



Industrial Style - Bulk Packed Keylocking Threaded Inserts

Thinwall - Inch

PART NUMBER*		INSERT			INSTALLATION					REMOVAL	
Carbon Steel	Stainless Steel	Internal Thread Class 2B	External Thread (Mod.) Class 2A	Length	Installation Tool Part No.*	Tap Drill Size	C'Sink Dia. $^{+.010}_{-.000}$	Thread Tap		Drill	
								Size Class 2B	Min. Depth	Size	Depth
65921	66321	10 - 24	5/16 - 18	.31	64721	"I"	.32	5/16 - 18	.37	7/32	1/8
66121	66521	10 - 32									
65922	66322	1/4 - 20	3/8 - 16	.37	64722	"Q"	.38	3/8 - 16	.43	9/32	3/16
66122	66522	1/4 - 28									
65923	66323	5/16 - 18	7/16 - 14	.43	64723	"X"	.44	7/16 - 14	.50	11/32	3/16
66123	66523	5/16 - 24									
65924	66324	3/8 - 16	1/2 - 13	.50	64724	29/64	.51	1/2 - 13	.56	13/32	3/16
66124	66524	3/8 - 24									
65925	66325	7/16 - 14	9/16 - 12	.56	64725	33/64	.57	9/16 - 12	.62	15/32	3/16
66125	66525	7/16 - 20									
65926	66326	1/2 - 13	5/8 - 11	.62	64726	37/64	.63	5/8 - 11	.68	17/32	3/16
66126	66526	1/2 - 20									

* To complete the abbreviated part numbers in the table above use the prefix "215-0"

Heavy Duty - Inch

PART NUMBER*		INSERT			INSTALLATION					REMOVAL	
Carbon Steel	Stainless Steel	Internal Thread Class 2B	External Thread (Mod.) Class 2A	Length	Installation Tool Part No.*	Tap Drill Size	C'Sink Dia. $^{+.010}_{-.000}$	Thread Tap		Drill	
								Size Class 2B	Min. Depth	Size	Depth
65900	66300	8 - 32	5/16 - 18	.31	64700	"I"	.32	5/16 - 18	.37	7/32	1/8
65901	66301	10 - 24									
66101	66501	10 - 32	3/8 - 16	.31	64701	"Q"	.38	3/8 - 16	.37	9/32	1/8
65902	66302	1/4 - 20									
66102	66502	1/4 - 28	7/16 - 14	.37	64702	"X"	.44	7/16 - 14	.43	11/32	3/16
65903	66303	5/16 - 18									
66103	66503	5/16 - 24	1/2 - 13	.43	64703	29/64	.51	1/2 - 13	.50	13/32	3/16
65904	66304	3/8 - 16									
66104	66504	3/8 - 24	9/16 - 12	.50	64704	33/64	.57	9/16 - 12	.56	15/32	3/16
65905	66305	7/16 - 14									
66105	66505	7/16 - 20	5/8 - 11	.62	64705	37/64	.63	5/8 - 11	.68	17/32	3/16
65906	66306	1/2 - 13									
66106	66506	1/2 - 20	3/4 - 16	.62	64706	45/64	.76	3/4 - 16	.68	21/32	3/16
65907	66307	9/16 - 12									
66107	66507	9/16 - 18	3/4 - 16	.81	64707	45/64	.76	3/4 - 16	.94	21/32	3/16
65908	66308	5/8 - 11									
66108	66508	5/8 - 18	7/8 - 14	.87	64708	53/64	.88	7/8 - 14	1.00	25/32	5/16
65909	66309	3/4 - 10									
66109	66509	3/4 - 16	1-1/8 - 12	1.12	64709	1-1/16	1.14	1-1/8 - 12	1.31	31/32	5/16
65910	66310	7/8 - 9									
66110	66510	7/8 - 14	1-1/4 - 12	1.25	64710	1-3/16	1.27	1-1/4 - 12	1.44	1-3/32	5/16
65911	66311	1" - 8									
66111	66511	1" - 12	1-3/8 - 12	1.37	64711	1-5/16	1.39	1-3/8 - 12	1.56	1-7/32	5/16
66112	—	1" - 14									
65913	—	1-1/8 - 7	1-1/2 - 12	1.62	64713	1-7/16	1.52	1-1/2 - 12	1.84	1-11/32	5/16
66113	—	1-1/8 - 12									
65914	—	1-1/4 - 7	1-5/8 - 12	1.81	64714	1-9/16	1.64	1-5/8 - 12	2.06	1-15/32	5/16
66114	—	1-1/4 - 12									
65916	—	1-1/2 - 6	1-7/8 - 12	2.00	64716	1-13/16	1.89	1-7/8 - 12	2.28	1-23/32	5/16
66116	—	1-1/2 - 12									

* To complete the abbreviated part numbers in the table above use the prefix "215-0"

Industrial Style - Bulk Packed Keylocking Threaded Inserts



Extra Heavy Duty - Inch

PART NUMBER*		INSERT			INSTALLATION					REMOVAL	
Carbon Steel	Stainless Steel	Internal Thread Class 2B	External Thread (Mod.) Class 2A	Length	Installation Tool Part No.*	Tap Drill Size	C'Sink Dia. $+.010$ $-.000$	Thread Tap		Drill	
								Size Class 2B	Min. Depth	Size	Depth
65931	66331	6 - 32	5/16 - 18	.31	64731	"I"	.32	5/16 - 18	.37	7/32	1/8
65932	66332	8 - 32	3/8 - 16	.31	64732	"Q"	.38	3/8 - 16	.37	9/32	1/8
65933	66333	10 - 24	7/16 - 14	.31	64733	"X"	.44	7/16 - 14	.37	11/32	3/16
66133	66533	10 - 32									
65934	66334	1/4 - 20	1/2 - 13	.37	64734	29/64	.51	1/2 - 13	.43	13/32	3/16
66134	66534	1/4 - 28									
65935	66335	5/16 - 18	9/16 - 12	.43	64735	33/64	.57	9/16 - 12	.50	15/32	3/16
66135	66535	5/16 - 24									
65936	66336	3/8 - 16	5/8 - 11	.50	64736	37/64	.63	5/8 - 11	.56	17/32	3/16
66136	66536	3/8 - 24									
65937	66337	7/16 - 14	3/4 - 16	.62	64737	45/64	.76	3/4 - 16	.68	21/32	3/16
66137	66537	7/16 - 20									
65938	66338	1/2 - 13	7/8 - 14	.68	64738	53/64	.88	7/8 - 14	.75	25/32	5/16
66138	66538	1/2 - 20									
65939	66339	9/16 - 12	7/8 - 14	.81	64739	53/64	.88	7/8 - 14	.94	25/32	5/16
66139	66539	9/16 - 18									
65940	66340	5/8 - 11	1" - 12	.87	64740	15/16	1.02	1" - 12	1.00	27/32	5/16
66140	66540	5/8 - 18									
65941	66341	3/4 - 10	1-1/4 - 12	1.12	64741	1-3/16	1.27	1-1/4 - 12	1.31	1-3/32	5/16
66141	66541	3/4 - 16									
65942	66342	7/8 - 9	1-3/8 - 12	1.25	64742	1-5/16	1.39	1-3/8 - 12	1.44	1-7/32	5/16
66142	66542	7/8 - 14									
65943	66343	1" - 8	1-1/2 - 12	1.37	64743	1-7/16	1.52	1-1/2 - 12	1.56	1-11/32	5/16
66143	66543	1" - 12									

* To complete the abbreviated part numbers in the table above use the prefix "215-0"

General Information For Industrial Style Keylocking Threaded Inserts

Material: Inserts -

Carbon Steel - C1215 or equivalent

Stainless Steel - 303 or equivalent

Keys - 302 CRES or equivalent

Finish: Carbon Steel - Zinc Phosphate

Stainless Steel - Passivated

Tolerances: $\pm .010$ inch or $\pm .25$ mm unless specified otherwise.

Dimensions: Are in inches except metric inserts are in millimeters.

Metric/Inch inserts have a metric internal thread while all other dimensions are in inches.

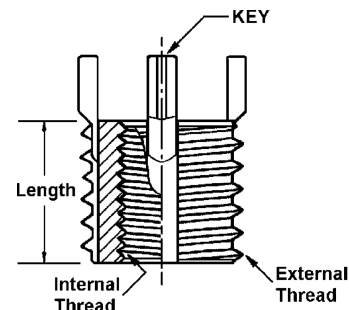
Keys: Inserts with an internal thread size of 5/16 or M7 and larger have 4 locking keys. Smaller sizes have 2 locking keys.

Tap Drill Hole Tolerance: Inch - .234 to .500 = $+.004/- .001$

Over .500 = $+.005/- .001$

Metric - 6.90 to 10.80 = $+.100/- .025$

Over 12.80 = $+.130/- .025$



See Page 2 for Installation and Removal Instructions



Industrial Style - Bulk Packed Keylocking Threaded Inserts

Thinwall - Metric

PART NUMBER*		INSERT			INSTALLATION				REMOVAL		
Carbon Steel	Stainless Steel	Internal Thread Class 6H	External Thread Class 6g	Length	Installation Tool Part No.*	Tap Drill Size	C'Sink Dia. $^{+.25}_{-.00}$	Thread Tap		Drill	
								Size Class 6H	Min. Depth	Size	Depth
65951	66351	M 5x0.8	M 8x1.25	8.0	64751	6.9	8.25	M 8x1.25	9.5	5.50	4.00
65952	66352	M 6x1.0	M 10x1.25	10.0	64752	8.8	10.25	M 10x1.25	11.5	7.50	4.75
65953	66353	M 8x1.25	M 12x1.25	12.0	64753	10.8	12.25	M 12x1.25	13.5	9.50	4.75
66153	66553	M 8x1.0									
65955	66355	M 10x1.5	M 14x1.5	14.0	64755	12.8	14.25	M 14x1.5	15.5	11.50	4.75
66155	66555	M 10x1.25									
65956	66356	M 12x1.75	M 16x1.5	16.0	64756	14.75	16.25	M 16x1.5	17.5	13.50	4.75
66156	66556	M 12x1.25									

* To complete the abbreviated part numbers in the table above use the prefix "215-0"

Heavy Duty - Metric

PART NUMBER*		INSERT			INSTALLATION				REMOVAL		
Carbon Steel	Stainless Steel	Internal Thread Class 6H	External Thread Class 6g	Length	Installation Tool Part No.*	Tap Drill Size	C'Sink Dia. $^{+.25}_{-.00}$	Thread Tap		Drill	
								Size Class 6H	Min. Depth	Size	Depth
65963	66363	M 4x0.7	M 8x1.25	8.0	64763	6.9	8.25	M 8x1.25	9.5	5.50	4.00
65964	66364	M 5x0.8	M 10x1.25	10.0	64764	8.8	10.25	M 10x1.25	12.5	7.50	4.75
65965	66365	M 6x1.0	M 12x1.25	12.0	64765	10.8	12.25	M 12x1.25	14.5	9.50	4.75
65966	66366	M 8x1.25	M 14x1.5	14.0	64766	12.8	14.25	M 14x1.5	16.5	11.50	4.75
66166	66566	M 8x1.0									
65967	66367	M 10x1.5	M 16x1.5	16.0	64767	14.75	16.25	M 16x1.5	18.5	13.50	4.75
66167	66567	M 10x1.25									
65969	66369	M 12x1.75	M 18x1.5	18.0	64769	16.75	18.25	M 18x1.5	20.5	15.50	4.75
66169	66569	M 12x1.25									
65970	66370	M 14x2.0	M 20x1.5	20.0	64770	18.75	20.25	M 20x1.5	22.5	17.50	4.75
66170	66570	M 14x1.5									
65971	66371	M 16x2.0	M 22x1.5	22.0	64771	20.5	22.25	M 22x1.5	24.5	17.75	6.35
66171	66571	M 16x1.5									
66172	66572	M 18x1.5	M 24x1.5	24.0	64772	22.5	24.25	M 24x1.5	26.5	19.75	6.35
65973	66373	M 20x2.5	M 30x2.0	30.0	64773	28.0	30.25	M 30x2.0	34.5	25.75	6.35
66173	66573	M 20x1.5									
66174	66574	M 22x1.5	M 32x2.0	32.0	64774	30.0	32.25	M 32x2.0	36.5	27.75	6.35
65975	66375	M 24x3.0	M 33x2.0	33.0	64775	31.0	33.25	M 33x2.0	37.5	28.75	6.35
66175	66575	M 24x2.0									

* To complete the abbreviated part numbers in the table above use the prefix "215-0"

Metric Internal / Inch External

PART NUMBER*		INSERT			INSTALLATION				REMOVAL		
Carbon Steel	Stainless Steel	Internal Thread Class 6H	External Thread (Mod.) Class 2A	Length	Installation Tool Part No.	Tap Drill Size	C'Sink Dia. $^{+.010}_{-.000}$	Thread Tap		Drill	
								Size Class 2B	Min. Depth	Size	Depth
66243	66643	M 6x1.0	3/8 - 16	.31	64843	"Q"	.38	3/8 - 16	.37	9/32	1/8
66244	66644	M 8x1.25	1/2 - 13	.43	64844	29/64	.51	1/2 - 13	.50	13/32	3/16
66245	66645	M 10x1.5	5/8 - 11	.50	64845	37/64	.63	5/8 - 11	.56	17/32	3/16
66247	66647	M 12x1.75	3/4 - 16	.62	64847	45/64	.76	3/4 - 16	.68	21/32	3/16
66248	66648	M 14x2.0	7/8 - 14	.81	64848	53/64	.88	7/8 - 14	.94	25/32	5/16
66249	66649	M 16x2.0	1" - 12	.87	64849	15/16	1.02	1" - 12	1.00	27/32	5/16

* To complete the abbreviated part numbers in the table above use the prefix "215-0"
(All dimensions are specified in inches except internal thread is metric.)

Industrial Style - Single Size Kits Keylocking Threaded Inserts



Thinwall - Inch

PART NUMBER*		Internal Thread Class 2B	External Thread (Mod.) Class 2A	Length	Number of Inserts Per Kit
Carbon Steel	Stainless Steel				
67921	68321	10 - 24	5/16-18	.31	9
68121	68521	10 - 32			
67922	68322	1/4 - 20	3/8 - 16	.37	8
68122	68522	1/4 - 28			
67923	68323	5/16 - 18	7/16 - 14	.43	7
68123	68523	5/16 - 24			
67924	68324	3/8 - 16	1/2 - 13	.50	6
68124	68524	3/8 - 24			
67925	68325	7/16 - 14	9/16 - 12	.56	6
68125	68525	7/16 - 20			
67926	68326	1/2 - 13	5/8 - 11	.62	4
68126	68526	1/2 - 20			

* To complete the abbreviated part numbers in the table above use the prefix "215-0"

Heavy Duty - Inch

PART NUMBER*		Internal Thread Class 2B	External Thread (Mod.) Class 2A	Length	Number of Inserts Per Kit
Carbon Steel	Stainless Steel				
67900	68300	8 - 32	5/16 - 18	.31	9
67901	68301	10 - 24	3/8 - 16	.31	9
68101	68501	10 - 32			
67902	68302	1/4 - 20	7/16 - 14	.37	8
68102	68502	1/4 - 28			
67903	68303	5/16 - 18	1/2 - 13	.43	7
68103	68503	5/16 - 24			
67904	68304	3/8 - 16	9/16 - 12	.50	6
68104	68504	3/8 - 24			
67905	68305	7/16 - 14	5/8 - 11	.62	6
68105	68505	7/16 - 20			
67906	68306	1/2 - 13	3/4 - 16	.62	4
68106	68506	1/2 - 20			
67907	68307	9/16 - 12	3/4 - 16	.81	3
68107	68507	9/16 - 18			
67908	68308	5/8 - 11	7/8 - 14	.87	3
68108	68508	5/8 - 18			
67909	68309	3/4 - 10	1-1/8 - 12	1.12	3
68109	68509	3/4 - 16			
67910	68310	7/8 - 9	1-1/4 - 12	1.25	3
68110	68510	7/8 - 14			
67911	68311	1" - 8	1-3/8 - 12	1.37	2
68111	68511	1" - 12			
67913	—	1-1/8 - 7	1-1/2 - 12	1.62	2
68113	—	1-1/8 - 12			
67914	—	1-1/4 - 7	1-5/8 - 12	1.81	2
68114	—	1-1/4 - 12			
67916	—	1-1/2 - 6	1-7/8 - 12	2.00	2
68116	—	1-1/2 - 12			

* To complete the abbreviated part numbers in the table above use the prefix "215-0"



Single Size Kits contain inserts of one size per box. Each Single Size Kit includes the quantity of inserts shown in the chart, one installation tool, and instructions for installation and removal.



Industrial Style - Single Size Kits Keylocking Threaded Inserts

Thinwall - Metric

PART NUMBER*		Internal Thread Class 6H	External Thread Class 6g	Length	Number of Inserts Per Kit
Carbon Steel	Stainless Steel				
67951	68351	M 5x0.8	M 8x1.25	8.0	8
67952	68352	M 6x1.0	M 10x1.25	10.0	8
67953	68353	M 8x1.25	M 12x1.25	12.0	6
68153	68553	M 8x1.0			
67955	68355	M 10x1.5	M 14x1.5	14.0	4
68155	68555	M 10x1.25			
67956	68356	M 12x1.75	M 16x1.5	16.0	3
68156	68556	M 12x1.25			

* To complete the abbreviated part numbers in the table above use the prefix "215-0"

Heavy Duty - Metric

PART NUMBER*		Internal Thread Class 6H	External Thread Class 6g	Length	Number of Inserts Per Kit
Carbon Steel	Stainless Steel				
67963	68363	M 4x0.7	M 8x1.25	8.0	9
67964	68364	M 5x0.8	M 10x1.25	10.0	8
67965	68365	M 6x1.0	M 12x1.25	12.0	8
67966	68366	M 8x1.25	M 14x1.5	14.0	6
68166	68566	M 8x1.0			
67967	68367	M 10x1.5	M 16x1.5	16.0	4
68167	68567	M 10x1.25			
67969	68369	M 12x1.75	M 18x1.5	18.0	3
68169	68569	M 12x1.25			
67970	68370	M 14x2.0	M 20x1.5	20.0	4
68170	68570	M 14x1.5			
67971	68371	M 16x2.0	M 22x1.5	22.0	3
68171	68571	M 16x1.5			
68172	68572	M 18x1.5	M 24x1.5	24.0	2
67973	68373	M 20x2.5	M 30x2.0	30.0	3
68173	68573	M 20x1.5			
68174	68574	M 22x1.5	M 32x2.0	32.0	3
67975	68375	M 24x3.0	M 33x2.0	33.0	2
68175	68575	M 24x2.0			

* To complete the abbreviated part numbers in the table above use the prefix "215-0"

Metric Internal / Inch External

PART NUMBER*		Internal Thread Class 6H	External Thread (Mod.) Class 2A	Length	Number of Inserts Per Kit
Carbon Steel	Stainless Steel				
68243	68643	M 6x1.0	3/8 - 16	.31	8
68244	68644	M 8x1.25	1/2 - 13	.43	8
68245	68645	M 10x1.5	5/8 - 11	.50	6
68247	68647	M 12x1.75	3/4 - 16	.62	4
68248	68648	M 14x2.0	7/8 - 14	.81	3
68249	68649	M 16x2.0	1" - 12	.87	3

* To complete the abbreviated part numbers in the table above use the prefix "215-0"

Industrial Style - Assortment Kits Keylocking Threaded Inserts



Large Assortments

Thinwall - Inch Coarse Series

Internal Thread Class 2B	External Thread (Mod.) Class 2A	Length	Quantity of Inserts per Kit
10 - 24	5/16 - 18	.31	20
1/4 - 20	3/8 - 16	.37	20
5/16 - 18	7/16 - 14	.43	15
3/8 - 16	1/2 - 13	.50	10
7/16 - 14	9/16 - 12	.56	10
1/2 - 13	5/8 - 11	.62	6

Carbon Steel Kit Part Number: **215-064943**
Stainless Steel Kit Part Number: **215-064963**

Thinwall - Inch Fine Series

Internal Thread Class 2B	External Thread (Mod.) Class 2A	Length	Quantity of Inserts per Kit
10 - 32	5/16 - 18	.31	20
1/4 - 28	3/8 - 16	.37	20
5/16 - 24	7/16 - 14	.43	15
3/8 - 24	1/2 - 13	.50	10
7/16 - 20	9/16 - 12	.56	10
1/2 - 20	5/8 - 11	.62	6

Carbon Steel Kit Part Number: **215-064944**
Stainless Steel Kit Part Number: **215-064964**

Heavy Duty - Inch Coarse Series

Internal Thread Class 2B	External Thread (Mod.) Class 2A	Length	Quantity of Inserts per Kit
1/4 - 20	7/16 - 14	.37	20
5/16 - 18	1/2 - 13	.43	15
3/8 - 16	9/16 - 12	.50	10
7/16 - 14	5/8 - 11	.62	10
1/2 - 13	3/4 - 16	.62	6
9/16 - 12	3/4 - 16	.81	5
5/8 - 11	7/8 - 14	.87	3
3/4 - 10	1-1/8 - 12	1.12	3
7/8 - 9	1-1/4 - 12	1.25	3
1" - 8	1-3/8 - 12	1.37	2

Carbon Steel Kit Part Number: **215-064941**
Stainless Steel Kit Part Number: **215-064966**

Heavy Duty - Inch Fine Series

Internal Thread Class 2B	External Thread (Mod.) Class 2A	Length	Quantity of Inserts per Kit
1/4 - 28	7/16 - 14	.37	20
5/16 - 24	1/2 - 13	.43	15
3/8 - 24	9/16 - 12	.50	10
7/16 - 20	5/8 - 11	.62	10
1/2 - 20	3/4 - 16	.62	6
9/16 - 18	3/4 - 16	.81	5
5/8 - 18	7/8 - 14	.87	3
3/4 - 16	1-1/8 - 12	1.12	3
7/8 - 14	1-1/4 - 12	1.25	3
1" - 12	1-3/8 - 12	1.37	2

Carbon Steel Kit Part Number: **215-064942**
Stainless Steel Kit Part Number: **215-064967**

Thinwall - Metric Series

Internal Thread Class 6H	External Thread Class 6g	Length	Quantity of Inserts per Kit
M 6x1.0	M 10x1.25	10.0	20
M 8x1.25	M 12x1.25	12.0	15
M 8x1.0			15
M 10x1.5	M 14x1.5	14.0	10
M 10x1.25			10
M 12x1.75	M 16x1.5	16.0	6
M 12x1.25			6

Carbon Steel Kit Part Number: **215-064945**
Stainless Steel Kit Part Number: **215-064965**



Industrial Style - Assortment Kits Keylocking Threaded Inserts

Small Assortments

Heavy Duty - Inch Coarse Series

Internal Thread Class 2B	External Thread (Mod.) Class 2A	Length	Quantity of Inserts per Kit
10 - 24	3/8 - 16	.31	5
1/4 - 20	7/16 - 14	.37	10
5/16 - 18	1/2 - 13	.43	10
3/8 - 16	9/16 - 12	.50	10
1/2 - 13	3/4 - 16	.62	10
5/8 - 11	7/8 - 14	.87	10
3/4 - 10	1-1/8 - 12	1.12	5

Carbon Steel Kit Part Number: **215-064951**
Stainless Steel Kit Part Number: **215-064961**

Heavy Duty - Inch Fine Series

Internal Thread Class 2B	External Thread (Mod.) Class 2A	Length	Quantity of Inserts per Kit
10 - 32	3/8 - 16	.31	5
1/4 - 28	7/16 - 14	.37	10
5/16 - 24	1/2 - 13	.43	10
3/8 - 24	9/16 - 12	.50	10
1/2 - 20	3/4 - 16	.62	10
5/8 - 18	7/8 - 14	.87	10
3/4 - 16	1-1/8 - 12	1.12	5

Carbon Steel Kit Part Number: **215-064952**
Stainless Steel Kit Part Number: **215-064962**

Thinwall - Metric Series

Internal Thread Class 6H	External Thread Class 6g	Length	Quantity of Inserts per Kit
M 5x0.8	M 8x1.25	8.0	8
M 6x1.0	M 10x1.25	10.0	8
M 8x1.25	M 12x1.25	12.0	6
M 8x1.0			6
M 10x1.5	M 14x1.5	14.0	4
M 10x1.25			4
M 12x1.75	M 16x1.5	16.0	3
M 12x1.25			3

Carbon Steel Kit Part Number: **215-064983**
Stainless Steel Kit Part Number: **215-064993**



Each Assortment Kit contains a selection of various size inserts and the proper installation tools. Instructions for installation and removal are also included. Assortment Kits provide convenient storage and easy access to the various inserts and tools.