loksert®

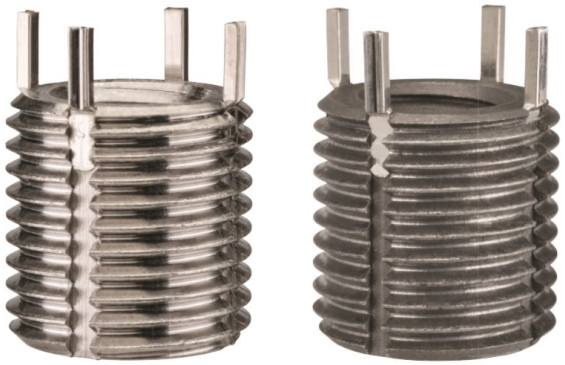
| | | |
|---|---|---|
| **Insert Part Number** | | 3621-24.00HD |
| **Military Specification** | | - |
| **Reference Number** | | KNHM 24X2F |
| **Insert Type** | | Heavy Duty |
| **Internal Thread Form** | | Metric Fine |
| **Internal Thread Size** | | M24 X 2 |
| External Thread Size | | M33 X 2 |
| **Nominal Length Q** | mm | 33.00 |
| **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 | 3600-24.00HT |
| 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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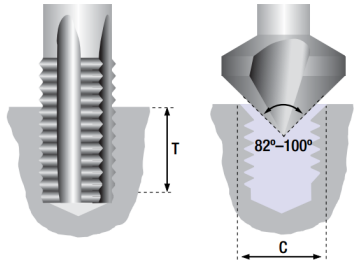


**IMPORTANT** The success of any drilling and tapping operation is dependant upon many factors -type of material being cut, cutting speed, coolant, equipment being used - and it is not possible to give specific drill sizes for each material. Drill sizes shown are recommendations only and Bordo International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

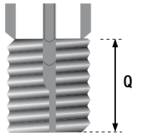
| **DRILLED HOLE DIMENSIONS** INTERMEDIATE/PLUG TAP | | |
|---|---|---|
| A Tapping Drill Size | mm | 31.00 |
| A Tapping Drill Size | inch | - |
| Tapping Drill Part Number | | 3620-31.00* |



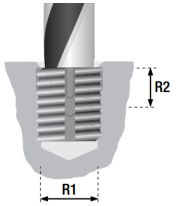

| TAPPED HOLE DIMENSIONS | | |
|---|---|---|
| Tap Size | | M33 X 2 |
| Tap Tolerance | | 6H |
| **T** Tapping Depth minimum | mm | 37.50 |
| **T** Tapping Depth minimum | inch | - |
| Loksert Tap Part Number | Intermediate | 3621-33.00I |
| **C** Countersink Width minimum | mm | 33.25 |
| **C** Countersink Width minimum | inch | - |




| INSERT SPECIFICATIONS | | |
|---|---|---|
| Internal Thread | | M24 X 2 |
| Internal Thread Tolerance | | 6H |
| External Thread | | M33 X 2 |
| External Thread Tolerance | | 6g |
| **Q** Nominal Length | mm | 33.00 |
| Locking Keys | # | 4 |




| INSERT REMOVAL SPECIFICATIONS | | |
|---|---|---|
| R1 Drill Size | mm | 28.75 |
| 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