

**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

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

THREAD SIZE	AEROSPACE STANDARD PART NUMBER FOR UNCOATED FREE RUNNING INSERT, CRES			AEROSPACE STANDARD PART NUMBER FOR UNCOATED FREE RUNNING INSERT, CRES			AEROSPACE STANDARD PART NUMBER FOR UNCOATED FREE RUNNING INSERT, CRES					
	1 DIA	1.5 DIA	2 DIA	2.5 DIA	3 DIA	3 DIA	1 DIA	1.5 DIA	2 DIA	2.5 DIA	3 DIA	3 DIA
DIA	PITCH	Helicoil PART NUMBER	Helicoil PART NUMBER	Helicoil PART NUMBER	Helicoil PART NUMBER	Helicoil PART NUMBER	Helicoil PART NUMBER	Helicoil PART NUMBER	Helicoil PART NUMBER	Helicoil PART NUMBER	Helicoil PART NUMBER	Helicoil PART NUMBER
2	0.04	MA3279-140	MA3279-190	MA3279-240	MA3279-290	MA3279-340	MA3279-390	MA3279-440	MA3279-490	MA3279-540	MA3279-590	MA3279-640
2.2	0.45	MA3279-100	MA3279-150	MA3279-200	MA3279-250	MA3279-300	MA3279-350	MA3279-400	MA3279-450	MA3279-500	MA3279-550	MA3279-600
2.5	0.45	MA3279-101	MA3279-151	MA3279-201	MA3279-251	MA3279-301	MA3279-351	MA3279-401	MA3279-451	MA3279-501	MA3279-551	MA3279-601
3	0.5	MA3279-102	MA3279-152	MA3279-202	MA3279-252	MA3279-302	MA3279-352	MA3279-402	MA3279-452	MA3279-502	MA3279-552	MA3279-602
3.5	0.6	MA3279-103	MA3279-153	MA3279-203	MA3279-253	MA3279-303	MA3279-353	MA3279-403	MA3279-453	MA3279-503	MA3279-553	MA3279-603
4	0.7	MA3279-104	MA3279-154	MA3279-204	MA3279-254	MA3279-304	MA3279-354	MA3279-404	MA3279-454	MA3279-504	MA3279-554	MA3279-604
5	0.8	MA3279-105	MA3279-155	MA3279-205	MA3279-255	MA3279-305	MA3279-355	MA3279-405	MA3279-455	MA3279-505	MA3279-555	MA3279-605
6	1.0	MA3279-106	MA3279-156	MA3279-206	MA3279-256	MA3279-306	MA3279-356	MA3279-406	MA3279-456	MA3279-506	MA3279-556	MA3279-606
7	1.0	MA3279-107	MA3279-157	MA3279-207	MA3279-257	MA3279-307	MA3279-357	MA3279-407	MA3279-457	MA3279-507	MA3279-557	MA3279-607
8	1.0	MA3279-108	MA3279-158	MA3279-208	MA3279-258	MA3279-308	MA3279-358	MA3279-408	MA3279-458	MA3279-508	MA3279-558	MA3279-608
8	1.25	MA3279-109	MA3279-159	MA3279-209	MA3279-259	MA3279-309	MA3279-359	MA3279-409	MA3279-459	MA3279-509	MA3279-559	MA3279-609
10	1.0	MA3279-110	MA3279-160	MA3279-210	MA3279-260	MA3279-310	MA3279-360	MA3279-410	MA3279-460	MA3279-510	MA3279-560	MA3279-610
10	1.25	MA3279-111	MA3279-161	MA3279-211	MA3279-261	MA3279-311	MA3279-361	MA3279-411	MA3279-461	MA3279-511	MA3279-561	MA3279-611
10	1.5	MA3279-112	MA3279-162	MA3279-212	MA3279-262	MA3279-312	MA3279-362	MA3279-412	MA3279-462	MA3279-512	MA3279-562	MA3279-612
12	1.25	MA3279-113	MA3279-163	MA3279-213	MA3279-263	MA3279-313	MA3279-363	MA3279-413	MA3279-463	MA3279-513	MA3279-563	MA3279-613
12	1.5	MA3279-114	MA3279-164	MA3279-214	MA3279-264	MA3279-314	MA3279-364	MA3279-414	MA3279-464	MA3279-514	MA3279-564	MA3279-614
14	1.5	MA3279-115	MA3279-165	MA3279-215	MA3279-265	MA3279-315	MA3279-365	MA3279-415	MA3279-465	MA3279-515	MA3279-565	MA3279-615
14	2.0	MA3279-116	MA3279-166	MA3279-216	MA3279-266	MA3279-316	MA3279-366	MA3279-416	MA3279-466	MA3279-516	MA3279-566	MA3279-616
16	1.5	MA3279-117	MA3279-167	MA3279-217	MA3279-267	MA3279-317	MA3279-367	MA3279-417	MA3279-467	MA3279-517	MA3279-567	MA3279-617
16	2.0	MA3279-118	MA3279-168	MA3279-218	MA3279-268	MA3279-318	MA3279-368	MA3279-418	MA3279-468	MA3279-518	MA3279-568	MA3279-618
18	1.5	MA3279-119	MA3279-169	MA3279-219	MA3279-269	MA3279-319	MA3279-369	MA3279-419	MA3279-469	MA3279-519	MA3279-569	MA3279-619
18	2.0	MA3279-120	MA3279-170	MA3279-220	MA3279-270	MA3279-320	MA3279-370	MA3279-420	MA3279-470	MA3279-520	MA3279-570	MA3279-620
18	2.5	MA3279-121	MA3279-171	MA3279-221	MA3279-271	MA3279-321	MA3279-371	MA3279-421	MA3279-471	MA3279-521	MA3279-571	MA3279-621
20	1.5	MA3279-122	MA3279-172	MA3279-222	MA3279-272	MA3279-322	MA3279-372	MA3279-422	MA3279-472	MA3279-522	MA3279-572	MA3279-622
20	2.0	MA3279-123	MA3279-173	MA3279-223	MA3279-273	MA3279-323	MA3279-373	MA3279-423	MA3279-473	MA3279-523	MA3279-573	MA3279-623
20	2.5	MA3279-124	MA3279-174	MA3279-224	MA3279-274	MA3279-324	MA3279-374	MA3279-424	MA3279-474	MA3279-524	MA3279-574	MA3279-624
22	1.5	MA3279-125	MA3279-175	MA3279-225	MA3279-275	MA3279-325	MA3279-375	MA3279-425	MA3279-475	MA3279-525	MA3279-575	MA3279-625
22	2.0	MA3279-126	MA3279-176	MA3279-226	MA3279-276	MA3279-326	MA3279-376	MA3279-426	MA3279-476	MA3279-526	MA3279-576	MA3279-626
22	2.5	MA3279-127	MA3279-177	MA3279-227	MA3279-277	MA3279-327	MA3279-377	MA3279-427	MA3279-477	MA3279-527	MA3279-577	MA3279-627
24	2.0	MA3279-128	MA3279-178	MA3279-228	MA3279-278	MA3279-328	MA3279-378	MA3279-428	MA3279-478	MA3279-528	MA3279-578	MA3279-628
24	3.0	MA3279-129	MA3279-179	MA3279-229	MA3279-279	MA3279-329	MA3279-379	MA3279-429	MA3279-479	MA3279-529	MA3279-579	MA3279-629
27	2.0	MA3279-130	MA3279-180	MA3279-230	MA3279-280	MA3279-330	MA3279-380	MA3279-430	MA3279-480	MA3279-530	MA3279-580	MA3279-630
27	3.0	MA3279-131	MA3279-181	MA3279-231	MA3279-281	MA3279-331	MA3279-381	MA3279-431	MA3279-481	MA3279-531	MA3279-581	MA3279-631
30	2.0	MA3279-132	MA3279-182	MA3279-232	MA3279-282	MA3279-332	MA3279-382	MA3279-432	MA3279-482	MA3279-532	MA3279-582	MA3279-632
30	3.0	MA3279-133	MA3279-183	MA3279-233	MA3279-283	MA3279-333	MA3279-383	MA3279-433	MA3279-483	MA3279-533	MA3279-583	MA3279-633
30	3.5	MA3279-134	MA3279-184	MA3279-234	MA3279-284	MA3279-334	MA3279-384	MA3279-434	MA3279-484	MA3279-534	MA3279-584	MA3279-634
33	2.0	MA3279-135	MA3279-185	MA3279-235	MA3279-285	MA3279-335	MA3279-385	MA3279-435	MA3279-485	MA3279-535	MA3279-585	MA3279-635
33	3.0	MA3279-136	MA3279-186	MA3279-236	MA3279-286	MA3279-336	MA3279-386	MA3279-436	MA3279-486	MA3279-536	MA3279-586	MA3279-636
33	3.5	MA3279-137	MA3279-187	MA3279-237	MA3279-287	MA3279-337	MA3279-387	MA3279-437	MA3279-487	MA3279-537	MA3279-587	MA3279-637
36	2.0	MA3279-138	MA3279-188	MA3279-238	MA3279-288	MA3279-338	MA3279-388	MA3279-438	MA3279-488	MA3279-538	MA3279-588	MA3279-638
36	3.0	MA3279-139	MA3279-189	MA3279-239	MA3279-289	MA3279-339	MA3279-389	MA3279-439	MA3279-489	MA3279-539	MA3279-589	MA3279-639
36	4.0	MA3279-140	MA3279-190	MA3279-240	MA3279-290	MA3279-340	MA3279-390	MA3279-440	MA3279-490	MA3279-540	MA3279-590	MA3279-640
39	2.0	MA3279-141	MA3279-191	MA3279-241	MA3279-291	MA3279-341	MA3279-391	MA3279-441	MA3279-491	MA3279-541	MA3279-591	MA3279-641
39	3.0	MA3279-142	MA3279-192	MA3279-242	MA3279-292	MA3279-342	MA3279-392	MA3279-442	MA3279-492	MA3279-542	MA3279-592	MA3279-642
39	4.0	MA3279-143	MA3279-193	MA3279-243	MA3279-293	MA3279-343	MA3279-393	MA3279-443	MA3279-493	MA3279-543	MA3279-593	MA3279-643

DRY FILM LUBRICATED FREE-RUNNING INSERTS  
AEROSPACE STANDARD BASE P/N IS "3280" INSTEAD OF "3279" ADD A "W" AFTER THE "CN" IN THE HELICOIL P/N

CADMIUM PLATED FREE-RUNNING INSERTS  
AEROSPACE STANDARD BASE P/N IS "3281" INSTEAD OF "3279" ADD A "Y" AFTER THE "CN" IN THE HELICOIL P/N

EXAMPLES:

UNCOATED	AEROSPACE STD P/N	HELICOIL P/N
DRY FILM LUBE	MA3279-100	0022
CAD PLATED	MA3281-100	0022

**STANLEY®**  
Engineered Fastening

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**Helicoil®**  
HOMS-1 Rev.5 (07/14)

### HELLICOIL® METRIC INSERTS

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

THREAD SIZE	AEROSPACE STANDARD PART NUMBER FOR UNCOATED SCREW LOCKING INSERTS, CRES.			AEROSPACE STANDARD INTERCHANGEABILITY LIST				
	HELLICOIL PART NUMBER	1.5 DIA	HELLICOIL PART NUMBER	2 DIA	2.5 DIA	HELLICOIL PART NUMBER	3 DIA	HELLICOIL PART NUMBER
2	MA3329-100	MA3329-190	4184-2CN030	MA3329-240	MA3329-290	4184-2CN040	MA3329-340	4284-2CN060
2.2	MA3329-101	MA3329-150	4184-2.2CN033	MA3329-200	MA3329-250	4184-2.2CN044	MA3329-300	4184-2.2CN066
2.5	MA3329-102	MA3329-151	4184-2.5CN038	MA3329-201	MA3329-251	4184-2.5CN050	MA3329-301	4184-2.5CN075
3	MA3329-103	MA3329-152	4184-3CN043	MA3329-202	MA3329-252	4184-3CN060	MA3329-302	4184-3CN080
3.5	MA3329-104	MA3329-153	4184-3.5CN053	MA3329-203	MA3329-253	4184-3.5CN070	MA3329-303	4184-3.5CN105
4	MA3329-105	MA3329-154	4184-4CN060	MA3329-204	MA3329-254	4184-4CN080	MA3329-304	4184-4CN120
5	MA3329-106	MA3329-155	4184-5CN075	MA3329-205	MA3329-255	4184-5CN100	MA3329-305	4184-5CN150
6	MA3329-107	MA3329-156	4184-6CN090	MA3329-206	MA3329-256	4184-6CN120	MA3329-306	4184-6CN180
7	MA3329-108	MA3329-157	4184-7CN105	MA3329-207	MA3329-257	4184-7CN140	MA3329-307	4184-7CN210
8	MA3329-109	MA3329-158	5255-8CN120	MA3329-208	MA3329-258	5255-8CN160	MA3329-308	5255-8CN240
8	MA3329-110	MA3329-159	4184-8CN120	MA3329-209	MA3329-259	4184-8CN160	MA3329-309	4184-8CN240
10	MA3329-111	MA3329-160	5255-10CN150	MA3329-210	MA3329-260	5255-10CN200	MA3329-310	5255-10CN300
10	MA3329-112	MA3329-161	5649-10CN150	MA3329-211	MA3329-261	5649-10CN200	MA3329-311	5649-10CN300
12	MA3329-113	MA3329-162	4184-10CN150	MA3329-212	MA3329-262	4184-10CN200	MA3329-312	4184-10CN300
12	MA3329-114	MA3329-163	5649-12CN180	MA3329-213	MA3329-263	5649-12CN240	MA3329-313	5649-12CN360
12	MA3329-115	MA3329-164	5145-12CN180	MA3329-214	MA3329-264	5145-12CN240	MA3329-314	5145-12CN360
14	MA3329-116	MA3329-165	4184-12CN180	MA3329-215	MA3329-265	4184-12CN240	MA3329-315	4184-12CN360
14	MA3329-117	MA3329-166	5145-14CN210	MA3329-216	MA3329-266	5145-14CN280	MA3329-316	5145-14CN420
16	MA3329-118	MA3329-167	4184-14CN210	MA3329-217	MA3329-267	4184-14CN280	MA3329-317	4184-14CN420
16	MA3329-119	MA3329-168	5145-16CN240	MA3329-218	MA3329-268	5145-16CN320	MA3329-318	5145-16CN480
18	MA3329-120	MA3329-169	4184-16CN240	MA3329-219	MA3329-269	4184-16CN320	MA3329-319	4184-16CN480
18	MA3329-121	MA3329-170	5145-18CN270	MA3329-220	MA3329-270	5145-18CN360	MA3329-320	5145-18CN540
18	MA3329-122	MA3329-171	5266-18CN270	MA3329-221	MA3329-271	5266-18CN360	MA3329-321	5266-18CN540
20	MA3329-123	MA3329-172	4184-18CN270	MA3329-222	MA3329-272	4184-18CN360	MA3329-322	4184-18CN540
20	MA3329-124	MA3329-173	5145-20CN300	MA3329-223	MA3329-273	5145-20CN400	MA3329-323	5145-20CN600
20	MA3329-125	MA3329-174	5266-20CN300	MA3329-224	MA3329-274	5266-20CN400	MA3329-324	5266-20CN600
22	MA3329-126	MA3329-175	4184-20CN300	MA3329-225	MA3329-275	4184-20CN400	MA3329-325	4184-20CN600
22	MA3329-127	MA3329-176	5145-22CN330	MA3329-226	MA3329-276	5145-22CN440	MA3329-326	5145-22CN660
22	MA3329-128	MA3329-177	5266-22CN330	MA3329-227	MA3329-277	5266-22CN440	MA3329-327	5266-22CN660
24	MA3329-129	MA3329-178	4184-22CN330	MA3329-228	MA3329-278	4184-22CN440	MA3329-328	4184-22CN660
24	MA3329-130	MA3329-179	5266-24CN360	MA3329-229	MA3329-279	5266-24CN480	MA3329-329	5266-24CN720
27	MA3329-131	MA3329-180	4184-24CN360	MA3329-230	MA3329-280	4184-24CN480	MA3329-330	4184-24CN720
30	MA3329-132	MA3329-181	5145-27CN405	MA3329-231	MA3329-281	5145-27CN540	MA3329-331	5145-27CN810
30	MA3329-133	MA3329-182	5266-27CN405	MA3329-232	MA3329-282	5266-27CN540	MA3329-332	5266-27CN810
30	MA3329-134	MA3329-183	4184-27CN405	MA3329-233	MA3329-283	4184-27CN540	MA3329-333	4184-27CN810
33	MA3329-135	MA3329-184	5266-30CN450	MA3329-234	MA3329-284	5266-30CN600	MA3329-334	5266-30CN900
33	MA3329-136	MA3329-185	5277-30CN450	MA3329-235	MA3329-285	5277-30CN600	MA3329-335	5277-30CN900
33	MA3329-137	MA3329-186	4184-30CN450	MA3329-236	MA3329-286	4184-30CN600	MA3329-336	4184-30CN900
36	MA3329-138	MA3329-187	5145-33CN495	MA3329-237	MA3329-287	5145-33CN660	MA3329-337	5145-33CN990
36	MA3329-139	MA3329-188	5266-33CN495	MA3329-238	MA3329-288	5266-33CN660	MA3329-338	5266-33CN990
39	MA3329-140	MA3329-189	4184-33CN495	MA3329-239	MA3329-289	4184-33CN660	MA3329-339	4184-33CN990
39	MA3329-141	MA3329-190	5266-36CN720	MA3329-240	MA3329-290	5266-36CN900	MA3329-340	5266-36CN1080
39	MA3329-142	MA3329-191	5277-36CN720	MA3329-241	MA3329-291	5277-36CN900	MA3329-341	5277-36CN1080
39	MA3329-143	MA3329-192	4184-36CN720	MA3329-242	MA3329-292	4184-36CN900	MA3329-342	4184-36CN1080
39	MA3329-144	MA3329-193	5145-36CN900	MA3329-243	MA3329-293	5145-36CN1200	MA3329-343	5145-36CN1710
39	MA3329-145	MA3329-194	5266-36CN900	MA3329-244	MA3329-294	5266-36CN1200	MA3329-344	5266-36CN1710
39	MA3329-146	MA3329-195	5277-36CN900	MA3329-245	MA3329-295	5277-36CN1200	MA3329-345	5277-36CN1710
39	MA3329-147	MA3329-196	4184-36CN900	MA3329-246	MA3329-296	4184-36CN1200	MA3329-346	4184-36CN1710
39	MA3329-148	MA3329-197	5145-39CN975	MA3329-247	MA3329-297	5145-39CN1260	MA3329-347	5145-39CN1770
39	MA3329-149	MA3329-198	5266-39CN975	MA3329-248	MA3329-298	5266-39CN1260	MA3329-348	5266-39CN1770
39	MA3329-150	MA3329-199	5277-39CN975	MA3329-249	MA3329-299	5277-39CN1260	MA3329-349	5277-39CN1770
39	MA3329-151	MA3329-200	4184-39CN975	MA3329-250	MA3329-300	4184-39CN1260	MA3329-350	4184-39CN1770

**DRY FILM LUBRICATED SCREW LOCKING INSERTS**  
AEROSPACE STD BASE P/N IS "3330" INSTEAD OF "3329" AND A "W" AFTER THE "CN" IN THE HELICOIL P/N

**CADMIUM PLATED SCREW LOCKING INSERTS**  
AEROSPACE STD BASE P/N IS "3331" INSTEAD OF "3329" AND A "W" AFTER THE "CN" IN THE HELICOIL P/N

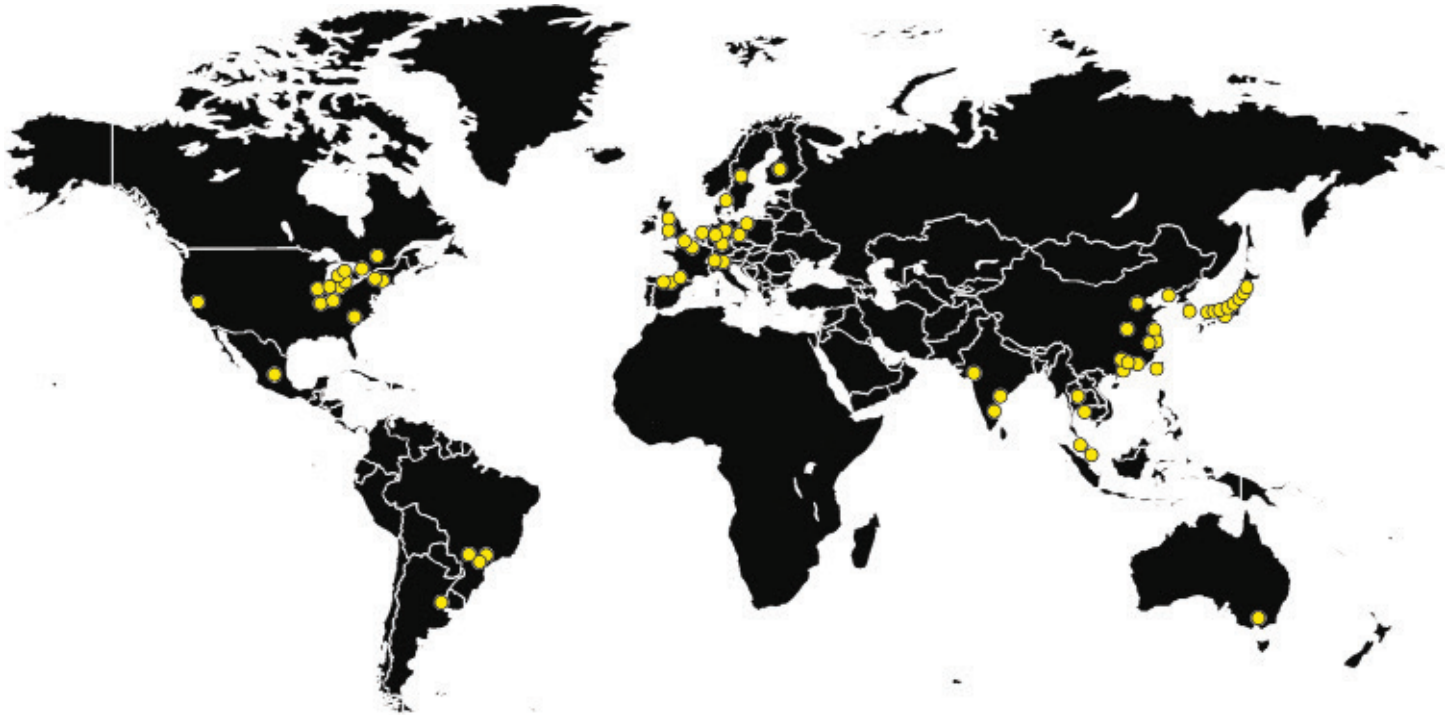
EXAMPLES:	HELLICOIL P/N	AEROSPACE STD P/N	HELLICOIL P/N
UNCOATED	MA3330-100	MA3330-100	4184-2.2CN022
DRY FILM LUBED	MA3330-100	MA3330-100	4184-2.2CN022
CAD PLATED	MA3331-100	MA3331-100	4184-2.2CN022



STANLEY ENGINEERED FASTENING  
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**STANLEY®**  
Engineered Fastening

HCM5-1 Rev.5 (07/14)



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