMENT: INSERT SHALL BE PASSIVATED PER QQ-P-35C OR
ADD SP TO PART NUMBER FOR SILVER PER QQ-S-365
- 6) LUBRICATION: FINISHED INSERTS WITH INTERNAL SELF-LOCKING FEATURE SHALL BE DRY FILM LUBRICATED PER AS 5272 TYPE 1.
- 7) PERFORMANCE: I.A.W. MIL-I-45914
- 8) INSERT WITH INTERNAL THREAD SIZES OF .1900 AND .2500 HAVE 2 LOCKING KEYS.
ALL OTHER SIZES HAVE 4 LOCKING KEYS.
- 9) CHAMFERS AND THREAD RELIEFS ARE 40° - 50° TYPICAL.
- 10) TO DESIGNATE PART WITH SELF-LOCKING INTERNAL THREAD,
FOLLOW DASH NUMBER WITH "L".

**INSERT, KEY LOCKED, SELF
BROACHING, HEAVY DUTY**

CAGE CODE	DWG NO. RA2014	Drawn by: R.S.	Date: 03/18/2017
63EM5	REV: A SHEET 1 OF 2	Approved by:	Date: 03/18/2017



TABLE I - COURSE INTERNAL THREAD

DASH NO.	INTERNAL THREAD SAE AS8879 UNJC-3B	EXTERNAL THREAD FED-STD-H28/2 EXCEPT MODIFIED MINOR DIA.		C ±.005	D ±.010	E ±.010	K	L ±.015	KEY DIMENSIONS			T ±.030
		SIZE	MINOR DIA.						M ±.002	N ±.004	P ±.015	
1201	.190-24	.375-16UNC-2A	.320 .312	.196	.070	.310	.288 .281	.312	.068	.040	.130	.220
1302	.250-20	.4375-14UNC-2A	.383 .375	.257	.070	.375	.348 .341	.375	.068	.040	.190	.220
1403	.3125-18	.500-13UNC-2A	.440 .432	.316	.070	.430	.411 .403	.437	.068	.040	.190	.220
1504	.375-16	.5625-12UNC-2A	.503 .495	.380	.070	.495	.473 .465	.500	.068	.040	.190	.250
1605	.4375-14	.625-11UNC-2A	.565 .551	.445	.100	.550	.536 .528	.625	.068	.040	.190	.280
1706	.500-13	.6875-11NS-2A	.625 .615	.507	.100	.615	.597 .591	.688	.068	.040	.190	.280
1807	.5625-12	.8125-16UN-2A	.752 .744	.580	.100	.745	.724 .716	.812	.068	.040	.190	.320
1908	.625-11	.875-14UNF-2A	.815 .807	.640	.100	.805	.786 .778	.875	.068	.040	.190	.330

TABLE II - FINE INTERNAL THREAD

DASH NO.	INTERNAL THREAD SAE AS8879 UNJF-3B	EXTERNAL THREAD FED-STD-H28/2 EXCEPT MODIFIED MINOR DIA.		C ±.005	D ±.010	E ±.010	K	L ±.015	KEY DIMENSIONS			T ±.030
		SIZE	MINOR DIA.						M ±.002	N ±.004	P ±.015	
2201	.190-32	.375-16UNC-2A	.320 .312	.196	.070	.310	.288 .281	.312	.068	.040	.130	.220
2302	.250-28	.4375-14UNC-2A	.383 .375	.257	.070	.375	.348 .341	.375	.068	.040	.190	.220
2403	.3125-24	.500-13UNC-2A	.440 .432	.316	.070	.430	.411 .403	.437	.068	.040	.190	.220
2504	.375-24	.5625-12UNC-2A	.503 .495	.380	.070	.495	.473 .465	.500	.068	.040	.190	.250
2605	.4375-20	.625-11UNC-2A	.565 .551	.445	.100	.550	.536 .528	.625	.068	.040	.190	.280
2706	.500-20	.6875-11NS-2A	.625 .615	.507	.100	.615	.597 .591	.688	.068	.040	.190	.280
2807	.5625-18	.8125-16UN-2A	.752 .744	.580	.100	.745	.724 .716	.812	.068	.040	.190	.320
2908	.625-18	.875-14UNF-2A	.815 .807	.640	.100	.805	.786 .778	.875	.068	.040	.190	.330

**INSERT, KEY LOCKED, SELF
BROACHING, HEAVY DUTY**

CAGE CODE 63EM5	DWG NO. RA2014 REV: A SHEET 2 OF 2	Drawn by: R.S,	Date: 03/18/2017
		Approved by:	Date: 03/18/2017