



Bolster Plate Bushings ..... 3.5

Installation and Removal  
Instructions ..... 3.2

Internal Locking Thread  
Repair Insert ..... 3.8-3.9

Keylocking, Extra Heavy Duty  
Industrial Style ..... 3.6

Keylocking, Heavy Duty  
Industrial Style ..... 3.4

Keylocking, Metric/Inch ..... 3.5

Keylocking, Solid Industrial Style ..... 3.7

Keylocking, Thinwall  
Industrial Style ..... 3.3

Miniature Metric  
Mil Spec Inserts ..... 3.10-3.11

Thread Repair Kits ..... 3.12-3.15

## 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 .010" to .030" below surface.



4. Drive keys down with proper installation tool.

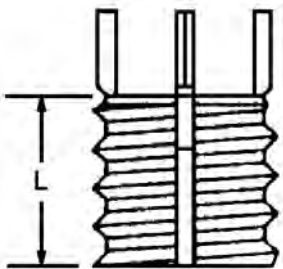
## Removal Information

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.

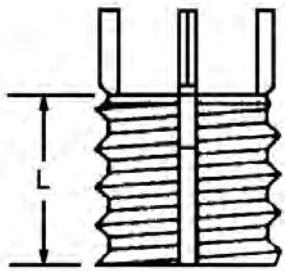


## Installation Information Preparation of External Threads Prior to Installation (For Keylocking Inserts Only)



Insert		Installation Data			Removal Data	
External Thread Class 2A	Length L	Tap Drill Size	C'sink Dia. +.010 -.000	Minimum Tap Depth	Drill	
					Size	Depth
5/16-18	.31	I	.323	.37	7/32	1/8
3/8-16	.31/.37	Q	.385	.37/.43	9/32	1/8
7/16-14	.31/.37/.43	X	.447	.37/.43/.50	11/32	3/16
1/2-13	.37/.43/.50	29/64	.510	.44/.50/.56	13/32	3/16
9/16-12	.43/.50/.56	33/64	.572	.50/.56/.62	15/32	3/16
5/8-11	.50/.62	37/64	.635	.56/.68	17/32	3/16
3/4-16	.62/.81	45/64	.760	.68/.94	21/32	3/16
7/8-14	.68/.81/.87	53/64	.885	.75/.94/1.0	25/32	3/16
1-12	.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

## Keylocking Inserts Thinwall Industrial Style



- Material: Carbon Steel Inserts - C1215 or equivalent  
Stainless Steel Insert - 303    Keys - 302
- Finish: Carbon Steel Inserts - Parkerized  
Stainless Steel Inserts - Passivated
- Tolerances: Inch  $\pm$ .010    Metric  $\pm$ .25mm
- Keys: Inserts with internal thread size of 5/16-18 or larger are furnished with four locking keys.

### Inch Inserts - Thinwall

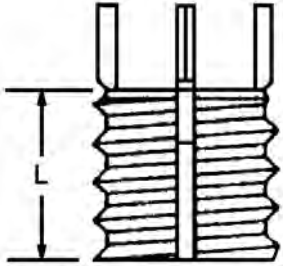
Internal Thread Class 2B	Part Number		External Thread	Length L	Installation Tool Part Number
	Carbon Steel	Stainless Steel			
10-24	25921	26321	5/16-18	.31	24721
10-32	26121	26521	5/16-18	.31	24721
1/4-20	25922	26322	3/8-16	.37	24722
1/4-28	26122	26522	3/8-16	.37	24722
5/16-18	25923	26323	7/16-14	.43	24723
5/16-24	26123	26523	7/16-14	.43	24723
3/8-16	25924	26324	1/2-13	.50	24724
3/8-24	26124	26524	1/2-13	.50	24724
7/16-14	25925	26325	9/16-12	.56	24725
7/16-20	26125	26525	9/16-12	.56	24725
1/2-13	25926	26326	5/8-11	.62	24726
1/2-20	26126	26526	5/8-11	.62	24726

See chart on page 3.2 for installation information.

### Metric Inserts - Thinwall

Part Number		Insert		Installation				Removal			
Carbon Steel	Stainless Steel	Internal Thread Class 6H	External Thread Class 6g	Length L	Installation Tool Part No.	Tap Drill Size	C'sink Dia. +.25 -.00	Thread Tap		Drill	
								Size Class 6h	Min. Depth	Size	Depth
25951	26351	M 5x0.8	M 8x1.25	8.0	24751	6.9	8.25	M 8x1.25	9.5	5.50	4.00
25952	26352	M 6x1.0	M 10x1.25	10.0	24752	8.8	10.25	M 10x1.25	11.5	7.50	4.75
25953	26353	M 8x1.25	M 12x1.25	12.0	24753	10.8	12.25	M 12x1.25	13.5	9.50	4.75
26153	26553	M 8x1.0	M 12x1.25	12.0	24753	10.8	12.25	M 12x1.25	13.5	9.50	4.75
25955	26355	M 10x1.5	M 14x1.5	14.0	24755	12.8	14.25	M 14x1.5	15.5	11.50	4.75
26155	26555	M 10x1.25	M 14x1.5	14.0	24755	12.8	14.25	M 14x1.5	15.5	11.50	4.75
25956	26356	M 12x1.75	M 16x1.5	16.0	24756	14.75	16.25	M 16x1.5	17.5	13.50	4.75
26156	26556	M 12x1.25	M 16x1.5	16.0	24756	14.75	16.25	M 16x1.5	17.5	13.50	4.75

## Keylocking Inserts Heavy Duty Industrial Style



- Material: Carbon Steel Inserts - C1215 or equivalent  
Stainless Steel Insert - 303  
Keys - 302
- Finish: Carbon Steel Inserts - Parkerized  
Stainless Steel Inserts - Passivated
- Tolerances: Inch  $\pm$ .010  
Metric  $\pm$ .25mm
- Keys: Inserts with internal thread size of 5/16-18 or larger are furnished with four locking keys.

## Inch Inserts - Heavy Duty

Internal Thread Class 2B	Part Number		External Thread	Length L	Installation Tool Part Number
	Carbon Steel	Stainless Steel			
8-32	25900	26300	5/16-18	.31	24719
10-24	25901	26301	3/8-16	.31	24701
10-32	26101	26501	3/8-16	.31	24701
1/4-20	25902	26302	7/16-14	.37	24702
1/4-28	26102	26502	7/16-14	.37	24702
5/16-18	25903	26303	1/2-13	.43	24703
5/16-24	26103	26503	1/2-13	.43	24703
3/8-16	25904	26304	9/16-12	.50	24704
3/8-24	26104	26504	9/16-12	.50	24704
7/16-14	25905	26305	5/8-11	.62	24705
7/16-20	26105	26505	5/8-11	.62	24705
1/2-13	25906	26306	3/4-16	.62	24706
1/2-20	26106	26506	3/4-16	.62	24706
9/16-12	25907	26307	3/4-16	.81	24707
9/16-18	26107	26507	3/4-16	.81	24707
5/8-11	25908	26308	7/8-14	.87	24708
5/8-18	26108	26508	7/8-14	.87	24708
3/4-10	25909	26309	1 1/8-12	1.12	24709
3/4-16	26109	26509	1 1/8-12	1.12	24709
7/8-9	25910	26310	1 1/4-12	1.25	24710
7/8-14	26110	26510	1 1/4-12	1.25	24710
1-8	25911	26311	1 3/8-12	1.37	24711
1-12	26111	26511	1 3/8-12	1.37	24711
1-14	26112	—	1 3/8-12	1.37	24711
1 1/8-7	25913	—	1 1/2-12	1.62	24713
1 1/8-12	26113	—	1 1/2-12	1.62	24713
1 1/4-7	25914	—	1 5/8-12	1.81	24714
1 1/4-12	26114	—	1 5/8-12	1.81	24714
1 1/2-6	25916	—	1 7/8-12	2.00	24716
1 1/2-12	26116	—	1 7/8-12	2.00	24716

See chart on page 3.2 for installation information.

## Metric Inserts - Heavy Duty

Part Number Carbon Steel	Part Number Stainless Steel	Insert			Installation					Removal	
		Internal Thread Class 6H	External Thread Class 6g	Length L	Installation Tool Part No.	Tap Drill Size	C'sink Diameter $\pm$ .25 -.00	Thread Tap		Drill	
								Size Class 6h	Min. Depth	Size	Depth
25963	26363	M 4x0.7	M 8x1.25	8.0	24763	6.9	8.25	M 8x1.25	9.5	5.50	4.00
25964	26364	M 5x0.8	M 10x1.25	10.0	24764	8.8	10.25	M 10x1.25	12.5	7.50	4.75
25965	26365	M 6x1.0	M 12x1.25	12.0	24765	10.8	12.25	M 12x1.25	14.5	9.50	4.75
25966	26366	M 8x1.25	M 14x1.5	14.0	24766	12.8	14.25	M 14x1.5	16.5	11.50	4.75
26166	26566	M 8x1.0	M 14x1.5	14.0	24766	12.8	14.25	M 14x1.5	16.5	11.50	4.75
25967	26367	M 10x1.5	M 16x1.5	16.0	24767	14.75	16.25	M 16x1.5	18.5	13.50	4.75
26167	26567	M 10x1.25	M 16x1.5	16.0	24767	14.75	16.25	M 16x1.5	18.5	13.50	4.75
25969	26369	M 12x1.75	M 18x1.5	18.0	24769	16.75	18.25	M 18x1.5	20.5	15.50	4.75
26169	26569	M 12x1.25	M 18x1.5	18.0	24769	16.75	18.25	M 18x1.5	20.5	15.50	4.75
25970	26370	M 14x2.0	M 20x1.5	20.0	24770	18.75	20.25	M 20x1.5	22.5	17.50	4.75
26170	26570	M 14x1.5	M 20x1.5	20.0	24770	18.75	20.25	M 20x1.5	22.5	17.50	4.75
25971	26371	M 16x2.0	M 22x1.5	22.0	24771	20.5	22.25	M 22x1.5	24.5	17.75	6.35
26171	26571	M 16x1.5	M 22x1.5	22.0	24771	20.5	22.25	M 22x1.5	24.5	17.75	6.35
26172	26572	M 18x1.5	M 24x1.5	24.0	24772	22.5	24.25	M 24x1.5	26.5	19.75	6.35
25973	26373	M 20x2.5	M 30x2.0	30.0	24773	28.0	30.25	M 30x2.0	34.5	25.75	6.35
26173	26573	M 20x1.5	M 30x2.0	30.0	24773	28.0	30.25	M 30x2.0	34.5	25.75	6.35
26174	26574	M 22x1.5	M 32x2.0	32.0	24774	30.0	32.25	M 32x2.0	36.5	27.75	6.35
25975	26375	M 24x3.0	M 33x2.0	33.0	24775	31.0	33.25	M 33x2.0	37.5	28.75	6.35
26175	26575	M 24x2.0	M 33x2.0	33.0	24775	31.0	33.25	M 33x2.0	37.5	28.75	6.35

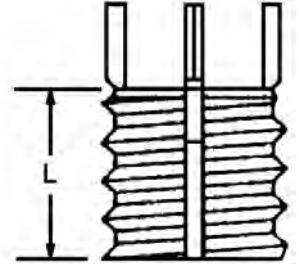
NOTE: Install insert .25mm to .76mm below surface and drive locking keys down. See C'sink Diameter column above.

## Keylocking Inserts Metric/Inch Inserts



### Create Metric Holes... With Inch Taps!

This unique product allows you to create a metric thread utilizing inch drills and taps. The insert O.D. is inch sized, the I.D. is metric.



### Metric Internal/Inch External - Heavy Duty Industrial Style

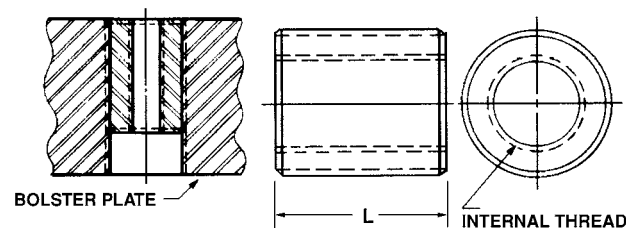
Part Number Carbon Steel	Insert			Installation					Removal	
	Internal Thread Class 6H	External Thread Class 2A	Length L	Installation Tool Part Number	Tap Drill Size	C'sink Diameter +.010 -.000	Thread Tap		Drill	
							Size Class 2b	Min. Depth	Size	Depth
26243	M 6x1.0	3/8 - 16	.31	24843	Q	.38	3/8 - 16	.37	9/32	1/8
26244	M 8x1.25	1/2 - 13	.43	24844	29/64	.51	1/2 - 13	.50	13/32	3/16
26245	M 10x1.5	5/8 - 11	.50	24845	37/64	.63	5/8 - 11	.56	17/32	3/16
26247	M 12x1.75	3/4 - 16	.62	24847	45/64	.76	3/4 - 16	.68	21/32	3/16
26248	M 14x2.0	7/8 - 14	.81	24848	53/64	.88	7/8 - 14	.94	25/32	5/16
26249	M 16x2.0	1" - 12	.87	24849	15/16	1.02	1" - 12	1.00	27/32	5/16

All dimensions are in inches except for internal thread, which is metric.

## Bolster Plate Bushings



- Material: Stressproof
- Finish: Black Oxide
- Internal Thread: 2B-UNC
- External Thread: 2A-UNF



Repairs are made quickly, easily, and right on the machine. Re-tap bolster plate hole, insert the threaded bushing to match, use a locking type sealant to lock the bushing in place. The Bolster Plate Bushings can also be used as threaded bushings in cast iron machine bases where greater thread strength is necessary. Eliminates the problems of "pulled-out" cast iron threads, reduces the need for bulky threaded cast iron sections.

Part Number	Internal Thread	External Thread	L	Wt. (lbs) 10 Pcs.
11701	3/8-16	3/4-16	1 1/2	1.25
11702	1/2-13	1 -14	1 1/2	2.20
11703	5/8-11	1 -14	1 1/2	1.85
11704	3/4-10	1 1/4-12	1 1/2	3.00
11705	1 -8	1 1/2-12	2	5.15

## Keylocking Inserts

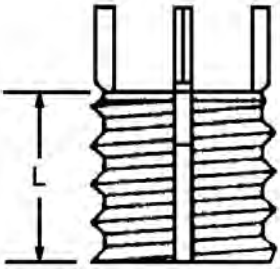
### Extra Heavy Duty

### Industrial Style



The increased wall thickness and greater external thread area of these extra heavy duty threaded inserts offer greater pull-out strength, stability, and longer life. These inserts should be used in materials with lower ultimate shear strength to obtain maximum pull-out strength and holding power.

- Greater Thread Area
- Increased Shear Engagement
- Offers Holding Power Comparable to Standard Heavy Duty Inserts in High Shear Strength Material
- Material: Carbon Steel Inserts - C1215 or equivalent  
Stainless Steel Insert - 303  
Keys - 302
- Finish: Carbon Steel Inserts - Parkerized  
Stainless Steel Inserts - Passivated
- Tolerances:  $\pm 0.010$
- Keys: Inserts with internal thread size of 5/16-18 or larger are furnished with four locking keys.



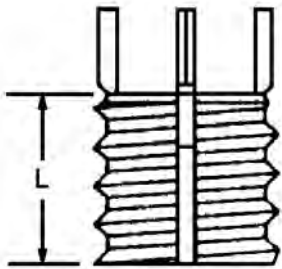
Internal Thread Class 2B	Part Number		External Thread Class 2A	Length L	Installation Tool Part Number
	Carbon Steel	Stainless Steel			
6-32	25931	26331	5/16-18	.31	24731
8-32	25932	26332	3/8-16	.31	24732
10-24	25933	26333	7/16-14	.31	24733
10-32	26133	26533	7/16-14	.31	24733
1/4-20	25934	26334	1/2-13	.37	24734
1/4-28	26134	26534	1/2-13	.37	24734
5/16-18	25935	26335	9/16-12	.43	24735
5/16-24	26135	26535	9/16-12	.43	24735
3/8-16	25936	26336	5/8-11	.50	24736
3/8-24	26136	26536	5/8-11	.50	24736
7/16-14	25937	26337	3/4-16	.62	24737
7/16-20	26137	26537	3/4-16	.62	24737
1/2-13	25938	26338	7/8-14	.68	24738
1/2-20	26138	26538	7/8-14	.68	24738
9/16-12	25939	26339	7/8-14	.81	24739
9/16-18	26139	26539	7/8-14	.81	24739
5/8-11	25940	26340	1-12	.87	24740
5/8-18	26140	26540	1-12	.87	24740
3/4-10	25941	26341	1 1/4-12	1.12	24741
3/4-16	26141	26541	1 1/4-12	1.12	24741
7/8-9	25942	26342	1 3/8-12	1.25	24742
7/8-14	26142	26542	1 3/8-12	1.25	24742
1-8	25943	26343	1 1/2-12	1.37	24743
1-12	26143	26543	1 1/2-12	1.37	24743

See chart on page 3.2 for installation information.

**Keylocking Inserts  
Solid Industrial Style**



- Material: Carbon Steel Inserts - C1215 or equivalent  
Stainless Steel Insert - 303  
Keys - 302
- Finish: Carbon Steel Inserts - Parkerized  
Stainless Steel Inserts - Passivated
- Tolerances: Inch  $\pm$ .010  
Metric  $\pm$ .25mm
- Keys: Inserts with internal thread size of M7 or larger are furnished with four locking keys.



- Salvage expensive castings
- Relocate holes that have been drilled or tapped in the wrong location
- Fill holes that are too large
- No need to alter original bolt size

External Thread Class 2A	Part Number		Length L	Installation Tool Part Number
	Carbon Steel	Stainless Steel		
5/16-18	<b>26001</b>	<b>26401</b>	.31	<b>24801</b>
3/8-16	<b>26002</b>	<b>26402</b>	.31	<b>24802</b>
7/16-14	<b>26003</b>	<b>26403</b>	.37	<b>24803</b>
1/2-13	<b>26004</b>	<b>26404</b>	.43	<b>24804</b>
9/16-12	<b>26005</b>	<b>26405</b>	.50	<b>24805</b>
5/8-11	<b>26006</b>	<b>26406</b>	.62	<b>24806</b>
3/4-16	<b>26007</b>	<b>26407</b>	.68	<b>24807</b>
7/8-14	<b>26008</b>	<b>26408</b>	.87	<b>24808</b>
1-12	<b>26009</b>	<b>26409</b>	.87	<b>24809</b>
1 1/8-12	<b>26010</b>	<b>26410</b>	1.12	<b>24810</b>
1 1/4-12	<b>26011</b>	<b>26411</b>	1.25	<b>24811</b>
1 3/8-12	<b>26012</b>	<b>26412</b>	1.37	<b>24812</b>

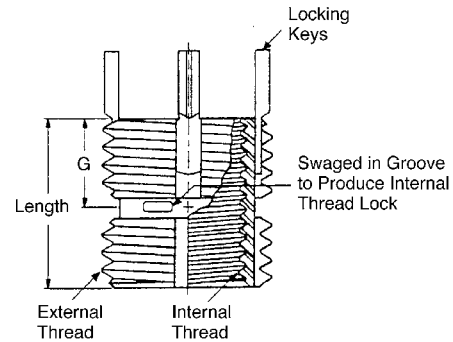
See chart on page 3.2 for installation information.

**Metric Inserts - Solid**

Part Number Carbon Steel	Insert		Installation					Removal	
	External Thread Class 6g	Length L	Installation Tool Part No.	Tap Drill Size	C'sink Dia. +.25 -.00	Thread Tap		Drill	
						Size Class 6h	Min. Depth	Size	Depth
<b>26021</b>	M 8x1.25	8.0	<b>24821</b>	6.9	8.25	M 8x1.25	9.5	5.50	4.00
<b>26022</b>	M 10x1.25	10.0	<b>24822</b>	8.8	10.25	M 10x1.25	12.5	7.50	4.75
<b>26023</b>	M 12x1.25	12.0	<b>24823</b>	10.8	12.25	M 12x1.25	14.5	9.50	4.75
<b>26024</b>	M 14x1.5	14.0	<b>24824</b>	12.8	14.25	M 14x1.5	16.5	11.50	4.75
<b>26025</b>	M 16x1.5	16.0	<b>24825</b>	14.75	16.25	M 16x1.5	18.5	13.50	4.75
<b>26026</b>	M 18x1.5	18.0	<b>24826</b>	16.75	18.25	M 18x1.5	20.5	15.50	4.75
<b>26027</b>	M 20x1.5	20.0	<b>24827</b>	18.75	20.25	M 20x1.5	22.5	17.50	4.75
<b>26028</b>	M 22x1.5	22.0	<b>24828</b>	20.5	22.25	M 22x1.5	24.5	17.75	6.35
<b>26029</b>	M 24x1.5	24.0	<b>24829</b>	22.5	24.25	M 24x1.5	26.5	19.75	6.35
<b>26030</b>	M 30x2.0	30.0	<b>24830</b>	28.0	30.25	M 30x2.0	34.5	25.75	6.35
<b>26031</b>	M 32x2.0	32.0	<b>24831</b>	30.0	32.25	M 32x2.0	36.5	27.75	6.35
<b>26032</b>	M 33x2.0	33.0	<b>24832</b>	31.0	33.25	M 33x2.0	37.5	28.75	6.35

## Internal Locking Thread Repair Inserts

Material: Inserts - 303 stainless steel or equivalent  
 Keys - 302 stainless steel or equivalent  
 Finish: Passivated  
 Tolerances: ± .010 inch unless specified otherwise.  
 Dimensions: All dimensions below are in inches.  
 Keys: Inserts with an internal thread size of 5/16 and larger are furnished with 4 locking keys. Smaller sizes have 2 locking keys.



### Thinwall - Locking

Insert					Installation					Removal	
Part Number	Internal Thread Class 2B	External Thread (Mod.) Class 2A	Length	G (Ref.)	Installation Tool Part No.	Tap Drill Size	C'sink Dia $+0.010$ $-0.000$	Thread Tap		Drill	
								Size Class 2B	Min. Depth	Size	Depth
24521	10 - 24	5/16 - 18	.31	.15	24721	"I"	.32	5/16 - 18	.37	7/32	1/8
24621	10 - 32										
24522	1/4 - 20	3/8 - 16	.37	.18	24722	"Q"	.38	3/8 - 16	.43	9/32	3/16
24622	1/4 - 28										
24523	5/16 - 18	7/16 - 14	.43	.21	24723	"X"	.44	7/16 - 14	.50	11/32	3/16
24623	5/16 - 24										
24524	3/8 - 16	1/2 - 13	.50	.25	24724	29/64	.51	1/2 - 13	.56	13/32	3/16
24624	3/8 - 24										
24525	7/16 - 14	9/16 - 12	.56	.28	24725	33/64	.57	9/16 - 12	.62	15/32	3/16
24625	7/16 - 20										
24526	1/2 - 13	5/8 - 11	.62	.31	24726	37/64	.63	5/8 - 11	.68	17/32	3/16
24626	1/2 - 20										

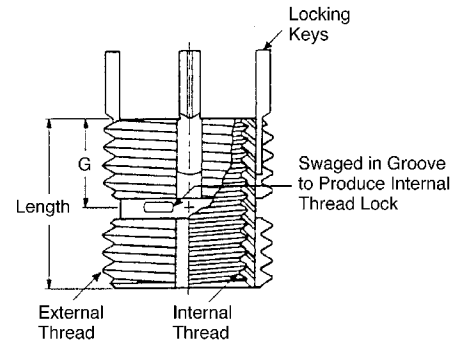
### Heavy Duty - Locking

Insert					Installation					Removal	
Part Number	Internal Thread Class 2B	External Thread (Mod.) Class 2A	Length	G (Ref.)	Installation Tool Part No.	Tap Drill Size	C'sink Dia $+0.010$ $-0.000$	Thread Tap		Drill	
								Size Class 2B	Min. Depth	Size	Depth
24500	8 - 32	5/16 - 18	.31	.15	24700	"I"	.32	5/16 - 18	.37	7/32	1/8
24501	10 - 24	3/8 - 16	.31	.15	24701	"Q"	.38	3/8 - 16	.37	9/32	1/8
24601	10 - 32										
24502	1/4 - 20	7/16 - 14	.37	.18	24702	"X"	.44	7/16 - 14	.43	11/32	3/16
24602	1/4 - 28										
24503	5/16 - 18	1/2 - 13	.43	.21	24703	29/64	.51	1/2 - 13	.50	13/32	3/16
24603	5/16 - 24										
24504	3/8 - 16	9/16 - 12	.50	.25	24704	33/64	.57	9/16 - 12	.56	15/32	3/16
24604	3/8 - 24										
24505	7/16 - 14	5/8 - 11	.62	.31	24705	37/64	.63	5/8 - 11	.68	17/32	3/16
24605	7/16 - 20										
24506	1/2 - 13	3/4 - 16	.62	.31	24706	45/64	.76	3/4 - 16	.68	21/32	3/16
24606	1/2 - 20										
24507	9/16 - 12	3/4 - 16	.81	.40	24707	45/64	.76	3/4 - 16	.94	21/32	3/16
24607	9/16 - 18										
24508	5/8 - 11	7/8 - 14	.87	.43	24708	53/64	.88	7/8 - 14	1.00	25/32	5/16
24608	5/8 - 18										
24509	3/4 - 10	1-1/8 - 12	1.12	.56	24709	1-1/16	1.14	1-1/8 - 12	1.31	31/32	5/16
24609	3/4 - 16										
24510	7/8 - 9	1-1/4 - 12	1.25	.62	24710	1-3/16	1.27	1-1/4 - 12	1.44	1-3/32	5/16
24610	7/8 - 14										
24511	1" - 8	1-3/8 - 12	1.37	.68	24711	1-5/16	1.39	1-3/8 - 12	1.56	1-7/32	5/16
24611	1" - 12										



**Metric Internal Locking Thread Repair Inserts**

Material: Inserts - 303 stainless steel or equivalent  
 Keys - 302 stainless steel or equivalent  
 Finish: Passivated  
 Tolerances: ±.25 mm unless specified otherwise.  
 Dimensions: All dimensions below are in millimeters  
 Keys: Inserts with an internal thread size of M7 and larger are furnished with 4 locking keys. Smaller sizes have 2 locking keys.



**Thinwall - Metric - Locking**

Part Number	Insert				Installation					Removal	
	Internal Thread Class 6H	External Thread Class 6g	Length	G (Ref.)	Installation Tool Part No.	Tap Drill Size	C'sink Dia. +.25 -.00	Thread Tap		Drill	
								Size Class 6h	Min. Depth	Size	Depth
24551	M 5x0.8	M8x1.25	8.0	4.0	24751	6.9	8.25	M 8x1.25	9.5	5.50	4.00
24552	M 6x1.0	M 10x1.25	10.0	5.0	24752	8.8	10.25	M 10x1.25	11.5	7.50	4.75
24553	M 8x1.25	M 12x1.25	12.0	6.0	24753	10.8	12.25	M 12x1.25	13.5	9.50	4.75
24653	M 8x1.0										
24555	M 10x1.5	M 14x1.5	14.0	7.0	24755	12.8	14.25	M 14x1.5	15.5	11.50	4.75
24655	M 10x1.25										
24556	M 12x1.75	M 16x1.5	16.0	8.0	24756	14.75	16.25	M 16x1.5	17.5	13.50	4.75
24656	M12x1.25										

**Heavy Duty - Metric - Locking**

Part Number	Insert				Installation					Removal	
	Internal Thread Class 6H	External Thread Class 6g	Length	G (Ref.)	Installation Tool Part No.	Tap Drill Size	C'sink Dia. +.25 -.00	Thread Tap		Drill	
								Size Class 6h	Min. Depth	Size	Depth
24563	M 4X0.7	M8x1.25	8.0	4.0	24763	6.9	8.25	M 8x1.25	9.5	5.50	4.00
24564	M 5x0.8	M 10x1.25	10.0	5.0	24764	8.8	10.25	M 10x1.25	12.5	7.50	4.75
24565	M 6x1.0	M 12x1.25	12.0	6.0	24765	10.8	12.25	M 12x1.25	14.5	9.50	4.75
24566	M 8x1.25	M 14x1.5	14.0	7.0	24766	12.8	14.25	M 14x1.5	16.5	11.50	4.75
24666	M 8x1.0										
24567	M 10x1.5	M 16x1.5	16.0	8.0	24767	14.75	16.25	M 16x1.5	18.5	13.50	4.75
24667	M 10x1.25										
24569	M 12x1.75	M 18x1.5	18.0	9.0	24769	16.75	18.25	M 18x1.5	20.5	15.50	4.75
24669	M 12x1.25										
24570	M 14x2.0	M 20x1.5	20.0	10.0	24770	18.75	20.25	M 20x1.5	22.5	17.50	4.75
24670	M 14x1.5										
24571	M 16x2.0	M 22x1.5	22.0	11.0	24771	20.5	22.25	M 22x1.5	24.5	17.75	6.35
24671	M 16x1.5										
24672	M 18x1.5	M 24x1.5	24.0	12.0	24772	22.5	24.25	M 24x1.5	26.5	19.75	6.35
24573	M 20x2.5	M 30x2.0	30.0	15.0	24773	28.0	30.25	M30x2.0	34.5	25.75	6.35
24673	M 20x1.5										
24674	M 22x1.5	M 32x2.0	32.0	16.0	24774	30.0	32.25	M 32x2.0	36.5	27.75	6.35
24575	M 24x3.0	M33x2.0	33.0	16.5	24775	31.0	33.25	M 33x2.0	37.5	28.75	6.35
24675	M 24x2.0										

## Miniature - Metric 303 CRES Keylocking Threaded Inserts

Material: Inserts - 303 CRES

Keys - 302 CRES

Finish: Passivated

Tolerances:  $\pm .25$  mm unless specified otherwise

Internal Threads: Per Fed Std H28/21, MJ Form

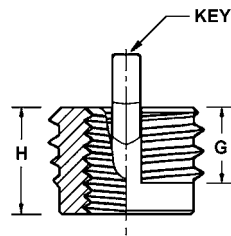
Dimensions: All dimensions below are in millimeters

Keys: Miniature Inserts are furnished with 2 locking keys

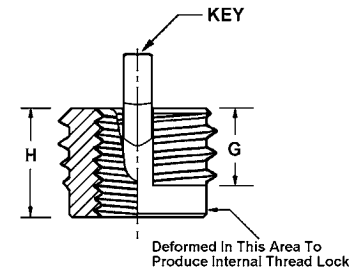
Material Identification Mark: None

Lubrication: Dry Film Lube on Self-Locking Inserts only

Non-Locking



Self-Locking



Part Number*			Insert			Installation					Removal	
Non-Locking	Self-Locking	Internal Thread Class 4H6H	External Thread Class 4h	Thread Length G	Length H	Install Tool Part No*	Tap Drill Size $+.080/- .025$	C'Sink Dia. $+.25/- .00$	Thread Tap		Drill	
									Size Class 6H	Min. Depth	Size	Depth
26382	27382	M 2x0.4	M 4x0.7	2.20	3.00	22682	3.4	4.1	M 4x0.7	4.0	2.8	2.00
26383	27383	M 2.5x0.45	M 4.5x0.75	2.70	3.81	22683	3.9	4.6	M 4.5x0.75	5.0	3.0	2.00
26384	27384	M 3x0.5	M 5x0.8	3.10	4.25	22684	4.4	5.1	M 5x0.8	5.5	3.5	2.25
26386	27386	M 4x0.7	M 6x0.75	4.11	5.25	22686	5.5	6.1	M 6x0.75	6.5	4.6	2.50

## Miniature - Inch 303 CRES Keylocking Threaded Inserts

Material: Inserts - 303 CRES

Keys - 302 CRES

Finish: Passivated

Tolerances:  $\pm .010$  inch unless specified otherwise

Internal Threads: Per SAE AS8879

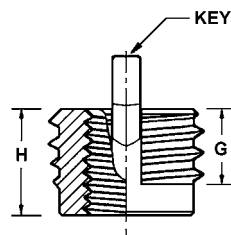
Dimensions: All dimensions below are in inches

Keys: Miniature Inserts are furnished with 2 locking keys

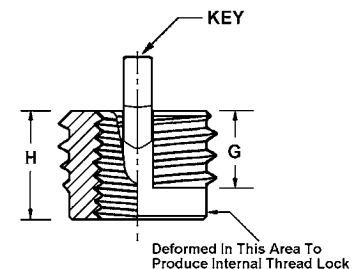
Material Identification Mark: None

Lubrication: Dry Film Lube on Self-Locking Inserts only

Non-Locking



Self-Locking



Part Number*			Insert			Installation					Removal	
Non-Locking	Self-Locking	Internal Thread Class 3B	External Thread Class 2A	G Thread Length	H Length	Install Tool Part No*	Tap Drill Size $+.003/- .001$	C'Sink Dia. $+.010/- .000$	Thread Tap		Drill	
									Size Class 2B	Min. Depth	Size	Depth
26283	27283	2 - 56	8 - 32	.090	.120	22552	.134	.166	8 - 32	.140	#33	1/16
26284	27284	4 - 40	10 - 32	.125	.170	22554	.161	.194	10 - 32	.160	#29	3/32
26285	27285	6 - 32	12 - 28	.125	.170	22556	.187	.220	12 - 28	.160	#21	3/32
26286	27286	8 - 32	1/4 - 28†	.175	.220	22558	.228	.255	1/4 - 28	.210	#8	1/8

† Modified Minor Diameter

High Strength Materials Available: These miniature inserts are also manufactured in high strength stainless steel (A-286 with heat treatment) and in alloy steel (4140 with heat treatment).

## MS/NAS Style Insert

Jergens now offers Mil-Spec Keylocking Threaded Inserts



### Thread Inserts

- Inch and metric sizes available
- Material: 303 CRES  
A286 CRES  
4140 Alloy Steel

Insert Style
<b>Miniature &amp; Lightweight</b> MS 51830/NAS 1394
<b>Heavy Duty</b> MS 51831/NAS 1395
<b>Extra Heavy Duty</b> MS 51832

**Please contact Jergens  
for cross reference and  
ordering information.  
1-800-Jergens (537-4367)**

## Master Thread Repair Kits

### Small Assortments



The Jergens Master Thread Repair Kits include several different kinds of inserts, installation tools and installation and removal instructions.

The Kits are available with inch or metric, carbon steel inserts or with stainless steel inserts.

### Coarse Series, Heavy Duty Kits

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

**Total Inserts Per Kit 60 pcs.**

**Carbon Steel Kit**

**25949**

**Stainless Steel Kit**

**26349**

### Fine Series, Heavy Duty Kits

Internal Thread Class 2B	External Thread 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

**Total Inserts Per Kit 60 pcs.**

**Carbon Steel Kit**

**26149**

**Stainless Steel Kit**

**26549**

### Metric, Thinwall Kits

Internal Thread Class 2B	External Thread Class 2A	Length (mm)	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	M 12x1.25	12.0	6
M 10x1.5	M 14x1.5	14.0	4
M 10x1.25	M 14x1.5	14.0	4
M 12x1.75	M 16x1.5	16.0	3
M 12x1.25	M 16x1.5	16.0	3

**Total Inserts Per Kit 42 pcs.**

**Metric Carbon Steel Kit**

**25999**

**Stainless Steel Kit**

**25998**

## Master Thread Repair Kits Large Assortments

### Coarse Series, Heavy Duty Kits

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

Total Inserts Per Kit 77 pcs.

Carbon Steel Kit
<b>25945</b>

Stainless Steel Kit
<b>26345</b>

### Fine Series, Heavy Duty Kits

Internal Thread Class 2B	External Thread (Mod) Class 2A	Length	Quantity of Inserts Per Kit
1/4 - 28	7/16 - 14	.37	10
5/16 - 24	1/2 - 13	.43	10
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

Total Inserts Per Kit 77 pcs.

Carbon Steel Kit
<b>26145</b>

Stainless Steel Kit
<b>26545</b>

### Metric, Thinwall Kits

Internal Thread Class 6H	External Thread Class 6g	Length (mm)	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	M 12x1.25	12.0	15
M 10x1.5	M 14x1.5	14.0	10
M 10x1.25	M 14x1.5	14.0	10
M 12x1.75	M 16x1.5	16.0	6
M 12x1.25	M 16x1.5	16.0	6

Total Inserts Per Kit 82 pcs.

Metric Carbon Steel Kit
<b>25997</b>

Stainless Steel Kit
<b>25996</b>

### Coarse Series, Thinwall Kits

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

Total Inserts Per Kit 81 pcs.

Carbon Steel Kit
<b>25948</b>

Stainless Steel Kit
<b>26348</b>

### Fine Series, Thinwall Kits

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

Total Inserts Per Kit 81 pcs.

Carbon Steel Kit
<b>25947</b>

Stainless Steel Kit
<b>26548</b>

## Inch Thread Repair Insert Kits



The Jergens Keylocking Inserts provide strong and durable threads in most types of material. They are easily installed using standard drills and taps.

**The Jergens Thread Repair Insert Kits include inserts, an installation tool, and installation and removal instructions.**

The Kits are available with either inch, metric, or metric internal/inch external carbon steel inserts.

Each Kit is comprised of one size of insert in various quantities. For Thread Repair Kits that include several different sizes, see pages 3.12 - 3.13.

### Inch Thread Kits - Heavy Duty

Carbon Steel Part Number	Stainless Steel Part Number	Internal Thread	External Thread	Inserts Per Kit	Insert Part Number	Stainless Steel Insert Part Number	Tool Part Number
75900	76300	8-32	5/16-18	9	25900	26300	24700
75901	76301	10-24	3/8-16	9	25901	26301	24701
76101	76501	10-32	3/8-16	9	26101	26501	24701
75902	76302	1/4-20	7/16-14	8	25902	26302	24702
76102	76502	1/4-28	7/16-14	8	26102	26502	24702
75903	76303	5/16-18	1/2-13	7	25903	26303	24703
76103	76503	5/16-24	1/2-13	7	26103	26503	24703
75904	76304	3/8-16	9/16-12	6	25904	26304	24704
76104	76504	3/8-24	9/16-12	6	26104	26504	24704
75905	76305	7/16-14	5/8-11	6	25905	26305	24705
76105	76505	7/16-20	5/8-11	6	26105	26505	24705
75906	76306	1/2-13	3/4-16	4	25906	26306	24706
76106	76506	1/2-20	3/4-16	4	26106	26506	24706
75907	76307	9/16-12	3/4-16	3	25907	26307	24707
76107	76507	9/16-18	3/4-16	3	26107	26507	24707
75908	76308	5/8-11	7/8-14	3	25908	26308	24708
76108	76508	5/8-18	7/8-14	3	26108	26508	24708
75909	76309	3/4-10	1 1/8-12	3	25909	26309	24709
76109	76509	3/4-16	1 1/8-12	3	26109	26509	24709
75910	76310	7/8-9	1 1/4-12	3	25910	26310	24710
76110	76510	7/8-14	1 1/4-12	3	26110	26510	24710
75911	76311	1 - 8	1 3/8-12	2	25911	26311	24711
76111	76511	1 -12	1 3/8-12	2	26111	26511	24711
75913		1 1/8-7	1 1/2-12	2	25913		24713
76113		1 1/8-12	1 1/2-12	2	26113		24713
75914		1 1/4-7	1 5/8-12	2	25914		24714
76114		1 1/4-12	1 5/8-12	2	26114		24714
75916		1 1/2-6	1 7/8-12	2	25916		24716
76116		1 1/2-12	1 7/8-12	2	26116		24716

### Inch Thread Kits - Thin Wall

Carbon Steel Part Number	Stainless Steel Part Number	Internal Thread	External Thread	Inserts Per Kit	Carbon Steel Insert Part Number	Stainless Steel Insert Part Number	Installation Tool Part Number
75921	76421	10-24	5/16-18	9	25921	26321	24721
76121	76521	10-32	5/16-18	9	26121	26521	24721
75922	76422	1/4-20	3/8-16	8	25922	26322	24722
76122	76522	1/4-28	3/8-16	8	26122	26522	24722
75923	76423	5/16-18	7/16-14	7	25923	26323	24723
76123	76523	5/16-24	7/16-14	7	26123	26523	24723
75924	76424	3/8-16	1/2-13	6	25924	26325	24724
76124	76524	3/8-24	1/2-13	6	26124	26524	24724
75925	76425	7/16-14	9/16-12	6	25925	26325	24725
76125	76525	7/16-20	9/16-12	6	26125	26525	24725
75926	76426	1/2-13	5/8-11	4	25926	26326	24726
76126	76526	1/2-20	5/8-11	4	26126	26526	24726

# Metric Thread Repair Insert Kits



The Jergens Keylocking Inserts provide strong and durable threads in most types of material. They are easily installed using standard drills and taps.

**The Jergens Thread Repair Insert Kits include inserts, an installation tool, and installation and removal instructions.**

The Kits are available with either inch, metric, or metric internal/inch external carbon steel inserts.

Each Kit is comprised of one size of insert in various quantities. For Thread Repair Kits that include several different sizes, see pages 3.12 - 3.13.

## Metric Thread Kits - Heavy Duty

Carbon Steel Part Number	Stainless Steel Part Number	Internal Thread	External Thread	Inserts Per Kit	Insert Part Number	Stainless Steel Insert Part Number	Tool Part Number
75963	76463	M4x0.7	M8x1.25	9	25963	26363	24763
75964	76464	M5x0.8	M10x1.25	8	25964	26364	24764
75965	76465	M6x1.0	M12x1.25	8	25965	26365	24765
75966	76466	M8x1.25	M14x1.5	6	25966	26366	24766
76166	76566	M8x1.0	M14x1.5	6	26166	26566	24766
75967	76467	M10x1.5	M16x1.5	4	25967	26367	24767
76167	76567	M10x1.25	M16x1.5	4	26167	26567	24767
75969	76469	M12x1.75	M18x1.5	3	25969	26369	24769
76169	76569	M12x1.25	M18x1.5	3	26169	26569	24769
75970	76470	M14x2.0	M20x1.5	4	25970	26370	24770
76170	76570	M14x1.5	M20x1.5	4	26170	26570	24770
75971	76471	M16x2.0	M22x1.5	3	25971	26371	24771
76171	76571	M16x1.5	M22x1.5	3	26171	26571	24771
76172	76572	M18x1.5	M24x1.5	2	26172	26572	24772
75973	76473	M20x2.5	M30x2.0	3	25973	26373	24773
76173	76573	M20x1.5	M30x2.0	3	26173	26573	24773
76174	76574	M22x1.5	M32x2.0	3	26174	26574	24774
75975	76475	M24x3.0	M33x2.0	3	25975	26375	24775
76175	76575	M24x2.0	M33x2.0	2	26175	26575	24775

## Metric Thread - Thin Wall

Carbon Steel Part Number	Stainless Steel Part Number	Internal Thread	External Thread	Inserts Per Kit	Insert Part Number	Stainless Steel Insert Part Number	Tool Part Number
75951	76451	M5x0.8	M8x1.25	8	25951	26351	24751
75952	76452	M6x1.0	M10x1.25	8	25952	26352	24752
75953	76453	M8x1.25	M12x1.25	6	25953	26353	24753
76153	76553	M8x1.0	M12x1.25	6	26153	26553	24753
75955	76455	M10x1.5	M14x1.5	4	25955	26355	24755
76155	76555	M10x1.25	M14x1.5	4	26155	26555	24755
75956	76456	M12x1.75	M16x1.5	3	25956	26356	24756
76156	76556	M12x1.25	M16x1.5	3	26156	26556	24756

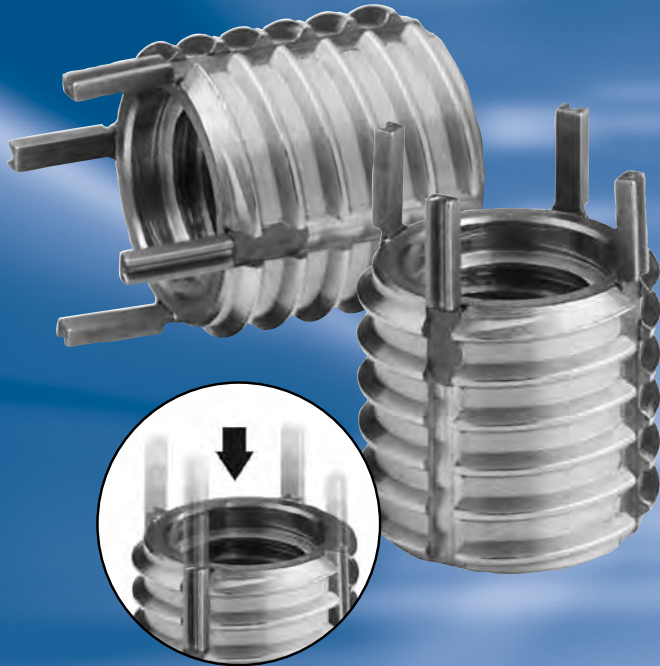
## Carbon Steel Kits - Metric Internal/Inch External Threads - Heavy Duty

Part Number	Internal Thread	External Thread	Inserts Per Kit	Insert Part Number	Tool Part Number
76243	M 6x1.0	3/8 - 16	8	26243	24843
76244	M 8x1.25	1/2 - 13	8	26244	24844
76245	M 10x1.5	5/8 - 11	6	26245	24845
76247	M 12x1.75	3/4 - 16	4	26247	24847
76248	M 14x2.0	7/8 - 14	3	26248	24848
76249	M 16x2.0	1" - 12	3	26249	24849

THE *Jergens*® DIFFERENCE

# Keylocking Inserts

**OURS**



Jergens keylocking inserts are easy to install with standard drills and taps.

**THEIRS**



Competitive thread repair devices require special drills, taps, and installation tools.

## **JERGENS KEYLOCKING INSERTS**

**VS.**

## **THREAD REPAIR FROM OTHER MANUFACTURERS**

Easy installation requires no special tools: uses standard drills and standard taps.

Installation requires special drills, taps, and installation tools.

"Keys" mechanically lock the insert into the base material.

Springs or locking patches do not mechanically lock the insert.

Rated among the highest in pullout strength of any thread repair device on the market.

Less pullout strength versus Jergens inserts.

Wide variety of styles, including thinwall, heavy duty, extra heavy duty, and solid inserts in both stainless steel and carbon steel materials.

Limited offerings may force you to settle on a device that doesn't meet all of your needs.

***Jergens***®

*The Standard Components with the Highest Standards™*

15700 Waterloo Road • Cleveland, OH 44110 • 800.537.4367 • [www.jergensinc.com](http://www.jergensinc.com)