

## 深圳安稳航空紧固件有限公司 NAS1130-4FL10 螺套 产品说明书

**Style:** Tangless**Type:** Locking**Thread Size:** 1/4-28**Nominal Length:** 1D**Unit of Measurement:** Unified**Thread Designation:** Fine

Free Outer Diameter

**Min:** 0.306**Max:** 0.326**Number of Free Coils ( $\pm 1/4$ ):** 5**Number of Free Coils Notes:**

For Tangless inserts, the number of free coils is counted from notch to notch.

For Tanged Unified sizes, the number of free coils is counted by starting 90° from tang.

For Tanged Metric sizes, the number of free coils is counted from the notch.

Part Numbers

**KATO Part Number:** 2TLF-4C-0250**NAS/NA Number:** NAS1130-4FL10**MS/MA Number or Equivalent:** MS21209F4-10**KATO Part Number (Dry Lube):** 2TLF-4C-0250W**NAS/NA Number (Dry Lube):** NAS1130-4FL10D**MS/MA Number (Dry Lube):** MS21209F4-10L**KATO Part Number (Cadmium Plated):** 2TLF-4C-0250Y**NAS/NA Number (Cadmium Plated):** NAS1130-4FL10P**MS/MA Number (Cadmium Plated):** MS21209F4-10P**Notes:**

For a strip feed designation, please add "SF" to the end of any KATO part number.

Strip feed is only available from 2-56 to 1/4" and M2.5 to M6.

Cadmium Plating is not available on strip.



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Suggested Tools

**Hex Electric Tool:** ---**Prewinder Air Tool:** 2KPAF-4**Prewinder Electric Tool:** 2KPEF-4**Prewinder Hand Tool:** 2KPHF-4**Round Shaft Tool:** ---**Removal Tool:** 2KRTF-4**Removal Extraction:** ---**Tang Break-Off Tool:** ---**Notes:** For air and electric tools, additional components (motors, drivers, transformers, etc.) are required.

CoilThread STI Taps (for free machining materials)

**3B/4H Plug:** CTF-4SRP-H2

**2B/5H Plug:** CTF-4SRP-H3

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**3B/4H Bottoming:** CTF-4SRB-H2

**2B/5H Bottoming:** CTF-4SRB-H3

CoilThread STI Gages

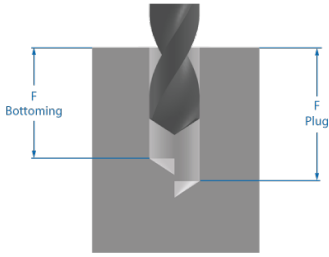
**3B/4H Working Gage:** CGF-4X-3B

**2B/5H Working Gage:** CGF-4X-2B



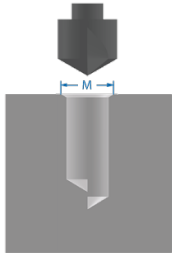
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Step 1: Drill



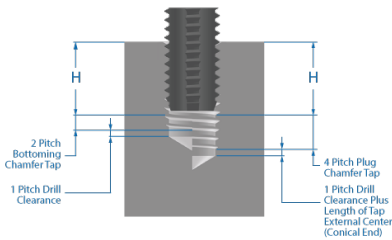
Suggested Drill Sizes
<b>Aluminum:</b> G (.2610)
<b>Steel:</b> 6.7mm (.2638)
Minimum Drilling Depths "F"
<b>For Plug Taps:</b> 0.589
<b>For Bottoming Taps:</b> 0.393

Step 2: Countersink - Use a 120° ± countersink.



Counter Sink "M" Diameter
<b>Min:</b> 0.29
<b>Max:</b> 0.32

Step 3: Tap with a KATO STI Tap.



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Minimum Tapping Depth
<b>"H" Dimension:</b> 0.29
<b>Tap Major Diameter Max:</b> 0.2995
<b>Thread Pitch:</b> 0.03751

Step 4: Gage - Check the thread with a Go/NoGo STI gage. Check minor diameter with a pingage.



Minor Diameter (After Tapping)
<b>Min All Classes:</b> 0.2577
<b>Max Class 3B/4H:</b> 0.2646
<b>Max Class 2B/5h:</b> 0.2661
Pitch Diameter
<b>Min:</b> 0.2732
<b>3B/4H Max:</b> 0.2754
<b>2B/5H Max:</b> 0.2765

**Notes:** All dimensions for unified sizes are in inches. All dimensions for metric sizes are in mm.