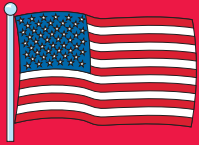


ROCK SOLID

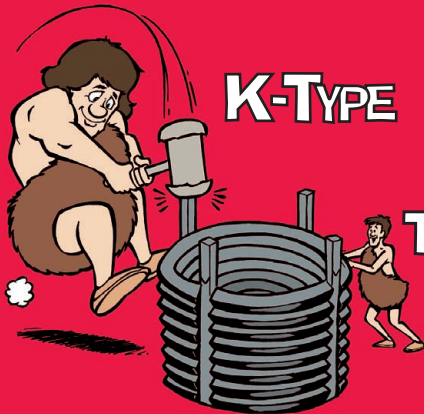
THREADED INSERTS



Made in the U.S.A.



In God We Trust



K-TYPE

**MAKE YOUR
THREAD REPAIRS
SOLID AS A**

ROCK



DISTRIBUTED BY



CHRISLYNN

THREADED

INSERTS

PRECISION



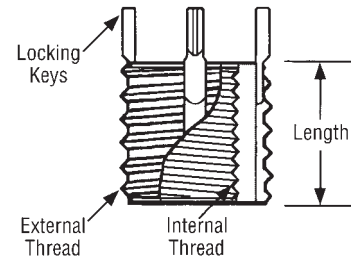
MS/NAS style inserts are produced to the following standards:

MS51830	NAS1395	NA0149
MS51831	NA0146	NA0150
MS51832	NA0147	NA0151
NAS1394	NA0148	

Call for part numbers and pricing on all certified requirements.

Rock Solid Inserts

A solid insert that is threaded on the outside with wedges (keys) attached to the top of the insert. After the part is re-threaded, the insert is screwed into the part and the wedges are driven down into the tapped threads to keep the insert from turning in either direction.



Perfect Installations using the **NEW CORRECTOR TOOL**



AFTER DRILLING & TAPPING:

Engage insert keys into vertical slots of the tool



Screw insert into part and flush with the top of part



Lift – Rotate tool
Hole fits over the keys –
Drive down as far as possible



Turn tool until timing mark lines up with key –
Drive until keys even with top of insert

Materials Available

- A. Carbon Steel - C1215 or equivalent
- B. Stainless Steel - 303
- C. Stainless Steel - 316
- D. A286 Stainless
- E. 4141 Alloy

Diameters Available

- A. American - #2 to 1 1/2"
- B. Metric - M2 to M24

Types Available

- A. Free Running
- B. Locking

Wall Thicknesses Available

- A. Thin Wall
- B. Heavy-Duty Wall
- C. Extra-Heavy-Duty Wall
- D. Solid Blank (Outside Thread Only)
- E. Miniatures

“Why?” Rock Solid Inserts

1. Only **Standard** Drills and Tap required.
2. Can be used in most materials... aluminum, magnesium, cast iron, carbon & stainless steel and plastic.

3. Simple installation compared to helical wire inserts.
4. Near **impossible** for the insert to turn after installation.
5. Near **impossible** to cross thread while installing.
6. Adhesive not required to hold insert in place.
7. Rarely affected by hot or cold temperatures because it is held in place mechanically.
8. Easy to remove.

Master Range - Repair Kits

M-KIT (MINI KIT)



C-KIT (COMPLETE KIT)

THIN WALL

HEAVY DUTY

M-Kit Without Drill & Tap		C-Kit With Drill & Tap		M-Kit Without Drill & Tap		C-Kit With Drill & Tap	
UNC	64969		64970		64962		64972
1/4-20 5/16-18 3/8-16 7/16-14 1/2-13				← Sizes			
UNF	64961		64971		64963		64973
1/4-28 5/16-24 3/8-24 7/16-20 1/2-20				← Sizes			
METRIC COARSE	64964		64974		64965		64975
M5x.08 M6x1 M8x1.25 M10x1.5 M12x1.75				← Sizes			
METRIC FINE	N/A		N/A		64966		64976
M4x.07 M8x1 M10x1.25 M12x1.25 M14x1.5				← Sizes			

Total Range - Repair Kits



CONTAINS:

- 1 - 64972 American Coarse
- 1 - 64973 American Fine
- 1 - 64975 Metric Coarse
- 1 - 64976 Metric Fine

	Order No.
WITHOUT LOCK	64967
WITH LOCK	64968



Total Kit - Combination

NOTE: Total Kit contains heavy duty inserts with tap, drill & tool for each thread size

Assortment Kits - Inserts Only

THIN WALL - AMERICAN

Carbon Steel	64900
303 Stainless	64901

HEAVY-DUTY WALL AMERICAN

Carbon Steel	64905
303 Stainless	64906



THIN WALL - METRIC

Carbon Steel	64910
303 Stainless	64911

HEAVY-DUTY WALL METRIC

Carbon Steel	64915
303 Stainless	64916

CONTAINS:

- | | |
|--------------|--------------|
| 12 - 10-24 | 12 - 10-32 |
| 12 - 1/4-20 | 12 - 1/4-28 |
| 10 - 5/16-18 | 10 - 5/16-24 |
| 10 - 3/8-16 | 10 - 3/8-24 |
| 6 - 7/16-14 | 6 - 7/16-20 |
| 6 - 1/2-13 | 6 - 1/2-20 |

CONTAINS:

- | | |
|--------------|---------------|
| 12 - M5x.08 | 10 - M10x1.5 |
| 12 - M6x1 | 10 - M10x1.25 |
| 10 - M8x1.25 | 6 - M12x1.75 |
| 10 - M8x1 | 6 - M12x1.25 |

Single Size - Repair Kits

M-KIT (MINI KIT)

CONTAINS: (for each thread size)

- 1 - Tool
- 1 - Package of Inserts

THIN WALL - AMERICAN

KITS

Inside Thread	Outside Thread	Insert Quantity	M-Kit Part Number	C-Kit Part Number
10-24	5/16-18	4	68921	69921
10-32			68121	69121
1/4-20	3/8-16	4	68922	69922
1/4-28			68122	69122
5/16-18	7/16-14	4	68923	69923
5/16-24			68123	69123
3/8-16	1/2-13	3	68924	69924
3/8-24			68124	69124
7/16-14	9/16-12	3	68925	69925
7/16-20			68125	69125
1/2-13	5/8-11	3	68926	69926
1/2-20			68126	69126

HEAVY-DUTY WALL - AMERICAN

KITS

Inside Thread	Outside Thread	Insert Quantity	M-Kit Part Number	C-Kit Part Number
8-32	5/16-18	4	68900	69900
10-24	3/8-16	4	68901	69901
10-32			68101	69101
1/4-20	7/16-14	4	68902	69902
1/4-28			68102	69102
5/16-18	1/2-13	4	68903	69903
5/16-24			68103	69103
3/8-16	9/16-12	3	68904	69904
3/8-24			68104	69104
7/16-14	5/8-11	3	68905	69905
7/16-20			68105	69105
1/2-13	3/4-16	3	68906	69906
1/2-20			68106	69106
9/16-12	3/4-16	3	68907	69907
9/16-18			68107	69107
5/8-11	7/8-14	2	68908	69908
5/8-18			68108	69108
3/4-10	1 1/8-12	2	68909	69909
3/4-16			68109	69109
7/8-9	1 1/4-12	2	68910	69910
7/8-14			68110	69110
1-8	1 3/8-12	2	68911	69911
1-12			68111	69111
1-14			68112	69112
1 1/8-7	1 1/2-12	2	68913	69913
1 1/8-12	1 1/2-12		68113	69113
1 1/4-7	1 5/8-12	2	68914	69914
1 1/4-12	1 5/8-12		68114	69114
1 1/2-6	1 7/8-12	2	68916	69916
1 1/2-12	1 7/8-12		68116	69116

C-KIT (COMPLETE KIT)

CONTAINS: (for each thread size)

- 1 - Tool
- 1 - Drill
- 1 - Tap
- 1 - Package of Inserts

REPLACEMENT PARTS



Refill Package	Tool Part Number	Tap Part Number	Drill Part Number	Drill Size
65921	67721	63100	81017	I
66121	67821			
65922	67722	63101	81019	Q
66122	67822			
65923	67723	63102	81026	X
66123	67823			
65924	67724	63103	81022	29/64
66124	67824			
65925	67725	63104	81021	33/64
66125	67825			
65926	67726	63105	81023	37/64
66126	67826			

REPLACEMENT PARTS



Refill Package	Tool Part Number	Tap Part Number	Drill Part Number	Drill Size
65900	67700	63100	81017	I
65901	67701	63101	81019	Q
66101	67801			
65902	67702	63102	81026	X
66102	67802			
65903	67703	63103	81022	29/64
66103	67803			
65904	67704	63104	81021	33/64
66104	67804			
65905	67705	63105	81023	37/64
66105	67805			
65906	67706	63106	81078	45/64
66106	67806			
65907	67707	63106	81078	45/64
66107	67807			
65908	67708	63107	81084	53/64
66108	67808			
65909	67709	63108	81091	1 1/16
66109	67809			
65910	67710	63109	81039	1 3/16
66110	67810			
65911	67711	63110	81059	1 5/16
66111	67811			
66112	67811			
65913	67713	63113	81098	1 7/16
66113	67813			
65914	67714	63114	81114	1 9/16
66114	67814			
65916	67716	63115	81062	1 13/16
66116	67816			

Single Size - Repair Kits

M-KIT (MINI KIT)

CONTAINS: (for each thread size)

- 1 - Tool
- 1 - Package of Inserts

THIN WALL - METRIC

KITS

Inside Thread	Outside Thread	Insert Quantity	M-Kit Part Number	C-Kit Part Number
M5x.8	M8x1.25	4	68951	69951
M6x1	M10x1.25	4	68952	69952
M8x1.25	M12x1.25	4	68953	69953
M8x1			68153	69153
M10x1.5	M14x1.5	3	68955	69955
M10x1.25			68155	69155
M12x1.75	M16x1.5	3	68956	69956
M12x1.25			68156	69156

HEAVY-DUTY WALL - METRIC

KITS

Inside Thread	Outside Thread	Insert Quantity	M-Kit Part Number	C-Kit Part Number
M4x.7	M8x1.25	4	68963	69963
M5x.8	M10x1.25	4	68964	69964
M6x1	M12x1.25	4	68965	69965
M8x1.25	M14x1.5	4	68966	69966
M8x1			68166	69166
M10x1.5	M16x1.5	3	68967	69967
M10x1.25			68167	69167
M12x1.75	M18x1.5	3	68969	69969
M12x1.25			68169	69169
M14x2	M20x1.5	3	68970	69970
M14x1.5			68170	69170
M16x2	M22x1.5	2	68971	69971
M16x1.5			68171	69171
M18x1.5	M24x1.5	2	68172	69172
M20x2.5	M30x2	2	68973	69973
M20x1.5			68173	69173
M22x1.5	M32x2	2	68174	69174
M24x3	M33x2	2	68975	69975
M24x2			68175	69175

MINIATURE KITS - AMERICAN & METRIC

(303 Stainless Only)

KITS

Inside Thread	Outside Thread	Insert Quantity	M-Kit Part Number	C-Kit Part Number
2-56	8-32	4	68283	69283
4-40	10-32	4	68284	69284
6-32	12-28	4	68285	69285
8-32	1/4-28	4	68286	69286
M2x0.4	4x0.7	4	68382	69382
M3x0.5	5x0.8	4	68384	69384
M4x0.7	6x0.75	4	68386	69386

C-KIT (COMPLETE KIT)

CONTAINS: (for each thread size)

- 1 - Tool
- 1 - Drill
- 1 - Tap
- 1 - Package of Inserts

REPLACEMENT PARTS



Refill Package	Tool Part Number	Tap Part Number	Drill Part Number	Drill Size
65951	67751	63163	81017	I
65952	67752	63164	81071	11/32
65953	67753	63165	81029	27/64
66153	67853			
65955	67755	63166	81030	1/2
66155	67855			
65956	67756	63167	81023	37/64
66156	67856			

REPLACEMENT PARTS



Refill Package	Tool Part Number	Tap Part Number	Drill Part Number	Drill Size
65963	67763	63163	81017	I
65964	67764	63164	81071	11/32
65965	67765	63165	81029	27/64
65966	67766	63166	81030	1/2
66166	67866			
65967	67767	63167	81023	37/64
66167	67867			
65969	67769	63169	81080	21/32
66169	67869			
65970	67770	63170	81082	47/64
66170	67870			
65971	67771	63171	81085	13/16
66171	67871			
66172	67772	63172	81034	57/64
65973	67773	63173	81089	13/32
66173				
66174	67774	63174	81039	13/16
65975	67775	63175	81094	17/32
66175				

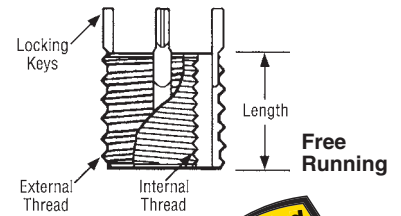
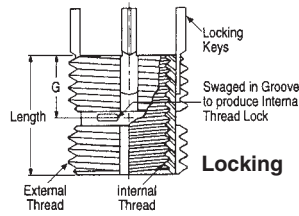
REPLACEMENT PARTS



Refill Package	Tool Part Number	Tap Part Number	Drill Part Number	Drill Size
65283	67712M	63090	81006	#29
65284	67713M	63091	81191	#20
65285	67714M	63092	81192	3/16
65286	67715M	63093	81193	#1
65382	67716M	63095	81006	#29
65384	67718M	63097	81009	#17
65386	67719M	63098	81198	7/32

Rock Solid - Thread Repair Inserts

NOTE: Tap size is the same as insert outside diameter.



THIN WALL - AMERICAN

INSERT SIZE		PART NUMBER					INSTALLATION		
Inside Thread	Outside Thread	Carbon Steel	303 SST	303 SST Locking	316 SST	A286 SST	Insert Length	Tool Number	Tap Drill
10-24	5/16-18	65921	66321	71321			.31	67721	I
10-32		66121	66521	71521				67821	
1/4-20	3/8-16	65922	66322	71322			.37	67722	Q
1/4-28		66122	66522	71522				67822	
5/16-18	7/16-14	65923	66323	71323	CALL	CALL	.43	67723	X
5/16-24		66123	66523	71523				67823	
3/8-16	1/2-13	65924	66324	71324	FOR	FOR	.50	67724	29/64
3/8-24		66124	66524	71524				67824	
7/16-14	9/16-12	65925	66325	71325	QUOTE	QUOTE	.56	67725	33/64
7/16-20		66125	66525	71525				67825	
1/2-13	5/8-11	65926	66326	71326			.62	67726	37/64
1/2-20		66126	66526	71526				67826	

HEAVY DUTY - AMERICAN

INSERT SIZE		PART NUMBER					INSTALLATION		
Inside Thread	Outside Thread	Carbon Steel	303 SST	303 SST Locking	316 SST	A286 SST	Insert Length	Tool Number	Tap Drill
8-32	5/16-18	65900	66300	71300			.31	67700	I
10-24	3/8-16	65901	66301	71301			.31	67701	Q
10-32		66101	66501	71501				67801	
1/4-20	7/16-14	65902	66302	71302			.37	67702	X
1/4-28		66102	66502	71502				67802	
5/16-18	1/2-13	65903	66303	71303			.43	67703	29/64
5/16-24		66103	66503	71503				67803	
3/8-16	9/16-12	65904	66304	71304			.50	67704	33/64
3/8-24		66104	66504	71504				67804	
7/16-14	5/8-11	65905	66305	71305			.62	67705	37/64
7/16-20		66105	66505	71505				67805	
1/2-13	3/4-16	65906	66306	71306			.62	67706	45/64
1/2-13	11/16-11	N/A	76306	77306				67726 C	41/64
1/2-20	3/4-16	66106	66506	71506				67806	45/64
1/2-20	11/16-11	N/A	76506	77506	CALL	CALL		67826 C	41/64
9/16-12	3/4-16	65907	66307	71307			.81	67707	45/64
9/16-18		66107	66507	71507	FOR	FOR		67807	
5/8-11	7/8-14	65908	66308	71308			.87	67708	53/64
5/8-18		66108	66508	71508	QUOTE	QUOTE		67808	
3/4-10	1 1/8-12	65909	66309	71309			1.12	67709	1 1/16
3/4-16		66109	66509	71509					
7/8-9	1 1/4-12	65910	66310	71310			1.25	67710	1 3/16
7/8-14		66110	66510	71510					
1-8	1 3/8-12	65911	66311	71311			1.37	67711	1 5/16
1-12		66111	66511	71511					
1-14		66112	~	~					
1 1/8-7	1 1/2-12	65913	~	~			1.62	67713	1 7/16
1 1/8-12		66113	~	~					
1 1/4-7	1 5/8-12	65914	~	~			1.81	67714	1 9/16
1 1/4-12		66114	~	~					
1 1/2-6	1 7/8-12	65916	~	~			2.00	67716	1 13/16
1 1/2-12		66116	~	~					

Rock Solid - Thread Repair Inserts

EXTRA HEAVY DUTY - AMERICAN

INSERT SIZE		PART NUMBER					INSTALLATION		
Inside Thread	Outside Thread	Carbon Steel	303 SST	303 SST Locking	316 SST	A286 SST	Insert Length	Tool Number	Tap Drill
6-32	5/16-18	65931	66331				.31	67731	I
8-32	3/8-16	65932	66332				.31	67732	Q
10-24	7/16-14	65933	66333				.31	67733	X
10-32		66133	66533						
1/4-20	1/2-13	65934	66334				.37	67734	29/64
1/4-28		66134	66534						
5/16-18	9/16-12	65935	66335				.43	67735	33/64
5/16-24		66135	66535						
3/8-16	5/8-11	65936	66336				.50	67736	37/64
3/8-24		66136	66536	CALL	CALL	CALL			
7/16-14	3/4-16	65937	66337				.62	67737	45/64
7/16-20		66137	66537	FOR	FOR	FOR			
1/2-13	7/8-14	65938	66338				.68	67738	53/64
1/2-20		66138	66538	QUOTE	QUOTE	QUOTE			
9/16-12	7/8-14	65939	66339				.81	67739	53/64
9/16-18		66139	66539						
5/8-11	1-12	65940	66340				.87	67740	15/16
5/8-18		66140	66540						
3/4-10	1 1/4-12	65941	66341				1.12	67741	1 3/16
3/4-16		66141	66541						
7/8-9	1 3/8-12	65942	66342				1.25	67742	1 5/16
7/8-14		66142	66542						
1-8	1 1/2-12	65943	66343				1.37	67743	1 7/16
1-12		66143	66543						



THIN WALL - METRIC

INSERT SIZE		PART NUMBER					INSTALLATION		
Inside Thread	Outside Thread	Carbon Steel	303 SST	303 SST Locking	316 SST	A286 SST	Insert Length	Tool Number	Tap Drill
M5x.8	M8x1.25	65951	66351	71351			8.0	67751	6.9
M6x1	M10x1.25	65952	66352	71352			10.0	67752	8.8
M8x1.25	M12x1.25	65953	66353	71353	CALL	CALL	12.0	67753	10.8
M8x1		66153	66553	71553				67853	
M10x1.5	M14x1.5	65955	66355	71355	FOR	FOR	14.0	67755	12.8
M10x1.25		66155	66555	71555				67855	
M12x1.75	M16x1.5	65956	66356	71356	QUOTE	QUOTE	16.0	67756	14.75
M12x1.25		66156	66556	71556				67856	



HEAVY DUTY - METRIC

INSERT SIZE		PART NUMBER					INSTALLATION		
Inside Thread	Outside Thread	Carbon Steel	303 SST	303 SST Locking	316 SST	A286 SST	Insert Length	Tool Number	Tap Drill
M4x.7	M8x1.25	65963	66363	71363			8.0	67763	6.9
M5x.8	M10x1.25	65964	66364	71364			10.0	67764	8.8
M6x1	M12x1.25	65965	66365	71365			12.0	67765	10.8
M8x1.25	M14x1.5	65966	66366	71366	CALL	CALL	14.0	67766	12.8
M8x1		66166	66566	71566				67866	
M10x1.5	M16x1.5	65967	66367	71367	FOR	FOR	16.0	67767	14.75
M10x1.25		66167	66567	71567				67867	
M12x1.75	M18x1.5	65969	66369	71369	QUOTE	QUOTE	18.0	67769	16.75
M12x1.25		66169	66569	71569				67869	
M14x2	M20x1.5	65970	66370	71370			20.0	67770	18.75
M14x1.5		66170	66570	71570				67870	



Rock Solid - Thread Repair Inserts

HEAVY DUTY - METRIC *Continued*

INSERT SIZE		PART NUMBER					INSTALLATION		
Inside Thread	Outside Thread	Carbon Steel	303 SST	303 SST Locking	316 SST	A286 SST	Insert Length	Tool Number	Tap Drill
M16x2	M22x1.5	65971	66371	71371			22.0	67771	20.5
M16x1.5		66171	66571	71571				67871	
M18x1.5	M24x1.5	66172	66572	71572	CALL	CALL	24.0	67772	22.5
M20x2.5	M30x2	65973	66373	71373			30.0	67773	28.0
M20x1.5		66173	66573	71573	FOR	FOR			
M22x1.5	M32x2	66174	66574	71574			32.0	67774	30.0
M24x3	M33x2	65975	66375	71375	QUOTE	QUOTE	33.0	67775	31.0
M24x2		66175	66575	71575					



SOLID - AMERICAN (OUTSIDE THREAD ONLY)

PART NUMBER				
Outside Thread	Carbon Steel	303 SST	Tool Number	Tap Drill
5/16-18	66601	66401	67701 B	I
3/8-16	66602	66402	67702 B	Q
7/16-14	66603	66403	67703 B	X
1/2-13	66604	66404	67704 B	29/64
9/16-12	66605	66405	67705 B	33/64
5/8-11	66606	66406	67706 B	37/64
3/4-16	66607	66407	67707 B	45/64
7/8-14	66608	66408	67708 B	53/64
1-12	66609	66409	67709 B	15/16
1 1/8-12	66610	66410	67710 B	1 1/16
1 1/4-12	66611	66411	67711 B	1 3/16
1 3/8-12	66612	66412	67712 B	1 5/16



SOLID - METRIC (OUTSIDE THREAD ONLY)

PART NUMBER				
Outside Thread	Carbon Steel	303 SST	Tool Number	Tap Drill
M8x1.25	66621	66421	67721 B	6.9
M10x1.25	66622	66422	67722 B	8.8
M12x1.25	66623	66423	67723 B	10.8
M14x1.5	66624	66424	67724 B	12.8
M16x1.5	66625	66425	67725 B	14.75
M18x1.5	66626	66426	67726 B	16.75
M20x1.5	66627	66427	67727 B	18.75
M22x1.5	66628	66428	67728 B	20.5
M24x1.5	66629	66429	67729 B	22.5
M30x2	66630	66430	67730 B	28.0
M32x2	66631	66431	67731 B	30.0
M33x2	66632	66432	67732 B	31.0



MINIATURE - AMERICAN (303 SST) (Meets MS Spec)

PART NUMBER				
Inside Thread	Outside Thread	Non Lock Insert	Locking Insert	Tool Number
2-56	8-32	76283	77283	67712
4-40	10-32	76284	77284	67713
6-32	12-28	76285	77285	67714
8-32	1/4-28	76286	77286	67715



MINIATURE - METRIC (303 SST) (Meets MS Spec)

PART NUMBER				
Inside Thread	Outside Thread	Non Lock Insert	Locking Insert	Tool Number
M2x0.4	M4x0.7	76382	77382	67716
M2.5x0.45	M4.5x0.75	76383	77383	67717
M3x0.5	M5x0.8	76384	77384	67718
M4x0.7	M6x0.75	76386	77385	67719

