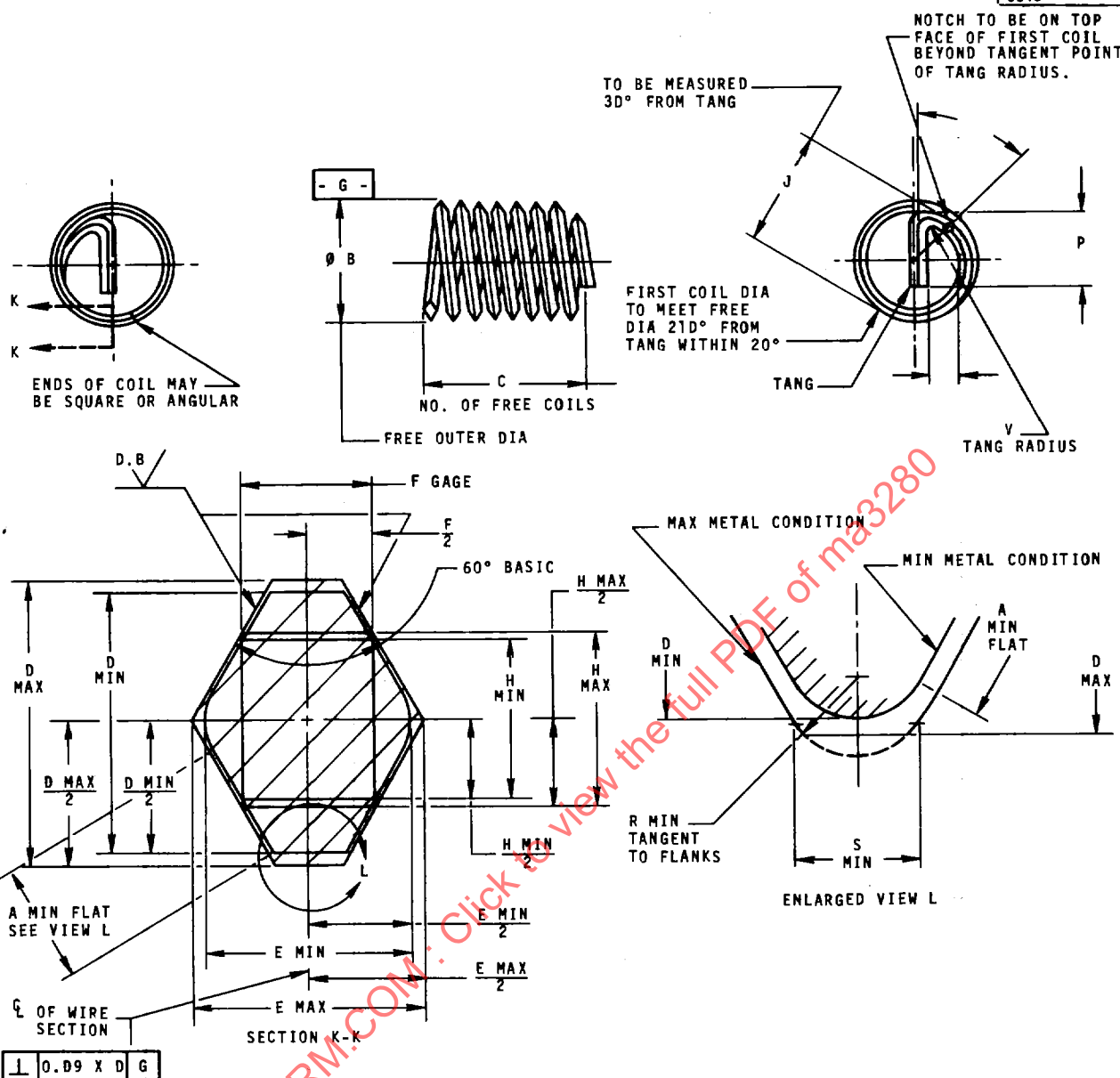


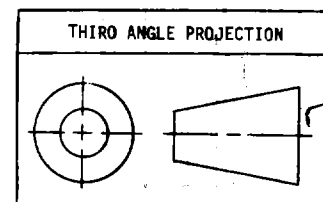
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MA3279
MA3280
MA3281

FED SUP CLASS
5340



1. NOMINAL LENG.H IS REFERENCE AND EQUALS MINIMUM LENGTH OF FULL THREAD INTO WHICH MAXIMUM INSERT CAN BE ASSEMBLED. SEE TABLE.
2. ASSEMBLED LENGTH OF INSERT TO BE AS SPECIFIED ON AEROSPACE STANDARD MA 1567.
3. ASSEMBLED LENGTH OF INSERT TO BE MEASURED FROM NOTCH.
4. NUMBER OF FREE COILS TO BE COUNTED FROM NOTCH.
5. MATERIAL CRES, SEE PROCUREMENT SPECIFICATION.
6. SURFACE TEXTURE: SYMBOLS PER ANSI Y14.36-1978; REQUIREMENTS PER ANSI B46.1-1978.
7. WHEN DRY FILM LUBRICANT IS SPECIFIED IT SHALL BE IN ACCORDANCE WITH MIL-L-8937.
8. WHEN CADMIUM PLATING IS SPECIFIED IT SHALL BE IN ACCORDANCE WITH QQ-P-416, TYPE II, EXCEPT THICKNESS SHALL BE A MAXIMUM OF 0.003 mm.
9. DIMENSIONING AND TOLERANCING: ANSI Y14.5-1973. DIMENSIONS APPLY BEFORE COATING.
10. LINEAR DIMENSIONS IN MILLIMETRES (mm).
11. INSERT CAN BE USED WITH M OR MJ EXTERNAL THREADS.
12. PROCUREMENT SPECIFICATION: MA1565.
13. DO NOT USE UNASSIGNED AEROSPACE STANDARD PART NUMBERS.



PREPARED BY SAE COMMITTEE E-25, GENERAL STANDARDS FOR AEROSPACE PROPULSION SYSTEMS

SHEET 1 OF 5 METRIC

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AEROSPACE STANDARD

INSERT, SCREW THREAD, HELICAL COIL, METRIC SERIES
FREE RUNNING, CRES

MA3279

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Printed in U.S.A.

REAFFIRMED 11/9/95

Revised 3-1-85
Issued 9-1-81

MA3279
MA3280
MA3281

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5340

THREAD SIZE			AEROSPACE STANDARD PART NUMBER FOR UNCOATED INSERT						AEROSPACE STANDARD PART NUMBER FOR DRY FILM LUBRICATED INSERT					
			1 DIA	1.5 DIA	2 DIA	2.5 DIA	3 DIA		1 DIA	1.5 DIA	2 DIA	2.5 DIA	3 DIA	
2.2	0.45	MA3279-100	MA3279-150	MA3279-200	MA3279-250	MA3279-300	MA3279-300		MA3280-100	MA3280-150	MA3280-200	MA3280-250	MA3280-300	
2.5	0.45	MA3279-101	MA3279-151	MA3279-201	MA3279-251	MA3279-301	MA3279-301		MA3280-101	MA3280-151	MA3280-201	MA3280-251	MA3280-301	
3	0.5	MA3279-102	MA3279-152	MA3279-202	MA3279-252	MA3279-302	MA3279-302		MA3280-102	MA3280-152	MA3280-202	MA3280-252	MA3280-302	
3.5	0.6	MA3279-103	MA3279-153	MA3279-203	MA3279-253	MA3279-303	MA3279-303		MA3280-103	MA3280-153	MA3280-203	MA3280-253	MA3280-303	
4	0.7	MA3279-104	MA3279-154	MA3279-204	MA3279-254	MA3279-304	MA3279-304		MA3280-104	MA3280-154	MA3280-204	MA3280-254	MA3280-304	
5	0.8	MA3279-105	MA3279-155	MA3279-205	MA3279-255	MA3279-305	MA3279-305		MA3280-105	MA3280-155	MA3280-205	MA3280-255	MA3280-305	
6	1	MA3279-106	MA3279-156	MA3279-206	MA3279-256	MA3279-306	MA3279-306		MA3280-106	MA3280-156	MA3280-206	MA3280-256	MA3280-306	
7	1	MA3279-107	MA3279-157	MA3279-207	MA3279-257	MA3279-307	MA3279-307		MA3280-107	MA3280-157	MA3280-207	MA3280-257	MA3280-307	
8	1	MA3279-108	MA3279-158	MA3279-208	MA3279-258	MA3279-308	MA3279-308		MA3280-108	MA3280-158	MA3280-208	MA3280-258	MA3280-308	
8	1.25	MA3279-109	MA3279-159	MA3279-209	MA3279-259	MA3279-309	MA3279-309		MA3280-109	MA3280-159	MA3280-209	MA3280-259	MA3280-309	
10	1.25	MA3279-110	MA3279-160	MA3279-210	MA3279-260	MA3279-310	MA3279-310		MA3280-110	MA3280-160	MA3280-210	MA3280-260	MA3280-310	
10	1.5	MA3279-111	MA3279-161	MA3279-211	MA3279-261	MA3279-311	MA3279-311		MA3280-111	MA3280-161	MA3280-211	MA3280-261	MA3280-311	
12	1.25	MA3279-112	MA3279-162	MA3279-212	MA3279-262	MA3279-312	MA3279-312		MA3280-112	MA3280-162	MA3280-212	MA3280-262	MA3280-312	
12	1.5	MA3279-113	MA3279-163	MA3279-213	MA3279-263	MA3279-313	MA3279-313		MA3280-113	MA3280-163	MA3280-213	MA3280-263	MA3280-313	
12	1.75	MA3279-114	MA3279-164	MA3279-214	MA3279-264	MA3279-314	MA3279-314		MA3280-114	MA3280-164	MA3280-214	MA3280-264	MA3280-314	
14	1.5	MA3279-115	MA3279-165	MA3279-215	MA3279-265	MA3279-315	MA3279-315		MA3280-115	MA3280-165	MA3280-215	MA3280-265	MA3280-315	
14	2	MA3279-116	MA3279-166	MA3279-216	MA3279-266	MA3279-316	MA3279-316		MA3280-116	MA3280-166	MA3280-216	MA3280-266	MA3280-316	
16	1.5	MA3279-117	MA3279-167	MA3279-217	MA3279-267	MA3279-317	MA3279-317		MA3280-117	MA3280-167	MA3280-217	MA3280-267	MA3280-317	
16	2	MA3279-118	MA3279-168	MA3279-218	MA3279-268	MA3279-318	MA3279-318		MA3280-118	MA3280-168	MA3280-218	MA3280-268	MA3280-318	
18	1.5	MA3279-119	MA3279-169	MA3279-219	MA3279-269	MA3279-319	MA3279-319		MA3280-119	MA3280-169	MA3280-219	MA3280-269	MA3280-319	
18	2	MA3279-120	MA3279-170	MA3279-220	MA3279-270	MA3279-320	MA3279-320		MA3280-120	MA3280-170	MA3280-220	MA3280-270	MA3280-320	
18	2.5	MA3279-121	MA3279-171	MA3279-221	MA3279-271	MA3279-321	MA3279-321		MA3280-121	MA3280-171	MA3280-221	MA3280-271	MA3280-321	
20	1.5	MA3279-122	MA3279-172	MA3279-222	MA3279-272	MA3279-322	MA3279-322		MA3280-122	MA3280-172	MA3280-222	MA3280-272	MA3280-322	
20	2	MA3279-123	MA3279-173	MA3279-223	MA3279-273	MA3279-323	MA3279-323		MA3280-123	MA3280-173	MA3280-223	MA3280-273	MA3280-323	
20	2.5	MA3279-124	MA3279-174	MA3279-224	MA3279-274	MA3279-324	MA3279-324		MA3280-124	MA3280-174	MA3280-224	MA3280-274	MA3280-324	
22	1.5	MA3279-125	MA3279-175	MA3279-225	MA3279-275	MA3279-325	MA3279-325		MA3280-125	MA3280-175	MA3280-225	MA3280-275	MA3280-325	
22	2	MA3279-126	MA3279-176	MA3279-226	MA3279-276	MA3279-326	MA3279-326		MA3280-126	MA3280-176	MA3280-226	MA3280-276	MA3280-326	
22	2.5	MA3279-127	MA3279-177	MA3279-227	MA3279-277	MA3279-327	MA3279-327		MA3280-127	MA3280-177	MA3280-227	MA3280-277	MA3280-327	
24	2	MA3279-128	MA3279-178	MA3279-228	MA3279-278	MA3279-328	MA3279-328		MA3280-128	MA3280-178	MA3280-228	MA3280-278	MA3280-328	
24	3	MA3279-129	MA3279-179	MA3279-229	MA3279-279	MA3279-329	MA3279-329		MA3280-129	MA3280-179	MA3280-229	MA3280-279	MA3280-329	
27	2	MA3279-130	MA3279-180	MA3279-230	MA3279-280	MA3279-330	MA3279-330		MA3280-130	MA3280-180	MA3280-230	MA3280-280	MA3280-330	
27	3	MA3279-131	MA3279-181	MA3279-231	MA3279-281	MA3279-331	MA3279-331		MA3280-131	MA3280-181	MA3280-231	MA3280-281	MA3280-331	
30	2	MA3279-132	MA3279-182	MA3279-232	MA3279-282	MA3279-332	MA3279-332		MA3280-132	MA3280-182	MA3280-232	MA3280-282	MA3280-332	
30	3	MA3279-133	MA3279-183	MA3279-233	MA3279-283	MA3279-333	MA3279-333		MA3280-133	MA3280-183	MA3280-233	MA3280-283	MA3280-333	
33	2	MA3279-134	MA3279-184	MA3279-234	MA3279-284	MA3279-334	MA3279-334		MA3280-134	MA3280-184	MA3280-234	MA3280-284	MA3280-334	
33	3	MA3279-135	MA3279-185	MA3279-235	MA3279-285	MA3279-335	MA3279-335		MA3280-135	MA3280-185	MA3280-235	MA3280-285	MA3280-335	
36	2	MA3279-136	MA3279-186	MA3279-236	MA3279-286	MA3279-336	MA3279-336		MA3280-136	MA3280-186	MA3280-236	MA3280-286	MA3280-336	
36	3	MA3279-137	MA3279-187	MA3279-237	MA3279-287	MA3279-337	MA3279-337		MA3280-137	MA3280-187	MA3280-237	MA3280-287	MA3280-337	
39	2	MA3279-138	MA3279-188	MA3279-238	MA3279-288	MA3279-338	MA3279-338		MA3280-138	MA3280-188	MA3280-238	MA3280-288	MA3280-338	
39	3	MA3279-139	MA3279-189	MA3279-239	MA3279-289	MA3279-339	MA3279-339		MA3280-139	MA3280-189	MA3280-239	MA3280-289	MA3280-339	

SHEET 2 OF 5 METRIC

AEROSPACE STANDARD

INSERT, SCREW THREAD, HELICAL COIL, METRIC SERIES
FREE RUNNING, CRES

MA3279

MA3280

MA3281

Issued 9-1-81 Revised 3-1-85

AEROSPACE STANDARD PART NUMBER FOR CADMIUM PLATED INSERT										NOMINAL LENGTH See Note 1					A		B						
THREAD SIZE		1 DIA		1.5 DIA		2.0 DIA		2.5 DIA		3 DIA		1 DIA		1.5 DIA		2 DIA		2.5 DIA		3 DIA		MIN	MAX
2-2	0.45	MA3281-100	MA3281-101	MA3281-150	MA3281-151	MA3281-200	MA3281-201	MA3281-250	MA3281-251	MA3281-300	MA3281-301	2.2	2.5	3.3	3.8	4.4	5.0	5.5	6.3	6.6	7.5	0.082	3.00
2-5	0.45	MA3281-102	MA3281-103	MA3281-152	MA3281-153	MA3281-202	MA3281-203	MA3281-252	MA3281-253	MA3281-302	MA3281-303	3.0	3.5	4.5	5.3	6.0	7.0	7.5	8.8	9.0	10.5	0.105	4.35
3	0.5	MA3281-104	MA3281-105	MA3281-154	MA3281-155	MA3281-204	MA3281-205	MA3281-254	MA3281-255	MA3281-304	MA3281-305	4.0	5.0	6.0	7.0	8.0	10.0	10.5	12.0	12.0	15.0	0.160	4.95
3-5	0.6	MA3281-106	MA3281-107	MA3281-156	MA3281-157	MA3281-206	MA3281-207	MA3281-256	MA3281-257	MA3281-306	MA3281-307	6.0	7.0	9.0	10.5	12.0	15.0	15.0	17.5	18.0	21.0	0.267	5.60
4	0.7	MA3281-108	MA3281-109	MA3281-158	MA3281-159	MA3281-208	MA3281-209	MA3281-258	MA3281-259	MA3281-308	MA3281-309	8.0	8.0	12.0	12.0	16.0	16.0	20.0	20.0	24.0	24.0	0.267	6.80
5	0.8	MA3281-110	MA3281-111	MA3281-160	MA3281-161	MA3281-210	MA3281-211	MA3281-260	MA3281-261	MA3281-310	MA3281-311	10.0	10.0	15.0	15.0	20.0	20.0	25.0	25.0	30.0	30.0	0.415	7.95
6	1	MA3281-112	MA3281-113	MA3281-162	MA3281-163	MA3281-212	MA3281-213	MA3281-262	MA3281-263	MA3281-312	MA3281-313	12.0	12.0	18.0	18.0	24.0	24.0	30.0	30.0	36.0	36.0	0.415	9.20
7	1	MA3281-114	MA3281-115	MA3281-164	MA3281-165	MA3281-214	MA3281-215	MA3281-264	MA3281-265	MA3281-314	MA3281-315	12.0	14.0	18.0	21.0	24.0	28.0	30.0	35.0	36.0	42.0	0.511	15.00
8	1.25	MA3281-116	MA3281-117	MA3281-166	MA3281-167	MA3281-216	MA3281-217	MA3281-266	MA3281-267	MA3281-316	MA3281-317	14.0	16.0	21.0	24.0	28.0	32.0	40.0	40.0	48.0	48.0	0.511	17.25
10	1.5	MA3281-118	MA3281-119	MA3281-168	MA3281-169	MA3281-218	MA3281-219	MA3281-268	MA3281-269	MA3281-318	MA3281-319	16.0	18.0	24.0	27.0	32.0	36.0	45.0	45.0	54.0	54.0	0.799	17.35
12	1.5	MA3281-120	MA3281-121	MA3281-170	MA3281-171	MA3281-220	MA3281-221	MA3281-270	MA3281-271	MA3281-320	MA3281-321	18.0	18.0	27.0	27.0	36.0	36.0	45.0	45.0	54.0	54.0	0.511	21.05
14	1.5	MA3281-122	MA3281-123	MA3281-172	MA3281-173	MA3281-222	MA3281-223	MA3281-272	MA3281-273	MA3281-322	MA3281-323	20.0	20.0	30.0	30.0	40.0	40.0	50.0	50.0	60.0	60.0	0.511	21.85
14	2	MA3281-124	MA3281-125	MA3281-174	MA3281-175	MA3281-224	MA3281-225	MA3281-274	MA3281-275	MA3281-324	MA3281-325	20.0	20.0	30.0	30.0	40.0	40.0	50.0	50.0	60.0	60.0	0.799	22.00
16	1.5	MA3281-126	MA3281-127	MA3281-176	MA3281-177	MA3281-226	MA3281-227	MA3281-276	MA3281-277	MA3281-326	MA3281-327	22.0	22.0	33.0	33.0	44.0	44.0	55.0	55.0	66.0	66.0	0.511	23.15
18	1.5	MA3281-128	MA3281-129	MA3281-178	MA3281-179	MA3281-228	MA3281-229	MA3281-278	MA3281-279	MA3281-328	MA3281-329	24.0	24.0	36.0	36.0	48.0	48.0	60.0	60.0	72.0	72.0	0.799	23.20
20	2	MA3281-130	MA3281-131	MA3281-180	MA3281-181	MA3281-230	MA3281-231	MA3281-280	MA3281-281	MA3281-330	MA3281-331	27.0	27.0	40.5	40.5	54.0	54.0	67.5	67.5	81.0	81.0	1.017	24.00
20	2.5	MA3281-132	MA3281-133	MA3281-182	MA3281-183	MA3281-232	MA3281-233	MA3281-282	MA3281-283	MA3281-332	MA3281-333	28.0	30.0	45.0	45.0	60.0	60.0	75.0	75.0	90.0	90.0	0.511	24.05
22	1.5	MA3281-134	MA3281-135	MA3281-184	MA3281-185	MA3281-234	MA3281-235	MA3281-284	MA3281-285	MA3281-334	MA3281-335	33.0	33.0	49.5	49.5	66.0	66.0	82.5	82.5	99.0	99.0	0.799	24.40
22	2	MA3281-136	MA3281-137	MA3281-186	MA3281-187	MA3281-236	MA3281-237	MA3281-286	MA3281-287	MA3281-336	MA3281-337	33.0	36.0	54.0	54.0	72.0	72.0	90.0	90.0	108.0	108.0	0.511	25.55
24	2	MA3281-138	MA3281-139	MA3281-188	MA3281-189	MA3281-238	MA3281-239	MA3281-288	MA3281-289	MA3281-338	MA3281-339	39.0	39.0	58.5	58.5	78.0	78.0	97.5	97.5	117.0	117.0	0.799	25.60
24	3																				1.017	26.90	
27	2																				0.799	26.45	
27	3																				1.234	26.50	
30	2																				0.799	28.10	
30	3																				1.234	29.00	
33	2																				0.799	31.30	
33	3																				1.234	32.30	
36	2																				0.799	32.40	
36	3																				1.234	32.40	
39	2																				0.799	35.70	
39	3																				1.234	36.10	
																					0.799	39.20	
																					1.234	39.50	
																					0.799	42.40	
																					1.234	42.70	
																					0.799	44.30	
																					1.234	45.80	

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C ± .25 COIL														FED SUP. CLASS 534D		
THREAD SIZE		D					E		F		H		J		P	
DIA	PITCH	1 DIA	1.5 DIA	2 DIA	2.5 DIA	3 DIA	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX
2-2	0.45	3.125	5.375	7.625	9.875	12.125	0.437	0.487	0.318	0.394	0.225	0.2920	2.60	2.80	1.40	2.00
2-5	0.45	3.375	5.750	8.125	10.500	12.750	0.437	0.487	0.318	0.394	0.225	0.2920	3.05	3.65	1.60	2.25
3	0.5	3.750	6.375	8.875	11.375	13.875	0.482	0.541	0.362	0.438	0.250	0.3250	3.60	4.30	1.95	2.80
3-5	0.6	3.750	6.375	8.875	11.375	13.875	0.586	0.650	0.449	0.525	0.300	0.3900	4.25	4.90	2.20	3.00
4	0.7	3.625	6.125	8.625	11.125	13.625	0.583	0.758	0.510	0.612	0.350	0.4550	4.90	5.55	2.50	3.55
5	0.8	4.125	6.875	9.625	12.375	15.125	0.775	0.866	0.598	0.700	0.400	0.5200	6.10	6.75	3.15	4.55
6	1	4.000	6.750	9.500	12.250	14.875	0.975	1.083	0.748	0.875	0.500	0.6500	7.25	7.90	3.70	4.85
7	1	4.875	8.000	11.125	14.125	17.250	0.975	1.083	0.748	0.875	0.500	0.6500	8.40	9.15	4.30	5.50
8	1	5.875	9.375	13.000	16.500	20.125	0.975	1.083	0.748	0.875	0.500	0.6500	9.20	9.90	4.75	6.50
8	1.25	4.500	7.375	10.250	13.250	16.125	1.251	1.353	0.967	1.094	0.625	0.8120	9.50	9.65	4.75	6.50
10	1.25	5.875	9.500	13.125	16.750	20.375	1.251	1.353	0.967	1.094	0.625	0.8120	11.50	11.95	5.50	8.00
10	1.5	4.875	8.000	11.125	14.250	17.375	1.522	1.624	1.160	1.312	0.750	0.9740	11.80	12.25	5.50	8.00
12	1.25	7.250	11.625	15.875	20.250	24.500	1.251	1.353	0.967	1.094	0.625	0.7990	13.50	14.00	6.70	9.75
12	1.5	6.000	9.625	13.375	17.000	20.750	1.522	1.624	1.160	1.312	0.750	0.9740	13.80	14.30	6.70	9.75
12	1.75	5.000	8.250	11.500	14.625	17.875	1.792	1.894	1.379	1.531	0.875	1.1370	14.10	14.60	6.70	9.75
14	1.5	7.125	11.375	15.625	20.000	24.250	1.522	1.624	1.160	1.312	0.750	0.9740	15.80	16.30	7.20	11.25
14	2	5.125	8.500	11.750	15.000	18.375	2.063	2.165	1.598	1.750	1.000	1.2865	16.40	16.90	7.20	11.25
16	1.5	8.250	13.125	18.000	22.750	27.625	1.522	1.624	1.160	1.312	0.750	0.9740	17.80	18.30	8.30	12.75
16	2	6.125	9.750	13.500	17.250	21.000	2.063	2.165	1.598	1.750	1.000	1.2865	18.40	18.90	8.30	12.75
18	1.5	9.500	15.000	20.375	25.875	31.375	1.522	1.624	1.160	1.312	0.750	0.9740	19.80	20.35	9.30	14.00
18	2	7.000	11.125	15.375	19.500	23.625	2.063	2.165	1.598	1.750	1.000	1.2865	20.40	20.95	9.30	14.00
18	2.5	5.375	8.875	12.250	15.625	19.000	2.604	2.706	1.998	2.188	1.250	1.6240	20.90	21.45	9.30	14.00
20	1.5	10.750	16.875	22.875	28.875	35.000	1.522	1.624	1.160	1.312	0.750	0.9740	21.80	22.50	10.40	14.50
20	2	7.875	12.500	17.250	21.875	26.500	2.063	2.165	1.598	1.750	1.000	1.2865	22.40	23.10	10.40	14.50
20	2.5	6.125	9.875	13.625	17.375	21.125	2.604	2.706	1.998	2.188	1.250	1.6240	22.90	23.60	10.40	14.50
22	1.5	11.875	18.500	25.125	31.625	38.250	1.522	1.624	1.160	1.312	0.750	0.9740	24.10	24.80	11.40	16.00
22	2	8.750	13.750	18.875	23.875	29.000	2.063	2.165	1.598	1.750	1.000	1.2865	24.40	25.10	11.40	16.00
22	2.5	6.750	10.875	14.875	19.000	23.125	2.604	2.706	1.998	2.188	1.250	1.6240	24.90	25.60	11.40	16.00
24	3	9.500	15.000	20.375	25.875	31.250	2.063	2.165	1.598	1.750	1.000	1.2865	26.40	27.10	12.50	16.50
24	3	6.125	10.000	13.750	17.500	21.375	3.146	3.248	2.396	2.625	1.500	1.9360	27.50	28.20	12.50	16.50
27	2	10.875	17.000	23.250	29.375	35.500	2.063	2.165	1.598	1.750	1.000	1.2865	29.40	30.10	14.00	17.50
27	3	7.000	11.250	15.500	19.750	24.000	2.604	2.706	1.998	2.188	1.500	1.9360	30.50	31.20	14.00	17.50
30	2	12.250	19.125	25.875	32.750	39.500	2.063	2.165	1.598	1.750	1.000	1.2865	32.50	33.20	15.00	19.00
30	3	7.875	12.500	17.125	21.875	26.500	3.146	3.248	2.396	2.625	1.500	1.9360	33.50	34.20	15.00	19.00
33	2	13.625	21.125	28.625	36.000	43.500	2.063	2.165	1.598	1.750	1.000	1.2865	35.80	36.50	17.00	21.00
33	3	8.750	13.875	19.000	24.125	29.250	3.146	3.248	2.396	2.625	1.500	1.9360	36.50	37.20	17.00	21.00
36	2	15.000	23.250	31.375	39.500	47.750	2.063	2.165	1.598	1.750	1.000	1.2865	39.00	39.70	18.50	22.50
36	3	9.750	15.250	20.875	26.500	32.000	3.146	3.248	2.396	2.625	1.500	1.9360	39.50	40.20	18.50	22.50
39	2	16.375	25.250	34.125	43.000	51.875	2.063	2.165	1.598	1.750	1.000	1.2865	42.30	43.00	20.00	24.00
39	3	10.750	16.750	22.750	28.875	34.875	3.146	3.248	2.396	2.625	1.500	1.9360	42.50	43.20	20.00	24.00
SHEET 4 OF 5 METRIC																
AEROSPACE STANDARD																
INSERT, SCREW THREAD, HELICAL COIL, METRIC SERIES																
FREE RUNNING, CRES																
MA3279																
MA3280																
MA3281																
Issued 9-1-81 Revised 3-1-85																

AEROSPACE STANDARD

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SHEET 4 OF 5 METRIC

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