



Insert Part Number		3732-5/16HDL
Military Specification		-
Reference Number		-
Insert Type		Heavy Duty SELF LOCKING
Internal Thread Form		UNJC
Internal Thread Size		5/16-18
External Thread Size		1/2-13
Nominal Length Q	inch	0.430
Insert Material		Stainless Steel - 303 CRES
Insert Finish		Passivated
Insert Coating		-

Loksert solid keylocking inserts are an easily installed thread assembly that are 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. The pre-positioned keys automatically position the insert at the correct depth below the surface of the parent material. 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.

COMPATIBLE LOKSERT INSTALLATION AND REMOVAL TOOLS	
TOOL TYPE	Part #
Hand Installation tool - Miniature	-
Hand Installation tool - Thin Wall	-
Hand Installation tool - Heavy Duty	3600-5/16HT
Hand Installation tool - Universal (TW & HD)	3600-312T
Hand Installation tool - Extra Heavy Duty	-
Hand Installation tool - Solid	-
Pneumatic Front End Assembly (FEA)	3732-5/16HDMIP
Pneumatic Tool	3700-MIP1

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DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP

A Tapping Drill Size	mm	29/64
A Tapping Drill Size	inch	
Tapping Drill Part Number		3632-29/64



TAPPED HOLE DIMENSIONS

Tap Size		1/2-13
Tap Tolerance		2B
T Tapping Depth minimum	mm	-
T Tapping Depth minimum	inch	0.5
Loksert Tap Part Number	Intermediate	3632-1/2I
C Countersink Width minimum	mm	-
C Countersink Width minimum	inch	0.51



INSERT SPECIFICATIONS

Internal Thread		5/16-18
Internal Thread Tolerance		3B
External Thread		1/2-13
External Thread Tolerance		2A (Mod)
Q Nominal Length	inch	0.430
Locking Keys	#	4



INSERT REMOVAL SPECIFICATIONS

R1 Drill Size	mm	-
R1 Drill Size	inch	13/32
R2 Drill Depth minimum	mm	-
R2 Drill Depth minimum	inch	3/16



For detailed removal instructions please visit powercoil.com.au