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Loksert[®]

keylocking insert system

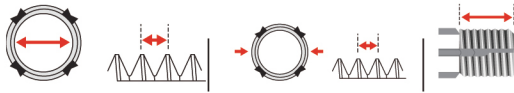


Loksert solid keylocking inserts

Provide high resistance to torque-out and pull out

Keys drive into the parent material for a positive, mechanical lock





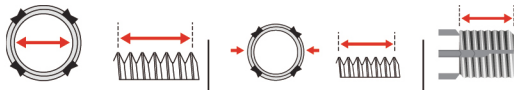
Insert Material: Carbon Steel



Insert Material: Stainless Steel

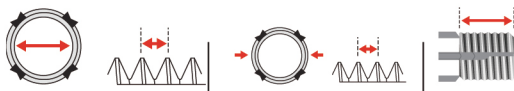
mm x mm	mm x mm	mm	Loksert #	X-Ref #	Loksert #	X-Ref #
MC			THIN WALL			
5.00 x 0.80	8.00 x 1.25	8.0	3620 - 5.00TW	7 5 9 5 1	3720 - 5.00TW	7 6 3 5 1
6.00 x 1.00	10.00 x 1.25	10.0	3620 - 6.00TW	7 5 9 5 2	3720 - 6.00TW	7 6 3 5 2
8.00 x 1.25	12.00 x 1.25	12.0	3620 - 8.00TW	7 5 9 5 3	3720 - 8.00TW	7 6 3 5 3
10.00 x 1.50	14.00 x 1.50	14.0	3620 - 10.00TW	7 5 9 5 5	3720 - 10.00TW	7 6 3 5 5
12.00 x 1.75	16.00 x 1.50	16.0	3620 - 12.00TW	7 5 9 5 6	3720 - 12.00TW	7 6 3 5 6

mm x mm	mm x mm	mm	Loksert #	X-Ref #	Loksert #	X-Ref #
MF			THIN WALL			
8.00 x 1.00	12.00 x 1.25	12.0	3621 - 8.00TW	7 6 1 5 3	3721 - 8.00TW	7 6 5 5 3
10.00 x 1.25	14.00 x 1.50	14.0	3621 - 10.00TW	7 6 1 5 5	3721 - 10.00TW	7 6 5 5 5
12.00 x 1.25	16.00 x 1.50	16.0	3621 - 12.00TW	7 6 1 5 6	3721 - 12.00TW	7 6 5 5 6

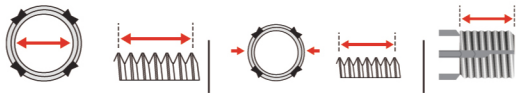


inch x tpi	inch x tpi	inch	Loksert #	X-Ref #	Loksert #	X-Ref #
UNC			THIN WALL			
10 x 24	5/16 x 18	0.31	3632 - 10GTW	7 5 9 2 1	3732 - 10GTW	7 6 3 2 1
1/4 x 20	3/8 x 16	0.37	3632 - 1/4TW	7 5 9 2 2	3732 - 1/4TW	7 6 3 2 2
5/16 x 18	7/16 x 14	0.43	3632 - 5/16TW	7 5 9 2 3	3732 - 5/16TW	7 6 3 2 3
3/8 x 16	1/2 x 13	0.50	3632 - 3/8TW	7 5 9 2 4	3732 - 3/8TW	7 6 3 2 4
7/16 x 14	9/16 x 12	0.56	3632 - 7/16TW	7 5 9 2 5	3732 - 7/16TW	7 6 3 2 5
1/2 x 13	5/8 x 11	0.62	3632 - 1/2TW	7 5 9 2 6	3732 - 1/2TW	7 6 3 2 6

inch x tpi	inch x tpi	inch	Loksert #	X-Ref #	Loksert #	X-Ref #
UNF			THIN WALL			
10 x 32	5/16 x 18	0.31	3634 - 10GTW	7 6 1 2 1	3734 - 10GTW	7 6 5 2 1
1/4 x 28	3/8 x 16	0.37	3634 - 1/4TW	7 6 1 2 2	3734 - 1/4TW	7 6 5 2 2
5/16 x 24	7/16 x 14	0.43	3634 - 5/16TW	7 6 1 2 3	3734 - 5/16TW	7 6 5 2 3
3/8 x 24	1/2 x 13	0.50	3634 - 3/8TW	7 6 1 2 4	3734 - 3/8TW	7 6 5 2 4
7/16 x 20	9/16 x 12	0.56	3634 - 7/16TW	7 6 1 2 5	3734 - 7/16TW	7 6 5 2 5
1/2 x 20	5/8 x 11	0.62	3634 - 1/2TW	7 6 1 2 6	3734 - 1/2TW	7 6 5 2 6



mm x mm	mm x mm	mm	Loksert #	X-Ref #	Loksert #	X-Ref #
MF			HEAVY DUTY			
8.00 x 1.00	14.00 x 1.5		3621 x 8.00HD	7 6 1 6 6	3721 - 8.00HD	7 6 5 6 6
10.00 x 1.25	16.00 x 1.5		3621 x 10.00HD	7 6 1 6 7	3721 - 10.00HD	7 6 5 6 7
12.00 x 1.25	18.00 x 1.5		3621 x 12.00HD	7 6 1 6 9	3721 - 12.00HD	7 6 5 6 9
14.00 x 1.50	20.00 x 1.5		3621 x 14.00HD	7 6 1 7 0	3721 - 14.00HD	7 6 5 7 0
16.00 x 1.50	22.00 x 1.5		3621 x 16.00HD	7 6 1 7 1	3721 - 16.00HD	7 6 5 7 1
18.00 x 1.50	24.00 x 1.5		3621 x 18.00HD	7 6 1 7 2	3721 - 18.00HD	7 6 5 7 2
20.00 x 1.50	30.00 x 2.0		3621 x 20.00HD	7 6 1 7 3	3721 - 20.00HD	7 6 5 7 3
22.00 x 1.50	32.00 x 2.0		3621 x 22.00HD	7 6 1 7 4	3721 - 22.00HD	7 6 5 7 4
24.00 x 2.00	33.00 x 2.0		3621 x 24.00HD	7 6 1 7 5	3721 - 24.00HD	7 6 5 7 5



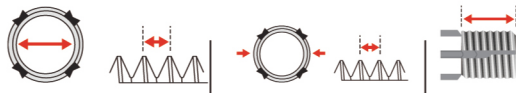
Insert Material: Carbon Steel



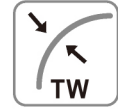
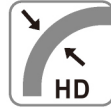
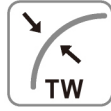
Insert Material: Stainless Steel

inch x tpi	inch x tpi	inch	Loksert #	X-Ref #	Loksert #	X-Ref #
UNC			HEAVY DUTY			
8 x 32	5/16 x 18	0.31	3632 - 8GHD	7 5 9 0 0	3732 - 8GHD	7 6 3 0 0
10 x 24	3/8 x 16	0.31	3632 - 10GHD	7 5 9 0 1	3732 - 10GHD	7 6 3 0 1
1/4 x 20	7/16 x 14	0.37	3632 - 1/4HD	7 5 9 0 2	3732 - 1/4HD	7 6 3 0 2
5/16 x 18	1/2 x 13	0.43	3632 - 5/16HD	7 5 9 0 3	3732 - 5/16HD	7 6 3 0 3
3/8 x 16	9/16 x 12	0.50	3632 - 3/8HD	7 5 9 0 4	3732 - 3/8HD	7 6 3 0 4
7/16 x 14	5/8 x 11	0.62	3632 - 7/16HD	7 5 9 0 5	3732 - 7/16HD	7 6 3 0 5
1/2 x 13	3/4 x 16	0.62	3632 - 1/2HD	7 5 9 0 6	3732 - 1/2HD	7 6 3 0 6
9/16 x 12	3/4 x 16	0.81	3632 - 9/16HD	7 5 9 0 7	3732 - 9/16HD	7 6 3 0 7
5/8 x 11	7/8 x 14	0.87	3632 - 5/8HD	7 5 9 0 8	3732 - 5/8HD	7 6 3 0 8
3/4 x 10	1-1/8 x 12	1.12	3632 - 3/4HD	7 5 9 0 9	3732 - 3/4HD	7 6 3 0 9
7/8 x 9	1-1/4 x 12	1.25	3632 - 7/8HD	7 5 9 1 0	3732 - 7/8HD	7 6 3 1 0
1 x 8	1-3/8 x 12	1.37	3632 - 1HD	7 5 9 1 1	3732 - 1HD	7 6 3 1 1
1-1/8 x 7	1-1/2 x 12	1.62	3632 - 1.1/8HD	7 5 9 1 3	3732 - 1.1/8HD	-
1-1/4 x 7	1-5/8 x 12	1.81	3632 - 1.1/4HD	7 5 9 1 4	3732 - 1.1/4HD	-
1-1/2 x 6	1-7/8 x 12	2.00	3632 - 1.1/2HD	7 5 9 1 6	3732 - 1.1/2HD	-

inch x tpi	inch x tpi	inch	Loksert #	X-Ref #	Loksert #	X-Ref #
UNF			HEAVY DUTY			
10 x 32	3/8 x 16		3634 - 10GHD	7 6 1 0 1	3734 - 10GHD	7 6 5 0 1
1/4 x 28	7/16 x 14		3634 - 1/4HD	7 6 1 0 2	3734 - 1/4HD	7 6 5 0 2
5/16 x 24	1/2 x 13		3634 - 5/16HD	7 6 1 0 3	3734 - 5/16HD	7 6 5 0 3
3/8 x 24	9/16 x 12		3634 - 3/8HD	7 6 1 0 4	3734 - 3/8HD	7 6 5 0 4
7/16 x 20	5/8 x 11		3634 - 7/16HD	7 6 1 0 5	3734 - 7/16HD	7 6 5 0 5
1/2 x 20	3/4 x 16		3634 - 1/2HD	7 6 1 0 6	3734 - 1/2HD	7 6 5 0 6
9/16 x 18	3/4 x 16		3634 - 9/16HD	7 6 1 0 7	3734 - 9/16HD	7 6 5 0 7
5/8 x 18	7/8 x 14		3634 - 5/8HD	7 6 1 0 8	3734 - 5/8HD	7 6 5 0 8
3/4 x 16	1-1/8 x 12		3634 - 3/4HD	7 6 1 0 9	3734 - 3/4HD	7 6 5 0 9
7/8 x 14	1-1/4 x 12		3634 - 7/8HD	7 6 1 1 0	3734 - 7/8HD	7 6 5 1 0
1 x 12	1-3/8 x 12		3634 - 1HD	7 6 1 1 1	3734 - 1HD	7 6 5 1 1
1 x 14	1-3/8 x 12		3635 - 1HD	7 6 1 1 2	3735 - 1HD	-
1-1/8 x 12	1-1/2 x 12		3634 - 1.1/8HD	7 6 1 1 3	3734 - 1.1/8HD	-
1-1/4 x 12	1-5/8 x 12		3634 - 1.1/4HD	7 6 1 1 4	3734 - 1.1/4HD	-
1-1/2 x 12	1-7/8 x 12		3634 - 1.1/2HD	7 6 1 1 6	3734 - 1.1/2HD	-



mm x mm	mm x mm	mm	Loksert #	X-Ref #	Loksert #	X-Ref #
MC			HEAVY DUTY			
4.00 x 0.70	8.00 x 1.25	8.0	3620 - 4.00HD	7 5 9 6 3	3720 - 4.00HD	7 6 3 6 3
5.00 x 0.80	10.00 x 1.25	10.0	3620 - 5.00HD	7 5 9 6 4	3720 - 5.00HD	7 6 3 6 4
6.00 x 1.00	12.00 x 1.25	12.0	3620 - 6.00HD	7 5 9 6 5	3720 - 6.00HD	7 6 3 6 5
8.00 x 1.25	14.00 x 1.50	14.0	3620 - 8.00HD	7 5 9 6 6	3720 - 8.00HD	7 6 3 6 6
10.00 x 1.50	16.00 x 1.50	16.0	3620 - 10.00HD	7 5 9 6 7	3720 - 10.00HD	7 6 3 6 7
12.00 x 1.75	18.00 x 1.50	18.0	3620 - 12.00HD	7 5 9 6 9	3720 - 12.00HD	7 6 3 6 9
14.00 x 2.00	20.00 x 1.50	20.0	3620 - 14.00HD	7 5 9 7 0	3720 - 14.00HD	7 6 3 7 0
16.00 x 2.00	22.00 x 1.50	22.0	3620 - 16.00HD	7 5 9 7 1	3720 - 16.00HD	7 6 3 7 1
20.00 x 2.50	30.00 x 2.00	30.0	3620 - 20.00HD	7 5 9 7 3	3720 - 20.00HD	7 6 3 7 3
24.00 x 3.00	33.00 x 2.00	33.0	3620 - 24.00HD	7 5 9 7 5	3720 - 24.00HD	7 6 3 7 5



mm	Loksert #	X-Ref #	Loksert #	X-Ref #	Loksert #	X-Ref #
MC / MF						
4.00	-	-	3600 - 4.00HT	HDM4	-	-
5.00	3600 - 5.00TT	TWM5	3600 - 5.00HT	HDM5	3600 - 190T	KS#10-M5
6.00	3600 - 6.00TT	TWM6	3600 - 6.00HT	HDM6	3600 - 250T	KS1/4-M6
8.00	3600 - 8.00TT	TWM8	3600 - 8.00HT	HDM8	3600 - 312T	KS5/16-M8
10.00	3600 - 10.00TT	TWM10	3600 - 10.00HT	HDM10	3600 - 375T	KS3/8-7/16-M10
12.00	3600 - 12.00TT	TWM12	3600 - 12.00HT	HDM12	3600 - 500T	KS1/2-9/16-M12
14.00	-	-	3600 - 14.00HT	HDM14	-	-
16.00	-	-	3600 - 16.00HT	HDM16	3600 - 625T	KS5/8-M16
18.00	-	-	3600 - 18.00HT	HDM18	-	-
20.00	-	-	3600 - 20.00HT	HDM20	3600 - 875T	KS3/4-7/8-M20-22
22.00	-	-	3600 - 22.00HT	HDM22	-	-
24.00	-	-	3600 - 24.00HT	HDM24	-	-



inch	Loksert #	X-Ref #	Loksert #	X-Ref #	Loksert #	X-Ref #
UNC / UNF						
8G	-	-	3600 - 8GHT	HD8	-	-
10G	3600 - 10GTT	TW10	3600 - 10GHT	HD10	3600 - 190T	KS#10-M5
1/4	3600 - 1/4TT	TW1/4	3600 - 1/4HT	HD1/4	3600 - 250T	KS1/4-M6
5/16	3600 - 5/16TT	TW5/16	3600 - 5/16HT	HD5/16	3600 - 312T	KS5/16-M8
3/8	3600 - 3/8TT	TW3/8	3600 - 3/8HT	HD3/8	3600 - 375T	KS3/8-7/16-M10
7/16	3600 - 7/16TT	TW7/16	3600 - 7/16HT	HD7/16	3600 - 375T	KS3/8-7/16-M10
1/2	3600 - 1/2TT	TW1/2	3600 - 1/2HT	HD1/2	3600 - 500T	KS1/2-9/16-M12
9/16	-	-	3600 - 9/16HT	HD9/16	3600 - 500T	KS1/2-9/16-M12
5/8	-	-	3600 - 5/8HT	HD5/8	3600 - 625T	KS5/8-M16
11/16	-	-	-	-	-	-
3/4	-	-	3600 - 3/4HT	HD3/4	3600 - 875T	KS3/4-7/8-M20-22
13/16	-	-	-	-	-	-
7/8	-	-	3600 - 7/8HT	HD7/8	3600 - 875T	KS3/4-7/8-M20-22
1	-	-	3600 - 1HT	HD1	3600 - 100T	KS5/8-M16
1-1/8	-	-	3600 - 1 1/8HT	HD1 1/8	-	-
1-1/4	-	-	3600 - 1 1/4HT	HD1 1/4	-	-
1-3/8	-	-	-	-	-	-
1-1/2	-	-	3600 - 1 1/2HT	HD1 1/2	-	-



1 DRILL

Drill to clear the damaged thread with a standard twist drill. Chamfer the hole with a standard countersink (82°-100°)



Note: Drill is oversize to accommodate external thread. Check technical charts for correct drill sizes.

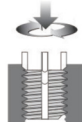


2 TAP

Create new thread using a standard tap. Check technical charts for correct tap size.



Note: Use of suitable lubricant is essential during all tapping procedures.



3 INSERT

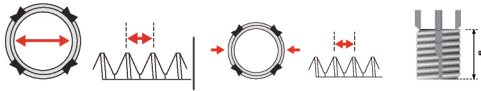
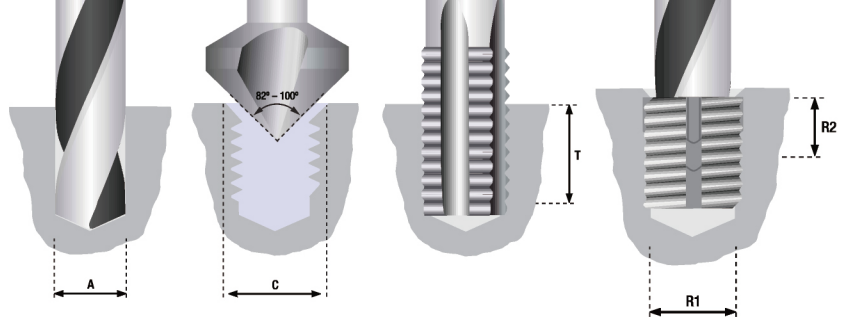
Screw the insert into the threaded hole until slightly below the surface of the parent material.



4 DRIVE

Select the correct size installation tool and place over the insert. Drive locking keys down using several hammer taps on end of installation tool.

Basic Installation Procedure



Installation

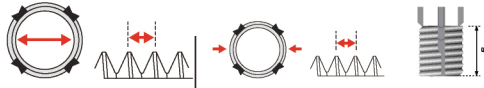
Remove

Internal Thread Class 2B inch	External Thread Mod. Class 2A inch	Q inch	Installation Tool #	A inch	C inch	Tap Class 2B inch	T Min. inch	R1 inch	R2 inch
THIN WALL									
10G x 24	5/16 x 18	0.31	3600 - 190T	"I"	0.32	5/16 x 18	0.37	7/32	1/8
10G x 32	5/16 x 18	0.31	3600 - 190T	"I"	0.32	5/16 x 18	0.37	7/32	1/8
1/4 x 20	3/8 x 16	0.37	3600 - 250T	"Q"	0.38	3/8 x 16	0.43	9/32	3/16
1/4 x 28	3/8 x 16	0.37	3600 - 250T	"Q"	0.38	3/8 x 16	0.43	9/32	3/16
5/16 x 18	7/16 x 14	0.43	3600 - 312T	"X"	0.44	7/16 x 14	0.50	11/32	3/16
5/16 x 24	7/16 x 14	0.43	3600 - 312T	"X"	0.44	7/16 x 14	0.50	11/32	3/16
3/8 x 16	1/2 x 13	0.50	3600 - 375T	29/64	0.51	1/2 x 13	0.56	13/32	3/16
3/8 x 24	1/2 x 13	0.50	3600 - 375T	29/64	0.51	1/2 x 13	0.56	13/32	3/16
7/16 x 14	9/16 x 12	0.56	3600 - 375T	33/64	0.57	9/16 x 12	0.62	15/32	3/16
7/14 x 20	9/16 x 12	0.56	3600 - 375T	33/64	0.57	9/16 x 12	0.62	15/32	3/16
1/2 x 13	5/8 x 11	0.62	3600 - 500T	37/64	0.63	5/8 x 11	0.68	17/32	3/16
1/2 x 20	5/8 x 11	0.62	3600 - 500T	37/64	0.63	5/8 x 11	0.68	17/32	3/16

HEAVY DUTY									
8G x 32	5/16 x 18	0.31	3600 - 8GHT	"I"	0.32	5/16 x 18	0.37	7/32	1/8
10G x 24	3/8 x 16	0.31	3600 - 190T	"Q"	0.38	3/8 x 16	0.37	9/32	1/8
10G x 32	3/8 x 16	0.31	3600 - 190T	"Q"	0.38	3/8 x 16	0.37	9/32	1/8
1/4 x 20	7/16 x 14	0.37	3600 - 250T	"X"	0.44	7/16 x 14	0.43	11/32	3/16
1/4 x 28	7/16 x 14	0.37	3600 - 250T	"X"	0.44	7/16 x 14	0.43	11/32	3/16
5/16 x 18	1/2 x 13	0.43	3600 - 312T	29/64	0.51	1/2 x 13	0.50	13/32	3/16
5/16 x 24	1/2 x 13	0.43	3600 - 312T	29/64	0.51	1/2 x 13	0.50	13/32	3/16
3/8 x 16	9/16 x 12	0.50	3600 - 375T	33/64	0.57	9/16 x 12	0.56	15/32	3/16
3/8 x 24	9/16 x 12	0.50	3600 - 375T	33/64	0.57	9/16 x 12	0.56	15/32	3/16
7/16 x 14	5/8 x 11	0.62	3600 - 375T	37/64	0.63	5/8 x 11	0.68	17/32	3/16
7/16 x 20	5/8 x 11	0.62	3600 - 375T	37/64	0.63	5/8 x 11	0.68	17/32	3/16
1/2 x 13	3/4 x 16	0.62	3600 - 500T	45/64	0.76	3/4 x 16	0.68	21/32	3/16
1/2 x 20	3/4 x 16	0.62	3600 - 500T	45/64	0.76	3/4 x 16	0.68	21/32	3/16
9/16 x 12	3/4 x 16	0.81	3600 - 500T	45/64	0.76	3/4 x 16	0.94	21/32	3/16
9/16 x 18	3/4 x 16	0.81	3600 - 500T	45/64	0.76	3/4 x 16	0.94	21/32	3/16
5/8 x 11	7/8 x 14	0.87	3600 - 625T	53/64	0.88	7/8 x 14	1.00	25/32	5/16
5/8 x 18	7/8 x 14	0.87	3600 - 625T	53/64	0.88	7/8 x 14	1.00	25/32	5/16
3/4 x 10	1-1/8 x 12	1.12	3600 - 875T	1-1/16	1.14	1-1/8 x 12	1.31	31/32	5/16
3/4 x 16	1-1/8 x 12	1.12	3600 - 875T	1-1/16	1.14	1-1/8 x 12	1.31	31/32	5/16
7/8 x 9	1-1/4 x 12	1.25	3600 - 875T	1-3/16	1.27	1-1/4 x 12	1.44	1-3/32	5/16
7/8 x 14	1-1/4 x 12	1.25	3600 - 875T	1-3/16	1.27	1-1/4 x 12	1.44	1-3/32	5/16
1 x 8	1-3/8 x 12	1.37	3600 - 100T	1-5/16	1.39	1-3/8 x 12	1.56	1-7/32	5/16
1 x 12	1-3/8 x 12	1.37	3600 - 100T	1-5/16	1.39	1-3/8 x 12	1.56	1-7/32	5/16
1 x 14	1-3/8 x 12	1.37	3600 - 100T	1-5/16	1.39	1-3/8 x 12	1.56	1-7/32	5/16
1-1/8 x 7	1-1/2 x 12	1.62	3600 - 1.1/8 HT	1-7/16	1.52	1-1/2 x 12	1.84	1-11/32	5/16
1-1/8 x 12	1-1/2 x 12	1.62	3600 - 1.1/8 HT	1-7/16	1.52	1-1/2 x 12	1.84	1-11/32	5/16
1-1/4 x 7	1-5/8 x 12	1.81	3600 - 1.1/4 HT	1-9/16	1.64	1-5/8 x 12	2.06	1-15/32	5/16
1-1/4 x 12	1-5/8 x 12	1.81	3600 - 1.1/4 HT	1-9/16	1.64	1-5/8 x 12	2.06	1-15/32	5/16
1-1/2 x 6	1-7/8 x 12	2.00	3600 - 1.1/2 HT	1-13/16	1.89	1-7/8 x 12	2.28	1-23/32	5/16
1-1/2 x 12	1-7/8 x 12	2.00	3600 - 1.1/2 HT	1-13/16	1.89	1-7/8 x 12	2.28	1-23/32	5/16

THIN WALL & HEAVY DUTY

Insert Material	Carbon Steel - C1215 or equivalent Stainless Steel - 303 or equivalent
Keys	302 CRES or equivalent
Finish	Carbon Steel - Zinc Phosphate; Stainless Steel - Passivated
Tolerances	±0.010 inch or ±0.25mm unless specified otherwise
Keys	insert with internal thread of 5/16" (M7) or larger have 4 locking keys. Smaller sizes have 2 keys.
Tap Drill Hole Tolerance - Inch	0.234 - 0.500 = +0.004 / -0.001 over 0.500 = +0.005 / -0.001
Tap Drill Hole Tolerance - Metric	6.90 - 10.80 = +0.100 / -0.025 over 12.80 = +0.130 / -0.025



Installation

| Remove

Internal Thread Class 6H mm	External Thread Class 6g mm	Q mm	Installation Tool #	A mm	C mm	Tap Class 6H mm	T Min.mm	R1 mm	R2 mm
THIN WALL									
M5 x 0.8	M8 x 1.25	8.0	3600 - 190T	6.9	8.25	M8 x 1.25	9.5	5.50	4.00
M6 x 1.0	M10 x 1.25	10.0	3600 - 250T	8.8	10.25	M10 x 1.25	11.5	7.50	4.75
M8 x 1.25	M12 x 1.25	12.0	3600 - 312T	10.8	12.25	M12 x 1.25	13.5	9.50	4.75
M8 x 1.0	M12 x 1.25	12.0	3600 - 312T	10.8	12.25	M12 x 1.25	13.5	9.50	4.75
M10 x 1.5	M14 x 1.5	14.0	3600 - 375T	12.8	14.25	M14 x 1.5	15.5	11.50	4.75
M10 x 1.25	M14 x 1.5	14.0	3600 - 375T	12.8	14.25	M14 x 1.5	15.5	11.50	4.75
M12 x 1.75	M16 x 1.5	16.0	3600 - 500T	14.75	16.25	M16 x 1.5	17.5	13.50	4.75
M12 x 1.25	M16 x 1.5	16.0	3600 - 500T	14.75	16.25	M16 x 1.5	17.5	13.50	4.75

HEAVY DUTY									
M4 x 0.7	M8 x 1.25	8.0	3600 - 4.00HT	6.9	8.25	M8 x 1.25	9.5	5.50	4.00
M5 x 0.8	M10 x 1.25	10.0	3600 - 190T	8.8	10.25	M10 x 1.25	12.5	7.50	4.75
M6 x 1.0	M12 x 1.25	12.0	3600 - 250T	10.8	12.25	M12 x 1.25	14.5	9.50	4.75
M8 x 1.25	M14 x 1.5	14.0	3600 - 312T	12.8	14.25	M14 x 1.5	16.5	11.50	4.75
M8 x 1.0	M14 x 1.5	14.0	3600 - 312T	12.8	14.25	M14 x 1.5	16.5	11.50	4.75
M10 x 1.5	M16 x 1.5	16.0	3600 - 375T	14.75	16.25	M16 x 1.5	18.5	13.50	4.75
M10 x 1.25	M16 x 1.5	16.0	3600 - 375T	14.75	16.25	M16 x 1.5	18.5	13.50	4.75
M12 x 1.75	M18 x 1.5	18.0	3600 - 500T	16.75	18.25	M18 x 1.5	20.5	15.50	4.75
M12 x 1.25	M18 x 1.5	18.0	3600 - 500T	16.75	18.25	M18 x 1.5	20.5	15.50	4.75
M14 x 2.0	M20 x 1.5	20.0	3600 - 14.00T	18.75	20.25	M20 x 1.5	22.5	17.50	4.75
M14 x 1.5	M20 x 1.5	20.0	3600 - 14.00T	18.75	20.25	M20 x 1.5	22.5	17.50	4.75
M16 x 2.0	M22 x 1.5	22.0	3600 - 625T	20.5	22.25	M22 x 1.5	24.5	17.75	6.35
M16 x 1.5	M22 x 1.5	22.0	3600 - 625T	20.5	22.25	M22 x 1.5	24.5	17.75	6.35
M18 x 1.5	M24 x 1.5	24.0	3600 - 18.00HT	22.5	24.25	M24 x 1.5	26.5	19.75	6.35
M20 x 2.5	M30 x 2.0	30.0	3600 - 875T	28.0	30.25	M30 x 2.0	34.5	25.75	6.35
M20 x 1.5	M30 x 2.0	30.0	3600 - 875T	28.0	30.25	M30 x 2.0	34.5	25.75	6.35
M22 x 1.5	M32 x 2.0	32.0	3600 - 22.00HT	30.0	32.25	M32 x 2.0	36.5	27.75	6.35
M24 x 3.0	M33 x 2.0	33.0	3600 - 24.00HT	31.0	33.25	M33 x 2.0	37.5	28.75	6.35
M24 x 2.0	M33 x 2.0	33.0	3600 - 24.00HT	31.0	33.25	M33 x 2.0	37.5	28.75	6.35



1 DRILL

Drill out the material between the locking keys and the internal thread to the specified depth.

Note: Drill size and drilling depth are shown in the loksert technical tables.



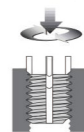
2 DEFLECT

Deflect locking keys inward and break off.



3 REMOVE

Remove the insert from the hole by winding it out using a screw extractor or similar type tool.



4 INSERT

A new loksert insert of exactly the same size can be installed in the original hole.

Basic Removal Procedure