



Insert Part Number		3621-12.00HD
Military Specification		-
Reference Number		-
Insert Type		Heavy Duty
Internal Thread Form		Metric Fine
Internal Thread Size		M12 X 1.25
External Thread Size		M18 X 1.5
Nominal Length Q	mm	18.00
Insert Material		Carbon Steel C1215 or Equiv.
Insert Finish		Black manganese or zinc phosphate
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	3600-12.00HT
Hand Installation tool - Universal (TW & HD)	3600-500T
Hand Installation tool - Extra Heavy Duty	-
Hand Installation tool - Solid	-
Pneumatic Front End Assembly (FEA)	-
Pneumatic Tool	-

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DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP

A Tapping Drill Size	mm	16.75
A Tapping Drill Size	inch	-
Tapping Drill Part Number		3620-16.75*



TAPPED HOLE DIMENSIONS

Tap Size		M18 X 1.5
Tap Tolerance		6H
T Tapping Depth minimum	mm	20.50
T Tapping Depth minimum	inch	-
Loksert Tap Part Number	Intermediate	3622-18.00I
C Countersink Width minimum	mm	18.25
C Countersink Width minimum	inch	-



INSERT SPECIFICATIONS

Internal Thread		M12 X 1.25
Internal Thread Tolerance		6H
External Thread		M18 X 1.5
External Thread Tolerance		6g
Q Nominal Length	mm	18.00
Locking Keys	#	4



INSERT REMOVAL SPECIFICATIONS

R1 Drill Size	mm	15.50
R1 Drill Size	inch	-
R2 Drill Depth minimum	mm	4.75
R2 Drill Depth minimum	inch	-



For detailed removal instructions please visit powercoil.com.au