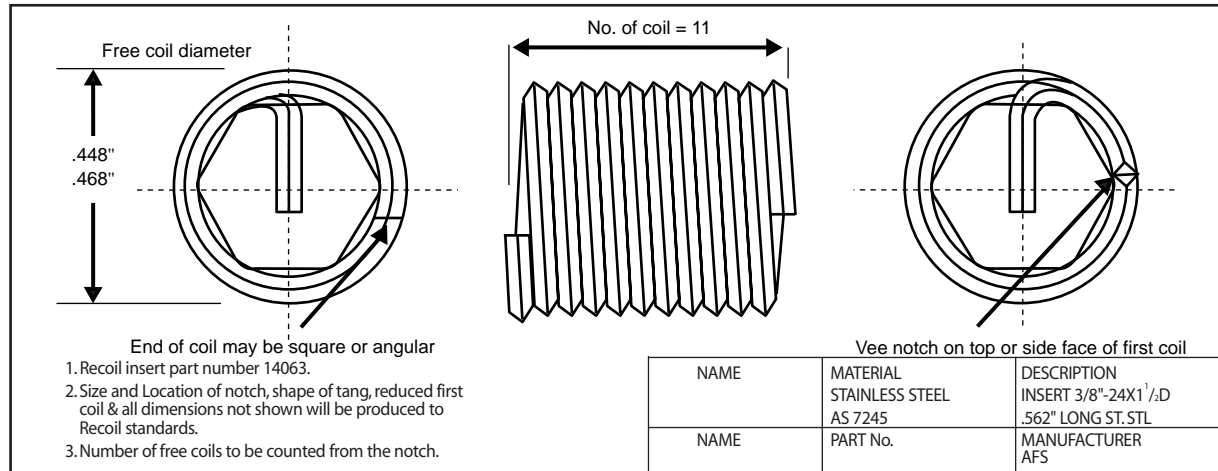


MS Insert Dimensional Data

Drawing Call-Out

An example of a typical drawing specification for a Recoil insert is shown below:



A typical drawing call-out for a Recoil screw-locking insert 3/8" - 24 x 11/2 dia. long Class 3B Unified Fine Thread (UNF) is shown.

Drawing call-outs can be simply defined by using a production sequence process sheet to provide the operational steps with the drawing showing dimensional limits and data. (Example shown below)

- 1) Drill hole $\frac{25}{64}$ " (.3906") diameter, depth .812" plus your normal standard for drilling depth.
- 2) Countersink $120^\circ \pm 5^\circ$.42"/.45" diameter.
- 3) Tap with Recoil STI Tap No. 44065 (class 3B) full thread depth .600".
- 4) Gauge with Recoil Gauge No. 64063 or according to your inspection requirements.
- 5) Install Recoil screw-lock insert 14063 with Recoil Inserting Tool No. 54061.
- 6) Break off driving tang with Recoil Tang Break-off Tool No. 59280.

MS Insert Dimensional Data

Recoil Thread Insert Part Numbering System

Recoil insert product part numbering system uses a logically structured 5 digit basic part number. Suffixes are typically added to differentiate between special or non-standard features.

This guide defines the structure of Recoil part numbers and may be used for reference to identify a Recoil insert from its part number.

