

**STANLEY**<sup>®</sup>  
Engineered Fastening

**HELI-COIL**<sup>®</sup>  
Aerospace Standard  
Metric Cross Reference

Technical Bulletin HCMS-1

**HeliCoil**<sup>®</sup>

### AEROSPACE STANDARD INTERCHANGEABILITY LIST

THREAD SIZE		AEROSPACE STANDARD PART NUMBER FOR UNCOATED FREE RUNNING INSERT, CRES				NOTE: DRY FILM LUBED BASE NO. IS 3330 (SEE EXAMPLE BELOW) CADMIUM PLATED INSERT BASE IS 3331 (SEE EXAMPLE BELOW)				Helicoil					
DIA	PITCH	Helicoil		Helicoil		2 DIA		Helicoil		2.5 DIA		Helicoil		Helicoil	
		1 DIA	PART NUMBER	1.5 DIA	PART NUMBER	2 DIA	PART NUMBER	2.5 DIA	PART NUMBER	3 DIA	PART NUMBER	3 DIA	PART NUMBER	3 DIA	PART NUMBER
2	0.04		MA3279-140		MA3279-190		MA3279-240		MA3279-290		MA3279-340		MA3279-340		1084-2CN
2.2	0.45		MA3279-100		MA3279-150		MA3279-200		MA3279-250		MA3279-300		MA3279-300		1084-2.2CN
2.5	0.45		MA3279-101		MA3279-151		MA3279-201		MA3279-251		MA3279-301		MA3279-301		1084-2.5CN
3	0.5		MA3279-102		MA3279-152		MA3279-202		MA3279-252		MA3279-302		MA3279-302		1084-3CN
3.5	0.6		MA3279-103		MA3279-153		MA3279-203		MA3279-253		MA3279-303		MA3279-303		1084-3.5CN
4	0.7		MA3279-104		MA3279-154		MA3279-204		MA3279-254		MA3279-304		MA3279-304		1084-4CN
5	0.8		MA3279-105		MA3279-155		MA3279-205		MA3279-255		MA3279-305		MA3279-305		1084-5CN
6	1.0		MA3279-106		MA3279-156		MA3279-206		MA3279-256		MA3279-306		MA3279-306		1084-6CN
7	1.0		MA3279-107		MA3279-157		MA3279-207		MA3279-257		MA3279-307		MA3279-307		1084-7CN
8	1.0		MA3279-108		MA3279-158		MA3279-208		MA3279-258		MA3279-308		MA3279-308		4255-8CN
8	1.25		MA3279-109		MA3279-159		MA3279-209		MA3279-259		MA3279-309		MA3279-309		1084-8CN
10	1.0														
10	1.0		MA3279-110		MA3279-160		MA3279-210		MA3279-260		MA3279-310		MA3279-310		4255-10CN
10	1.25		MA3279-111		MA3279-161		MA3279-211		MA3279-261		MA3279-311		MA3279-311		4649-10CN
12	1.25		MA3279-112		MA3279-162		MA3279-212		MA3279-262		MA3279-312		MA3279-312		1084-10CN
12	1.5		MA3279-113		MA3279-163		MA3279-213		MA3279-263		MA3279-313		MA3279-313		4649-12CN
12	1.75		MA3279-114		MA3279-164		MA3279-214		MA3279-264		MA3279-314		MA3279-314		3745-12CN
14	1.5		MA3279-115		MA3279-165		MA3279-215		MA3279-265		MA3279-315		MA3279-315		1084-12CN
14	2.0		MA3279-116		MA3279-166		MA3279-216		MA3279-266		MA3279-316		MA3279-316		3745-14CN
16	1.5		MA3279-117		MA3279-167		MA3279-217		MA3279-267		MA3279-317		MA3279-317		1084-14CN
16	2.0		MA3279-118		MA3279-168		MA3279-218		MA3279-268		MA3279-318		MA3279-318		3745-16CN
18	1.5		MA3279-119		MA3279-169		MA3279-219		MA3279-269		MA3279-319		MA3279-319		1084-16CN
18	2.0		MA3279-120		MA3279-170		MA3279-220		MA3279-270		MA3279-320		MA3279-320		3745-18CN
18	2.5		MA3279-121		MA3279-171		MA3279-221		MA3279-271		MA3279-321		MA3279-321		4266-18CN
20	1.5		MA3279-122		MA3279-172		MA3279-222		MA3279-272		MA3279-322		MA3279-322		1084-18CN
20	2.0		MA3279-123		MA3279-173		MA3279-223		MA3279-273		MA3279-323		MA3279-323		3745-20CN
20	2.0		MA3279-124		MA3279-174		MA3279-224		MA3279-274		MA3279-324		MA3279-324		4266-20CN
22	1.5		MA3279-125		MA3279-175		MA3279-225		MA3279-275		MA3279-325		MA3279-325		1084-20CN
22	2.0		MA3279-126		MA3279-176		MA3279-226		MA3279-276		MA3279-326		MA3279-326		3745-22CN
22	2.5		MA3279-127		MA3279-177		MA3279-227		MA3279-277		MA3279-327		MA3279-327		4266-22CN
24	2.0		MA3279-128		MA3279-178		MA3279-228		MA3279-278		MA3279-328		MA3279-328		1084-22CN
24	3.0		MA3279-129		MA3279-179		MA3279-229		MA3279-279		MA3279-329		MA3279-329		4266-24CN
27	2.0		MA3279-130		MA3279-180		MA3279-230		MA3279-280		MA3279-330		MA3279-330		1084-24CN
27	3.0		MA3279-131		MA3279-181		MA3279-231		MA3279-281		MA3279-331		MA3279-331		3745-26CN
30	2.0		MA3279-132		MA3279-182		MA3279-232		MA3279-282		MA3279-332		MA3279-332		4266-27CN
30	3.0		MA3279-133		MA3279-183		MA3279-233		MA3279-283		MA3279-333		MA3279-333		4266-30CN
30	3.5														4277-30CN
33	3.5														1084-30CN
33	3.5														1084-30CN
36	2.0		MA3279-134		MA3279-184		MA3279-234		MA3279-284		MA3279-334		MA3279-334		4266-33CN
36	3.0		MA3279-135		MA3279-185		MA3279-235		MA3279-285		MA3279-335		MA3279-335		4266-36CN
36	3.0														4277-33CN
36	3.0														4277-36CN
36	3.5														1084-36CN
39	2.0		MA3279-136		MA3279-186		MA3279-236		MA3279-286		MA3279-336		MA3279-336		4266-36CN
39	3.0		MA3279-137		MA3279-187		MA3279-237		MA3279-287		MA3279-337		MA3279-337		4266-36CN
39	4.0														4277-36CN
39	4.0														1084-36CN
39	4.0		MA3279-138		MA3279-188		MA3279-238		MA3279-288		MA3279-338		MA3279-338		4266-39CN
39	4.0		MA3279-139		MA3279-189		MA3279-239		MA3279-289		MA3279-339		MA3279-339		4277-39CN
39	4.0														1084-39CN

AEROSPACE STANDARD BASE P/N IS "3280" INSTEAD OF "3279" ADD A "W" AFTER THE "CN" IN THE HELI-COIL P/N			
CADMIUM PLATED FREE-RUNNING INSERTS			
AEROSPACE STANDARD BASE P/N IS "3281" INSTEAD OF "3279" ADD A "V" AFTER THE "CN" IN THE HELI-COIL P/N			
EXAMPLES:			
M72 x 0.45 x 1 DIA	UNCOATED	MA3279-100	0022
	DRY FILM LUBE	MA3280-100	0022
	CAD PLATED	MA3281-100	0022

**STANLEY®**  
Engineered Fastening

STANLEY ENGINEERED FASTENING  
Shelton Lock Lane  
Danbury, CT 06810  
Tel: (877) 364-2781

**HeliCoil®**  
HMS-1 Rev.5 (07/14)

# HELI-COIL® METRIC INSERTS

NOTE: DRY FILM LUBED BASE NO. IS 3330 (SEE EXAMPLE BELOW)  
CADIUM PLATED INSERT BASE IS 3331 (SEE EXAMPLE BELOW)

DIA	PITCH	1 DIA	1.5 DIA	2 DIA	2.5 DIA	3 DIA	Helicoil PART NUMBER	Helicoil PART NUMBER	Helicoil PART NUMBER	Helicoil PART NUMBER
2	0.4	--	MA3329-190	MA3329-240	MA3329-290	MA3329-340	4184-2CN030	4184-2CN040	4184-2CN050	4184-2CN060
	0.45	MA3329-100	MA3329-150	MA3329-200	MA3329-250	MA3329-300	4184-2.2CN033	4184-2.2CN044	4184-2.2CN055	4184-2.2CN066
	0.45	MA3329-101	MA3329-151	MA3329-201	MA3329-251	MA3329-301	4184-2.5CN038	4184-2.5CN049	4184-2.5CN063	4184-2.5CN075
3	0.5	MA3329-102	MA3329-152	MA3329-202	MA3329-252	MA3329-302	4184-3CN045	4184-3CN056	4184-3CN075	4184-3CN090
	0.6	MA3329-103	MA3329-153	MA3329-203	MA3329-253	MA3329-303	4184-3.5CN053	4184-3.5CN070	4184-3.5CN088	4184-3.5CN105
	0.7	MA3329-104	MA3329-154	MA3329-204	MA3329-254	MA3329-304	4184-4CN060	4184-4CN080	4184-4CN100	4184-4CN120
5	0.8	MA3329-105	MA3329-155	MA3329-205	MA3329-255	MA3329-305	4184-5CN075	4184-5CN100	4184-5CN125	4184-5CN150
	1.0	MA3329-106	MA3329-156	MA3329-206	MA3329-256	MA3329-306	4184-6CN090	4184-6CN120	4184-6CN150	4184-6CN180
	1.0	MA3329-107	MA3329-157	MA3329-207	MA3329-257	MA3329-307	4184-7CN105	4184-7CN125	4184-7CN150	4184-7CN180
8	1.0	MA3329-108	MA3329-158	MA3329-208	MA3329-258	MA3329-308	5255-8CN120	5255-8CN160	5255-8CN200	5255-8CN240
	1.25	MA3329-109	MA3329-159	MA3329-209	MA3329-259	MA3329-309	4184-8CN120	4184-8CN160	4184-8CN200	4184-8CN240
	1.0	--	--	--	--	--	5255-10CN150	5255-10CN200	5255-10CN250	5255-10CN300
10	1.25	MA3329-110	MA3329-160	MA3329-210	MA3329-260	MA3329-310	5649-10CN100	5649-10CN200	5649-10CN300	5649-10CN400
10	1.5	MA3329-111	MA3329-161	MA3329-211	MA3329-261	MA3329-311	4184-10CN100	4184-10CN200	4184-10CN250	4184-10CN300
12	1.25	MA3329-112	MA3329-162	MA3329-212	MA3329-262	MA3329-312	5649-12CN180	5649-12CN240	5649-12CN300	5649-12CN360
12	1.5	MA3329-113	MA3329-163	MA3329-213	MA3329-263	MA3329-313	5145-12CN120	5145-12CN240	5145-12CN360	5145-12CN480
12	1.75	MA3329-114	MA3329-164	MA3329-214	MA3329-264	MA3329-314	4184-12CN180	4184-12CN240	4184-12CN300	4184-12CN360
14	1.5	MA3329-115	MA3329-165	MA3329-215	MA3329-265	MA3329-315	5145-14CN120	5145-14CN280	5145-14CN350	5145-14CN420
	2.0	MA3329-116	MA3329-166	MA3329-216	MA3329-266	MA3329-316	4184-14CN210	4184-14CN320	4184-14CN380	4184-14CN480
	1.5	MA3329-117	MA3329-167	MA3329-217	MA3329-267	MA3329-317	5145-16CN160	5145-16CN320	5145-16CN400	5145-16CN480
16	2.0	MA3329-118	MA3329-168	MA3329-218	MA3329-268	MA3329-318	4184-16CN240	4184-16CN320	4184-16CN400	4184-16CN480
18	1.5	MA3329-119	MA3329-169	MA3329-219	MA3329-269	MA3329-319	5145-18CN180	5145-18CN360	5145-18CN450	5145-18CN540
	2.0	MA3329-120	MA3329-170	MA3329-220	MA3329-270	MA3329-320	5266-18CN180	5266-18CN360	5266-18CN450	5266-18CN540
	2.5	MA3329-121	MA3329-171	MA3329-221	MA3329-271	MA3329-321	4184-18CN180	4184-18CN360	4184-18CN450	4184-18CN540
20	1.5	MA3329-122	MA3329-172	MA3329-222	MA3329-272	MA3329-322	5145-20CN180	5145-20CN400	5145-20CN500	5145-20CN600
	2.0	MA3329-123	MA3329-173	MA3329-223	MA3329-273	MA3329-323	5266-20CN180	5266-20CN400	5266-20CN500	5266-20CN600
	2.5	MA3329-124	MA3329-174	MA3329-224	MA3329-274	MA3329-324	4184-20CN200	4184-20CN400	4184-20CN500	4184-20CN600
22	1.5	MA3329-125	MA3329-175	MA3329-225	MA3329-275	MA3329-325	5145-22CN180	5145-22CN440	5145-22CN550	5145-22CN660
	2.0	MA3329-126	MA3329-176	MA3329-226	MA3329-276	MA3329-326	5266-22CN180	5266-22CN440	5266-22CN550	5266-22CN660
	2.5	MA3329-127	MA3329-177	MA3329-227	MA3329-277	MA3329-327	4184-22CN220	4184-22CN440	4184-22CN550	4184-22CN660
24	2.0	MA3329-128	MA3329-178	MA3329-228	MA3329-278	MA3329-328	5266-24CN160	5266-24CN480	5266-24CN600	5266-24CN720
	3.0	MA3329-129	MA3329-179	MA3329-229	MA3329-279	MA3329-329	4184-24CN240	4184-24CN480	4184-24CN600	4184-24CN720
	2.0	MA3329-130	MA3329-180	MA3329-230	MA3329-280	MA3329-330	5266-27CN180	5266-27CN540	5266-27CN675	5266-27CN810
30	2.0	MA3329-132	MA3329-182	MA3329-232	MA3329-282	MA3329-332	5266-30CN180	5266-30CN600	5266-30CN750	5266-30CN900
	3.0	MA3329-133	MA3329-183	MA3329-233	MA3329-283	MA3329-333	5277-30CN180	5277-30CN600	5277-30CN750	5277-30CN900
	3.5	--	--	--	--	--	4184-30CN180	4184-30CN600	4184-30CN750	4184-30CN900
33	2.0	MA3329-134	MA3329-184	MA3329-234	MA3329-284	MA3329-334	5266-33CN180	5266-33CN660	5266-33CN825	5266-33CN990
	3.0	MA3329-135	MA3329-185	MA3329-235	MA3329-285	MA3329-335	5277-33CN180	5277-33CN660	5277-33CN825	5277-33CN990
	3.5	--	--	--	--	--	4184-33CN180	4184-33CN660	4184-33CN825	4184-33CN990
36	2.0	MA3329-136	MA3329-186	MA3329-236	MA3329-286	MA3329-336	5266-36CN180	5266-36CN720	5266-36CN900	5266-36CN1080
	3.0	MA3329-137	MA3329-187	MA3329-237	MA3329-287	MA3329-337	5277-36CN180	5277-36CN720	5277-36CN900	5277-36CN1080
	4.0	--	--	--	--	--	4184-36CN180	4184-36CN720	4184-36CN900	4184-36CN1080
39	2.0	MA3329-138	MA3329-188	MA3329-238	MA3329-288	MA3329-338	5266-39CN180	5266-39CN780	5266-39CN975	5266-39CN1170
	3.0	MA3329-139	MA3329-189	MA3329-239	MA3329-289	MA3329-339	5277-39CN180	5277-39CN780	5277-39CN975	5277-39CN1170
	4.0	--	--	--	--	--	4184-39CN180	4184-39CN780	4184-39CN975	4184-39CN1170

## DRY FILM LUBRICATED SCREW-LOCKING INSERTS

AEROSPACE STD BASE Q/N IS "330" INSTEAD OF "320." ADD A "W" AFTER THE "CN" IN THE HELI-COM Q/N.

**CADMIUM PLATED SCREW-LOCKING INSERTS**

AEROSPACE STD BASE P/N IS "3331" INSTEAD OF "3329." ADD A "V" AFTER THE "CN" IN THE HELI-COIL P/N

EXAMPLES:	AEROSPACE STD P/N	HELL-COIL P/N

12.2 X 0.45 X 1 DIA	UNCOATED	MA3329-100	4184-2-2CNC02
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DRY FILM LUBED	MA333D-100	4184-2-2C/NW022
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CAD PLATED	MA3331-100	4184-2-2CIN022
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Helicoil®

HCMS-1 Rev.5 (07/14)

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