

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	External Thread	Q	Installation Tool	A	C	Tap	T	R1	R2
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



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	External Thread	Q	Installation Tool	A	C	Tap	T	R1	R2
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

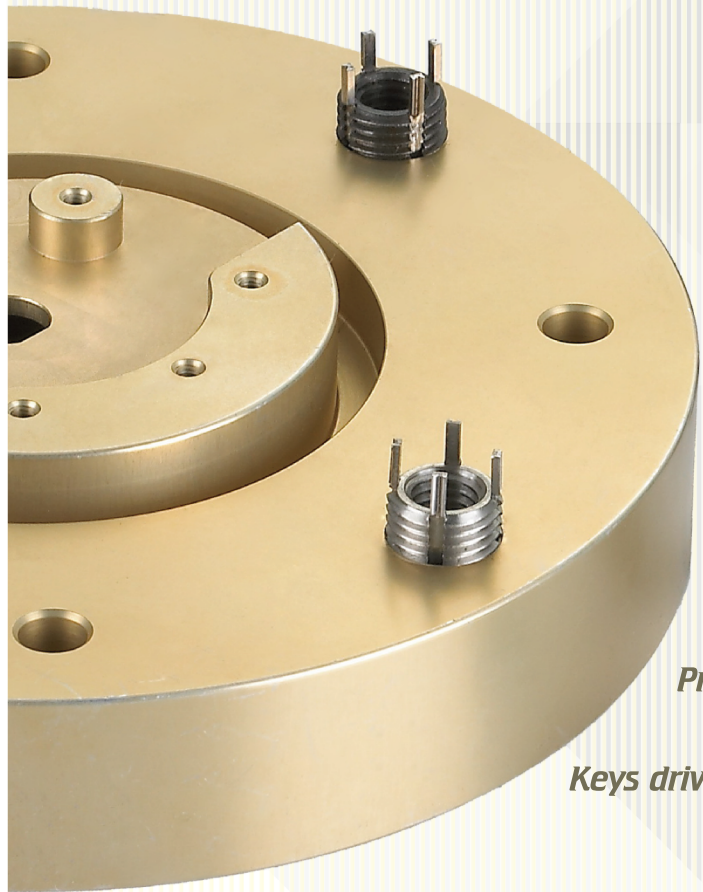
A new loksert insert of exactly the same size can be installed in the original hole.

Basic Removal Procedure

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keylocking insert system

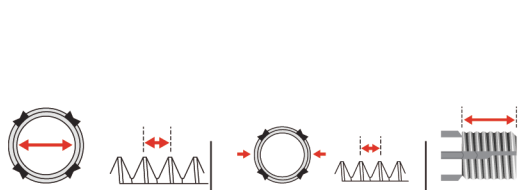


Loksert solid keylocking inserts

Provide high resistance to torque-out and pull out

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





Insert Material: Carbon Steel

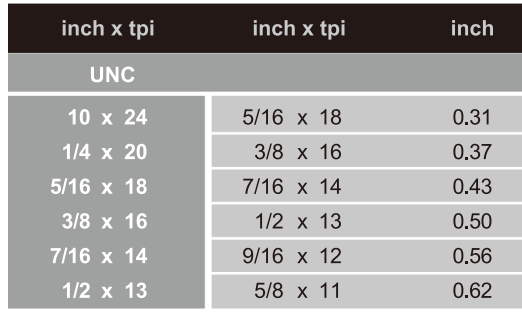


Insert Material: Stainless Steel

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



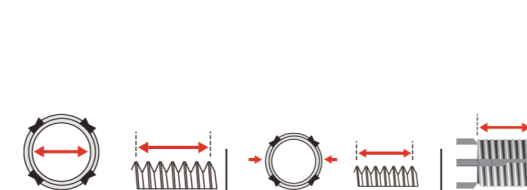
mm x mm	mm x mm	mm	Loksert #	X-Ref #	Loksert #	X-Ref #
MF			THIN WALL			
8.00 x 1.00	12.00 x 1.25	12.0	3621 - 8.00TW	7 6 1 5 3	3721 - 8.00TW	7 6 5 5 3
10.00 x 1.25	14.00 x 1.50	14.0	3621 - 10.00TW	7 6 1 5 5	3721 - 10.00TW	7 6 5 5 5
12.00 x 1.25	16.00 x 1.50	16.0	3621 - 12.00TW	7 6 1 5 6	3721 - 12.00TW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



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

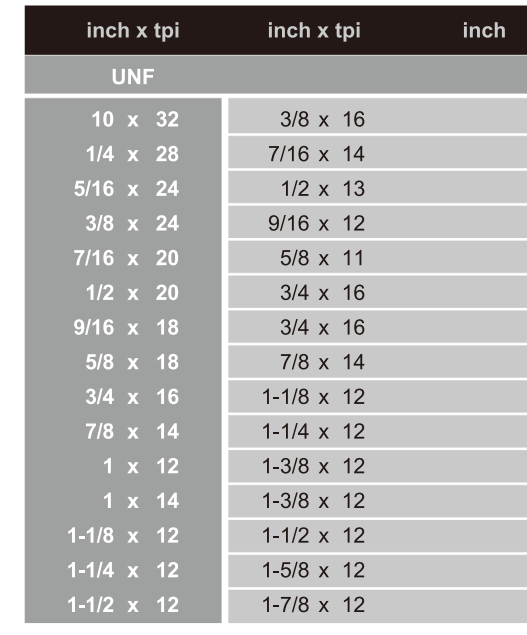


Insert Material: Carbon Steel



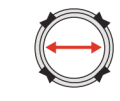
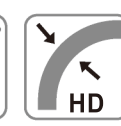
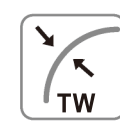
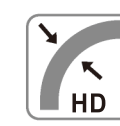
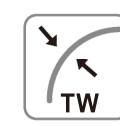
Insert Material: Stainless Steel

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	-

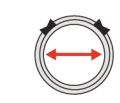


inch x tpi	inch x tpi	inch	Loksert #	X-Ref #	Loksert #	X-Ref #
UNF			HEAVY DUTY			
10 x 32	3/8 x 16		3634 - 10GHD	7 6 1 0 1	3734 - 10GHD	7 6 5 0 1
1/4 x 28	7/16 x 14		3634 - 1/4HD	7 6 1 0 2	3734 - 1/4HD	7 6 5 0 2
5/16 x 24	1/2 x 13		3634 - 5/16HD	7 6 1 0 3	3734 - 5/16HD	7 6 5 0 3
3/8 x 24	9/16 x 12	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

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

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