loksert®

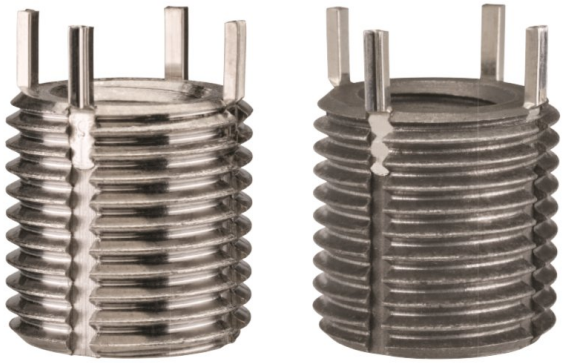
Insert Part Number		3632-1.1/2HD
Military Specification		-
Reference Number		RKK 1 1/2-6
Insert Type		Heavy Duty
Internal Thread Form		UNJC
Internal Thread Size		1.1/2-6
External Thread Size		1.7/8-12
Nominal Length Q	inch	2.000
Insert Material		Carbon Steel C1215 or Equiv.
Insert Finish		Black manganese 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	3600-1.1/2HT
Hand Installation tool - Universal (TW & HD)	-
Hand Installation tool - Extra Heavy Duty	-
Hand Installation tool - Solid	-
Pneumatic Front End Assembly (FEA)	-
Pneumatic Tool	-

powercoil.com.au

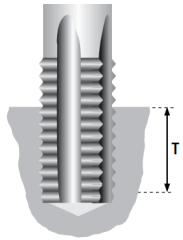
PowerCoil and Loksert are registered trademarks of Bordo International Pty Ltd Australia

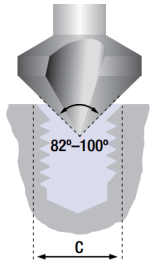


IMPORTANT The success of any drilling and tapping operation is dependant upon many factors -type of material being cut, cutting speed, coolant, equipment being used - and it is not possible to give specific drill sizes for each material. Drill sizes shown are recommendations only and Bordo International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

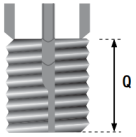
DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP		
A Tapping Drill Size	mm	-
A Tapping Drill Size	inch	1-13/16
Tapping Drill Part Number		3632-1.13/16**

TAPPED HOLE DIMENSIONS		
Tap Size		1-7/8-12
Tap Tolerance		2B
T Tapping Depth minimum	mm	-
T Tapping Depth minimum	inch	2.28
Loksert Tap Part Number	Intermediate	3632-1.7/8I
C Countersink Width minimum	mm	-
C Countersink Width minimum	inch	1.89

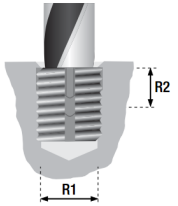




INSERT SPECIFICATIONS		
Internal Thread		1.1/2-6
Internal Thread Tolerance		3B
External Thread		1.7/8-12
External Thread Tolerance		2A (Mod)
Q Nominal Length	inch	2.000
Locking Keys	#	4



INSERT REMOVAL SPECIFICATIONS		
R1 Drill Size	mm	-
R1 Drill Size	inch	1.23/32
R2 Drill Depth minimum	mm	-
R2 Drill Depth minimum	inch	5/16



For detailed removal instructions please visit powercoil.com.au