



## THREADED INSERTS

### Installation Information



1. Drill to allow full tap depth shown in chart.  
**Note:** Tap drill is oversized; see chart below. Countersink as shown in chart.



2. Tap to depth shown in chart.



3. Install Insert 0.010" to 0.030" below surface.



4. Drive keys down with proper installation tool.

### Removal Information



Jergens Keylocking Inserts can be removed without damage to the parent material.

1. Drill the insert to the size and depth shown under removal data in the chart below.
2. Bend the keys down and break them off.
3. Remove the insert using an E-Z out or similar tool.





## THREADED INSERTS

### Installation Information: Inch

Preparation for External Threads - Prior to installation (for Keylocking Inserts only)

Insert		Installation Data			Removal Data	
External Thread Class 2A	Length L (In)	Tap Drill Size	Countersink Diameter +0.010-0.000 (In)	Minimum Tap Depth (In)	Drill Size	Drill Depth (In)
5/16-18	0.31	I	0.323	0.37	7/32	1/8
3/8-16	0.31/0.37	Q	0.385	0.37/0.43	9/32	1/2
7/16-14	0.31/0.37/0.43	X	0.447	0.37/0.43/0.50	11/32	3/16
1/2-13	0.37/0.43/0.50	29/64	0.510	0.44/0.50/0.56	13/32	3/16
9/16-12	0.43/0.50/0.56	33/64	0.572	0.50/0.56/0.62	15/32	3/16
5/8-11	0.50/0.62	37/64	0.635	0.56/0.68	17/32	3/16
3/4-16	0.62/0.81	45/64	0.760	0.68/0.94	21/32	3/16
7/8-14	0.68/0.81/0.87	53/64	0.885	0.75/0.94/1.0	25/32	3/16
1-12	0.87	15/16	1.020	1.0	27/32	5/16
1 1/8-12	1.12	1 1/16	1.145	1.31	31/32	5/16
1 1/4-12	1.12/1.25	1 3/16	1.270	1.31/1.44	1 3/32	5/16
1 3/8-12	1.25/1.37	1.5/16	1.395	1.44/1.56	1 7/32	5/16
1 1/2-12	1.37/1.62	1 7/16	1.520	1.56/1.84	1 11/32	5/16
1 5/8-12	1.81	1 9/16	1.640	2.06	1 15/32	5/16
1 7/8-12	2.00	1 13/16	1.890	2.28	1 23/32	5/16

### Installation Information: Metric

Insert		Installation Data				Removal Data	
External Thread Class 6G	Length L (mm)	Tap Drill Size	Countersink Diameter +0.25-0.000 (mm)	Thread Tap Size Class 6h	Minimum Tap Depth (mm)	Drill Size	Drill Depth (mm)
M8 x 1.25	8.0	6.9	8.25	M8 x 1.25	9.5	5.50	4.00
M10 x 1.25	10.0	8.8	10.25	M10 x 1.25	12.5	7.50	4.75
M12 x 1.25	12.0	10.8	12.25	M12 x 1.25	14.5	9.50	4.75
M14 x 1.5	14.0	12.8	14.25	M14 x 1.5	16.5	11.50	4.75
M16 x 1.5	16.0	14.75	16.25	M16 x 1.5	18.5	13.50	4.75
M18 x 1.5	18.0	16.75	18.25	M18 x 1.5	20.5	15.50	4.75
M20 x 1.5	20.0	18.75	20.25	M20 x 1.5	22.5	17.50	4.75
M22 x 1.5	22.0	20.5	22.25	M22 x 1.5	24.5	17.75	6.35
M24 x 1.5	24.0	22.5	24.25	M24 x 1.5	26.5	19.75	6.35
M30 x 2.0	30.0	28.0	30.25	M30 x 2.0	34.5	25.75	6.35
M32 x 2.0	32.0	30.0	32.25	M32 x 2.0	36.5	27.75	6.35
M33 x 2.0	33.0	31.0	33.25	M33 x 2.0	37.5	28.75	6.35