loksert®

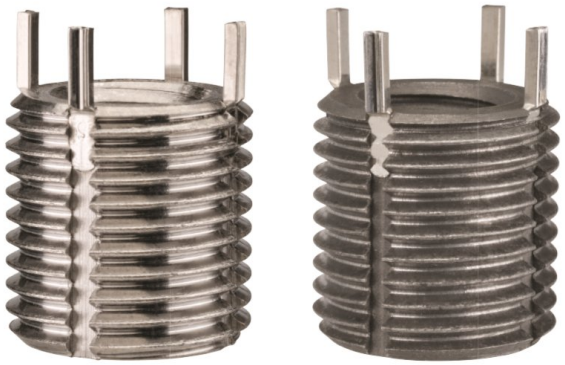
Insert Part Number		3621-22.00HD
Military Specification		-
Reference Number		KNHM 22X1.5F
Insert Type		Heavy Duty
Internal Thread Form		Metric Fine
Internal Thread Size		M22 X 1.5
External Thread Size		M32 X 2
Nominal Length Q	mm	32.00
Insert Material		Carbon Steel C1215 or Equiv.
Insert Finish		Black 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	3600-22.00HT
Hand Installation tool - Universal (TW & HD)	-
Hand Installation tool - Extra Heavy Duty	-
Hand Installation tool - Solid	-
Pneumatic Front End Assembly (FEA)	-
Pneumatic Tool	-

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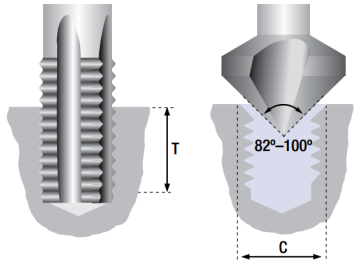


IMPORTANT The success of any drilling and tapping operation is dependant upon many factors -type of material being cut, cutting speed, coolant, equipment being used - and it is not possible to give specific drill sizes for each material. Drill sizes shown are recommendations only and Bordo International would strongly suggest that independent testing be performed for specific and critical applications.

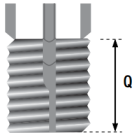
DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP		
A Tapping Drill Size	mm	30.00
A Tapping Drill Size	inch	-
Tapping Drill Part Number		3620-30.00*



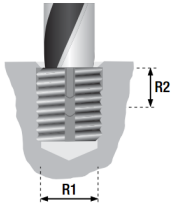
TAPPED HOLE DIMENSIONS		
Tap Size		M32 X 2
Tap Tolerance		6H
T Tapping Depth minimum	mm	36.50
T Tapping Depth minimum	inch	-
Loksert Tap Part Number	Intermediate	3622-32.00I
C Countersink Width minimum	mm	32.25
C Countersink Width minimum	inch	-



INSERT SPECIFICATIONS		
Internal Thread		M22 X 1.5
Internal Thread Tolerance		6H
External Thread		M32 X 2
External Thread Tolerance		6g
Q Nominal Length	mm	32.00
Locking Keys	#	4



INSERT REMOVAL SPECIFICATIONS		
R1 Drill Size	mm	27.75
R1 Drill Size	inch	-
R2 Drill Depth minimum	mm	6.35
R2 Drill Depth minimum	inch	-



For detailed removal instructions please visit powercoil.com.au