

Table 1 Metric (M, MJ) Series of Coarse Wire Thread Inserts Parameter Table
unit :(mm)

Screw Thread d×p	K×d	t ₂	do	t ₁	L ₂	t ₃	dz	N (≈)	Kg/千 件
2×0.4	1d	2	2	4	1.6	1.6	2.62~ 2.76	2.9	0.02
	1.5d	3		5	2.6	2.6		4.7	0.03
	2d	4		6	3.6	3.6		6.5	0.05
2.5× 0.45	1d	2.5	2.6	4.3	2.1	2.1	3.3~ 3.5	3.5	0.03
	1.5d	3.25		5.6	3.3	3.3		5.9	0.05
	2d	5		6.8	4.6	4.6		8.1	0.07
3×0.5	1d	3	3.1	5.8	2.5	2.5	3.82~ 4.00	4	0.05
	1.5d	4.5		7.3	4	4		6.3	0.08
	2d	6		8.8	5.5	5.5		8.7	0.11
	2.5d	7.5		10.3	7	7		11	0.14
	3d	9		11.8	8.5	8.5		13.5	0.18
4×0.7	1d	4	4.1	7.8	3.3	3.3	5.12~ 5.30	3.7	0.12
	1.5d	6		9.8	5.3	5.3		6	0.20
	2d	8		11.8	7.3	7.3		8.4	0.27
	2.5d	10		13.8	9.3	9.3		11	0.38
	3d	12		15.8	11.3	11.3		13.2	0.45
5×0.8	1d	5	5.2	9.2	4.2	4.2	6.32~ 6.54	4.3	0.22
	1.5d	7.5		11.7	6.7	6.7		6.9	0.36
	2d	10		14.2	9.2	9.2		9.7	0.49
	2.5d	12.5		16.7	11.7	11.7		12.3	0.68
	3d	15		19.2	14.2	14.2		14.8	0.80
6×1	1d	6	6.2	11.1	5	5	7.62~ 7.84	4.2	0.41
	1.5d	9		14.1	8	8		7	0.67
	2d	12		17.1	11	11		9.6	0.91
	2.5d	15		20.1	14	14		12.3	1.20
	3d	18		23.1	17	17		14.6	1.50
8× 1.25	1d	8	8.3	14.2	6.8	6.8	9.85~ 10.1	4.7	0.94
	1.5d	12		18.2	10.8	10.8		7.4	1.51
	2d	16		22.2	14.8	14.8		10.6	2.07
	2.5d	20		26.2	18.8	18.8		13.5	2.80
	3d	24		30.2	22.8	22.8		16.4	3.40
10× 1.5	1d	10	10.3	17.3	8.5	8.5	12.1~ 12.5	5.0	1.80
	1.5d	15		22.3	13.5	13.5		8.0	2.85
	2d	20		27.3	18.5	18.5		11.2	3.90
	2.5d	25		32.3	23.5	23.5		14.2	5.47
	3d	30		37.3	28.5	28.5		17.2	6.60
12× 1.75	1d	12	12.4	20.3	10.3	10.3	14.4~ 14.8	5.2	2.95
	1.5d	18		26.3	16.3	16.3		8.4	4.75
	2d	24		32.3	22.3	22.3		11.7	8.60
	2.5d	30		38.3	28.3	28.3		14.7	9.00
	3d	36		44.3	34.3	34.3		18.0	11.0
14×2	1d	14	14.5	22.	12	11	17.2~ 17.7	5.2	4.7
	1.5d	21		29	19	18		8.3	7.35
	2d	28		36	26	25		11.5	10.1

16×2	1d	16	16.5	25.3	14	14	18.73 ~19.5	6.0	6.35
	1.5d	24		33.3	22	22		9.7	9.99
	2d	32		41.3	30	30		13.3	13.30
	2.5d	40		49.3	38	38		16.8	17.00
20× 2.5	1d	20	20.5	31.2	17.5	17.5	23.7~ 24.2	6.3	13.0
	1.5d	30		41.2	27.5	27.5		10	19.3
	2d	40		51.2	37.5	37.5		13.7	26.6
22× 2.5	1d	22	22.5	33.2	19.5	19.5	26.3~ 26.8	7	15.3
	1.5d	33		44.2	30.5	30.5		11	23.8
	2d	44		55.2	41.5	41.5		15	32.6
24×3	1d	24	24.6	37.1	21	21	28.6~ 29.1	6.3	34.0
	1.5d	36		49.1	33	33		10.0	43.0
	2d	48		61.1	45	45		14.0	62.0
30× 3.5	1d	30	30.7	45.2	26.5	26.5	35.2~ 35.7	7	40.3
	1.5d	45		60.2	41.5	41.5		11	62.5
	2d	60		75.2	56.5	56.5		14.9	84.1

Table 2 Metric (M, MJ) Series of Fine Wire Thread Inserts Parameter Table
unit :(mm)

Screw Thread d×p	K×d	t ₂	do	t ₁	L ₂	t ₃	dz	N (≈)	Kg/千 件
8×1	1d	8	8.2	13	7	7	9.85~ 10.1	6	0.78
	1.5d	12		17	11	11		9.5	1.19
	2d	16		21	15	15		13	1.60
10×1	1d	10	10.2	15	9	9	12.1~ 12.5	7.6	1.24
	1.5d	15		20	14	14		12	1.90
	2d	20		25	19	19		16.3	2.55
12× 1.25	1d	12	12.3	18	10.8	10.8	14.4~ 14.8	7.4	2.22
	1.5d	18		24	16.8	16.8		11.6	3.44
	2d	24		30	22.8	22.8		16	4.69
12× 1.5	1d	12	12.4	19.3	10.5	10.5	14.4~ 14.8	6.2	2.68
	1.5d	18		25.3	16.5	16.5		9.8	4.17
	2d	24		31.3	22.5	22.5		13.5	5.70
14× 1.5	1d	14	14.4	21.3	12.5	12.5	17.2~ 17.8	7	3.72
	1.5d	21		28.3	19.5	19.5		11.2	5.79
	2d	28		35.3	26.5	26.5		15.3	7.86
16× 1.5	1d	16	16.4	23.3	14.5	14.5	19.4~ 19.9	8.3	4.92
	1.5d	24		31.3	22.5	22.5		13	7.62
	2d	32		39.3	30.5	30.5		17.7	10.4
18× 1.5	0.75d	13.5	18.4	20.8	12	12	21.5~ 22.0	7.0	4.69
	1d	18		25.3	16.5	16.5		9.5	6.25
	1.5d	27		34.3	25.5	25.5		15	9.70
20× 1.5	0.75d	15	20.4	22.3	13.5	13.5	23.7~ 24.2	8	5.83
	1d	20		27.3	18.5	18.5		10.7	7.77
	1.5d	30		37.3	28.5	28.5		16.7	12.0
22× 1.5	0.75d	16.5	22.5	23.8	15	15	26.3~ 26.8	8.6	7.1
	1d	22		29.3	20.5	20.5		11.7	9.46
	1.5d	33		40.3	31.5	31.5		18	14.6
24× 1.5	0.5d	12	24.4	19.3	10.5	10.5	28.6~ 29.1	6	5.70
	0.75d	18		25.3	16.5	16.5		9.5	8.55
	1d	24		31.3	22.5	22.5		13	11.4
	1.5d	36		43.3	34.5	34.5		19.8	17.4
27× 1.5	0.5d	13.5	27.4	20.8	12	12	32.2~ 32.7	6.7	7.7
	0.75d	20.3		27.6	18.8	18.8		10.7	11.6
	1d	27		34.3	25.5	25.5		14.6	15.4

	1.5d	40.5		47.8	39.0	39.0		22.6	23.1
27×2	0.5d	13.5	27.5	22.8	11.5	11.5	32.2~ 32.7	5	9.35
	0.75d	20.3		29.6	18.3	18.3		8	14.0
	1d	27		36.3	25.0	25.0		10.8	18.7
	1.5d	40		49.8	38.5	38.5		16.8	28.8
30×1.5	0.5d	15	30.4	22.3	13.5	13.5	35.2~ 35.7	7.8	9
	0.75d	22.5		29.8	21.0	21.0		12.2	13.5
	1d	30		37.3	28.5	28.5		16.5	18
	1.5d	45		52.3	43.5	43.5		25.3	27.4
33×2	0.5d	16.5	33.5	25.8	14.5	14.5	38.3~ 38.8	6.4	14.4
	0.75d	24.5		34.1	22.8	22.8		10	21.6
	1d	33		42.3	31.0	31.0		13.7	28.8
	1.5d	49.5		58.8	47.5	47.5		21.2	43.4
33×1.5	0.5d	16.6	33.4	24	15	15	38.3~ 38.8	9.1	11.0
	0.75d	24.5		31	23	23		13.7	16.4
	1d	33		39	31.5	31.5		18.3	21.8
	1.5d	49.5		55.5	48	48		28	33.2

Table 3 Unified Coarse Screw Thread (UN) Series of Wire Thread Inserts Parameter Table
unit :(mm)

Screw Thread d×p	Nominal length k×d	drill and tapping parameter			Installed parameters		Free-stated parameters	
		t ₂	drill do	t ₁	L ₂	t ₃	D ₂	N (≈)
4—40 0.112— 40	1d	2.9	3	5.7	2.5	2.2	3.66~ 4.04	3.2
	1.5d	4.3		7.1	3.9	3.6		5.1
	2d	5.8		8.6	5.4	5.1		7.2
5—40 0.125— 40	1d	3.2	3.4	6	2.8	2.5	4.01~ 4.39	3.7
	1.5d	4.8		7.6	4.3	4.1		5.9
	2d	6.4		9.2	6	5.7		8.2
6—32 0.138— 32	1d	3.5	3.7	7.1	3.1	2.7	4.52~ 4.90	2.8
	1.5d	5.3		8.8	4.9	4.5		4.8
	2d	7.0		10.6	6.6	6.2		6.8
8—32 0.164— 32	1d	4.2	4.4	7.7	3.8	3.4	5.20~ 5.56	4.0
	1.5d	6.25		9.8	5.9	5.5		6.0
	2d	8.3		11.9	8	7.5		8.7
10—24 0.190— 24	1d	4.8	5.1	9.6	4.3	3.8	6.19~ 6.58	3.3
	1.5d	7.2		12	6.7	6.2		5.4
	2d	9.6		14.4	9.1	8.6		7.5
12—24 0.216— 24	1d	5.5	5.8	10.3	5	4.4	6.86~ 7.24	4.0
	1.5d	8.2		13	7.7	7.1		6.3
	2d	11.0		15.7	10.5	9.9		8.8
1/4" — 20	1d	6.4	6.7	12.1	5.8	5.1	7.86~ 8.38	3.9
	1.5d	9.5		15.2	8.9	8.2		6.2
	2d	12.7		18.4	12.1	11.4		8.6
3/8" — 16	1d	9.5	9.9	16.7	8.7	7.9	11.48~ 11.99	4.8
	1.5d	14.3		21.4	13.5	12.7		7.7
	2d	19.1		26.2	18.3	17.5		10.6
7/16" — 14	1d	11.1	11.6	19.3	10.2	9.3	13.36~ 13.99	4.9
	1.5d	16.7		24.8	15.8	14.9		7.9

	2d	22.2		30.4	21.3	20.4		10.7
1/2" — 13	1d	12.7	13.1	21.5	11.7	10.7	15.16~ 15.80	5.2
	1.5d	19.1		27.8	18.1	17.1		8.3
	2d	25.4		34.2	12.4	23.4		11.4
5/8" — 11	1d	15.9	16.4	26.3	14.7	13.6	18.84~ 19.48	5.7
	1.5d	23.8		34.2	22.6	21.5		9.0
	2d	31.8		42.1	30.6	29.4		12.3
3/4" — 10	1d	19.1	19.6	30.5	17.8	16.5	22.36~ 23.00	6.3
	1.5d	28.6		40	27.3	26		9.9
	2d	38.1		49.5	36.8	35.5		13.5
1" —8	1d	25.4	26.1	39.7	23.8	22.2	29.62~ 30.38	6.8
	1.5d	38.1		52.4	36.5	34.9		10.6
	2d	50.8		65.1	49.2	47.6		14.5

Table 4 Unified Fine Screw Thread (UN) Series of Wire Thread Inserts Parameter Table
unit :(mm)

Screw Thread d×p	Nominal length k×d	drill and tapping parameter			Installed parameters		Free-stated parameters	
		t ₂	drill do	t ₁	L ₂	t ₃	D ₂	N (≈)
8—36 0.164— 36	1d	4.2	4.3	7.3	3.8	3.4	5.18~ 5.68	4.5
	1.5d	6.3		9.4	5.9	5.5		7.2
	2d	8.3		11.5	7.9	7.6		9.7
10—32 0.19— 32	1d	4.83	5.0	8.4	4.4	4	5.99~ 6.50	4.1
	1.5d	7.24		10.8	6.8	6.5		6.9
	2d	9.6		13.2	9.2	8.9		10
1/4" — 28	1d	6.35	6.6	10.4	5.9	5.5	7.77~ 8.28	5.0
	1.5d	9.5		13.6	9	8.6		8.6
	2d	12.7		16.8	12.2	11.8		11.8
5/16" — 24	1d	7.9	8.2	12.7	7.4	6.9	9.65~ 10.16	5.9
	1.5d	11.9		16.7	11.4	10.9		9.4
	2d	15.9		20.6	15.4	14.9		12.8
3/8" — 24	1d	9.5	9.8	14.3	9	8.4	11.37~ 11.88	7.3
	1.5d	14.3		19.1	13.8	13.2		11.5
	2d	19.1		23.8	18.6	18		15.6
7/16— 20	1d	11.1	11.4	16.8	10.5	9.8	13.3~ 13.7	7.0
	1.5d	16.7		22.4	16.1	15.4		11.1
	2d	22.2		27.9	21.6	20.9		15.0
1/2—20	1d	12.7	13.0	18.4	12.1	11.4	15.03~ 15.67	7.9
	1.5d	19.7		24.8	18.5	17.8		12.8
	2d	25.4		31.1	24.8	24.1		17.3
9/16— 18	1d	14.3	14.6	20.6	13.6	12.9	16.91~ 17.55	7.9
	1.5d	21.5		27.8	20.8	20.1		12.0
	2d	28.6		34.9	27.9	27.2		16.0
5/8" — 18	1d	15.9	16.2	22.2	15.2	14.5	18.61~ 19.25	9.4
	1.5d	23.8		30.2	23.1	22.4		14.5

	2d	31.8		38.1	31.1	30.4		19.7
3/4" — 16	1d	19.1	19.4	26.2	18.3	17.5	22.25~ 22.88	10.1
	1.5d	28.6		35.7	27.8	27		15.6
	2d	38.1		45.2	37.3	36.5		21.0
7/8" — 14	1d	22.2	22.6	30.4	21.3	20.4	25.93~ 26.69	10.3
	1.5d	33.3		41.5	21.4	31.5		15.9
	2d	44.5		52.6	43.6	42.7		21.6
1" —14	1d	25.4	25.9	33.6	24.5	23.6	29.69~ 30.45	11.8
	1.5d	38.1		46.3	37.2	36.3		18.1
	2d	50.8		59	49.9	49		24.5
1" —12	1d	25.4	30.0	34.9	24.3	23.3	29.69~ 30.45	10.0
	1.5d	38.1		47.6	37	36		15.6