

KEYSERT



THREAD REPAIR INSERTS



KEYSERT®

Thread Repair Inserts

The Solid Alternative for Thread Repair

Keyserts are solid, one-piece, key-locking inserts used to repair damaged threads or for use in original equipment. The Keysert locking keys provide a positive mechanical lock which prevents rotation due to vibration or torsion. Keyserts are available in carbon or stainless steel, both in inch and metric series. Thinwall, Heavy Duty, Extra Heavy Duty, and Solid insert styles are available separately or in repair kits containing a range of sizes. Installation tools are also available separately.



Features

- Installed with standard drills and taps
- Easy installation
- May be used in virtually any material; aluminum, magnesium, cast iron, cold rolled steel, and plastic.
- Easy to remove

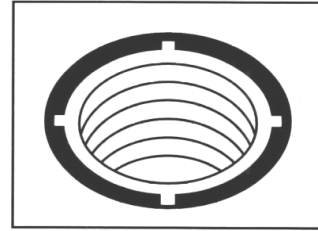
Typical Applications

- Trucks
- Machinery
- RV's
- Small Engine
- Molds
- Tool and Die

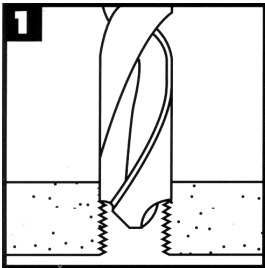
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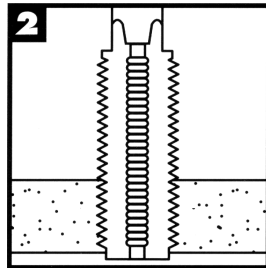
Installation and Removal



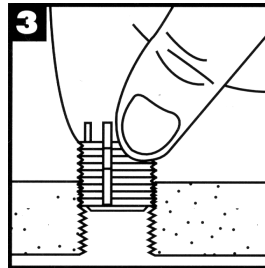
Installation



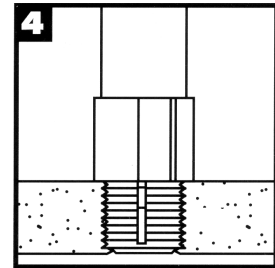
Drill out old threads with a standard drill.
Note: Drill is oversize - see charts for proper dimensions. Chamfer the hole with a standard countersink (82°-100°).



Tap new threads with a standard tap. See slightly below surface charts for proper size and depth.

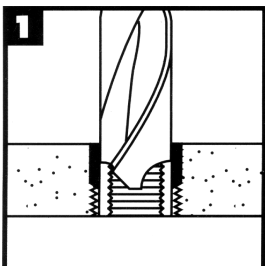


Screw in the insert until flush with surface.

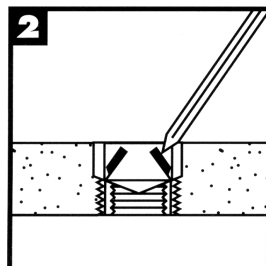


Drive keys down with several hammer taps on the proper installation tool.

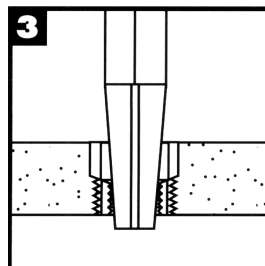
Removal



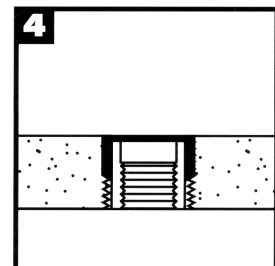
Drill out material between keys and internal thread with standard drill to specified depth (refer to charts for proper dimensions).



Deflect keys inward and break off.



Remove insert using a Drill-Out, E-Z Out, or similar type tool.



Same size replacement insert may be installed in the original hole.

Carbon Steel Bulk Keyserts

Thinwall - Inch Series - Carbon Steel

INSERT					INSTALLATION			REMOVAL			
Insert Part No.	Alternate Part No.	Internal Thread Class 2B	External Thread (Mod.) Class 2A	Length	Installation Tool Part No.	Tap Drill Size	C'Sink Diameter +.010/-.000	Thread Tap		Drill	
								Size Class 2B	Min. Depth	Size	Depth
*73601	RKKA 10-24	10-24	5/16-18	0.31	70601	I	0.32	5/16-18	0.37	7/32	1/8
*74601	RKKA 10-32	10-32									
*73041	RKKA 1/4-20	1/4-20	3/8-16	0.37	70041	Q	0.38	3/8-16	0.43	9/32	3/16
*74041	RKKA 1/4-28	1/4-28									
*73051	RKKA 5/16-18	5/16-18	7/16-14	0.43	70051	X	0.44	7/16-14	0.50	11/32	3/16
*74051	RKKA 5/16-24	5/16-24									
*73061	RKKA 3/8-16	3/8-16	1/2-13	0.50	70061	29/64	0.51	1/2-13	0.56	13/32	3/16
*74061	RKKA 3/8-24	3/8-24									
*73071	RKKA 7/16-14	7/16-14	9/16-12	0.56	70071	33/64	0.57	9/16-12	0.62	15/32	3/16
*74071	RKKA 7/16-20	7/16-20									
*73081	RKKA 1/2-13	1/2-13	5/8-11	0.62	70081	37/64	0.63	5/8-11	0.68	17/32	3/16
*74081	RKKA 1/2-20	1/2-20									

Heavy Duty - Inch Series - Carbon Steel

INSERT					INSTALLATION			REMOVAL			
Insert Part No.	Alternate Part No.	Internal Thread Class 2B	External Thread (Mod.) Class 2A	Length	Installation Tool Part No.	Tap Drill Size	C'Sink Diameter +.010/-.000	Thread Tap		Drill	
								Size Class 2B	Min. Depth	Size	Depth
*73582		8-32	5/16-18	0.31	70582	I	0.32	5/16-18	0.37	7/32	1/8
*73602	RKK 10-24	10-24	3/8-16	0.31	70602	Q	0.38	3/8-16	0.37	9/32	1/8
*74602	RKK 10-32	10-32									
*73042	RKK 1/4-20	1/4-20	7/16-14	0.37	70042	X	0.44	7/16-14	0.43	11/32	3/16
*74042	RKK 1/4-28	1/4-28									
*73052	RKK 5/16-18	5/16-18	1/2-13	0.43	70052	29/64	0.51	1/2-13	0.50	13/32	3/16
*74052	RKK 5/16-24	5/16-24									
*73062	RKK 3/8-16	3/8-16	9/16-12	0.50	70062	33/64	0.57	9/16-12	0.56	15/32	3/16
*74062	RKK 3/8-24	3/8-24									
*73072	RKK 7/16-14	7/16-14	5/8-11	0.62	70072	37/64	0.63	5/8-11	0.68	17/32	3/16
*74072	RKK 7/16-20	7/16-20									
*73082	RKK 1/2-13	1/2-13	3/4-16	0.62	70082	45/64	0.76	3/4-16	0.68	21/32	3/16
*74082	RKK 1/2-20	1/2-20									
*73092	RKK 9/16-12	9/16-12	3/4-16	0.81	70092	45/64	0.76	3/4-16	0.94	21/32	3/16
*74092	RKK 9/16-18	9/16-18									
*73102	RKK 5/8-11	5/8-11	7/8-14	0.87	70102	53/64	0.88	7/8-14	1.00	25/32	5/16
*74102	RKK 5/8-18	5/8-18									
*73122	RKK 3/4-10	3/4-10	1 1/8-12	1.12	70122	1 1/16	1.14	1 1/8-12	1.31	31/32	5/16
*74122	RKK 3/4-16	3/4-16									
*73142		7/8-9	1 1/4-12	1.25	70142	1 3/16	1.27	1 1/4-12	1.44	1 3/32	5/16
*74142		7/8-14									
*73162	RKK 1-8	1-8	1 3/8-12	1.37	70162	1 5/16	1.39	1 3/8-12	1.56	1 7/32	5/16
*74162	RKK 1-12	1-12									
74162-14		1-14									
*73182		1 1/8-7	1 1/2-12	1.62	70182	1 7/16	1.52	1 1/2-12	1.84	1 11/32	5/16
*74182		1 1/8-12									
*73202		1 1/4-7	1 5/8-12	1.81	70202	1 9/16	1.64	1 5/8-12	2.06	1 15/32	5/16
*74202		1 1/4-12									
*73242		1 1/2-6	1 7/8-12	2.00	70242	1 13/16	1.89	1 7/8-12	2.28	1 23/32	5/16
*74242		1 1/2-12									

* INDICATES PARTS NORMALLY AVAILABLE FROM STOCK.
LEAD TIMES AND MINIMUMS MAY APPLY ON ALL OTHER SIZES.

Carbon Steel Bulk Keyserts

Technical Notes :

Material: Inserts - C1215 or equivalent
Keys - 302 Stainless Steel
Finish: Carbon Steel Inserts - Zinc Phosphate and
Ferrocate 364-3 Oil
Stainless Steel Inserts - Passivated
Tolerances: ±0.10 inch or ±.25 mm unless
specified otherwise.
Dimensions: Inch sizes are in inches.
Metric sizes are in millimeters.
Keys: Inserts with internal thread size 5/16 or M7
and larger are furnished with 4 locking keys.



Thinwall - Metric - Carbon Steel

INSERT					INSTALLATION			REMOVAL			
Insert Part No.	Alternate Part No.	Internal Thread Class 6H	External Thread Class 6g	Length	Installation Tool Part No.	Tap Drill Size	C'Sink Diameter +.25/- .00	Thread Tap		Drill	
								Size Class 6H	Min. Depth	Size	Depth
*75051	KNM 5X0.8F	M5-.8	M8-1.25	8.0	71051	6.9	8.25	M8-1.25	9.5	5.50	4.00
*75061	KNM 6X1F	M6-1	M10-1.25	10.0	71061	8.8	10.25	M10-1.25	11.5	7.50	4.75
*75081	KNM 8X1.25F	M8-1.25	M12-1.25	12.0	71081	10.8	12.25	M12-1.25	13.5	9.50	4.75
*77081		M8-1									
*75101	KNM 10X1.5F	M10-1.5	M14-1.5	14.0	71101	12.8	14.25	M14-1.5	15.5	11.50	4.75
*77101		M10-1.25									
*75121	KNM 12X1.75F	M12-1.75	M16-1.5	16.0	71121	14.75	16.25	M16-1.5	17.5	13.50	4.75
*78121		M12-1.25									

Heavy Duty - Metric - Carbon Steel

INSERT				INSTALLATION			REMOVAL			
Insert Part No.	Internal Thread Class 6H	External Thread Class 6g	Length	Installation Tool Part No.	Tap Drill Size	C'Sink Diameter +.25/- .00	Thread Tap		Drill	
							Size Class 6H	Min. Depth	Size	Depth
75042	M4-.7	M8-1.25	8.0	71042	6.90	8.25	M8-1.25	9.5	5.50	4.00
75052	M5-.8	M10-1.25	10.0	71052	8.80	10.25	M10-1.25	12.5	7.50	4.75
75062	M6-1	M12-1.25	12.0	71062	10.80	12.25	M12-1.25	14.5	9.50	4.75
75082	M8-1.25	M14-1.5	14.0	71082	12.80	14.25	M14-1.5	16.5	11.50	4.75
77082	M8-1									
75102	M10-1.5	M16-1.5	16.0	71102	14.75	16.25	M16-1.5	18.5	13.50	4.75
77102	M10-1.25									
75122	M12-1.75	M18-1.5	18.0	71122	16.75	18.25	M18-1.5	20.5	15.50	4.75
78122	M12-1.25									
*75142	M14-2	M20-1.5	20.0	71142	18.75	20.25	M20-1.5	22.5	17.50	4.75
*77142	M14-1.5									
*75162	M16-2	M22-1.5	22.0	71162	20.50	22.25	M22-1.5	24.5	17.75	6.35
*77162	M16-1.5									
*78182	M18-1.5	M24-1.5	24.0	71182	22.50	24.25	M24-1.5	26.5	19.75	6.35
*75202	M20-2.5	M30-2	30.0	71202	28.00	30.25	M30-2	34.5	25.75	6.35
*78202	M20-1.5									
*78222	M22-1.5	M32-2	32.0	71222	30.00	32.25	M32-2	36.5	27.75	6.35
75242	M24-3	M33-2	33.0	71242	31.00	33.25	M33-2	37.5	28.75	6.35
*77242	M24-2									

* INDICATES PARTS NORMALLY AVAILABLE FROM STOCK.
LEAD TIMES AND MINIMUMS MAY APPLY ON ALL OTHER SIZES.

Carbon Steel Bulk Keyserts

Solid threaded inserts are perfect for:

- relocating holes that have been drilled or tapped in the wrong place
- plugging holes or filling in holes that are too big

Technical Notes:

Material: Inserts - C1215 or equivalent
Keys - 302 Stainless Steel
Finish: Carbon Steel Inserts - Zinc Phosphate and Ferrocote 364-3 Oil
Stainless Steel Inserts - Passivated
Tolerances: ±0.10 inch or ±.25 mm unless specified otherwise.
Dimensions: Inch sizes are in inches.
Metric sizes are in millimeters.
Keys: Inserts with internal thread size 5/16 or M7 and larger are furnished with 4 locking keys.



Solid - Inch Series - Carbon Steel

INSTALLATION						REMOVAL			
Insert Part No.	External Thread (Mod.) Class 2A	Length	Installation Tool Part No.	Tap Drill Size	C'Sink Diameter +.010/- .000	Thread Tap		Drill	
						Size Class 2B	Min. Depth	Size	Depth
73054	5/16-18	0.31	70054	I	0.32	5/16-18	0.37	7/32	1/8
73064	3/8-16	0.31	70064	Q	0.38	3/8-16	0.37	9/32	1/8
73074	7/16-14	0.37	70074	X	0.44	7/16-14	0.43	11/32	3/16
73084	1/2-13	0.43	70084	29/64	0.51	1/2-13	0.50	13/32	3/16
73094	9/16-12	0.50	70094	33/64	0.57	9/16-12	0.56	15/32	3/16
73104	5/8-11	0.62	70104	37/64	0.63	5/8-11	0.68	17/32	3/16
73124	3/4-16	0.68	70124	45/64	0.76	3/4-16	0.68	21/32	3/16
73144	7/8-14	0.87	70144	53/64	0.88	7/8-14	1.00	25/32	5/16
74164	1-12	0.87	70164	15/16	1.02	1-12	1.00	27/32	5/16
74184	1 1/8-12	1.12	70184	1 1/16	1.14	1 1/8-12	1.31	31/32	5/16
74204	1 1/4-12	1.25	70204	1 3/16	1.27	1 1/4-12	1.44	1 3/32	5/16
74224	1 3/8-12	1.37	70224	1 5/16	1.39	1 3/8-12	1.56	1 7/32	5/16

Solid - Metric - Carbon Steel

INSTALLATION						REMOVAL			
Insert Part No.	External Thread Class 6g	Length	Installation Tool Part No.	Tap Drill Size	C'Sink Diameter +.25/- .00	Thread Tap		Drill	
						Size Class 6H	Min. Depth	Size	Depth
75084	M8-1.25	8.0	71084	6.90	8.25	M8-1.25	9.5	5.50	4.00
77104	M10-1.25	10.0	71104	8.80	10.25	M10-1.25	12.5	7.50	4.75
78124	M12-1.25	12.0	71124	10.80	12.25	M12-1.25	14.5	9.50	4.75
77144	M14-1.5	14.0	71144	12.80	14.25	M14-1.5	16.5	11.50	4.75
77164	M16-1.5	16.0	71164	14.75	16.25	M16-1.5	18.5	13.50	4.75
78184	M18-1.5	18.0	71184	16.75	18.25	M18-1.5	20.5	15.50	4.75
78204	M20-1.5	20.0	71204	18.75	20.25	M20-1.5	22.5	17.50	4.75
78224	M22-1.5	22.0	71224	20.50	22.25	M22-1.5	24.5	17.75	6.35
78244	M24-1.5	24.0	71244	22.50	24.25	M24-1.5	26.5	19.75	6.35
77304	M30-2	30.0	71304	28.00	30.25	M30-2	34.5	25.75	6.35
77322	M32-2	32.0	71322	30.00	32.25	M32-2	36.5	27.75	6.35
77332	M33-2	33.0	71332	31.00	33.25	M33-2	37.5	28.75	6.35

ALL ITEMS ON THIS PAGE ARE CONSIDERED NON-STOCK ITEMS. LEAD TIMES AND MINIMUMS MAY APPLY.

Carbon Steel Bulk Keyserts

Extra Heavy Duty - Inch Series - Carbon Steel

INSERT				INSTALLATION			REMOVAL			
Insert Part No.	Internal Thread Class 2B	External Thread (Mod.) Class 2A	Length	Installation Tool Part No.	Tap Drill Size	C'Sink Diameter +.010/-.000	Thread Tap		Drill	
							Size Class 2B	Min. Depth	Size	Depth
73563	6-32	5/16-18	0.31	70563	I	0.32	5/16-18	0.37	7/32	1/8
73583	8-32	3/8-16	0.31	70583	Q	0.38	3/8-16	0.37	9/32	1/8
73603	10-24	7/16-14	0.31	70603	X	0.44	7/16-14	0.37	11/32	3/16
74603	10-32									
73043	1/4-20	1/2-13	0.37	70043	29/64	0.51	1/2-13	0.43	13/32	3/16
74043	1/4-28									
73053	5/16-18	9/16-12	0.43	70053	33/64	0.57	9/16-12	0.50	15/32	3/16
74053	5/16-24									
73063	3/8-16	5/8-11	0.50	70063	37/64	0.63	5/8-11	0.56	17/32	3/16
74063	3/8-24									
73073	7/16-14	3/4-16	0.62	70073	45/64	0.76	3/4-16	0.68	21/32	3/16
74073	7/16-20									
73083	1/2-13	7/8-14	0.68	70083	53/64	0.88	7/8-14	0.75	25/32	5/16
74083	1/2-20									
73093	9/16-12	7/8-14	0.81	70093	53/64	0.88	7/8-14	0.94	25/32	5/16
74093	9/16-18									
73103	5/8-11	1-12	0.87	70103	15/16	1.02	1-12	1.00	27/32	5/16
74103	5/8-18									
73123	3/4-10	1 1/4-12	1.12	70123	1 3/16	1.27	1 1/4-12	1.31	1 3/32	5/16
74123	3/4-16									
73143	7/8-9	1 3/8-12	1.25	70143	1 5/16	1.39	1 3/8-12	1.44	1 7/32	5/16
74143	7/8-14									
73163	1-8	1 1/2-12	1.37	70163	1 7/16	1.52	1 1/2-12	1.56	1 11/32	5/16
74163	1-12									

ALL ITEMS ON THIS PAGE ARE CONSIDERED NON-STOCK ITEMS. LEAD TIMES AND MINIMUMS MAY APPLY.

Carbon Steel Cross-Reference Index

Keysert Part No.	Alternate Part No.	Keysert Part No.	Alternate Part No.	Keysert Part No.	Alternate Part No.
73041	RKKA 1/4-20	73601	RKKA 10-24	74202	RKK 1 1/4-12
73042	RKK 1/4-20	73602	RKK 10-24	74242	RKK 1 1/2-12
73051	RKKA 5/16-18	74041	RKKA 1/4-28	74601	RKKA 10-32
73052	RKK 5/16-18	74042	RKK 1/4-28	74602	RKK 10-32
73061	RKKA 3/8-16	74051	RKKA 5/16-24	75051	KNM 5x0.8F
73062	RKK 3/8-16	74052	RKK 5/16-24	75061	KNM 6x1F
73071	RKKA 7/16-14	74061	RKKA 3/8-24	75081	KNM 8x1.25F
73072	RKK 7/16-14	74062	RKK 3/8-24	75101	KNM 10x1.5F
73081	RKKA 1/2-13	74071	RKKA 7/16-20	75121	KNM 12x1.75F
73082	RKK 1/2-13	74072	RKK 7/16-20	77081	KNM 8x1F
73092	RKK 9/16-12	74081	RKKA 1/2-20	77101	KNM 10x1.25F
73102	RKK 5/8-11	74082	RKK 1/2-20	78121	KNM 12x1.25F
73122	RKK 3/4-10	74092	RKK 9/16-18	75142	KNHM 14x2F
73142	RKK 7/8-9	74102	RKK 5/8-18	77142	KNHM 14x1.5F
73162	RKK 1-8	74122	RKK 3/4-16	77162	KNHM 16x1.5F
73182	RKK 1 1/8-7	74142	RKK 7/8-14	78182	KNHM 18x1.5F
73202	RKK 1 1/4-7	74162-14	RKK 1-14	78202	KNHM 20x1.5F
73242	RKK 1 1/2-6	74162	RKK 1-12	78222	KNHM 22x1.5F
73582	RKK 8-32	74182	RKK 1 1/8-12	77242	KNHM 24x2F

Stainless Steel Bulk Keyserts

Thinwall - Inch Series - Stainless Steel

INSERT				INSTALLATION			REMOVAL			
Insert Part No.	Internal Thread Class 2B or 3B	External Thread (Mod) Class 2A	Length	Installation Tool Part No.	Tap Drill Size	C'Sink Diameter +.010/-.000	Thread Tap		Drill	
							Size Class 2B	Min. Depth	Size	Depth
*73606	10-24	5/16-18	0.31	70601	I	0.32	5/16-18	0.37	7/32	1/8
*74606	10-32									
*73046	1/4-20	3/8-16	0.37	70041	Q	0.38	3/8-16	0.43	9/32	3/16
*74046	1/4-28									
*73056	5/16-18	7/16-14	0.43	70051	X	0.44	7/16-14	0.50	11/32	3/16
*74056	5/16-24									
*73066	3/8-16	1/2-13	0.50	70061	29/64	0.51	1/2-13	0.56	13/32	3/16
*74066	3/8-24									
*73076	7/16-14	9/16-12	0.56	70071	33/64	0.57	9/16-12	0.62	15/32	3/16
74076	7/16-20									
*73086	1/2-13	5/8-11	0.62	70081	37/64	0.63	5/8-11	0.68	17/32	3/16
*74086	1/2-20									

Heavy Duty - Inch Series - Stainless Steel

INSERT				INSTALLATION			REMOVAL			
Insert Part No.	Internal Thread Class 2B or 3B	External Thread (Mod) Class 2A	Length	Installation Tool Part No.	Tap Drill Size	C'Sink Diameter +.010/-.000	Thread Tap		Drill	
							Size Class 2B	Min. Depth	Size	Depth
*73587	8-32	5/16-18	0.31	70582	I	0.32	5/16-18	0.37	7/32	1/8
*73607	10-24	3/8-16	0.31	70602	Q	0.38	3/8-16	0.37	9/32	1/8
*74607	10-32									
*73047	1/4-20	7/16-14	0.37	70042	X	0.44	7/16-14	0.43	11/32	3/16
*74047	1/4-28									
*73057	5/16-18	1/2-13	0.43	70052	29/64	0.51	1/2-13	0.50	13/32	3/16
*74057	5/16-24									
*73067	3/8-16	9/16-12	0.50	70062	33/64	0.57	9/16-12	0.56	15/32	3/16
*74067	3/8-24									
*73077	7/16-14	5/8-11	0.62	70072	37/64	0.63	5/8-11	0.68	17/32	3/16
74077	7/16-20									
*73087NONMS	1/2-13	3/4-16	0.62	70082	45/64	0.76	3/4-16	0.68	21/32	3/16
*74087NONMS	1/2-20									
73097	9/16-12	3/4-16	0.81	70092	45/64	0.76	3/4-16	0.94	21/32	3/16
74097	9/16-18									
73107	5/8-11	7/8-14	0.87	70102	53/64	0.88	7/8-14	1.00	25/32	5/16
74107	5/8-18									
73127	3/4-10	1 1/8-12	1.12	70122	1 1/16	1.14	1 1/8-12	1.31	31/32	5/16
74127	3/4-16									
73147	7/8-9	1 1/4-12	1.25	70142	1 3/16	1.27	1 1/4-12	1.44	1 3/32	5/16
74147	7/8-14									
73167	1-8	1 3/8-12	1.37	70162	1 5/16	1.39	1 3/8-12	1.56	1 7/32	5/16
74167	1-12									

* INDICATES PARTS NORMALLY AVAILABLE FROM STOCK AND INTERNAL THREAD CLASS 3B.
LEAD TIMES AND MINIMUMS MAY APPLY ON ALL OTHER SIZES.

Stainless Steel Bulk Keyserts

Technical Notes :

Material: Inserts - 303 Stainless Steel
Keys - 302 Stainless Steel
Finish: Carbon Steel Inserts - Zinc Phosphate and
Ferrocote 364-3 Oil
Stainless Steel Inserts - Passivated
Tolerances: ±0.10 inch or ±.25 mm unless
specified otherwise.
Dimensions: Inch sizes are in inches.
Metric sizes are in millimeters.
Keys: Inserts with internal thread size 5/16 or M7
and larger are furnished with 4 locking keys.



Thinwall - Metric - Stainless Steel

INSERT				INSTALLATION				REMOVAL		
Insert Part No.	Internal Thread Class 6H	External Thread Class 6g	Length	Installation Tool Part No.	Tap Drill Size	C'Sink Diameter +.25/- .00	Thread Tap		Drill	
							Size Class 6H	Min. Depth	Size	Depth
*75056	M5-.8	M8-1.25	8.0	71051	6.9	8.25	M8-1.25	9.5	5.50	4.00
*75066	M6-1	M10-1.25	10.0	71061	8.8	10.25	M10-1.25	11.5	7.50	4.75
*75086	M8-1.25	M12-1.25	12.0	71081	10.8	12.25	M12-1.25	13.5	9.50	4.75
77086	M8-1									
*75106	M10-1.5	M14-1.5	14.0	71101	12.8	14.25	M14-1.5	15.5	11.50	4.75
77106	M10-1.25									
*75126	M12-1.75	M16-1.5	16.0	71121	14.75	16.25	M16-1.5	17.5	13.50	4.75
78126	M12-1.25									

Heavy Duty - Metric - Stainless Steel

INSERT				INSTALLATION				REMOVAL		
Insert Part No.	Internal Thread Class 6H	External Thread Class 6g	Length	Installation Tool Part No.	Tap Drill Size	C'Sink Diameter +.25/- .00	Thread Tap		Drill	
							Size Class 6H	Min. Depth	Size	Depth
75047	M4-.7	M8-1.25	8.0	71042	6.90	8.25	M8-1.25	9.5	5.50	4.00
75057	M5-.8	M10-1.25	10.0	71052	8.80	10.25	M10-1.25	12.5	7.50	4.75
75067	M6-1	M12-1.25	12.0	71062	10.80	12.25	M12-1.25	14.5	9.50	4.75
75087	M8-1.25	M14-1.5	14.0	71082	12.80	14.25	M14-1.5	16.5	11.50	4.75
77087	M8-1									
75107	M10-1.5	M16-1.5	16.0	71102	14.75	16.25	M16-1.5	18.5	13.50	4.75
77107	M10-1.25									
75127	M12-1.75	M18-1.5	18.0	71122	16.75	18.25	M18-1.5	20.5	15.50	4.75
78127	M12-1.25									
75147	M14-2	M20-1.5	20.0	71142	18.75	20.25	M20-1.5	22.5	17.50	4.75
77147	M14-1.5									
75167	M16-2	M22-1.5	22.0	71162	20.50	22.25	M22-1.5	24.5	17.75	6.35
77167	M16-1.5									
78187	M18-1.5	M24-1.5	24.0	71182	22.50	24.25	M24-1.5	26.5	19.75	6.35
75207	M20-2.5	M30-2	30.0	71202	28.00	30.25	M30-2	34.5	25.75	6.35
78207	M20-1.5									
78227	M22-1.5	M32-2	32.0	71222	30.00	32.25	M32-2	36.5	27.75	6.35
75247	M24-3	M33-2	33.0	71242	31.00	33.25	M33-2	37.5	28.75	6.35
77247	M24-2									

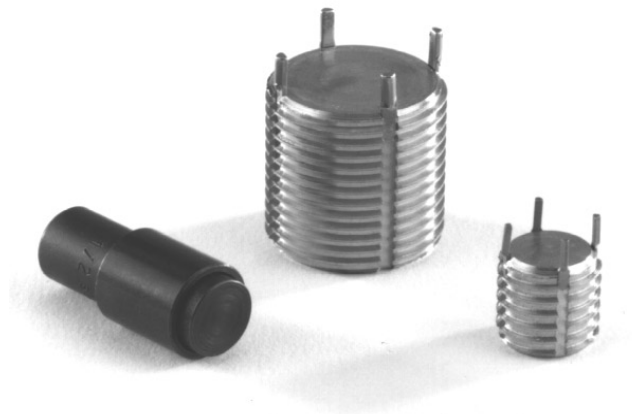
* INDICATES PARTS NORMALLY AVAILABLE FROM STOCK.
LEAD TIMES AND MINIMUMS MAY APPLY ON ALL OTHER SIZES.

Stainless Steel Bulk Keyserts

- Solid threaded inserts are perfect for:
- relocating holes that have been drilled or tapped in the wrong place
 - plugging holes or filling in holes that are too big

Technical Notes :

Material: Inserts - 303 Stainless Steel
Keys - 302 Stainless Steel
Finish: Carbon Steel Inserts - Zinc Phosphate and
Ferrocote 364-3 Oil
Stainless Steel Inserts - Passivated
Tolerances: ±0.10 inch or ±.25 mm unless
specified otherwise.
Dimensions: Inch sizes are in inches.
Metric sizes are in millimeters.
Keys: Inserts with internal thread size 5/16 or M7
and larger are furnished with 4 locking keys.



Solid - Inch Series - Stainless Steel

INSTALLATION						REMOVAL			
Insert Part No.	External Thread (Mod.) Class 2A	Length	Installation Tool Part No.	Tap Drill Size	C'Sink Diameter +.010/- .000	Thread Tap		Drill	
						Size Class 2B	Min. Depth	Size	Depth
73059	5/16-18	0.31	70054	I	0.32	5/16-18	0.37	7/32	1/8
73069	3/8-16	0.31	70064	Q	0.38	3/8-16	0.37	9/32	1/8
73079	7/16-14	0.37	70074	X	0.44	7/16-14	0.43	11/32	3/16
73089	1/2-13	0.43	70084	29/64	0.51	1/2-13	0.50	13/32	3/16
73099	9/16-12	0.50	70094	33/64	0.57	9/16-12	0.56	15/32	3/16
73109	5/8-11	0.62	70104	37/64	0.63	5/8-11	0.68	17/32	3/16
73129	3/4-16	0.68	70124	45/64	0.76	3/4-16	0.68	21/32	3/16
73149	7/8-14	0.87	70144	53/64	0.88	7/8-14	1.00	25/32	5/16
74169	1-12	0.87	70164	15/16	1.02	1-12	1.00	27/32	5/16
74189	1 1/8-12	1.12	70184	1 1/16	1.14	1 1/8-12	1.31	31/32	5/16
74209	1 1/4-12	1.25	70204	1 3/16	1.27	1 1/4-12	1.44	1 3/32	5/16
74229	1 3/8-12	1.37	70224	1 5/16	1.39	1 3/8-12	1.56	1 7/32	5/16

ALL ITEMS ON THIS PAGE ARE CONSIDERED NON-STOCK ITEMS. LEAD TIMES AND MINIMUMS MAY APPLY.

Stainless Steel Bulk Keyserts

Extra Heavy Duty - Inch Series - Stainless Steel

INSERT				INSTALLATION			REMOVAL			
Insert Part No.	Internal Thread Class 2B	External Thread (Mod.) Class 2A	Length	Installation Tool Part No.	Tap Drill Size	C'Sink Diameter +.010/-.000	Thread Tap		Drill	
							Size Class 2B	Min. Depth	Size	Depth
73568	6-32	5/16-18	0.31	70563	I	0.32	5/16-18	0.37	7/32	1/8
73588	8-32	3/8-16	0.31	70583	Q	0.38	3/8-16	0.37	9/32	1/8
73608	10-24	7/16-14	0.31	70603	X	0.44	7/16-14	0.37	11/32	3/16
74608	10-32									
73048	1/4-20	1/2-13	0.37	70043	29/64	0.51	1/2-13	0.43	13/32	3/16
74048	1/4-28									
73058	5/16-18	9/16-12	0.43	70053	33/64	0.57	9/16-12	0.50	15/32	3/16
74058	5/16-24									
73068	3/8-16	5/8-11	0.50	70063	37/64	0.63	5/8-11	0.56	17/32	3/16
74068	3/8-24									
73078	7/16-14	3/4-16	0.62	70073	45/64	0.76	3/4-16	0.68	21/32	3/16
74078	7/16-20									
73088	1/2-13	7/8-14	0.68	70083	53/64	0.88	7/8-14	0.75	25/32	5/16
74088	1/2-20									
73098	9/16-12	7/8-14	0.81	70093	53/64	0.88	7/8-14	0.94	25/32	5/16
74098	9/16-18									
73108	5/8-11	1-12	0.87	70103	15/16	1.02	1-12	1.00	27/32	5/16
74108	5/8-18									
73128	3/4-10	1 1/4-12	1.12	70123	1 3/16	1.27	1 1/4-12	1.31	1 3/32	5/16
74128	3/4-16									
73148	7/8-9	1 3/8-12	1.25	70143	1 5/16	1.39	1 3/8-12	1.44	1 7/32	5/16
74148	7/8-14									
73168	1-8	1 1/2-12	1.37	70163	1 7/16	1.52	1 1/2-12	1.56	1 11/32	5/16
74168	1-12									

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Australia

Recoil Pty (Head Office)

ACN 073 750 428
20 Stamford Road
Oakleigh Vic 3166
Telephone +61 3 9563 1500
Facsimile +61 3 9563 1980
E-mail sales@recoil.com.au
Website <http://www.recoil.com.au>

USA

Recoil USA

1051 Third Avenue SW
Carmel IN 46032
Telephone (317) 846 8830 or (800) 826 2884
Facsimile (317) 846 8858 or (800) 5-RECOIL
E-mail recoilsales@iquest.net

United Kingdom

Recoil (Europe) Ltd

Unit 7, Fallings Park
Industrial Estate, Park Lane
Wolverhampton WV10 9QE
Telephone (01902) 307 800
Facsimile (01902) 307 829
Email postmaster@recoil.demon.co.uk

Belgium

Recoil Marketing BVBA

Langestraat 103
B-9300 Aalst, Belgium
Telephone 32(0) 5377 0102
Facsimile 32(0) 5377 4310
Email recoilbel@pophost.eunet.be

Singapore

Recoil Pte Ltd

Blk 194 Pandan Loop
#07-16, Pantech Industrial Complex
Singapore 128383
Telephone (65) 778 9233
Facsimile (65) 778 0151
Email sales@recoil.com.sg

Thailand

Recoil Co. Ltd

33/260 Mooban Tor Ruam Chok 11
Chok Chai 4, Ladprao 53 Road
Ladprao, Bangkok 10230
Telephone (+662) 539 0693
Facsimile (+662) 539 0638
E-mail recoil@asiaaccess.net.th

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