



|                        |    |                                   |
|------------------------|----|-----------------------------------|
| Insert Part Number     |    | 3621-10.00TW                      |
| Military Specification |    | -                                 |
| Reference Number       |    | KNM 10X1.25F                      |
| Insert Type            |    | Thin Wall                         |
| Internal Thread Form   |    | Metric Fine                       |
| Internal Thread Size   |    | M10 X 1.25                        |
| External Thread Size   |    | M14 X 1.5                         |
| Nominal Length Q       | mm | 14.00                             |
| 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                | 3600-10.00TT |
| Hand Installation tool - Heavy Duty               | -            |
| Hand Installation tool - Universal (TW & HD)      | 3600-375T    |
| 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   | 12.80     |
| A Tapping Drill Size      | inch | -         |
| Tapping Drill Part Number |      | 3620-12.8 |



#### TAPPED HOLE DIMENSIONS

|                             |              |             |
|-----------------------------|--------------|-------------|
| Tap Size                    |              | M14 X 1.5   |
| Tap Tolerance               |              | 6H          |
| T Tapping Depth minimum     | mm           | 15.50       |
| T Tapping Depth minimum     | inch         | -           |
| Loksert Tap Part Number     | Intermediate | 3621-14.00I |
| C Countersink Width minimum | mm           | 14.25       |
| C Countersink Width minimum | inch         | -           |



#### INSERT SPECIFICATIONS

|                           |    |            |
|---------------------------|----|------------|
| Internal Thread           |    | M10 X 1.25 |
| Internal Thread Tolerance |    | 6g         |
| External Thread           |    | M14 X 1.5  |
| External Thread Tolerance |    | 6H         |
| Q Nominal Length          | mm | 14.00      |
| Locking Keys              | #  | 4          |



#### INSERT REMOVAL SPECIFICATIONS

|                        |      |       |
|------------------------|------|-------|
| R1 Drill Size          | mm   | 11.50 |
| 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](http://powercoil.com.au)