

Keenserts

The introduction of keenserts

Keenserts have thread of internal external, and its external thread has four or two bolts, which are special fasteners. Keenserts are installed in tapped bottom hole, and then four bolts are pressed in to repair and strengthen internal thread, strong and tight.

Keenserts applies in military, aerospace, railway locomotives, vibration machinery and so on, which require higher thread strength.

The classification of Keenserts

Thin wall, Solid, heavy duty, Extra heavy duty

The application of Keenserts:

repair and strengthen internal thread

The installation procedure of Keenserts:

drill-tapping-install- press in bolts

Among them, drilling and tapping are completely same to the processing of general internal thread.

When installing (screwed into) , you had better use special tools in order to improve efficiency

The material of Keenserts:

- 1、 SUS303(the most commonly used);
- 2、 carbon steel

Metric specification parameter of Keenserts (Thin wall)				1
internal thread	external thread	length L (mm)	drill size	depth of bottom hole
M 2x0.4	M 4x0.7	3.00	3.40	4.0
M 2.5x0.45	M 4.5x0.75	3.81	3.90	5.0
M 3x0.5	M 5x0.8	4.25	4.40	5.5
M 4x0.7	M 6x0.75	5.25	5.50	6.5
M 5x 0.8	M 8x1.25	8.00	6.90	9.5
M 6x 1.0	M10x1.25	10.00	8.80	11.5
M 8x1.25	M12x1.25	12.00	10.80	13.5
M 8x 1.0	M12x1.25	12.00	10.80	13.5
M10x 1.5	M14x 1.5	14.00	12.80	15.5
M10x1.25	M14x 1.5	14.00	12.80	15.5
M12x1.75	M16x 1.5	16.00	14.75	17.5
M12x1.25	M16x 1.5	16.00	14.75	17.5
Metric specification parameter of Keenserts (heavy duty)				2
internal thread	external thread	length L (mm)	drill size	depth of bottom hole

M 4x 0.7	M 8x1.25	8.00	6.90	9.5
M 5x 0.8	M10x1.25	10.00	8.80	12.5
M 6x 1.0	M12x1.25	12.00	10.80	14.5
M 8x1.25	M14x 1.5	14.00	12.80	16.5
M 8x 1.0	M14x 1.5	14.00	12.80	16.5
M10x 1.5	M16x 1.5	16.00	14.75	18.5
M10x1.25	M16x 1.5	16.00	14.75	18.5
M12x1.75	M18x 1.5	18.00	16.75	20.5
M12x1.25	M18x1.5	18.00	16.75	20.5
M14x 2.0	M20x 1.5	20.00	18.75	22.5
M14x 1.5	M20x 1.5	20.00	18.75	22.5
M16x 2.0	M22x 1.5	22.00	20.50	24.5
M16x 1.5	M22x 1.5	22.00	20.50	24.5
M18x 1.5	M24x 1.5	24.00	22.50	26.5
M20x 2.5	M30x 2.0	30.00	28.00	34.5
M20x 1.5	M30x 2.0	30.00	28.00	34.5
M22x 1.5	M32x 2.0	32.00	30.00	36.5
M24x 3.0	M33x 2.0	33.00	31.00	37.5
M24x 2.0	M33x 2.0	33.00	31.00	37.5

Imperial specification parameter of Keenserts (Thin wall)				3
internal thread	external thread	length L (mm)	drill size	depth of bottom hole
M 10-24	M 5/16-18	0.31		0.37
M10-32	M 5/16-18	0.31		0.37
M1/4-20	M 3/8-16	0.37		0.43
M1/4-28	M 3/8-16	0.37		0.43
M 5/16-18	M7/16-14	0.43		0.5
M 5/16-24	M7/16-14	0.43		0.5
M 3/8-16	M1/2-13	0.5	29/64	0.56
M 3/8-24	M1/2-13	0.5	29/64	0.56
M7/16-14	M9/16-12	0.56	33/64	0.62
M7/16-20	M9/16-12	0.56	33/64	0.62
M1/2-13	M5/8-11	0.62	37/64	0.68
M1/2-20	M5/8-11	0.62	37/64	0.68
Imperial specification parameter of Keenserts (heavy duty)				4

internal thread	external thread	length L (mm)	drill size	depth of bottom hole
M 8-32	M 5/16-18	0.31		0.37
M 10-24	M 3/8	0.31		0.37
M10-32	M 3/8	0.31		0.37
M1/4-20	M7/16-14	0.37		0.43
M1/4-28	M7/16-14	0.37		0.43
M 5/16-18	M1/2-13	0.43	29/64	0.5
M 5/16-24	M1/2-13	0.43	29/64	0.5
M 3/8-16	M9/16-12	0.50	33/64	0.56
M 3/8-24	M9/16-12	0.50	33/64	0.56
M7/16-14	M5/8-11	0.62	37/64	0.68
M7/16-20	M5/8-11	0.62	37/64	0.68
M1/2-13	M3/4-16	0.62	45/64	0.68
M1/2-20	M3/4-16	0.62	45/64	0.68
M9/16-12	M3/4-16	0.81	45/64	0.94
M9/16-18	M3/4-16	0.81	45/64	0.94
M5/8-11	M7/8-14	0.87	53/64	1.00
M5/8-18	M7/8-14	0.87	53/64	1.00
M3/4-10	M1 1/8-12	1.12	1 1/16	1.31
M3/4-16	M1 1/8-12	1.12	1 1/16	1.31
M7/8-9	M1 1/4-12	1.25	1 3/16	1.44
M7/8-14	M1 1/4-12	1.25	1 3/16	1.44
M1-8	M1 3/8-12	1.37	1 5/16	1.56
M1-12	M1 3/8-12	1.37	1 5/16	1.56
M1-14	M1 3/8-12	1.37	1 5/16	1.56
M1 1/8-7	M1 1/2-12	1.62	1 7/16	1.84
M1 1/8-12	M1 1/2-12	1.62	1 7/16	1.84
M1 1/4-7	M1 5/8-12	1.81	1 9/16	2.06
M1 1/4-12	M1 5/8-12	1.81	1 9/16	2.06
M1 1/2-6	M1 7/8-12	2.00	1 13/16	2.28
M1 1/2-12	M1 7/8-12	2.00	1 13/16	2.28