

# Loksert<sup>®</sup>

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Loksert solid keylocking inserts are used to repair damaged or worn out threads or to create new threads in original equipment.

Loksert keylocking one piece inserts are available in carbon steel and stainless steel in both metric and inch sizes.

The Loksert solid keylocking insert utilizes locking keys which provide a positive mechanical lock into the threads of the surrounding base material. The resulting thread is resistant to rotation due to vibration and torsion. Loksert solid keylocking inserts require no special drills or taps.



### solid keylocking insert system features & benefits

- Solid, one-piece insert provides a high degree of pull-out strength.
- Keys provide a positive mechanical lock preventing rotation.
- Simple installation and removal.
- Installed using standard drills and taps.
- No prewinder or expensive installation tools required.
- No tang to break off.
- Available in carbon steel and stainless steel.
- Suitable for use in a wide variety of materials.
- Also available in MS/NAS Standards.

### solid keylocking insert system installation instructions



#### 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.

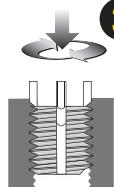


#### 2 TAP

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

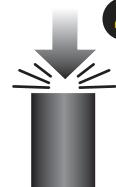


**Note:** Use of a suitable lubricant is essential during all tapping procedures.



#### 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.



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# THE LOKSERT® RANGE & PART NUMBERS

SIZE ID	THINWALL / LIGHTWEIGHT SERIES				THICK WALL / HEAVY DUTY SERIES				Universal Tool (No XHD)	EXTRA HEAVY DUTY SERIES			
	OD	CARBON STEEL P/N	STAINLESS STEEL P/N	INSTALL TOOL	OD	CARBON STEEL P/N	STAINLESS STEEL P/N	INSTALL TOOL		OD	CARBON STEEL P/N	STAINLESS STEEL P/N	
<b>UNC</b>													
6-32	-	-	-	-	-	-	-	-	-	-	5/16-18	3632-6GXHD	3732-6GXHD
8-32	-	-	-	-	5/16-18	3632-8GHD	3732-8GHD	3600-8GHT	-	-	3/8-16	3632-8GXHD	3732-8GXHD
10-24	5/16-18	3632-10GTW	M551830-105	3600-10GTT	3/8-16	3632-10GHD	M551831-101	3600-10GHT	3600-190T	7/16-14	3632-10GXHD	3732-10GXHD	
1/4-20	3/8-16	3632-1/4TW	M551830-106	3600-1/4TT	7/16-14	3632-1/4HD	M551831-102	3600-1/4HT	3600-250T	1/2-13	3632-1/4XHD	3732-1/4XHD	
5/16-18	7/16-14	3632-5/16TW	M551830-107	3600-5/16TT	1/2-13	3632-5/16HD	M551831-103	3600-5/16HT	3600-312T	9/16-12	3632-5/16XHD	3732-5/16XHD	
3/8-16	1/2-13	3632-3/8TW	M551830-108	3600-3/8TT	9/16-12	3632-3/8HD	M551831-104	3600-3/8HT	3600-375T	5/8-11	3632-3/8XHD	3732-3/8XHD	
7/16-14	9/16-12	3632-7/16TW	M551830-109	3600-7/16TT	5/8-11	3632-7/16HD	M551831-105	3600-7/16HT	3600-375T	3/4-16	3632-7/16XHD	3732-7/16XHD	
1/2-13	5/8-11	3632-1/2TW	M551830-110	3600-1/2TT	3/4-16	3632-1/2HD	3732-1/2HD	3600-1/2HT	3600-500T	7/8-14	3632-1/2XHD	3732-1/2XHD	
9/16-12	-	-	-	-	3/4-16	3632-9/16HD	M551831-107	-	3600-500T	7/8-14	3632-9/16XHD	3732-9/16XHD	
5/8-11	-	-	-	-	7/8-14	3632-5/8HD	M551831-108	-	3600-625T	1-12	3632-5/8XHD	3732-5/8XHD	
3/4-10	-	-	-	-	1.1/8-12	3632-3/4HD	M551831-109	-	3600-875T	1.1/4-12	3632-3/4XHD	3732-3/4XHD	
7/8-9	-	-	-	-	1.1/4-12	3632-7/8HD	M551831-110	-	3600-875T	1.3/8-12	3632-7/8XHD	3732-7/8XHD	
1-8	-	-	-	-	1.3/8-12	3632-1HD	M551831-111	-	3600-100T	1.1/2-12	3632-1XHD	3732-1XHD	
1 1/8-7	-	-	-	-	1.1/2-12	3632-1.1/8HD	-	3600-1.1/8HT	-	-	-	-	
1 1/4-7	-	-	-	-	1.5/8-12	3632-1.1/4HD	-	3600-1.1/4HT	-	-	-	-	
1 1/2-6	-	-	-	-	1.7/8-12	3632-1.1/2HD	-	3600-1.1/2HT	-	-	-	-	
<b>UNF</b>													
10-32	5/16-18	3634-10GTW	M551830-201	3600-10GTT	3/8-16	3634-10GHD	M551831-201	3600-10GHT	3600-190T	7/16-20	3634-10GXHD	3734-10GXHD	
1/4-28	3/8-16	3634-1/4TW	M551830-202	3600-1/4TT	7/16-14	3634-1/4HD	M551831-202	3600-1/4HT	3600-250T	1/2-20	3634-1/4XHD	3734-1/4XHD	
5/16-24	7/16-14	3634-5/16TW	M551830-203	3600-5/16TT	1/2-13	3634-5/16HD	M551831-203	3600-5/16HT	3600-312T	9/16-18	3634-5/16XHD	3734-5/16XHD	
3/8-24	1/2-13	3634-3/8TW	M551830-204	3600-3/8TT	9/16-12	3634-3/8HD	M551831-204	3600-3/8HT	3600-375T	5/8-18	3634-3/8XHD	3734-3/8XHD	
7/16-20	9/16-12	3634-7/16TW	M551830-205	3600-7/16TT	5/8-11	3634-7/16HD	M551831-205	3600-7/16HT	3600-375T	3/4-16	3634-7/16XHD	3734-7/16XHD	
1/2-20	5/8-11	3634-1/2TW	M551830-206	3600-1/2TT	3/4-16	3634-1/2HD	3732-1/2HD	3600-1/2HT	3600-500T	7/8-14	3634-1/2XHD	3734-1/2XHD	
9/16-18	-	-	-	-	3/4-16	3634-9/16HD	M551831-207	-	3600-500T	7/8-14	3634-9/16XHD	3734-9/16XHD	
5/8-18	-	-	-	-	7/8-14	3634-5/8HD	M551831-208	-	3600-625T	1-12	3634-5/8XHD	3734-5/8XHD	
3/4-16	-	-	-	-	1.1/8-12	3634-3/4HD	M551831-209	-	3600-875T	1.1/4-12	3634-3/4XHD	3734-3/4XHD	
7/8-14	-	-	-	-	1.1/4-12	3634-7/8HD	M551831-210	-	3600-875T	1.3/8-12	3634-7/8XHD	3734-7/8XHD	
1-12	-	-	-	-	1.3/8-12	3634-1HD	M551831-211	-	3600-100T	1.1/2-12	3634-1XHD	3734-1XHD	
1-14	-	-	-	-	1.3/8-12	3635-1HD	-	-	-	-	-	-	
1 1/8-12	-	-	-	-	1.1/2-12	3534-1.1/8HD	-	3600-1.1/8HT	-	-	-	-	
1 1/4-12	-	-	-	-	1.5/8-12	3534-1.1/4HD	-	3600-1.1/4HT	-	-	-	-	
1 1/2-12	-	-	-	-	1.7/8-12	3634-1.1/2HD	-	3600-1.1/2HT	-	-	-	-	
<b>METRIC</b>													
M4-.7	-	-	-	-	M8-1.25	3620-5.00TW	3720-5.00TW	3600-5.00TT	-	<b>VARIOUS KITS, WITH INSTALLATION TOOLS INCLUDED AVAILABLE IN BOTH CARBON AND STAINLESS STEEL</b>			
M5-.8	M8-1.25	3620-5.00TW	3720-5.00TW	3600-5.00TT	M10-1.25	3620-6.00TW	3720-6.00TW	3600-6.00TT	3600-190T				
M6-1.0	M10-1.25	3620-6.00TW	3720-6.00TW	3600-6.00TT	M12-1.25	3620-8.00TW	3720-8.00TW	3600-8.00TT	3600-250T	<b>EXTRA HEAVY DUTY INSERT STYLES ARE GENERALLY NOT STOCK ITEMS. PLEASE CHECK FOR AVAILABILITY. SOLID STYLE INSERTS ARE AVAILABLE UPON REQUEST.</b>			
M8-1.25	M12-1.25	3620-8.00TW	3720-8.00TW	3600-8.00TT	M14-1.5	3621-8.00TW	3721-8.00TW	3600-8.00TT	3600-312T				
M8-1.0	M12-1.25	3621-8.00TW	3721-8.00TW	3600-8.00TT	M16-1.5	3620-10.00TW	3720-10.00TW	3600-10.00TT	3600-312T	<b>INSERTS ALSO AVAILABLE TO THE FOLLOWING MILITARY STANDARDS IN BOTH NON-LOCKING &amp; SELF-LOCKING STYLES:</b>			
M10-1.5	M14-1.5	3620-10.00TW	3720-10.00TW	3600-10.00TT	M16-1.5	3621-10.00TW	3721-10.00TW	3600-10.00TT	3600-375T				
M10-1.25	M14-1.5	3621-10.00TW	3721-10.00TW	3600-10.00TT	M18-1.5	3620-12.00TW	3720-12.00TW	3600-12.00TT	3600-500T	- M551830			
M12-1.75	M16-1.5	3620-12.00TW	3720-12.00TW	3600-12.00TT	M18-1.5	3621-12.00TW	3721-12.00TW	3600-12.00TT	3600-500T	- M551831			
M12-1.25	M16-1.5	3621-12.00TW	3721-12.00TW	3600-12.00TT	M20-1.5	3620-14.00HD	3620-14.00HD	3600-14.00HT	3600-500T	- NAS1394			
M14-2.0	-	-	-	-	M20-1.5	3621-14.00HD	3721-14.00HD	3600-14.00HT	-	- NAS1395			
M14-1.5	-	-	-	-	M22-1.5	3520-16.00HD	3520-16.00HD	-	-				
M16-2.0	-	-	-	-	M22-1.5	3521-16.00HD	3521-16.00HD	-	3600-625T				
M16-1.5	-	-	-	-	M24-1.5	3621-18.00HD	3721-18.00HD	3600-18.00HT	3600-625T				
M18-1.5	-	-	-	-	M30-2.0	3620-20.00HD	3620-20.00HD	-	-				
M20-2.5	-	-	-	-	M30-2.0	3621-20.00HD	3721-20.00HD	-	3600-875T				
M20-1.5	-	-	-	-	M32-2.0	3621-22.00HD	3721-22.00HD	-	3600-875T				
M22-1.5	-	-	-	-	M33-2.0	3620-24.00HD	3620-24.00HD	3600-24.00HT	3600-875T				
M24-3.0	-	-	-	-	M33-2.0	3621-24.00HD	3721-24.00HD	3600-24.00HT	-				
M24-2.0	-	-	-	-					-				
M24-1.5	-	-	-	-					-				
M30-2.0	-	-	-	-					-				
M32-2.0	-	-	-	-					-				
M33-2.0	-	-	-	-					-				



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