



D		1.0D		1.5D		2.0D		2.5D		3.0D	
mm	mm	mm	#	mm	#	mm	#	mm	#	mm	#
<b>METRIC COARSE</b>											
2.00	0.40	2.00	3520-2.00X1.0DSL	3.00	3520-2.00X1.5DSL	4.00	3520-2.00X2.0DSL	5.00	3520-2.00X2.5DSL	6.00	3520-2.00X3.0DSL
2.20	0.45	2.20	3520-2.20X1.0DSL	3.30	3520-2.20X1.5DSL	4.40	3520-2.20X2.0DSL	5.50	3520-2.20X2.5DSL	6.60	3520-2.20X3.0DSL
2.50	0.45	2.50	3520-2.50X1.0DSL	3.75	3520-2.50X1.5DSL	5.00	3520-2.50X2.0DSL	6.25	3520-2.50X2.5DSL	9.00	3520-2.50X3.0DSL
3.00	0.50	3.00	3520-3.00X1.0DSL	4.50	3520-3.00X1.5DSL	6.00	3520-3.00X2.0DSL	7.50	3520-3.00X2.5DSL	9.00	3520-3.00X3.0DSL
3.50	0.60	3.50	3520-3.50X1.0DSL	5.25	3520-3.50X1.5DSL	7.00	3520-3.50X2.0DSL	8.75	3520-3.50X2.5DSL	10.50	3520-3.50X3.0DSL
4.00	0.70	4.00	3520-4.00X1.0DSL	6.00	3520-4.00X1.5DSL	8.00	3520-4.00X2.0DSL	10.00	3520-4.00X2.5DSL	12.00	3520-4.00X3.0DSL
5.00	0.80	5.00	3520-5.00X1.0DSL	7.50	3520-5.00X1.5DSL	10.00	3520-5.00X2.0DSL	12.50	3520-5.00X2.5DSL	15.00	3520-5.00X3.0DSL
6.00	1.00	6.00	3520-6.00X1.0DSL	9.00	3520-6.00X1.5DSL	12.00	3520-6.00X2.0DSL	15.00	3520-6.00X2.5DSL	18.00	3520-6.00X3.0DSL
7.00	1.00	7.00	3520-7.00X1.0DSL	10.50	3520-7.00X1.5DSL	14.00	3520-7.00X2.0DSL	17.50	3520-7.00X2.5DSL	21.00	3520-7.00X3.0DSL
8.00	1.25	8.00	3520-8.00X1.0DSL	12.00	3520-8.00X1.5DSL	16.00	3520-8.00X2.0DSL	20.00	3520-8.00X2.5DSL	24.00	3520-8.00X3.0DSL
9.00	1.25	9.00	3520-9.00X1.0DSL	13.50	3520-9.00X1.5DSL	18.00	3520-9.00X2.0DSL	22.50	3520-9.00X2.5DSL	27.00	3520-9.00X3.0DSL
10.00	1.50	10.00	3520-10.00X1.0DSL	15.00	3520-10.00X1.5DSL	20.00	3520-10.00X2.0DSL	25.00	3520-10.00X2.5DSL	30.00	3520-10.00X3.0DSL
11.00	1.50	11.00	3520-11.00X1.0DSL	16.50	3520-11.00X1.5DSL	22.00	3520-11.00X2.0DSL	27.50	3520-11.00X2.5DSL	33.00	3520-11.00X3.0DSL
12.00	1.75	12.00	3520-12.00X1.0DSL	18.00	3520-12.00X1.5DSL	24.00	3520-12.00X2.0DSL	30.00	3520-12.00X2.5DSL	36.00	3520-12.00X3.0DSL
14.00	2.00	14.00	3520-14.00X1.0DSL	21.00	3520-14.00X1.5DSL	28.00	3520-14.00X2.0DSL	35.00	3520-14.00X2.5DSL	42.00	3520-14.00X3.0DSL
16.00	2.00	16.00	3520-16.00X1.0DSL	24.00	3520-16.00X1.5DSL	32.00	3520-16.00X2.0DSL	40.00	3520-16.00X2.5DSL	48.00	3520-16.00X3.0DSL
18.00	2.50	18.00	3520-18.00X1.0DSL	27.00	3520-18.00X1.5DSL	36.00	3520-18.00X2.0DSL	45.00	3520-18.00X2.5DSL	54.00	3520-18.00X3.0DSL
20.00	2.50	20.00	3520-20.00X1.0DSL	30.00	3520-20.00X1.5DSL	40.00	3520-20.00X2.0DSL	50.00	3520-20.00X2.5DSL	60.00	3520-20.00X3.0DSL
22.00	2.50	22.00	3520-22.00X1.0DSL	33.00	3520-22.00X1.5DSL	44.00	3520-22.00X2.0DSL	55.00	3520-22.00X2.5DSL	66.00	3520-22.00X3.0DSL
24.00	3.00	24.00	3520-24.00X1.0DSL	36.00	3520-24.00X1.5DSL	48.00	3520-24.00X2.0DSL	60.00	3520-24.00X2.5DSL	72.00	3520-24.00X3.0DSL

### LOCKING INSERT TORQUE VALUES – METRIC COARSE

(for inserts conforming to MA3329, MA3330 and MA3331)

Nominal Thread Size	Max. Locking Torque		Min. Locking Torque	
	Nm		Nm	
M2.20 X 0.45	0.14	0.02		
M2.50 X 0.45	0.23	0.05		
M3.00 X 0.50	0.45	0.10		
M3.50 X 0.60	0.68	0.12		
M4.00 X 0.70	0.90	0.15		
M5.00 X 0.80	1.60	0.30		
M6.00 X 1.00	3.00	0.40		
M7.00 X 1.00	4.50	0.60		
M8.00 X 1.25	6.00	0.80		

Nominal Thread Size	Max. Locking Torque		Min. Locking Torque	
	Nm		Nm	
M10.00 X 1.50	10.50	1.40		
M12.00 X 1.75	15.50	2.10		
M14.00 X 2.00	23.50	3.00		
M16.00 X 2.00	31.50	4.20		
M18.00 X 2.50	42.00	5.50		
M20.00 X 2.50	54.00	7.00		
M22.00 X 2.50	67.50	9.00		
M24.00 X 3.00	80.00	10.50		