

KEY INSERTS – SOLID

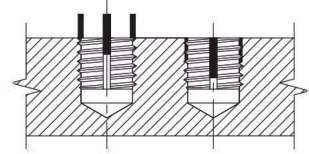
BODY: 1215 STEEL, BLACK OXIDE FINISH OR DRY LUBE, OR 303 STAINLESS STEEL.
KEYS: 302 STAINLESS STEEL



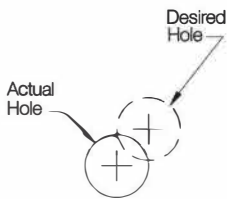
**Solid –
Steel and
Stainless Steel**

Solid Key Inserts are ideal for relocating a drilled or tapped hole. This threaded plug installs quickly, and the locking keys positively prevent the insert from rotating.

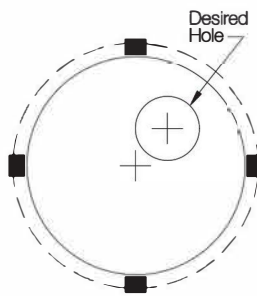
See Technical Information at the beginning of this section for complete installation steps. Key Inserts are installed with standard drills and taps. Important: Use exactly the tap-drill size specified in the tables (slightly larger than the standard tap drill for that thread size). Locking keys are driven down into the parent material during installation, providing a positive mechanical lock against rotation. See tables for optional installation tools.



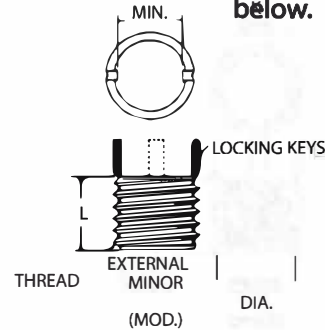
**For installation
tools, see table
below.**



Before Repair



After Repair



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SOLID – STAINLESS STEEL (INCH)

PART NO.	INSERT DIMENSIONS				INSTALLATION DATA				REMOVAL DATA		
	EXTERNAL THREAD	L	K	SHEAR ENGAGEMENT (SQ. IN.)	REQ'D TAP DRILL	C'SINK DIA +.010/-0.000	STANDARD TAP UN-2B	MIN. THREAD DEPTH	INSTALLATION TOOL PART NO.	DRILL SIZE	DRILL DEPTH
CL-51618-KSS	5/16-18	.31	.216	.152	I	.323	5/16-18	.37	CL-51618-KSST	7/32	1/8
CL-3816-KSS	3/8-16	.31	.285	.190	Q	.385	3/8-16	.37	CL-3816-KSST	9/32	1/8
CL-71614-KSS	7/16-14	.37	.341	.284	X	.447	7/16-14	.43	CL-71614-KSST	11/32	3/16
CL-1213-KSS	1/2-13	.43	.403	.359	29/64	.510	1/2-13	.50	CL-1213-KSST	13/32	3/16
CL-91612-KSS	9/16-12	.50	.465	.498	33/64	.572	9/16-12	.56	CL-91612-KSST	15/32	3/16
CL-5811-KSS	5/8-11	.62	.528	.717	37/64	.635	5/8-11	.68	CL-5811-KSST	17/32	3/16
CL-111611-KSS	11/16-11-NS	.68	.590	.888	41/64	.700	11/16-11-NS	.75	CL-111611-KSST	19/32	3/16
CL-131616-KSS	13/16-16	.81	.716	1.249	49/64	.822	13/16-16	.94	CL-131616-KSST	23/32	3/16
CL-7814-KSS	7/8-14	.87	.778	1.487	53/64	.885	7/8-14	1.00	CL-7814-KSST	25/32	3/16
CL-11812-KSS	1-1/8"-12	1.12	.970	2.490	1-1/16	1.145	1-1/8"-12	1.31	CL-11812-KSST	31/32	5/16
CL-11412-KSS	1-1/4"-12	1.25	1.095	3.137	1-3/16	1.270	1-1/4"-12	1.41	CL-11412-KSST	1-3/32	5/16
CL-13812-KSS	1-3/8"-12	1.37	1.220	3.838	1-5/16	1.395	1-3/8"-12	1.56	CL-13812-KSST	1-7/32	5/16

SOLID – STEEL (METRIC)

PART NO.	EXTERNAL THREAD	EXTERNAL THREAD PITCH (mm)	L LENGTH (mm)	K MINIMUM (mm)	SHEAR ENGAGEMENT AREA (sq mm)
CLM-8125-KSSM	M8	1.25	8	5.5	99
CLM-10125-KSSM	M10x1.25		10	7.5	135
CLM-12125-KSSM	M12x1.25		12	9	214
CLM-1615-KSSM	M16x1.5	1.5	16	13.5	470
CLM-2015-KSSM	M20x1.5		20	17.5	757
CLM-2415-KSSM	M24x1.5		24	20.5	1130
CLM-302-KSSM	M30x2	2	30	26	1800