



**SOLID KEYLOCKING INSERTS
INSERTOS DE SEGURIDAD
INSERTS À CLAVETTES**

BUYER'S GUIDE 03/2017

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Loksert solid keylocking inserts are an easily installed thread assembly that is ideal for replacing damaged or worn threads in virtually any material – ferrous, non-ferrous and non-metallic. They are constructed from high quality carbon steel or extremely hard-wearing stainless steel. One piece Loksert inserts are supplied with the dove-tailed locking keys pre-assembled. Lokserts are suitable for repairing and creating threads in a wide range of applications including forgings and castings and are especially suited to situations that experience heavy wear and vibration, such as mining, construction and earthmoving equipment.

Los insertos de seguridad Loksert son de fácil instalación. y su ensamblaje es ideal para reemplazar roscas dañadas o gastadas en. esencialmente. cualquier material – ferroso. no ferroso y no metálico. Están fabricados con la más alta calidad de acero al carbón o de acero inoxidable. Un inserto loksert se suministra con los arrastres pre-ensamblados. Los filetes de apriete posicionados automáticamente colocan al inserto en la profundidad correcta de la superficie del material de alojamiento. Los lokserts están recomendados para reparación y creación de roscas en un amplio rango de aplicaciones incluyendo herrerías y fundiciones y se recomiendan especialmente para casos de gran desgaste de uso y vibración. tales como minería. construcción y equipo de gran movimiento.

"Loksert solid keylocking inserts" [Inserts à clavettes] sont un assemblage de filet facile à installer et idéal pour remplacer les filets endommagés ou usés pour n'importe quel type de matière (ferreux, non-ferreux, non-métallique). Ils sont fabriqués à partir d'acier au carbone de haute qualité ou d'acier inoxydable extrêmement résistant à l'usure. Les inserts monobloc sont fournis avec les clavettes de blocage préassemblées. Les clavettes pré positionnées mettent automatiquement le filet rapporté en place à la profondeur correcte, juste en-dessous de la surface d'installation. Les Lokserts conviennent à la réparation et à la création de filets pour une large gamme d'applications, dont forgeages et les moulages, et ils conviennent particulièrement aux situations qui subissent une forte usure et de fortes vibrations, tels que les équipements miniers, le matériel de construction et de terrassement.

Features and Benefits

- Solid bushing utilising locking keys provides positive mechanical lock against rotation.
- High strength and reliability provides maximum pullout strength.
- Installed using standard drills and taps.
- Simple installation - no special skills required.
- Suitable for use in a wide range of parent materials.
- Impossible to cross thread during installation.
- Simple removal process if required.
- No tang to break and remove.
- Available in metric sizes, inch sizes and spark plug sizes.
- Available in Thinwall and Heavy Duty.

Características y Beneficios

- Sólidos. utilizan filetes de apriete que proporcionan una alta seguridad mecánica contra la rotación.
- Alta resistencia y fiabilidad que proporciona una gran resistencia contra el desplazamiento.
- Se instalan usando machos y brocas standard.
- Instalación sencilla. No requiere de conocimientos especiales.
- Recomendados para su uso en un amplio rango de materiales de alojamiento.
- Imposible de confundir las roscas durante la instalación.
- En caso de ser necesario. sencillo proceso de desalojo.
- Sin arrastre que cortar y quitar.
- Disponibles en medidas métricas. pulgadas y para bujías.
- Disponible en paredes delgadas y para trabajos pesados.

Caractéristiques et avantages

- Une douille solide utilisant des clavettes de blocage fournit une résistance mécanique contre la rotation
- La grande résistance et la fiabilité procurent une résistance maximale à l'arrachement
- L'installation se fait à l'aide de forets et de tarauds standards
- L'installation est simple, aucune compétence spéciale n'est requise
- Ils sont appropriés à l'utilisation dans une gamme variée de matériaux récepteurs
- Impossible de sauter des filets durant l'installation
- Facile à retirer si nécessaire
- Aucun système d'entraînement à casser et à retirer
- Disponibles en dimensions métriques, pouces et dimensions de bougies d'allumage
- Disponibles en version légère et renforcée

loksert INSTALLATION

- 1 DRILL AND COUNTERSINK**
Drill to create hole, or clear the damaged thread, with a standard hand 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.

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

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

loksert REMOVAL

- 1 DRILL**
Drill out the material between the locking keys and the internal thread to the specified depth.
- 2 DEFLECT**
Deflect locking keys inward and break off.
- 3 REMOVE**
Remove the insert from the hole by wiggling 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.

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



1 Drill with a standard tap drill and countersink with a standard 82°-100° countersink tool; see tables for correct dimensions.

Use una broca estándar y después preferiblemente avellane a 82°-100°; consultar medidas correctas en las tablas disponibles.

Préparez le trou avec un foret standard. et chamfreinez. jusqu'à 82°-100° avec un outil à chamfrein. voir tableau pour les dimensions utilisées.



2 Tap new threads with a standard tap; see tables for correct dimensions.

Rosque el agujero previo con un macho estándar; consultar tablas.

Faites le taraudage avec un taraud standard. voir tableau pour les dimensions utilisées.



3 Screw in the insert until it is 0.25-0.70 mm (0.010-0.030 inch) below the surface. Insert keys locate the Loksert at the correct depth.

Rosque el inserto introduciéndolo 0.25-0.70mm (0.010-0.030") por debajo del ras de la pieza. Las pestañas de arrastre se usan de referencia para calibrar la profundidad de instalación.

Installez l'insert jusqu'à ce qu'il se trouve 0.25 à 0.70 mm en dessous la surface. Les clavettes indiquent que le Loksert est à la profondeur correcte.



4 Drive keys down with several hammer taps on the specified installation tool.

Las pestañas deben ser recogidas en el propio inserto presionándolas con la herramienta de instalación.

Chassez les clavettes dans la surface à l'ai de l'outil prédisposé. et un marteau.



Correctly installed insert.

Inserto correctamente instalado.

Insert installé correctement.



AISI303 (STAINLESS STEEL) – METRIC / INCH		C1215 (CARBON STEEL) – METRIC / INCH	
Material:	Insert - AISI303. Keys - AISI302	Material:	Insert - C1215. Keys - AISI302
Finish:	Passivated	Finish:	Black Manganese Phosphate
Tolerances:	±0.25 mm / ±0.010 unless specified otherwise	Tolerances:	±0.25 mm / ±0.010 unless specified otherwise
Internal thread:	M - 5H / Inch SAE AS8879 - 3B	Internal thread:	M - 6H / Inch SAE AS8879 - 3B
External thread:	M - 4h / Inch - 2A	External thread:	M - 6g / Inch - 2A
Keys:	≤ M6. 2 keys - >M6. 4 keys ≤ 1/4. 2 keys - >1/4. 4 keys	Keys:	≤ M6. 2 keys - >M6. 4 keys ≤ 1/4. 2 keys - >1/4. 4 keys
Matière:	Insert - AISI303. Clavettes - AISI302	Matière:	Insert - C1215. Clavettes - AISI302
Finition:	Passivé	Finition:	Phosphate de manganèse noir
Tolérances:	±0.25 mm / ±0.010 sauf spécifié autrement	Tolérances:	±0.25 mm / ±0.010 sauf spécifié autrement
Filet intérieur:	M - 5H / Inch SAE AS8879 - 3B	Filet intérieur:	M - 6H / Inch SAE AS8879 - 3B
Filet extérieur:	M - 4h / Inch - 2A	Filet extérieur:	M - 6g / Inch - 2A
Clavettes:	≤ M6. 2 clavettes - >M6. 4 clavettes ≤ 1/4. 2 clavettes - >1/4. 4 clavettes	Clavettes:	≤ M6. 2 clavettes - >M6. 4 clavettes ≤ 1/4. 2 clavettes - >1/4. 4 clavettes
Material:	Inserto - AISI303. Pestañas - AISI302	Material:	Inserto - C1215. pestañas - AISI302
Acabado:	Pasivado.	Acabado:	Fosfato de manganeso negro
Tolerancias:	±0.25 mm / ±0.010 Salvo que se indiquen otras.	Tolerancias:	±0.25 mm / ±0.010 Salvo que se indiquen otras.
Rosca interior:	M - 5H / Medida imperial SAE AS8879 - 3B	Rosca interior:	M - 6H / Medida imperial SAE AS8879 - 3B
Rosca exterior:	M - 4h / Medida Imperial - 2A	Rosca Exterior:	M - 6g / Medida imperial - 2A
Pestañas:	≤ M6. 2 pestañas - >M6. 4 pestañas ≤ 1/4. 2 pestañas - >1/4. 4 pestañas	Pestañas:	≤ M6. 2 pestañas - >M6. 4 pestañas ≤ 1/4. 2 pestañas - >1/4. 4 pestañas

Insert Internal Thread
Rosca interna del inserto
Filetage interne du filet rapporté

Insert External Thread
Rosca externa del inserto
Filetage externe du filet rapporté

Insert Length
Longitud del inserto
Longueur du filet rapporté

Tapping Drill Size
Diámetro de la broca previa
Dimension du foret de préparation

Thread Tap Size
Dimensión del macho de roscar
Dimension du taraud de filetage

Tapping Depth (Minimum)
Longitud de roscado (mínima)
Profondeur du taraudage

Countersink Diameter
Diámetro del avellanador
Diámetro de la fraise

Installation Tool Part #
Referencia de la Herramienta de instalación
Outil d'installation

of Inserts
Número de roscas del insert
Nb de filets rapportés

Removal Drill Size and Depth
Diámetro de la broca de extracción y profundidad
Dimension et profondeur du foret (démontage)

Loksert Thin Wall Insert
Inserto de seguridad Loksert de pared delgada
Loksert Thin Wall Insert
(Filet rapporté Loksert à paroi fine)

Loksert Heavy Duty Insert
Inserto de seguridad Loksert reforzado
Loksert Heavy Duty Insert
(Filet rapporté Loksert à paroi renforcée)

TW

HD

STAINLESS STEEL AISI303	THIN WALL
ACERO INOXIDABLE AISI303	PARED DELGADA
ACIER INOXIDABLE AISI303	PAROIE FINE



METRIC – THIN WALL STAINLESS STEEL BULK INSERTS										
INSERT				INSTALLATION					REMOVAL	
5H	4h	MM	PART #	MM	6H	MM	MM	PART #	R1 MM	R2 MM
METRIC COARSE										
M5 X 0.8	M8 X 1.25	8.00	3720-5.00TW	6.90	M8 X 1.25	9.50	8.25	3600-5.00TT	5.50	4.00
M6 X 1	M10 X 1.25	10.00	3720-6.00TW	8.80	M10 X 1.25	11.50	10.25	3600-6.00TT	7.50	4.75
M8 X 1.25	M12 X 1.25	12.00	3720-8.00TW	10.80	M12 X 1.25	13.50	12.25	3600-8.00TT	9.50	4.75
M10 X 1.5	M14 X 1.5	14.00	3720-10.00TW	12.80	M14 X 1.5	15.50	14.25	3600-10.00TT	11.50	4.75
M12 X 1.75	M16 X 1.5	16.00	3720-12.00TW	14.75	M16 X 1.5	17.50	16.25	3600-12.00TT	13.50	4.75
METRIC FINE										
M8 X 1	M12 X 1.25	12.00	3721-8.00TW	10.80	M12 X 1.25	13.50	12.25	3600-8.00TT	9.50	4.75
M10 X 1.25	M14 X 1.5	14.00	3721-10.00TW	12.80	M14 X 1.5	15.50	14.25	3600-10.00TT	11.50	4.75
M12 X 1.25	M16 X 1.5	16.00	3721-12.00TW	14.75	M16 X 1.5	17.50	16.25	3600-12.00TT	13.50	4.75

STAINLESS STEEL AISI303	HEAVY DUTY
ACERO INOXIDABLE AISI303	PARED REFORZADA
ACIER INOXIDABLE AISI303	PAROIE RENFORCÉE



METRIC – HEAVY DUTY STAINLESS STEEL BULK INSERTS										
INSERT				INSTALLATION					REMOVAL	
5H	4h	MM	PART #	MM	6H	MM	MM	PART #	R1 MM	R2 MM
METRIC COARSE										
M4 X 0.7	M8 X 1.25	8.00	3720-4.00HD	6.90	M8 X 1.25	9.50	8.25	3600-4.00HT	5.50	4.00
M5 X 0.8	M10 X 1.25	10.00	3720-5.00HD	8.80	M10 X 1.25	12.50	10.25	3600-5.00HT	7.50	4.75
M6 X 1	M12 X 1.25	12.00	3720-6.00HD	10.80	M12 X 1.25	14.50	12.25	3600-6.00HT	9.50	4.75
M8 X 1.25	M14 X 1.5	14.00	3720-8.00HD	12.80	M14 X 1.5	16.50	14.25	3600-8.00HT	11.50	4.75
M10 X 1.5	M16 X 1.5	16.00	3720-10.00HD	14.75	M16 X 1.5	18.50	16.25	3600-10.00HT	13.50	4.75
M12 X 1.75	M18 X 1.5	18.00	3720-12.00HD	16.75	M18 X 1.5	20.50	18.25	3600-12.00HT	15.50	4.75
M14 X 2	M20 X 1.5	20.00	3720-14.00HD	18.75	M20 X 1.5	22.50	20.25	3600-14.00HT	17.50	4.75
M16 X 2	M22 X 1.5	22.00	3720-16.00HD	20.50	M22 X 1.5	24.50	22.25	3600-16.00HT	17.75	6.35
M20 X 2.5	M30 X 2	30.00	3720-20.00HD	28.00	M30 X 2	34.50	30.25	3600-20.00HT	25.75	6.35
M24 X 3	M33 X 2	33.00	3720-24.00HD	31.00	M33 X 2	37.50	33.25	3600-24.00HT	28.75	6.35
METRIC FINE										
M8 X 1	M14 X 1.5	14.00	3721-8.00HD	12.80	M14 X 1.5	16.50	14.25	3600-8.00HT	11.50	4.75
M10 X 1.25	M16 X 1.5	16.00	3721-10.00HD	14.75	M16 X 1.5	18.50	16.25	3600-10.00HT	13.50	4.75
M12 X 1.25	M18 X 1.5	18.00	3721-12.00HD	16.75	M18 X 1.5	20.50	18.25	3600-12.00HT	15.50	4.75
M14 X 1.5	M20 X 1.5	20.00	3721-14.00HD	18.75	M20 X 1.5	22.50	20.25	3600-14.00HT	17.50	4.75
M16 X 1.5	M22 X 1.5	22.00	3721-16.00HD	20.50	M22 X 1.5	24.50	22.25	3600-16.00HT	17.75	6.35
M18 X 1.5	M24 X 1.5	24.00	3721-18.00HD	22.50	M24 X 1.5	26.50	24.25	3600-18.00HT	19.75	6.35
M20 X 1.5	M30 X 2	30.00	3721-20.00HD	28.00	M30 X 2	34.50	30.25	3600-20.00HT	25.75	6.35
M22 X 1.5	M32 X 2	32.00	3721-22.00HD	30.00	M32 X 2	36.50	32.25	3600-22.00HT	27.75	6.35
M24 X 2	M33 X 2	33.00	3721-24.00HD	31.00	M33 X 2	37.50	33.25	3600-24.00HT	28.75	6.35



INSERTS
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INSERTOS
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INSERTS
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STAINLESS STEEL AISI303 THIN WALL

ACERO INOXIDABLE AISI303 PARED DELGADA
ACIER INOXIDABLE AISI303 PAROIE FINE

UN – THIN WALL STAINLESS STEEL BULK INSERTS

INSERT					INSTALLATION					REMOVAL	
3B	2A	INCH	PART #	MS #	INCH	2B	INCH	INCH	PART #	R1 INCH	R2 INCH
UNJC		UNC									
10-24	5/16-18	0.312	3732-10GTW	MS51830-105	"I"	5/16-18	0.37	0.323	3600-10GTT	7/32	5/32
1/4-20	3/8-16	0.375	3732-1/4TW	MS51830-106	"Q"	3/8-16	0.43	0.385	3600-1/4TT	9/32	3/16
5/16-18	7/16-14	0.437	3732-5/16TW	MS51830-107	"X"	7/16-14	0.50	0.447	3600-5/16TT	11/32	3/16
3/8-16	1/2-13	0.500	3732-3/8TW	MS51830-108	29/64	1/2-13	0.56	0.510	3600-3/8TT	13/32	3/16
7/16-14	9/16-12	0.562	3732-7/16TW	MS51830-109	33/64	9/16-12	0.62	0.572	3600-7/16TT	15/32	3/16
1/2-13	5/8-11	0.625	3732-1/2TW	MS51830-110	37/64	5/8-11	0.68	0.635	3600-1/2TT	17/32	3/16
UNJF		UNC									
10-32	5/16-18	0.312	3734-10GTW	MS51830-201	"I"	5/16-18	0.37	0.323	3600-10GTT	7/32	5/32
1/4-28	3/8-16	0.375	3734-1/4TW	MS51830-202	"Q"	3/8-16	0.43	0.385	3600-1/4TT	9/32	3/16
5/16-24	7/16-14	0.437	3734-5/16TW	MS51830-203	"X"	7/16-14	0.50	0.447	3600-5/16TT	11/32	3/16
3/8-24	1/2-13	0.500	3734-3/8TW	MS51830-204	29/64	1/2-13	0.56	0.510	3600-3/8TT	13/32	3/16
7/16-20	9/16-12	0.562	3734-7/16TW	MS51830-205	33/64	9/16-12	0.62	0.572	3600-7/16TT	15/32	3/16
1/2-20	5/8-11	0.625	3734-1/2TW	MS51830-206	37/64	5/8-11	0.68	0.635	3600-1/2TT	17/32	3/16

STAINLESS STEEL AISI303 HEAVY DUTY

ACERO INOXIDABLE AISI303 PARED REFORZADA
ACIER INOXIDABLE AISI303 PAROIE RENFORCÉE



UN – HEAVY DUTY STAINLESS STEEL BULK INSERTS

INSERT					INSTALLATION					REMOVAL	
3B	2A	INCH	PART #	MS #	INCH	2B	INCH	INCH	PART #	R1 INCH	R2 INCH
UNJC		UNC									
8-32	5/16-18	0.312	3732-8GHD	-	"I"	5/16-18	0.37	0.323	3600-8GHT	7/32	1/8
10-24	3/8-16	0.312	3732-10GHD	MS51831-101	"Q"	3/8-16	0.37	0.385	3600-10GHT	9/32	1/8
1/4-20	7/16-14	0.375	3732-1/4HD	MS51831-102	"X"	7/16-14	0.43	0.447	3600-1/4HT	11/32	3/16
5/16-18	1/2-13	0.437	3732-5/16HD	MS51831-103	29/64	1/2-13	0.50	0.510	3600-5/16HT	13/32	3/16
3/8-16	9/16-12	0.500	3732-3/8HD	MS51831-104	33/64	9/16-12	0.56	0.572	3600-3/8HT	15/32	3/16
7/16-14	5/8-11	0.625	3732-7/16HD	MS51831-105	37/64	5/8-11	0.68	0.635	3600-7/16HT	17/32	3/16
1/2-13	11/16-11NS	0.688	3733-1/2HD	MS51831-106	41/64	11/16-11NS	0.75	0.700	3600-1/2HT	19/32	3/16
1/2-13	3/4-16	0.625	3732-1/2HD	-	45/64	3/4-16	0.68	0.762	3600-1/2HT-3/4	21/32	3/16
9/16-12	3/4-16	0.812	3732-9/16HD	-	45/64	3/4-16	0.94	0.762	3600-9/16HT-3/4	21/32	3/16
9/16-12	13/16-16	0.812	3733-9/16HD	MS51831-107	49/64	13/16-16	0.94	0.822	3600-9/16HT	23/32	3/16
5/8-11	7/8-14	0.875	3732-5/8HD	MS51831-108	53/64	7/8-14	1.00	0.885	3600-5/8HT	25/32	3/16
3/4-10	1-1/8-12	1.125	3732-3/4HD	MS51831-109	1-1/16	1-1/8-12	1.31	1.145	3600-3/4HT	31/32	5/16
7/8-9	1-1/4-12	1.250	3732-7/8HD	MS51831-110	1-3/16	1-1/4-12	1.44	1.270	3600-7/8HT	1-3/32	5/16
1-8	1-3/8-12	1.375	3732-1HD	MS51831-111	1-5/16	1-3/8-12	1.56	1.395	3600-1HT	1-7/32	5/16
UNJF		UNC									
10-32	3/8-16	0.312	3734-10GHD	MS51831-201	"Q"	3/8-16	0.37	0.385	3600-10GHT	9/32	1/8
1/4-28	7/16-14	0.375	3734-1/4HD	MS51831-202	"X"	7/16-14	0.43	0.447	3600-1/4HT	11/32	3/16
5/16-24	1/2-13	0.437	3734-5/16HD	MS51831-203	29/64	1/2-13	0.50	0.510	3600-5/16HT	13/32	3/16
3/8-24	9/16-12	0.500	3734-3/8HD	MS51831-204	33/64	9/16-12	0.56	0.572	3600-3/8HT	15/32	3/16
7/16-20	5/8-11	0.625	3734-7/16HD	MS51831-205	37/64	5/8-11	0.68	0.635	3600-7/16HT	17/32	3/16
1/2-20	11/16-11NS	0.688	3735-1/2HD	MS51831-206	41/64	11/16-11NS	0.75	0.700	3600-1/2HT	19/32	3/16
1/2-20	3/4-16	0.625	3734-1/2HD	-	45/64	3/4-16	0.68	0.762	3600-1/2HT-3/4	21/32	3/16
9/16-18	3/4-16	0.812	3734-9/16HD	-	45/64	3/4-16	0.94	0.762	3600-9/16HT-3/4	21/32	3/16
9/16-18	13/16-16	0.812	3735-9/16HD	MS51831-207	49/64	13/16-16	0.94	0.822	3600-9/16HT	23/32	3/16
5/8-18	7/8-14	0.875	3734-5/8HD	MS51831-208	53/64	7/8-14	1.00	0.885	3600-5/8HT	25/32	3/16
3/4-16	1-1/8-12	1.125	3734-3/4HD	MS51831-209	1-1/16	1-1/8-12	1.31	1.145	3600-3/4HT	31/32	5/16
7/8-14	1-1/4-12	1.250	3734-7/8HD	MS51831-210	1-3/16	1-1/4-12	1.44	1.270	3600-7/8HT	1-3/32	5/16
1-12	1-3/8-12	1.375	3734-1HD	MS51831-211	1-5/16	1-3/8-12	1.56	1.395	3600-1HT	1-7/32	5/16

CARBON STEEL C1215	THIN WALL
ACERO AL CARBONO C1215	PARED DELGADA
ACIER CARBONE C1215	PAROIE FINE

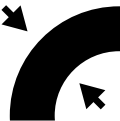

METRIC – THIN WALL CARBON STEEL BULK INSERTS

INSERT				INSTALLATION					REMOVAL	
6H	6g	MM	PART #	MM	6H	MM	MM	PART #	R1 MM	R2 MM
METRIC COARSE										
M5 X 0.8	M8 X 1.25	8.00	3620-5.00TW	6.90	M8 X 1.25	9.50	8.25	3600-5.00TT	5.50	4.00
M6 X 1	M10 X 1.25	10.00	3620-6.00TW	8.80	M10 X 1.25	11.50	10.25	3600-6.00TT	7.50	4.75
M8 X 1.25	M12 X 1.25	12.00	3620-8.00TW	10.80	M12 X 1.25	13.50	12.25	3600-8.00TT	9.50	4.75
M10 X 1.5	M14 X 1.5	14.00	3620-10.00TW	12.80	M14 X 1.5	15.50	14.25	3600-10.00TT	11.50	4.75
M12 X 1.75	M16 X 1.5	16.00	3620-12.00TW	14.75	M16 X 1.5	17.50	16.25	3600-12.00TT	13.50	4.75
METRIC FINE										
M8 X 1	M12 X 1.25	12.00	3621-8.00TW	10.80	M12 X 1.25	13.50	12.25	3600-8.00TT	9.50	4.75
M10 X 1.25	M14 X 1.5	14.00	3621-10.00TW	12.80	M14 X 1.5	15.50	14.25	3600-10.00TT	11.50	4.75
M12 X 1.25	M16 X 1.5	16.00	3621-12.00TW	14.75	M16 X 1.5	17.50	16.25	3600-12.00TT	13.50	4.75

CARBON STEEL C1215	HEAVY DUTY
ACERO AL CARBONO C1215	PARED REFORZADA
ACIER CARBONE C1215	PAROIE RENFORCÉE


METRIC – HEAVY DUTY CARBON STEEL BULK INSERTS

INSERT				INSTALLATION					REMOVAL	
6H	6g	MM	PART #	MM	6H	MM	MM	PART #	R1 MM	R2 MM
METRIC COARSE										
M4 X 0.7	M8 X 1.25	8.00	3620-4.00HD	6.90	M8 X 1.25	9.50	8.25	3600-4.00HT	5.50	4.00
M5 X 0.8	M10 X 1.25	10.00	3620-5.00HD	8.80	M10 X 1.25	12.50	10.25	3600-5.00HT	7.50	4.75
M6 X 1	M12 X 1.25	12.00	3620-6.00HD	10.80	M12 X 1.25	14.50	12.25	3600-6.00HT	9.50	4.75
M8 X 1.25	M14 X 1.5	14.00	3620-8.00HD	12.80	M14 X 1.5	16.50	14.25	3600-8.00HT	11.50	4.75
M10 X 1.5	M16 X 1.5	16.00	3620-10.00HD	14.75	M16 X 1.5	18.50	16.25	3600-10.00HT	13.50	4.75
M12 X 1.75	M18 X 1.5	18.00	3620-12.00HD	16.75	M18 X 1.5	20.50	18.25	3600-12.00HT	15.50	4.75
M14 X 2	M20 X 1.5	20.00	3620-14.00HD	18.75	M20 X 1.5	22.50	20.25	3600-14.00HT	17.50	4.75
M16 X 2	M22 X 1.5	22.00	3620-16.00HD	20.50	M22 X 1.5	24.50	22.25	3600-16.00HT	17.75	6.35
M20 X 2.5	M30 X 2	30.00	3620-20.00HD	28.00	M30 X 2	34.50	30.25	3600-20.00HT	25.75	6.35
M24 X 3	M33 X 2	33.00	3620-24.00HD	31.00	M33 X 2	37.50	33.25	3600-24.00HT	28.75	6.35
METRIC FINE										
M8 X 1	M14 X 1.5	14.00	3621-8.00HD	12.80	M14 X 1.5	16.50	14.25	3600-8.00HT	11.50	4.75
M10 X 1.25	M16 X 1.5	16.00	3621-10.00HD	14.75	M16 X 1.5	18.50	16.25	3600-10.00HT	13.50	4.75
M12 X 1.25	M18 X 1.5	18.00	3621-12.00HD	16.75	M18 X 1.5	20.50	18.25	3600-12.00HT	15.50	4.75
M14 X 1.5	M20 X 1.5	20.00	3621-14.00HD	18.75	M20 X 1.5	22.50	20.25	3600-14.00HT	17.50	4.75
M16 X 1.5	M22 X 1.5	22.00	3621-16.00HD	20.50	M22 X 1.5	24.50	22.25	3600-16.00HT	17.75	6.35
M18 X 1.5	M24 X 1.5	24.00	3621-18.00HD	22.50	M24 X 1.5	26.50	24.25	3600-18.00HT	19.75	6.35
M20 X 1.5	M30 X 2	30.00	3621-20.00HD	28.00	M30 X 2	34.50	30.25	3600-20.00HT	25.75	6.35
M22 X 1.5	M32 X 2	32.00	3621-22.00HD	30.00	M32 X 2	36.50	32.25	3600-22.00HT	27.75	6.35
M24 X 2	M33 X 2	33.00	3621-24.00HD	31.00	M33 X 2	37.50	33.25	3600-24.00HT	28.75	6.35





INSERTS
UN

INSERTOS
UN

INSERTS
UNIFIES

CARBON STEEL C1215		THIN WALL
ACERO AL CARBONO C1215		PARED DELGADA
ACIER CARBONE C1215		PAROIE FINE

UN – THIN WALL CARBON STEEL BULK INSERTS

INSERT				INSTALLATION					REMOVAL	
3B	2A	INCH	PART #	INCH	2B	INCH	INCH	PART #	R1 INCH	R2 INCH
UNJC		UNC								
10-24	5/16-18	0.312	3632-10GTW	"I"	5/16-18	0.37	0.323	3600-10GTT	7/32	5/32
1/4-20	3/8-16	0.375	3632-1/4TW	"Q"	3/8-16	0.43	0.385	3600-1/4TT	9/32	3/16
5/16-18	7/16-14	0.437	3632-5/16TW	"X"	7/16-14	0.50	0.447	3600-5/16TT	11/32	3/16
3/8-16	1/2-13	0.500	3632-3/8TW	29/64	1/2-13	0.56	0.510	3600-3/8TT	13/32	3/16
7/16-14	9/16-12	0.562	3632-7/16TW	33/64	9/16-12	0.62	0.572	3600-7/16TT	15/32	3/16
1/2-13	5/8-11	0.625	3632-1/2TW	37/64	5/8-11	0.68	0.635	3600-1/2TT	17/32	3/16
UNJF		UNC								
10-32	5/16-18	0.312	3634-10GTW	"I"	5/16-18	0.37	0.323	3600-10GTT	7/32	5/32
1/4-28	3/8-16	0.375	3634-1/4TW	"Q"	3/8-16	0.43	0.385	3600-1/4TT	9/32	3/16
5/16-24	7/16-14	0.437	3634-5/16TW	"X"	7/16-14	0.50	0.447	3600-5/16TT	11/32	3/16
3/8-24	1/2-13	0.500	3634-3/8TW	29/64	1/2-13	0.56	0.510	3600-3/8TT	13/32	3/16
7/16-20	9/16-12	0.562	3634-7/16TW	33/64	9/16-12	0.62	0.572	3600-7/16TT	15/32	3/16
1/2-20	5/8-11	0.625	3634-1/2TW	37/64	5/8-11	0.68	0.635	3600-1/2TT	17/32	3/16

CARBON STEEL C1215		HEAVY DUTY
ACERO AL CARBONO C1215		PARED REFORZADA
ACIER CARBONE C1215		PAROIE RENFORCÉE



UN – HEAVY DUTY CARBON STEEL BULK INSERTS

INSERT				INSTALLATION					REMOVAL	
3B	2A	INCH	PART #	INCH	2B	INCH	INCH	PART #	R1 INCH	R2 INCH
UNJC		UNC								
8-32	5/16-18	0.312	3632-8GHD	"I"	5/16-18	0.37	0.323	3600-8GHT	7/32	1/8
10-24	3/8-16	0.312	3632-10GHD	"Q"	3/8-16	0.37	0.385	3600-10GHT	9/32	1/8
1/4-20	7/16-14	0.375	3632-1/4HD	"X"	7/16-14	0.43	0.447	3600-1/4HT	11/32	3/16
5/16-18	1/2-13	0.437	3632-5/16HD	29/64	1/2-13	0.50	0.510	3600-5/16HT	13/32	3/16
3/8-16	9/16-12	0.500	3632-3/8HD	33/64	9/16-12	0.56	0.572	3600-3/8HT	15/32	3/16
7/16-14	5/8-11	0.625	3632-7/16HD	37/64	5/8-11	0.68	0.635	3600-7/16HT	17/32	3/16
1/2-13	3/4-16	0.625	3632-1/2HD	45/64	3/4-16	0.68	0.762	3600-1/2HT-3/4	21/32	3/16
9/16-12	3/4-16	0.812	3632-9/16HD	45/64	3/4-16	0.94	0.762	3600-9/16HT-3/4	21/32	3/16
5/8-11	7/8-14	0.875	3632-5/8HD	53/64	7/8-14	1.00	0.885	3600-5/8HT	25/32	3/16
3/4-10	1-1/8-12	1.125	3632-3/4HD	1-1/16	1-1/8-12	1.31	1.145	3600-3/4HT	31/32	5/16
7/8-9	1-1/4-12	1.250	3632-7/8HD	1-3/16	1-1/4-12	1.44	1.270	3600-7/8HT	1-3/32	5/16
1-8	1-3/8-12	1.375	3632-1HD	1-5/16	1-3/8-12	1.56	1.395	3600-1HT	1-7/32	5/16
1-1/8-7	1-1/2-12	1.62	3632-1.1/8HD	1-7/16	1-1/2-12	1.84	1.52	3600-1.1/8HT	1-11/32	5/16
1-1/4-7	1-5/8-12	1.81	3632-1.1/4HD	1-9/16	1-5/8-12	2.06	1.64	3600-1.1/4HT	1-15/32	5/16
1-1/2-6	1-7/8-12	2.00	3632-1.1/2HD	1-13/16	1-7/8-12	2.28	1.89	3600-1.1/2HT	1-23/32	5/16
UNJF		UNC								
10-32	3/8-16	0.312	3634-10GHD	"Q"	3/8-16	0.37	0.385	3600-10GHT	9/32	1/8
1/4-28	7/16-14	0.375	3634-1/4HD	"X"	7/16-14	0.43	0.447	3600-1/4HT	11/32	3/16
5/16-24	1/2-13	0.437	3634-5/16HD	29/64	1/2-13	0.50	0.510	3600-5/16HT	13/32	3/16
3/8-24	9/16-12	0.500	3634-3/8HD	33/64	9/16-12	0.56	0.572	3600-3/8HT	15/32	3/16
7/16-20	5/8-11	0.625	3634-7/16HD	37/64	5/8-11	0.68	0.635	3600-7/16HT	17/32	3/16
1/2-20	3/4-16	0.625	3634-1/2HD	45/64	3/4-16	0.68	0.762	3600-1/2HT-3/4	21/32	3/16
9/16-18	3/4-16	0.812	3634-9/16HD	45/64	3/4-16	0.94	0.762	3600-9/16HT-3/4	21/32	3/16
5/8-18	7/8-14	0.875	3634-5/8HD	53/64	7/8-14	1.00	0.885	3600-5/8HT	25/32	3/16
3/4-16	1-1/8-12	1.125	3634-3/4HD	1-1/16	1-1/8-12	1.31	1.145	3600-3/4HT	31/32	5/16
7/8-14	1-1/4-12	1.250	3634-7/8HD	1-3/16	1-1/4-12	1.44	1.270	3600-7/8HT	1-3/32	5/16
1-12	1-3/8-12	1.375	3634-1HD	1-5/16	1-3/8-12	1.56	1.395	3600-1HT	1-7/32	5/16
1-14	1-3/8-12	1.375	3635-1HD	1-5/16	1-3/8-12	1.56	1.395	3600-1HT	1-7/32	5/16
1-1/8-12	1-1/2-12	1.62	3634-1.1/8HD	1-7/16	1-1/2-12	1.84	1.52	3600-1.1/8HT	1-11/32	5/16
1-1/4-12	1-5/8-12	1.81	3634-1.1/4HD	1-9/16	1-5/8-12	2.06	1.64	3600-1.1/4HT	1-15/32	5/16
1-1/2-12	1-7/8-12	2.00	3634-1.1/2HD	1-13/16	1-7/8-12	2.28	1.89	3600-1.1/2HT	1-23/32	5/16

KITS
METRIC

JUEGOS
MEDIDA MÉTRICA

COFFRET
MÉTRIQUE

loksert

STAINLESS STEEL AISI303	THIN WALL KITS
ACERO INOXIDABLE AISI303	JUEGOS EN PARED DELGADA
ACIER INOXIDABLE AISI303	COFFRET PAROIE FINE



METRIC – THIN WALL STAINLESS STEEL INSERT KITS								
INSERT				INCLUDED IN KIT				NOT INCLUDED
5H	4h	MM	PART #	#	MM	6H	PART #	MM
METRIC COARSE								
M5 X 0.8	M8 X 1.25	8.00	3720-5.00TWK	5	6.90	M8 X 1.25	3600-5.00TT	8.25
M6 X 1	M10 X 1.25	10.00	3720-6.00TWK	5	8.80	M10 X 1.25	3600-6.00TT	10.25
M8 X 1.25	M12 X 1.25	12.00	3720-8.00TWK	5	10.80	M12 X 1.25	3600-8.00TT	12.25
M10 X 1.5	M14 X 1.5	14.00	3720-10.00TWK	5	12.80	M14 X 1.5	3600-10.00TT	14.25
M12 X 1.75	M16 X 1.5	16.00	3720-12.00TWK	5	14.75	M16 X 1.5	3600-12.00TT	16.25
METRIC FINE								
M8 X 1	M12 X 1.25	12.00	3721-8.00TWK	5	10.80	M12 X 1.25	3600-8.00TT	12.25
M10 X 1.25	M14 X 1.5	14.00	3721-10.00TWK	5	12.80	M14 X 1.5	3600-10.00TT	14.25
M12 X 1.25	M16 X 1.5	16.00	3721-12.00TWK	5	14.75	M16 X 1.5	3600-12.00TT	16.25

STAINLESS STEEL AISI303	HEAVY DUTY KITS
ACERO INOXIDABLE AISI303	JUEGOS EN PARED REFORZADA
ACIER INOXIDABLE AISI303	COFFRET PAROIE RENFORCÉE



METRIC – HEAVY DUTY STAINLESS STEEL INSERT KITS								
INSERT				INCLUDED IN KIT				NOT INCLUDED
5H	4h	MM	PART #	#	MM	6H	PART #	MM
METRIC COARSE								
M5 X 0.8	M10 X 1.25	10.00	3720-5.00HDK	5	8.80	M10 X 1.25	3600-5.00HT	10.25
M6 X 1	M12 X 1.25	12.00	3720-6.00HDK	5	10.80	M12 X 1.25	3600-6.00HT	12.25
M8 X 1.25	M14 X 1.5	14.00	3720-8.00HDK	5	12.80	M14 X 1.5	3600-8.00HT	14.25
M10 X 1.5	M16 X 1.5	16.00	3720-10.00HDK	5	14.75	M16 X 1.5	3600-10.00HT	16.25
M12 X 1.75	M18 X 1.5	18.00	3720-12.00HDK	5	16.75	M18 X 1.5	3600-12.00HT	18.25
M16 X 2	M22 X 1.5	22.00	3720-16.00HDK	5	20.50	M22 X 1.5	3600-16.00HT	22.25
METRIC FINE								
M8 X 1	M14 X 1.5	14.00	3721-8.00HDK	5	12.80	M14 X 1.5	3600-8.00HT	14.25
M10 X 1.25	M16 X 1.5	16.00	3721-10.00HDK	5	14.75	M16 X 1.5	3600-10.00HT	16.25
M12 X 1.25	M18 X 1.5	18.00	3721-12.00HDK	5	16.75	M18 X 1.5	3600-12.00HT	18.25
M16 X 1.5	M22 X 1.5	22.00	3721-16.00HDK	5	20.50	M22 X 1.5	3600-16.00HT	22.25



KITS
UN

JUEGOS
ROSCA UN

COFFERTS
UNIFÉ

STAINLESS STEEL AISI303 THIN WALL KITS
ACERO INOXIDABLE AISI303 JUEGOS EN PARED DELGADA
ACIER INOXIDABLE AISI303 COFFRET PAROIE FINE

UN – THIN WALL STAINLESS STEEL INSERT KITS

INSERT				INCLUDED IN KIT				NOT INCLUDED
3B	2A	INCH	PART #	#	INCH	2B	PART #	INCH
UNJC	UNC							
10-24	5/16-18	0.312	3732-10GTWK	5	"I"	5/16-18	3600-10GTT	0.323
1/4-20	3/8-16	0.375	3732-1/4TWK	5	"Q"	3/8-16	3600-1/4TT	0.385
5/16-18	7/16-14	0.437	3732-5/16TWK	5	"X"	7/16-14	3600-5/16TT	0.447
3/8-16	1/2-13	0.500	3732-3/8TWK	5	29/64	1/2-13	3600-3/8TT	0.510
7/16-14	9/16-12	0.562	3732-7/16TWK	5	33/64	9/16-12	3600-7/16TT	0.572
1/2-13	5/8-11	0.625	3732-1/2TWK	5	37/64	5/8-11	3600-1/2TT	0.635
UNJF	UNC							
10-32	5/16-18	0.312	3734-10GTWK	5	"I"	5/16-18	3600-10GTT	0.323
1/4-28	3/8-16	0.375	3734-1/4TWK	5	"Q"	3/8-16	3600-1/4TT	0.385
5/16-24	7/16-14	0.437	3734-5/16TWK	5	"X"	7/16-14	3600-5/16TT	0.447
3/8-24	1/2-13	0.500	3734-3/8TWK	5	29/64	1/2-13	3600-3/8TT	0.510
7/16-20	9/16-12	0.562	3734-7/16TWK	5	33/64	9/16-12	3600-7/16TT	0.572
1/2-20	5/8-11	0.625	3734-1/2TWK	5	37/64	5/8-11	3600-1/2TT	0.635



STAINLESS STEEL AISI303 HEAVY DUTY KITS
ACERO INOXIDABLE AISI303 JUEGOS EN PARED REFORZADA
ACIER INOXIDABLE AISI303 COFFRET PAROIE RENFORCÉE



UN – HEAVY DUTY STAINLESS STEEL INSERT KITS

INSERT				INCLUDED IN KIT				NOT INCLUDED
3B	2A	INCH	PART #	#	INCH	2B	PART #	INCH
UNJC	UNC							
10-24	3/8-16	0.312	3732-10GHDK	5	"Q"	3/8-16	3600-10GHT	0.385
1/4-20	7/16-14	0.375	3732-1/4HDK	5	"X"	7/16-14	3600-1/4HT	0.447
5/16-18	1/2-13	0.437	3732-5/16HDK	5	29/64	1/2-13	3600-5/16HT	0.510
3/8-16	9/16-12	0.500	3732-3/8HDK	5	33/64	9/16-12	3600-3/8HT	0.572
7/16-14	5/8-11	0.625	3732-7/16HDK	5	37/64	5/8-11	3600-7/16HT	0.635
1/2-13	11/16-11NS	0.688	3733-1/2HDK	5	41/64	11/16-11NS	3600-1/2HT	0.700
1/2-13	3/4-16	0.625	3732-1/2HDK	5	45/64	3/4-16	3600-1/2HT-3/4	0.762
9/16-12	3/4-16	0.812	3732-9/16HDK	5	45/64	3/4-16	3600-9/16HT-3/4	0.762
9/16-12	13/16-16	0.812	3733-9/16HDK	5	49/64	13/16-16	3600-9/16HT	0.822
5/8-11	7/8-14	0.875	3732-5/8HDK	5	53/64	7/8-14	3600-5/8HT	0.885
UNJF	UNC							
10-32	3/8-16	0.312	3734-10GHDK	5	"Q"	3/8-16	3600-10GHT	0.385
1/4-28	7/16-14	0.375	3734-1/4HDK	5	"X"	7/16-14	3600-1/4HT	0.447
5/16-24	1/2-13	0.437	3734-5/16HDK	5	29/64	1/2-13	3600-5/16HT	0.510
3/8-24	9/16-12	0.500	3734-3/8HDK	5	33/64	9/16-12	3600-3/8HT	0.572
7/16-20	5/8-11	0.625	3734-7/16HDK	5	37/64	5/8-11	3600-7/16HT	0.635
1/2-20	11/16-11NS	0.688	3735-1/2HDK	5	41/64	11/16-11NS	3600-1/2HT	0.700
1/2-20	3/4-16	0.625	3734-1/2HDK	5	45/64	3/4-16	3600-1/2HT-3/4	0.762
9/16-18	3/4-16	0.812	3734-9/16HDK	5	45/64	3/4-16	3600-9/16HT-3/4	0.762
9/16-18	13/16-16	0.812	3735-9/16HDK	5	49/64	13/16-16	3600-9/16HT	0.822
5/8-18	7/8-14	0.875	3734-5/8HDK	5	53/64	7/8-14	3600-5/8HT	0.885



CARBON STEEL C1215	THIN WALL KITS
ACERO AL CARBONO C1215	JUEGOS EN PARED DELGADA
ACIER CARBONE C1215	COFFRET PAROIE FINE



METRIC – THIN WALL CARBON STEEL INSERT KITS

INSERT				INCLUDED IN KIT				NOT INCLUDED
6H	6g	MM	PART #	#	MM	6H	PART #	MM
METRIC COARSE								
M5 X 0.8	M8 X 1.25	8.00	3620-5.00TWK	5	6.90	M8 X 1.25	3600-5.00TT	8.25
M6 X 1	M10 X 1.25	10.00	3620-6.00TWK	5	8.80	M10 X 1.25	3600-6.00TT	10.25
M8 X 1.25	M12 X 1.25	12.00	3620-8.00TWK	5	10.80	M12 X 1.25	3600-8.00TT	12.25
M10 X 1.5	M14 X 1.5	14.00	3620-10.00TWK	5	12.80	M14 X 1.5	3600-10.00TT	14.25
M12 X 1.75	M16 X 1.5	16.00	3620-12.00TWK	5	14.75	M16 X 1.5	3600-12.00TT	16.25
METRIC FINE								
M8 X 1	M12 X 1.25	12.00	3621-8.00TWK	5	10.80	M12 X 1.25	3600-8.00TT	12.25
M10 X 1.25	M14 X 1.5	14.00	3621-10.00TWK	5	12.80	M14 X 1.5	3600-10.00TT	14.25
M12 X 1.25	M16 X 1.5	16.00	3621-12.00TWK	5	14.75	M16 X 1.5	3600-12.00TT	16.25

CARBON STEEL C1215	HEAVY DUTY KITS
ACERO AL CARBONO C1215	JUEGOS EN PARED REFORZADA
ACIER CARBONE C1215	COFFRET PAROIE RENFORCÉE



METRIC – HEAVY DUTY CARBON STEEL INSERT KITS

INSERT				INCLUDED IN KIT				NOT INCLUDED
6H	6g	MM	PART #	#	MM	6H	PART #	MM
METRIC COARSE								
M5 X 0.8	M10 X 1.25	10.00	3620-5.00HDK	5	8.80	M10 X 1.25	3600-5.00HT	10.25
M6 X 1	M12 X 1.25	12.00	3620-6.00HDK	5	10.80	M12 X 1.25	3600-6.00HT	12.25
M8 X 1.25	M14 X 1.5	14.00	3620-8.00HDK	5	12.80	M14 X 1.5	3600-8.00HT	14.25
M10 X 1.5	M16 X 1.5	16.00	3620-10.00HDK	5	14.75	M16 X 1.5	3600-10.00HT	16.25
M12 X 1.75	M18 X 1.5	18.00	3620-12.00HDK	5	16.75	M18 X 1.5	3600-12.00HT	18.25
M16 X 2	M22 X 1.5	22.00	3620-16.00HDK	5	20.50	M22 X 1.5	3600-16.00HT	22.25
METRIC FINE								
M8 X 1	M14 X 1.5	14.00	3621-8.00HDK	5	12.80	M14 X 1.5	3600-8.00HT	14.25
M10 X 1.25	M16 X 1.5	16.00	3621-10.00HDK	5	14.75	M16 X 1.5	3600-10.00HT	16.25
M12 X 1.25	M18 X 1.5	18.00	3621-12.00HDK	5	16.75	M18 X 1.5	3600-12.00HT	18.25
M16 X 1.5	M22 X 1.5	22.00	3621-16.00HDK	5	20.50	M22 X 1.5	3600-16.00HT	22.25



CARBON STEEL C1215	THIN WALL KITS
ACERO AL CARBONO C1215	JUEGOS EN PARED DELGADA
ACIER CARBONE C1215	COFFRET PAROIE FINE

UN – THIN WALL CARBON STEEL INSERT KITS

INSERT				INCLUDED IN KIT				NOT INCLUDED
3B	2A	INCH	PART #	#	INCH	2B	PART #	INCH
UNJC	UNC							
10-24	5/16-18	0.312	3632-10GTWK	5	"I"	5/16-18	3600-10GTT	0.323
1/4-20	3/8-16	0.375	3632-1/4TWK	5	"Q"	3/8-16	3600-1/4TT	0.385
5/16-18	7/16-14	0.437	3632-5/16TWK	5	"X"	7/16-14	3600-5/16TT	0.447
3/8-16	1/2-13	0.500	3632-3/8TWK	5	29/64	1/2-13	3600-3/8TT	0.510
7/16-14	9/16-12	0.562	3632-7/16TWK	5	33/64	9/16-12	3600-7/16TT	0.572
1/2-13	5/8-11	0.625	3632-1/2TWK	5	37/64	5/8-11	3600-1/2TT	0.635
UNJF	UNC							
10-32	5/16-18	0.312	3634-10GTWK	5	"I"	5/16-18	3600-10GTT	0.323
1/4-28	3/8-16	0.375	3634-1/4TWK	5	"Q"	3/8-16	3600-1/4TT	0.385
5/16-24	7/16-14	0.437	3634-5/16TWK	5	"X"	7/16-14	3600-5/16TT	0.447
3/8-24	1/2-13	0.500	3634-3/8TWK	5	29/64	1/2-13	3600-3/8TT	0.510
7/16-20	9/16-12	0.562	3634-7/16TWK	5	33/64	9/16-12	3600-7/16TT	0.572
1/2-20	5/8-11	0.625	3634-1/2TWK	5	37/64	5/8-11	3600-1/2TT	0.635



CARBON STEEL C1215	HEAVY DUTY KITS
ACERO AL CARBONO C1215	JUEGOS EN PARED REFORZADA
ACIER CARBONE C1215	COFFRET PAROIE RENFORCÉE


UN – HEAVY DUTY CARBON STEEL INSERT KITS

INSERT				INCLUDED IN KIT				NOT INCLUDED
3B	2A	INCH	PART #	#	INCH	2B	PART #	INCH
UNJC	UNC							
10-24	3/8-16	0.312	3632-10GHDK	5	"Q"	3/8-16	3600-10GHT	0.385
1/4-20	7/16-14	0.375	3632-1/4HDK	5	"X"	7/16-14	3600-1/4HT	0.447
5/16-18	1/2-13	0.437	3632-5/16HDK	5	29/64	1/2-13	3600-5/16HT	0.510
3/8-16	9/16-12	0.500	3632-3/8HDK	5	33/64	9/16-12	3600-3/8HT	0.572
7/16-14	5/8-11	0.625	3632-7/16HDK	5	37/64	5/8-11	3600-7/16HT	0.635
1/2-13	3/4-16	0.625	3632-1/2HDK	5	45/64	3/4-16	3600-1/2HT-3/4	0.762
9/16-12	3/4-16	0.812	3632-9/16HDK	5	45/64	3/4-16	3600-9/16HT-3/4	0.762
5/8-11	7/8-14	0.875	3632-5/8HDK	5	53/64	7/8-14	3600-5/8HT	0.885
UNJF	UNC							
10-32	3/8-16	0.312	3634-10GHDK	5	"Q"	3/8-16	3600-10GHT	0.385
1/4-28	7/16-14	0.375	3634-1/4HDK	5	"X"	7/16-14	3600-1/4HT	0.447
5/16-24	1/2-13	0.437	3634-5/16HDK	5	29/64	1/2-13	3600-5/16HT	0.510
3/8-24	9/16-12	0.500	3634-3/8HDK	5	33/64	9/16-12	3600-3/8HT	0.572
7/16-20	5/8-11	0.625	3634-7/16HDK	5	37/64	5/8-11	3600-7/16HT	0.635
1/2-20	3/4-16	0.625	3634-1/2HDK	5	45/64	3/4-16	3600-1/2HT-3/4	0.762
9/16-18	3/4-16	0.812	3634-9/16HDK	5	45/64	3/4-16	3600-9/16HT-3/4	0.762
5/8-18	7/8-14	0.875	3634-5/8HDK	5	53/64	7/8-14	3600-5/8HT	0.885



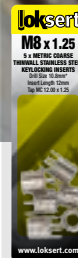
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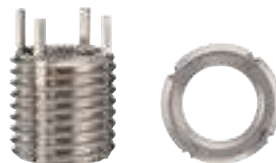
STAINLESS STEEL AISI303	THIN WALL PACKETS
ACERO INOXIDABLE AISI303	BLISTERS DE INSERTOS PARED DELGADA
ACIER INOXIDABLE AISI303	SACHETS PAROIE FINE



METRIC – THIN WALL STAINLESS STEEL INSERTS RETAIL PACKETS

INSERT					INSTALLATION					REMOVAL	
5H	4h	MM	#	PART #	MM	6H	MM	MM	PART #	R1 MM	R2 MM
METRIC COARSE											
M5 X 0.8	M8 X 1.25	8.00	5	3720-5.00TWP	6.90	M8 X 1.25	9.50	8.25	3600-190T	5.50	4.00
M6 X 1	M10 X 1.25	10.00	5	3720-6.00TWP	8.80	M10 X 1.25	11.50	10.25	3600-250T	7.50	4.75
M8 X 1.25	M12 X 1.25	12.00	5	3720-8.00TWP	10.80	M12 X 1.25	13.50	12.25	3600-312T	9.50	4.75
M10 X 1.5	M14 X 1.5	14.00	5	3720-10.00TWP	12.80	M14 X 1.5	15.50	14.25	3600-375T	11.50	4.75
M12 X 1.75	M16 X 1.5	16.00	5	3720-12.00TWP	14.75	M16 X 1.5	17.50	16.25	3600-500T	13.50	4.75
METRIC FINE											
M8 X 1	M12 X 1.25	12.00	5	3721-8.00TWP	10.80	M12 X 1.25	13.50	12.25	3600-312T	9.50	4.75
M10 X 1.25	M14 X 1.5	14.00	5	3721-10.00TWP	12.80	M14 X 1.5	15.50	14.25	3600-375T	11.50	4.75
M12 X 1.25	M16 X 1.5	16.00	5	3721-12.00TWP	14.75	M16 X 1.5	17.50	16.25	3600-500T	13.50	4.75

STAINLESS STEEL AISI303	THIN WALL PACKETS
ACERO INOXIDABLE AISI303	BLISTERS DE INSERTOS PARED DELGADA
ACIER INOXIDABLE AISI303	SACHETS PAROIE FINE



UN – THIN WALL STAINLESS STEEL INSERTS RETAIL PACKETS

INSERT					INSTALLATION					REMOVAL	
3B	2A	INCH	#	PART #	INCH	2B	INCH	INCH	PART #	R1 INCH	R2 INCH
UNJC											
10-24	5/16-18	0.312	5	3732-10GTWP	"I"	5/16-18	0.37	0.323	3600-190T	7/32	5/32
1/4-20	3/8-16	0.375	5	3732-1/4TWP	"Q"	3/8-16	0.43	0.385	3600-250T	9/32	3/16
5/16-18	7/16-14	0.437	5	3732-5/16TWP	"X"	7/16-14	0.50	0.447	3600-312T	11/32	3/16
3/8-16	1/2-13	0.500	5	3732-3/8TWP	29/64	1/2-13	0.56	0.510	3600-375T	13/32	3/16
7/16-14	9/16-12	0.562	5	3732-7/16TWP	33/64	9/16-12	0.62	0.572	3600-375T	15/32	3/16
1/2-13	5/8-11	0.625	5	3732-1/2TWP	37/64	5/8-11	0.68	0.635	3600-500T	17/32	3/16
UNJF											
10-32	5/16-18	0.312	5	3734-10GTWP	"I"	5/16-18	0.37	0.323	3600-190T	7/32	5/32
1/4-28	3/8-16	0.375	5	3734-1/4TWP	"Q"	3/8-16	0.43	0.385	3600-250T	9/32	3/16
5/16-24	7/16-14	0.437	5	3734-5/16TWP	"X"	7/16-14	0.50	0.447	3600-312T	11/32	3/16
3/8-24	1/2-13	0.500	5	3734-3/8TWP	29/64	1/2-13	0.56	0.510	3600-375T	13/32	3/16
7/16-20	9/16-12	0.562	5	3734-7/16TWP	33/64	9/16-12	0.62	0.572	3600-375T	15/32	3/16
1/2-20	5/8-11	0.625	5	3734-1/2TWP	37/64	5/8-11	0.68	0.635	3600-500T	17/32	3/16



CARBON STEEL C1215		THIN WALL PACKETS	
ACERO AL CARBONO C1215		BLISTERS DE INSERTOS PARED DELGADA	
ACIER CARBONE C1215		SACHETS PAROIE FINE	

METRIC – THIN WALL CARBON STEEL INSERTS RETAIL PACKETS

INSERT					INSTALLATION					REMOVAL	
6H	6g	MM	#	PART #	MM	6H	MM	MM	PART #	R1 MM	R2 MM
METRIC COARSE											
M5 X 0.8	M8 X 1.25	8.00	5	3620-5.00TWP	6.90	M8 X 1.25	9.50	8.25	3600-190T	5.50	4.00
M6 X 1	M10 X 1.25	10.00	5	3620-6.00TWP	8.80	M10 X 1.25	11.50	10.25	3600-250T	7.50	4.75
M8 X 1.25	M12 X 1.25	12.00	5	3620-8.00TWP	10.80	M12 X 1.25	13.50	12.25	3600-312T	9.50	4.75
M10 X 1.5	M14 X 1.5	14.00	5	3620-10.00TWP	12.80	M14 X 1.5	15.50	14.25	3600-375T	11.50	4.75
M12 X 1.75	M16 X 1.5	16.00	5	3620-12.00TWP	14.75	M16 X 1.5	17.50	16.25	3600-500T	13.50	4.75
METRIC FINE											
M8 X 1	M12 X 1.25	12.00	5	3621-8.00TWP	10.80	M12 X 1.25	13.50	12.25	3600-312T	9.50	4.75
M10 X 1.25	M14 X 1.5	14.00	5	3621-10.00TWP	12.80	M14 X 1.5	15.50	14.25	3600-375T	11.50	4.75
M12 X 1.25	M16 X 1.5	16.00	5	3621-12.00TWP	14.75	M16 X 1.5	17.50	16.25	3600-500T	13.50	4.75

CARBON STEEL C1215		THIN WALL PACKETS	
ACERO AL CARBONO C1215		BLISTERS DE INSERTOS PARED DELGADA	
ACIER CARBONE C1215		SACHETS PAROIE FINE	



UN – THIN WALL CARBON STEEL INSERTS RETAIL PACKETS

INSERT					INSTALLATION					REMOVAL	
3B	2A	INCH	#	PART #	INCH	2B	INCH	INCH	PART #	R1 INCH	R2 INCH
UNJC											
10-24	5/16-18	0.312	5	3632-10GTWP	"I"	5/16-18	0.37	0.323	3600-190T	7/32	5/32
1/4-20	3/8-16	0.375	5	3632-1/4TWP	"Q"	3/8-16	0.43	0.385	3600-250T	9/32	3/16
5/16-18	7/16-14	0.437	5	3632-5/16TWP	"X"	7/16-14	0.50	0.447	3600-312T	11/32	3/16
3/8-16	1/2-13	0.500	5	3632-3/8TWP	29/64	1/2-13	0.56	0.510	3600-375T	13/32	3/16
7/16-14	9/16-12	0.562	5	3632-7/16TWP	33/64	9/16-12	0.62	0.572	3600-375T	15/32	3/16
1/2-13	5/8-11	0.625	5	3632-1/2TWP	37/64	5/8-11	0.68	0.635	3600-500T	17/32	3/16
UNJF											
10-32	5/16-18	0.312	5	3634-10GTWP	"I"	5/16-18	0.37	0.323	3600-190T	7/32	5/32
1/4-28	3/8-16	0.375	5	3634-1/4TWP	"Q"	3/8-16	0.43	0.385	3600-250T	9/32	3/16
5/16-24	7/16-14	0.437	5	3634-5/16TWP	"X"	7/16-14	0.50	0.447	3600-312T	11/32	3/16
3/8-24	1/2-13	0.500	5	3634-3/8TWP	29/64	1/2-13	0.56	0.510	3600-375T	13/32	3/16
7/16-20	9/16-12	0.562	5	3634-7/16TWP	33/64	9/16-12	0.62	0.572	3600-375T	15/32	3/16
1/2-20	5/8-11	0.625	5	3634-1/2TWP	37/64	5/8-11	0.68	0.635	3600-500T	17/32	3/16

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PACKETS

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METRIC – THIN WALL INSERTS							
INSERT		DRILL		TAP			
		MM	PART #	6H	MM	MM	PART #
METRIC COARSE							
M5 X 0.8	M8 X 1.25	6.90	3620-6.9	M8 X 1.25	9.50	72.00	3620-8.00I
M6 X 1	M10 X 1.25	8.80	3620-8.8	M10 X 1.25	11.50	76.00	3621-10.00I
M8 X 1.25	M12 X 1.25	10.80	3620-10.8	M12 X 1.25	13.50	84.00	3622-12.00I
M10 X 1.5	M14 X 1.5	12.80	3620-12.8	M14 X 1.5	15.50	95.00	3621-14.00I
M12 X 1.75	M16 X 1.5	14.75	3620-14.75*	M16 X 1.5	17.50	102.00	3621-16.00I
METRIC FINE							
M8 X 1	M12 X 1.25	10.80	3620-10.8	M12 X 1.25	13.50	84.00	3622-12.00I
M10 X 1.25	M14 X 1.5	12.80	3620-12.8	M14 X 1.5	15.50	95.00	3621-14.00I
M12 X 1.25	M16 X 1.5	14.75	3620-14.75*	M16 X 1.5	17.50	102.00	3621-16.00I



METRIC – HEAVY DUTY INSERTS							
INSERT		DRILL		TAP			
		MM	PART #	6H	MM	MM	PART #
METRIC COARSE							
M4 X 0.7	M8 X 1.25	6.90	3620-6.9	M8 X 1.25	9.50	72.00	3620-8.00I
M5 X 0.8	M10 X 1.25	8.80	3620-8.8	M10 X 1.25	12.50	76.00	3621-10.00I
M6 X 1	M12 X 1.25	10.80	3620-10.8	M12 X 1.25	14.50	84.00	3622-12.00I
M8 X 1.25	M14 X 1.5	12.80	3620-12.8	M14 X 1.5	16.50	95.00	3621-14.00I
M10 X 1.5	M16 X 1.5	14.75	3620-14.75*	M16 X 1.5	18.50	102.00	3621-16.00I
M12 X 1.75	M18 X 1.5	16.75	3620-16.75*	M18 X 1.5	20.50	104.00	3622-18.00I
M14 X 2	M20 X 1.5	18.75	3620-18.75*	M20 X 1.5	22.50	104.00	3623-20.00I
M16 X 2	M22 X 1.5	20.50	3620-20.50*	M22 X 1.5	24.50	113.00	3621-22.00I
M20 X 2.5	M30 X 2	28.00	3620-28.00*	M30 X 2	34.50	137.00	3621-30.00I
M24 X 3	M33 X 2	31.00	3620-31.00*	M33 X 2	37.50	137.00	3621-33.00I
METRIC FINE							
M8 X 1	M14 X 1.5	12.80	3620-12.8	M14 X 1.5	16.50	84.00	3621-14.00I
M10 X 1.25	M16 X 1.5	14.75	3620-14.75*	M16 X 1.5	18.50	95.00	3621-16.00I
M12 X 1.25	M18 X 1.5	16.75	3620-16.75*	M18 X 1.5	20.50	102.00	3622-18.00I
M14 X 1.5	M20 X 1.5	18.75	3620-18.75*	M20 X 1.5	22.50	104.00	3623-20.00I
M16 X 1.5	M22 X 1.5	20.50	3620-20.50*	M22 X 1.5	24.50	113.00	3621-22.00I
M18 X 1.5	M24 X 1.5	22.50	3620-22.50*	M24 X 1.5	26.50	120.00	3624-24.00I
M20 X 1.5	M30 X 2	28.00	3620-28.00*	M30 X 2	34.50	127.00	3621-30.00I
M22 X 1.5	M32 X 2	30.00	3620-30.00*	M32 X 2	36.50	137.00	3622-32.00I
M24 X 2	M33 X 2	31.00	3620-31.00*	M33 X 2	37.50	137.00	3621-33.00I

* Supplied as Reduced Shank HSS 118° notched point drill.

** Supplied as Morse Taper Shank (MTS) HSS 118° notched point drill.





UN – THIN WALL INSERTS							
INSERT		DRILL		TAP			
		INCH	PART #	2B	INCH	MM	PART #
UNJC	UNC						
10-24	5/16-18	"I"	3632-I	5/16-18	0.37	72.00	3632-5/16I
1/4-20	3/8-16	"Q"	3632-Q	3/8-16	0.43	80.00	3632-3/8I
5/16-18	7/16-14	"X"	3632-X	7/16-14	0.50	85.00	3632-7/16I
3/8-16	1/2-13	29/64	3632-29/64	1/2-13	0.56	89.00	3632-1/2I
7/16-14	9/16-12	33/64	3632-33/64*	9/16-12	0.62	95.00	3632-9/16I
1/2-13	5/8-11	37/64	3632-37/64*	5/8-11	0.68	102.00	3632-5/8I
UNJF	UNC						
10-32	5/16-18	"I"	3632-I	5/16-18	0.37	72.00	3632-5/16I
1/4-28	3/8-16	"Q"	3632-Q	3/8-16	0.43	80.00	3632-3/8I
5/16-24	7/16-14	"X"	3632-X	7/16-14	0.50	85.00	3632-7/16I
3/8-24	1/2-13	29/64	3632-29/64	1/2-13	0.56	89.00	3632-1/2I
7/16-20	9/16-12	33/64	3632-33/64*	9/16-12	0.62	95.00	3632-9/16I
1/2-20	5/8-11	37/64	3632-37/64*	5/8-11	0.68	102.00	3632-5/8I



UN – HEAVY DUTY INSERTS							
INSERT		DRILL		TAP			
		INCH	PART #	2B	INCH	MM	PART #
UNJC	UNC						
8-32	5/16-18	"I"	3632-I	5/16-18	0.37	72.00	3632-5/16I
10-24	3/8-16	"Q"	3632-Q	3/8-16	0.37	80.00	3632-3/8I
1/4-20	7/16-14	"X"	3632-X	7/16-14	0.43	85.00	3632-7/16I
5/16-18	1/2-13	29/64	3632-29/64	1/2-13	0.50	89.00	3632-1/2I
3/8-16	9/16-12	33/64	3632-33/64*	9/16-12	0.56	95.00	3632-9/16I
7/16-14	5/8-11	37/64	3632-37/64*	5/8-11	0.68	102.00	3632-5/8I
1/2-13	11/16-11NS	41/64	3632-41/64*	11/16-11NS	0.75	112.00	3632-11/16I
1/2-13	3/4-16	45/64	3632-45/64*	3/4-16	0.68	104.00	3632-3/4I
9/16-12	3/4-16	45/64	3632-45/64*	3/4-16	0.94	104.00	3632-3/4I
9/16-12	13/16-16	49/64	3632-49/64*	13/16-16	0.94	118.00	3632-13/16I
5/8-11	7/8-14	53/64	3632-53/64*	7/8-14	1.00	113.00	3632-7/8I
3/4-10	1-1/8-12	1-1/16	3632-1.1/16*	1-1/8-12	1.31	127.00	3632-1.1/8I
7/8-9	1-1/4-12	1-3/16	3632-1.3/16*	1-1/4-12	1.44	137.00	3632-1.1/4I
1-8	1-3/8-12	1-5/16	3632-1.5/16**	1-3/8-12	1.56	144.00	3632-1.3/8I
1-1/8-7	1-1/2-12	1-7/16	3632-1.7/16**	1-1/2-12	1.84	149.00	3632-1.1/2I
1-1/4-7	1-5/8-12	1-9/16	3632-1.9/16**	1-5/8-12	2.06	170.00	3632-1.5/8I
1-1/2-6	1-7/8-12	1-13/16	3632-1.13/16**	1-7/8-12	2.28	186.00	3632-1.7/8I
UNJF	UNC						
10-32	3/8-16	"Q"	3632-Q	3/8-16	0.37	80.00	3632-3/8I
1/4-28	7/16-14	"X"	3632-X	7/16-14	0.43	85.00	3632-7/16I
5/16-24	1/2-13	29/64	3632-29/64	1/2-13	0.50	89.00	3632-1/2I
3/8-24	9/16-12	33/64	3632-33/64*	9/16-12	0.56	95.00	3632-9/16I
7/16-20	5/8-11	37/64	3632-37/64*	5/8-11	0.68	102.00	3632-5/8I
1/2-20	11/16-11NS	41/64	3632-41/64*	11/16-11NS	0.75	112.00	3632-11/16I
1/2-20	3/4-16	45/64	3632-45/64*	3/4-16	0.68	104.00	3632-3/4I
9/16-18	3/4-16	45/64	3632-45/64*	3/4-16	0.94	104.00	3632-3/4I
9/16-18	13/16-16	49/64	3632-49/64*	13/16-16	0.94	118.00	3632-13/16I
5/8-18	7/8-14	53/64	3632-53/64*	7/8-14	1.00	113.00	3632-7/8I
3/4-16	1-1/8-12	1-1/16	3632-1.1/16*	1-1/8-12	1.31	127.00	3632-1.1/8I
7/8-14	1-1/4-12	1-3/16	3632-1.3/16*	1-1/4-12	1.44	137.00	3632-1.1/4I
1-12	1-3/8-12	1-5/16	3632-1.5/16**	1-3/8-12	1.56	144.00	3632-1.3/8I
1-14	1-3/8-12	1-5/16	3632-1.7/16**	1-3/8-12	1.56	144.00	3632-1.3/8I
1-1/8-12	1-1/2-12	1-7/16	3632-1.9/16**	1-1/2-12	1.84	149.00	3632-1.1/2I
1-1/4-12	1-5/8-12	1-9/16	3632-1.13/16**	1-5/8-12	2.06	170.00	3632-1.5/8I
1-1/2-12	1-7/8 X12	1-13/16	3632-1.13/16**	1-7/8 X12	2.28	186.00	3632-1.7/8I



THIN WALL INSTALLATION TOOLS

		PART #	PART #
METRIC COARSE			
M5 X 0.8	M8 X 1.25	3600-5.00TT	3600-190T
M6 X 1	M10 X 1.25	3600-6.00TT	3600-250T
M8 X 1.25	M12 X 1.25	3600-8.00TT	3600-312T
M10 X 1.5	M14 X 1.5	3600-10.00TT	3600-375T
M12 X 1.75	M16 X 1.5	3600-12.00TT	3600-500T
METRIC FINE			
M8 X 1	M12 X 1.25	3600-8.00TT	3600-312T
M10 X 1.25	M14 X 1.5	3600-10.00TT	3600-375T
M12 X 1.25	M16 X 1.5	3600-12.00TT	3600-500T

		PART #	PART #
UNJC		UNC	
10-24	5/16-18	3600-10GTT	3600-190T
1/4-20	3/8-16	3600-1/4TT	3600-250T
5/16-18	7/16-14	3600-5/16TT	3600-312T
3/8-16	1/2-13	3600-3/8TT	3600-375T
7/16-14	9/16-12	3600-7/16TT	3600-375T
1/2-13	5/8-11	3600-1/2TT	3600-500T
UNJF		UNC	
10-32	5/16-18	3600-10GTT	3600-190T
1/4-28	3/8-16	3600-1/4TT	3600-250T
5/16-24	7/16-14	3600-5/16TT	3600-312T
3/8-24	1/2-13	3600-3/8TT	3600-375T
7/16-20	9/16-12	3600-7/16TT	3600-375T
1/2-20	5/8-11	3600-1/2TT	3600-500T

HEAVY DUTY INSTALLATION TOOLS

		PART #	PART #
METRIC COARSE			
M4 X 0.7	M8 X 1.25	3600-4.00HT	-
M5 X 0.8	M10 X 1.25	3600-5.00HT	3600-190T
M6 X 1	M12 X 1.25	3600-6.00HT	3600-250T
M8 X 1.25	M14 X 1.5	3600-8.00HT	3600-312T
M10 X 1.5	M16 X 1.5	3600-10.00HT	3600-375T
M12 X 1.75	M18 X 1.5	3600-12.00HT	3600-500T
M14 X 2	M20 X 1.5	3600-14.00HT	-
M16 X 2	M22 X 1.5	3600-16.00HT	3600-625T
M20 X 2.5	M30 X 2	3600-20.00HT	3600-875T
M24 X 3	M33 X 2	3600-24.00HT	-
METRIC FINE			
M8 X 1	M14 X 1.5	3600-8.00HT	3600-312T
M10 X 1.25	M16 X 1.5	3600-10.00HT	3600-375T
M12 X 1.25	M18 X 1.5	3600-12.00HT	3600-500T
M14 X 1.5	M20 X 1.5	3600-14.00HT	-
M16 X 1.5	M22 X 1.5	3600-16.00HT	3600-625T
M18 X 1.5	M24 X 1.5	3600-18.00HT	-
M20 X 1.5	M30 X 2	3600-20.00HT	3600-875T
M22 X 1.5	M32 X 2	3600-22.00HT	-
M24 X 2	M33 X 2	3600-24.00HT	-

		PART #	PART #
UNJC		UNC	
8-32	5/16-18	3600-8GHT	-
10-24	3/8-16	3600-10GHT	3600-190T
1/4-20	7/16-14	3600-1/4HT	3600-250T
5/16-18	1/2-13	3600-5/16HT	3600-312T
3/8-16	9/16-12	3600-3/8HT	3600-375T
7/16-14	5/8-11	3600-7/16HT	3600-375T
1/2-13	11/16-11NS	3600-1/2HT	3600-500T
1/2-13	3/4-16	3600-1/2HT-3/4	3600-500T
9/16-12	3/4-16	3600-9/16HT-3/4	3600-500T
9/16-12	13/16-16	3600-9/16HT	-
5/8-11	7/8-14	3600-5/8HT	3600-625T
3/4-10	1-1/8-12	3600-3/4HT	3600-875T
7/8-9	1-1/4-12	3600-7/8HT	3600-875T
1-8	1-3/8-12	3600-1HT	3600-100T
1-1/8-7	1-1/2-12	3600-1.1/8HT	-
1-1/4-7	1-5/8-12	3600-1.1/4HT	-
1-1/2-6	1-7/8-12	3600-1.1/2HT	-
UNJF		UNC	
10-32	3/8-16	3600-10GHT	3600-190T
1/4-28	7/16-14	3600-1/4HT	3600-250T
5/16-24	1/2-13	3600-5/16HT	3600-312T
3/8-24	9/16-12	3600-3/8HT	3600-375T
7/16-20	5/8-11	3600-7/16HT	3600-375T
1/2-20	11/16-11NS	3600-1/2HT	3600-500T
1/2-20	3/4-16	3600-1/2HT-3/4	3600-500T
9/16-18	3/4-16	3600-9/16HT-3/4	3600-500T
9/16-18	13/16-16	3600-9/16HT	-
5/8-18	7/8-14	3600-5/8HT	3600-625T
3/4-16	1-1/8-12	3600-3/4HT	3600-875T
7/8-14	1-1/4-12	3600-7/8HT	3600-875T
1-12	1-3/8-12	3600-1HT	3600-100T
1-14	1-3/8-12	3600-1HT	3600-100T
1-1/8-12	1-1/2-12	3600-1.1/8HT	-
1-1/4-12	1-5/8-12	3600-1.1/4HT	-
1-1/2-12	1-7/8-12	3600-1.1/2HT	-



CARBON STEEL C1215	THIN WALL
ACCIAIO AL CARBONIO C1215	THIN WALL
ACIER CARBONE C1215	PAROIE FINE
KOHLENSTOFFSTAHL	DÜNNWANDIG
ACERO AL CARBONO C1215	BLISTERS DE INSERTOS PARED DELGADA

MERCHANDISER

DESCRIPTION	PART #
LOKSERT HANG SELL MERCHANDISER	3600-D1


THIN WALL INSERTS

QTY	DESCRIPTION	PART #
2	M6 x 1	3620-6.00TWP
2	M8 x 1,25	3620-8.00TWP
1	M10 x 1,5	3620-10.00TWP
1	M12 x 1,75	3620-12.00TWP
1	1/4-20	3632-1/4TWP
1	1/4-28	3634-1/4TWP
1	5/16-18	3632-5/16TWP
1	3/8-16	3632-3/8TWP
1	3/8-24	3634-3/8TWP
1	1/2-13	3632-1/2TWP


DRILLS – HSS

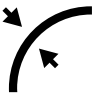
QTY	DESCRIPTION	PART #
1	HSS DRILL 8.8mm	3620-8.8
1	HSS DRILL 10.8mm	3620-10.8
1	HSS DRILL 12.8mm	3620-12.8
1	HSS DRILL 14.75mm	3620-14.75
1	HSS DRILL Q(8.43/0.332)	3632-Q
1	HSS DRILL X(10.0/0.397)	3632-X
1	HSS DRILL 29/64	3632-29/64
1	HSS DRILL 37/64	3632-37/64

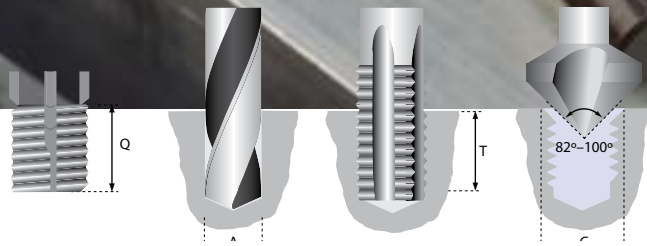

TAPS – INTERMEDIATE

QTY	DESCRIPTION	PART #
1	M10 x 1,25	3621-10.00I
1	M12 x 1,25	3622-12.00I
1	M14 x 1,5	3621-14.00I
1	M16 x 1,5	3621-16.00I
1	3/8-16	3632-3/8I
1	7/16-14	3632-7/16I
1	1/2-13	3632-1/2I
1	5/8-11	3632-5/8I


INSTALLATION TOOLS

QTY	DESCRIPTION	PART #
1	UNIVERSAL TOOL	3600-250T
1	UNIVERSAL TOOL	3600-312T
1	UNIVERSAL TOOL	3600-375T
1	UNIVERSAL TOOL	3600-500T





THIN WALL & HEAVY DUTY LOKSERTS

Insert Material

Carbon Steel - C1215 or equivalent
Stainless Steel - 303 or equivalent

Keys

302 CRES or equivalent

Finish

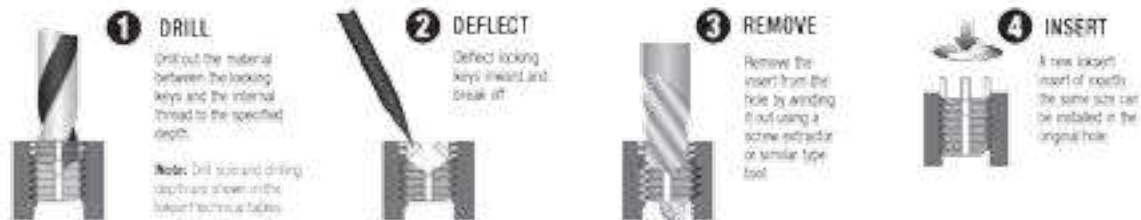
Carbon Steel
Black
Manganese Phosphate;
Stainless Steel - Passivated

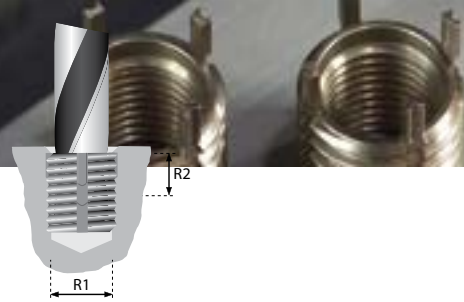
Tolerances

±0.010 inch or ±0.25mm unless specified otherwise

	INSERT SPECIFICATIONS			Internal Thread Class 6G	DRILL, TAP & COUNTERSINK SPECIFICATIONS				Internal Thread Class 6G	REMOVAL SPECIFICATIONS	
	External Thread Class 6G	Q Nominal Length	Installation Tool		A Drill Size	Tap Size Class 6H	T Minimum Tapping Depth	C Min. Width Countersink		R1 Drill Size	R2 Minimum Drilling Depth
	mm	mm	Part #		mm	mm	mm	mm		mm	mm
THIN WALL				THIN WALL					THIN WALL		
M5 X 0.8	M8 X 1.25	8.0	3600-190T	M5 X 0.8	6.90	M8 X 1.25	9.50	8.25	M5 X 0.8	5.50	4.00
M6 X 1.0	M10 X 1.25	10.0	3600-250T	M6 X 1.0	8.80	M10 x 1.25	11.50	10.25	M6 X 1.0	7.50	4.75
M8 X 1.25	M12 x 1.25	12.0	3600-312T	M8 X 1.25	10.80	M12 x 1.25	13.50	12.25	M8 X 1.25	9.50	4.75
M8 X 1.0	M12 x 1.25	12.0	3600-312T	M8 X 1.0	10.80	M12 x 1.25	13.50	12.25	M8 X 1.0	9.50	4.75
M10 X 1.5	M14 x 1.5	14.0	3600-375T	M10 X 1.5	12.80	M14 x 1.5	15.50	14.25	M10 X 1.5	11.50	4.75
M10 X 1.25	M14 x 1.5	14.0	3600-375T	M10 X 1.25	12.80	M14 x 1.5	15.50	14.25	M10 X 1.25	11.50	4.75
M12 X 1.75	M16 x 1.5	16.0	3600-500T	M12 X 1.75	14.75	M16 x 1.5	17.50	16.25	M12 X 1.75	13.50	4.75
M12 X 1.25	M16 x 1.5	16.0	3600-500T	M12 X 1.25	14.75	M16 x 1.5	17.50	16.25	M12 X 1.25	13.50	4.75
HEAVY DUTY				HEAVY DUTY					HEAVY DUTY		
M4 X 0.7	M8 X 1.25	8.0	3600-4.00HT	M4 X 0.7	6.90	M8 X 1.25	9.50	8.25	M4 X 0.7	5.50	4.00
M5 X 0.8	M10 X 1.25	10.0	3600-190T	M5 X 0.8	8.80	M10 x 1.25	12.50	10.25	M5 X 0.8	7.50	4.75
M6 X 1.0	M12 x 1.25	12.0	3600-250T	M6 X 1.0	10.80	M12 x 1.25	14.50	12.25	M6 X 1.0	9.50	4.75
M8 X 1.25	M14 x 1.5	14.0	3600-312T	M8 X 1.25	12.80	M14 x 1.5	16.50	14.25	M8 X 1.25	11.50	4.75
M8 X 1.0	M14 x 1.5	14.0	3600-312T	M8 X 1.0	12.80	M14 x 1.5	16.50	14.25	M8 X 1.0	11.50	4.75
M10 X 1.5	M16 x 1.5	16.0	3600-375T	M10 X 1.5	14.75	M16 x 1.5	18.50	16.25	M10 X 1.5	13.50	4.75
M10 X 1.25	M16 x 1.5	16.0	3600-375T	M10 X 1.25	14.75	M16 x 1.5	18.50	16.25	M10 X 1.25	13.50	4.75
M12 X 1.75	M18 X 1.5	18.0	3600-500T	M12 X 1.75	16.75	M18 X 1.5	20.50	18.25	M12 X 1.75	15.50	4.75
M12 X 1.25	M18 X 1.5	18.0	3600-500T	M12 X 1.25	16.75	M18 X 1.5	20.50	18.25	M12 X 1.25	15.50	4.75
M14 X 2.0	M20 X 1.5	20.0	3600-14.00HT	M14 X 2.0	18.75	M20 X 1.5	22.50	20.25	M14 X 2.0	17.50	4.75
M14 X 1.5	M20 X 1.5	20.0	3600-14.00HT	M14 X 1.5	18.75	M20 X 1.5	22.50	20.25	M14 X 1.5	17.50	4.75
M16 X 2.0	M22 X 1.5	22.0	3600-625T	M16 X 2.0	20.50	M22 X 1.5	24.50	22.25	M16 X 2.0	17.75	6.35
M16 X 1.5	M22 X 1.5	22.0	3600-625T	M16 X 1.5	20.50	M22 X 1.5	24.50	22.25	M16 X 1.5	17.75	6.35
M18 X 1.5	M24 X 1.5	24.0	3600-18.00HT	M18 X 1.5	22.50	M24 X 1.5	26.50	24.25	M18 X 1.5	19.75	6.35
M20 X 2.5	M30 X 2.0	30.0	3600-875T	M20 X 2.5	28.00	M30 X 2.0	34.50	30.25	M20 X 2.5	25.75	6.35
M20 X 1.5	M30 X 2.0	30.0	3600-875T	M20 X 1.5	28.00	M30 X 2.0	34.50	30.25	M20 X 1.5	25.75	6.35
M22 X 1.5	M32 X 2.0	32.0	3600-22.00HT	M22 X 1.5	30.00	M32 X 2.0	36.50	32.25	M22 X 1.5	27.75	6.35
M24 X 3.0	M33 X 2.0	33.0	3600-24.00HT	M24 X 3.0	31.00	M33 X 2.0	37.50	33.25	M24 X 3.0	28.75	6.35
M24 X 2.0	M33 X 2.0	33.0	3600-24.00HT	M24 X 2.0	31.00	M33 X 2.0	37.50	33.25	M24 X 2.0	28.75	6.35

LOKSERT REMOVAL





Internal Thread Class 2B	INSERT SPECIFICATIONS			Internal Thread Class 2B	DRILL, TAP & COUNTERSINK SPECIFICATIONS				Internal Thread Class 2B	REMOVAL SPECIFICATIONS	
	External Thread Mod Class 2A	Q Nominal Length	Installation Tool		A Drill Size	Tap Size Class 2B	T Minimum Tapping Depth	C Min. Width Countersink		R1 Drill Size	R2 Minimum Drilling Depth
inch	inch	inch	Part #	inch	inch	inch	inch	inch	inch	inch	inch
THIN WALL				THIN WALL				THIN WALL			
10G X 24	5/16 X 18	0.31	3600-190T	10G X 24	"I"	5/16 X 18	0.37	0.32	10G X 24	7/32	1/8
10G X 32	5/16 X 18	0.31	3600-190T	10G X 32	"I"	5/16 X 18	0.37	0.32	10G X 32	7/32	1/8
1/4 X 20	3/8 X 16	0.37	3600-250T	1/4 X 20	"Q"	3/8 X 16	0.43	0.38	1/4 X 20	9/32	3/16
1/4 X 28	3/8 X 16	0.37	3600-250T	1/4 X 28	"Q"	3/8 X 16	0.43	0.38	1/4 X 28	9/32	3/16
5/16 X 18	7/16 X 14	0.43	3600-312T	5/16 X 18	"X"	7/16 X 14	0.50	0.44	5/16 X 18	11/32	3/16
5/16 X 24	7/16 X 14	0.43	3600-312T	5/16 X 24	"X"	7/16 X 14	0.50	0.44	5/16 X 24	11/32	3/16
3/8 X 16	1/2 X 13	0.50	3600-375T	3/8 X 16	29/64	1/2 X 13	0.56	0.51	3/8 X 16	13/32	3/16
3/8 X 24	1/2 X 13	0.50	3600-375T	3/8 X 24	29/64	1/2 X 13	0.56	0.51	3/8 X 24	13/32	3/16
7/16 X 14	9/16 X 12	0.56	3600-375T	7/16 X 14	33/64	9/16 X 12	0.62	0.57	7/16 X 14	15/32	3/16
7/16 X 20	9/16 X 12	0.56	3600-375T	7/16 X 20	33/64	9/16 X 12	0.62	0.57	7/16 X 20	15/32	3/16
1/2 X 13	5/8 X 11	0.62	3600-500T	1/2 X 13	37/64	5/8 X 11	0.68	0.63	1/2 X 13	17/32	3/16
1/2 X 20	5/8 X 11	0.62	3600-500T	1/2 X 20	37/64	5/8 X 11	0.68	0.63	1/2 X 20	17/32	3/16
HEAVY DUTY				HEAVY DUTY				HEAVY DUTY			
8G X 32	5/16 X 18	0.31	3600-8GHT	8G X 32	"I"	5/16 X 18	0.37	0.32	8G X 32	7/32	1/8
10G X 24	3/8 X 16	0.31	3600-190T	10G X 24	"Q"	3/8 X 16	0.37	0.38	10G X 24	9/32	1/8
10G X 32	3/8 X 16	0.31	3600-190T	10G X 32	"Q"	3/8 X 16	0.37	0.38	10G X 32	9/32	1/8
1/4 X 20	7/16 X 14	0.37	3600-250T	1/4 X 20	"X"	7/16 X 14	0.43	0.44	1/4 X 20	11/32	3/16
1/4 X 28	7/16 X 14	0.37	3600-250T	1/4 X 28	"X"	7/16 X 14	0.43	0.44	1/4 X 28	11/32	3/16
5/16 X 18	1/2 X 13	0.43	3600-312T	5/16 X 18	29/64	1/2 X 13	0.50	0.51	5/16 X 18	13/32	3/16
5/16 X 24	1/2 X 13	0.43	3600-312T	5/16 X 24	29/64	1/2 X 13	0.50	0.51	5/16 X 24	13/32	3/16
3/8 X 16	9/16 X 12	0.50	3600-375T	3/8 X 16	33/64	9/16 X 12	0.56	0.57	3/8 X 16	15/32	3/16
3/8 X 24	9/16 X 12	0.50	3600-375T	3/8 X 24	33/64	9/16 X 12	0.56	0.57	3/8 X 24	15/32	3/16
7/16 X 14	5/8 X 11	0.62	3600-375T	7/16 X 14	37/64	5/8 X 11	0.68	0.63	7/16 X 14	17/32	3/16
7/16 X 20	5/8 X 11	0.62	3600-375T	7/16 X 20	37/64	5/8 X 11	0.68	0.63	7/16 X 20	17/32	3/16
1/2 X 13	3/4 X 16	0.62	3600-500T	1/2 X 13	45/64	3/4 X 16	0.68	0.76	1/2 X 13	21/32	3/16
1/2 X 20	3/4 X 16	0.62	3600-500T	1/2 X 20	45/64	3/4 X 16	0.68	0.76	1/2 X 20	21/32	3/16
9/16 X 12	3/4 X 16	0.81	3600-500T	9/16 X 12	45/64	3/4 X 16	0.94	0.76	9/16 X 12	21/32	3/16
9/16 X 18	3/4 X 16	0.81	3600-500T	9/16 X 18	45/64	3/4 X 16	0.94	0.76	9/16 X 18	21/32	3/16
5/8 X 11	7/8 X 14	0.87	3600-625T	5/8 X 11	53/64	7/8 X 14	1.00	0.88	5/8 X 11	25/32	5/16
5/8 X 18	7/8 X 14	0.87	3600-625T	5/8 X 18	53/64	7/8 X 14	1.00	0.88	5/8 X 18	25/32	5/16
3/4 X 10	1-1/8 X 12	1.12	3600-875T	3/4 X 10	1-1/16	1-1/8 X 12	1.31	1.14	3/4 X 10	31/32	5/16
3/4 X 16	1-1/8 X 12	1.12	3600-875T	3/4 X 16	1-1/16	1-1/8 X 12	1.31	1.14	3/4 X 16	31/32	5/16
7/8 X 9	1-1/4 X 12	1.25	3600-875T	7/8 X 9	1-3/16	1-1/4 X 12	1.44	1.27	7/8 X 9	1-3/32	5/16
7/8 X 14	1-1/4 X 12	1.25	3600-875T	7/8 X 14	1-3/16	1-1/4 X 12	1.44	1.27	7/8 X 14	1-3/32	5/16
1 X 8	1-3/8 X 12	1.37	3600-100T	1 X 8	1-5/16	1-3/8 X 12	1.56	1.39	1 X 8	1-7/32	5/16
1 X 12	1-3/8 X 12	1.37	3600-100T	1 X 12	1-5/16	1-3/8 X 12	1.56	1.39	1 X 12	1-7/32	5/16
1 X 14	1-3/8 X 12	1.37	3600-100T	1 X 14	1-5/16	1-3/8 X 12	1.56	1.39	1 X 14	1-7/32	5/16
1-1/8 X 7	1-1/2 X 12	1.62	3600-1.1/8HT	1-1/8 X 7	1-7/16	1-1/2 X 12	1.84	1.52	1-1/8 X 7	1-11/32	5/16
1-1/8 X 12	1-1/2 X 12	1.62	3600-1.1/8HT	1-1/8 X 12	1-7/16	1-1/2 X 12	1.84	1.52	1-1/8 X 12	1-11/32	5/16
1-1/4 X 7	1-5/8 X 12	1.81	3600-1.1/4HT	1-1/4 X 7	1-9/16	1-5/8 X 12	2.06	1.64	1-1/4 X 7	1-15/32	5/16
1-1/4 X 12	1-5/8 X 12	1.81	3600-1.1/4HT	1-1/4 X 12	1-9/16	1-5/8 X 12	2.06	1.64	1-1/4 X 12	1-15/32	5/16
1-1/2 X 6	1-7/8 X 12	2.00	3600-1.1/2HT	1-1/2 X 6	1-13/16	1-7/8 X 12	2.28	1.89	1-1/2 X 6	1-23/32	5/16
1-1/2 X 12	1-7/8 X 12	2.00	3600-1.1/2HT	1-1/2 X 12	1-13/16	1-7/8 X 12	2.28	1.89	1-1/2 X 12	1-23/32	5/16

THIN WALL & HEAVY DUTY LOKSERTS

Keys

Inserts with internal thread of 5/16" (M7) or larger have 4 locking keys. Smaller sizes have 2 keys.

Tap Drill Hole

0.234 - 0.500 = +0.004 / -0.001

Tolerance Inch

over 0.500 = +0.005 / -0.001

Tap Drill Hole

6.90 - 10.80 = +0.100 / -0.025

Tolerance Metric

over 12.80 = +0.130 / -0.025

loksert®



Part No. 9910-LOKCAT0217



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