



Insert Part Number		3634-5/16HD
Military Specification		-
Reference Number		RKK 5/16-24
Insert Type		Heavy Duty
Internal Thread Form		UNJF
Internal Thread Size		5/16-24
External Thread Size		1/2-13
Nominal Length Q	inch	0.437
Insert Material		Carbon Steel C1215 or Equiv.
Insert Finish		Black manganese or zinc phosphate
Insert Coating		-

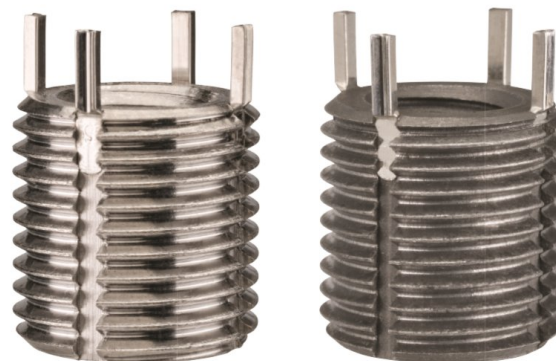
Loksert solid keylocking inserts are an easily installed thread assembly that are ideal for replacing damaged or worn threads in virtually any material - ferrous, non-ferrous and non-metallic.

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	3600-5/16HT
Hand Installation tool - Universal (TW & HD)	3600-312T
Hand Installation tool - Extra Heavy Duty	-
Hand Installation tool - Solid	-
Pneumatic Front End Assembly (FEA)	-
Pneumatic Tool	-

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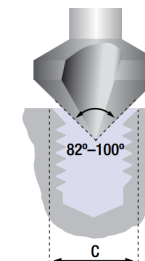
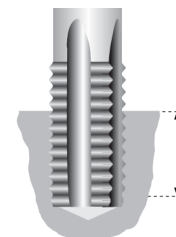
DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP

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



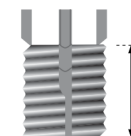
TAPPED HOLE DIMENSIONS

Tap Size		1/2-13
Tap Tolerance		2B
T Tapping Depth minimum	mm	-
T Tapping Depth minimum	inch	0.50
Loksert Tap Part Number	Intermediate	3632-1/2I
C Countersink Width minimum	mm	-
C Countersink Width minimum	inch	0.51



INSERT SPECIFICATIONS

Internal Thread		5/16-24
Internal Thread Tolerance		3B
External Thread		1/2-13
External Thread Tolerance		2A (Mod)
Q Nominal Length	inch	0.437
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