

Keylocking threaded inserts CLAVSERT



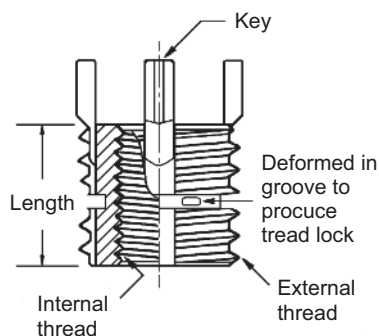
www.ameca-sa.fr

Z.I. le Sauvage - Mognard - BP 21- F.73410 ALBENS
Tel. +33 4 79 54 13 47 - Fax +33 4 79 54 11 29
info@ameca-sa.fr

AMECA

Threaded inserts

Clav-Sert



Once the keys are pushed in, the Clav-Sert inserts ensure optimum threading

Break resistant

The Clav-Sert threaded insert comes in the form of a rigid one-piece bush. According to its diameter, it has two or four locking keys.

There are several sizes of external thread for the same size of threading of the insert.

An easy insert to fit

The fitting of the insert could not be simpler. All you have to do is drill a hole, tap it to the required dimensions, screw in the insert and lock it in position by pushing the two or four keys simultaneously. These will stop the insert rotating against the wall.



1. Drill a hole with a standard drill (see table)



2. Then tap it with a standard tap



3. Screw the Clav-Sert insert into the housing



4. Push in the keys by hitting on the fitting tool

Threaded inserts

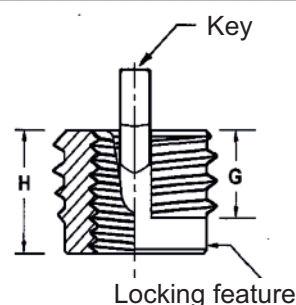
Clav-Sert

A huge choice of materials and sizes



Material	Surface finish	Dimensions
Stainless steel	Passivated	Metric thread M4 to M24
Carbon steel	Phosphate coated	UNC – UNF THREAD SIZES 8-32 at 1"

CLAVSERT inserts can be used in any ferrous or non-ferrous materials that can be machined with a tap.



STAINLESS STEEL – screwlock/free running – MS quality - Metric Miniature series

REFERENCES		THREADING		Length (mm)	FITTING					REMOVAL	
FREE RUNNING / + Dry Lub	SELF- LOCKING / + Dry Lub	4H 6H	4h		Ref. Tool	Ø Drilling +0.003/- 0.001"	Ø Milling +0.25-0"	Tapping before fitting		Drill	
		Internal	External					2B	Min. dept h	Ø	Depth
9010202040	9014102040	M2X.40	M4x.70	3.0	72682	3.4	4.1	M4	4.0	2.8	2.00
9010225045	9014125045	.5X.45	4.5x.75	3.8	72683	3.9	4.6	4.5x.75	5.0	3.0	2.00
9010203050	9014103050	M3X.50	M5x.80	4.25	72684	4.4	5.1	M5	5.5	3.5	2.25
9010204070	9014104070	M4X.70	6x.75	5.25	72686	5.5	6.1	6x.75	6.5	4.6	2.50
Tolerance: ± 0.25				Tapping: in accordance with FED Std J28/21 (MJ)							

Material: Stainless steel insert 303, 2 keys, stainless steel 302 **General tolerance:** ±0.25 mm

Threading: MJ

Surface: Passivation + dry lubrication for screwlock Clav-Sert (dry lub for screw lock type)

www.ameca-sa.fr

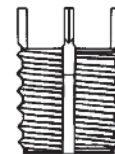
Z.I. le Sauvage - MOGNARD - BP 21 - F.73410 ALBENS
Tel. +33 4 79 54 13 47 - Fax +33 4 79 54 11 29 - info@ameca-sa.fr



Free running Clav-Sert

STEEL or STAINLESS STEEL – free running – standard quality - metric

Free Running



Thin wall / TW

threaded inserts

LIGHT SERIES / TW					FITTING					REMOVAL	
REFERENCE		THREADING		Length	Ref. Tool	Ø Drill	Ø Milling C'Sink +0.25 -0.0	Tap prior to fitting/Tap		Drill	
STEEL	STAINLESS STEEL	internal 6H	external 6g					6H	Min. depth	Ø	Depth
9100005080	9110005080	5X080	8X125	8	64751	6.90	8.25	8X125	9.5	5.5	4.00
9100006100	9110006100	6X100	10X125	10	64752	8.80	10.25	10X125	11.5	7.5	4.75
9100008125	9110008125	8X125	12X125	12	64753	10.8	12.25	12X125	13.5	9.5	4.75
9100008100	9110008100	8X100		12		10.8	12.25			9.5	4.75
9100010150	9110010150	10X150	14X150	14	64755	12.8	14.25	14X150	15.5	11.5	4.75
9100010125	9110010125	10X125		14		12.8	14.25			11.5	4.75
9100012175	9110012175	12X175	16X150	16	64756	14.75	16.25	16X150	17.5	13.5	4.75
9100012125	9110012125	12X125		16		14.75	16.25			13.5	4.75

Heavy duty / HD

STRENGTHENED SERIES / HD					FITTING					REMOVAL	
REFERENCE		THREADING		Length	Ref. Tool	Ø Drilling	Ø Milling C'Sink +0.25 -0.0	Tap before fitting		Drill	
STEEL	STAINLESS STEEL	internal 6H	external 6g					6H	Min. depth	Ø	Depth
9200004070	9210004070	4X70	8X125	8	64763	6.90	8.25	8X125	9.5	5.50	4.00
9200005080	9210005080	5X80	10X125	10	64764	8.80	10.25	10X125	12.5	7.50	4.75
9200006100	9210006100	6X100	12X125	12	64765	10.80	12.25	12X125	14.5	9.50	4.75
9200008125	9210008125	8X125	14X150	14	64766	12.80	14.25	14X150	16.5	11.50	4.75
9200008100	9210008100	8X100		14		12.80	14.25			11.50	4.75
9200010150	9210010150	10X150	16X150	16	64767	14.75	16.25	16X150	18.5	13.50	4.75
9200010125	9210010125	10X125		16		14.75	16.25			13.50	4.75
9200012175	9210012175	12X175	18X150	18	64769	16.75	18.25	18X150	20.5	15.50	4.75
9200012125	9210012125	12X125		18		16.75	18.25			15.50	4.75
9200014200	9210014200	14X200	20X150	20	64770	18.75	20.25	20X150	22.5	17.50	4.75
9200014150	9210014150	14X150		20		18.75	20.25			17.50	4.75
9200016200	9210016200	16X200	22X150	22	64771	20.50	22.25	22X150	24.5	17.75	6.35
9200016150	9210016150	16X150		22		20.50	22.25			17.75	6.35
9200018150	9210018150	18X150	24X150	24	64772	22.50	24.25	24X150	28.5	19.75	6.35
9200020250	9210020250	20X250	30X200	30	64773	28.00	30.25	30X200	34.5	15.75	6.35
9200020150	9210020150	20X150		30		28.00	30.25			25.75	6.35
9200022150	9210022150	22X150	32X200	32	64774	30.00	32.25	32X200	36.5	27.75	6.35
9200024300	9210024300	24X300	33X200	33	64775	31.00	33.25	33X200	37.5	28.75	6.35
9200024200	9210024200	24X200		33		31.00	33.25			28.75	6.35

① Drilling tolerance: .6.90 to 10.80 +0.10/-0.025 – Above: +0.013 / -0.025

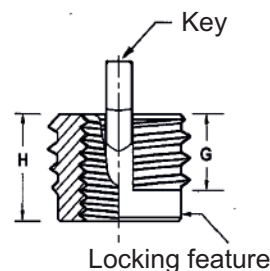
www.ameca-sa.fr

Z.I. le Sauvage - MOGNARD - BP 21 - F.73410 ALBENS
Tel. +33 4 79 54 13 47 - Fax +33 4 79 54 11 29 - info@ameca-sa.fr



Free running Clav-Sert

**STAINLESS STEEL – screwlock/free running –
MS quality
(UNC/UNF)**



Miniature series

REFERENCES		THREADING		Length (mm)	FITTING Installation					REMOVAL	
FREE RUNNING / /	SELF- LOCKING / + Dry Lub	Internal 3B	External 2A		Ref. Tool	ØDrill +0.003/- 0.001"	ØMilling +0.25-0"	Tapping before fitting		Drill	
								2B	Min. dept h	Ø	Depth
9010276283	9014177283	2-56	8-32	3.05	72552	0.134	0.166	8-32	0.14	#33	0.0625
9010276284	9014177284	4-40	10-32	4.3	72554	0.161	0.194	10-32	0.16	#29	0.0938
9010276285	9014177285	6-32	12-28	4.3	72556	0.187	0.220	12-28	0.16	#21	0.0938
9010276286	9014177286	8-32	1/4-28	5.6	72558	0.228	0.255	1/4-28	0.21	#8	0.1250

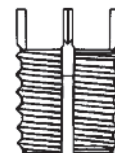
tolerance: ± 0.254 (0.010") in accordance with SAE AS8879, MIL-I-4591A (MS51830)

Material: Stainless steel insert 303, 2 keys, stainless steel 302 **General tolerance:** ± 0.25 mm

Threading: MJ

Surface: Passivation + dry lubrication for screwlock Clav-Sert (dry lub for screw lock type)

**STEEL or STAINLESS STEEL – free running – standard quality
(UNC/UNF)**



threaded inserts

Thin wall / TW

Free running				FITTING					REMOVAL		
ref. STEEL	ref. STAINLESS STEEL	THREADING		Length	Ref. Tool	Ø Drill	Ø Milling C'Sink +0.01 -0.00	Tap before fitting		Drill	
		internal 2B	external 2A					2B	Min.d epth	Ø	Prof.
9100065921	9110066321	10-24	5/16-18	.31	64721	.272 (I)	.32	5/16- 18	.37	7/32	1/8
9100066121	9110066521	10-32		.31		.272 (I)	.32		.37	7/32	1/8
9100065922	9110066322	1/4-20	3/8-16	.37	64722	.332 (Q)	.38	3/8-16	.43	9/32	3/16
9100066122	9110066522	1/4-28		.37		.332 (Q)	.38		.43	9/32	3/16
9100065923	9110066323	5/16-18	7/16-14	.43	64723	.397 (X)	.44	7/16- 14	.50	11/32	3/16
9100066123	9110066523	5/16-24		.43		.397 (X)	.44		.50	11/32	3/16
9100065924	9110066324	3/8-16	1/2-13	.50	64724	.453	.51	1/2-13	.56	13/32	3/16
9100066124	9110066524	3/8-24		.50		.453	.51		.56	13/32	3/16
9100065925	9110066325	7/16-14	9/16-12	.56	64725	.516	.57	9/16- 12	.62	15/32	3/16
9100066125	9110066525	7/16-20		.56		.516	.57		.62	15/32	3/16
9100065926	9110066326	1/2-13	5/8-11	.62	64726	.578	.63	5/8-11	.68	17/32	3/16
9100066126	9110066526	1/2-20		.62		.578	.63		.68	17/32	3/16

Inch sizes

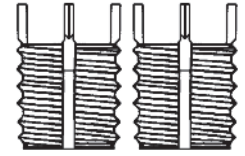
www.ameca-sa.fr

Z.I. le Sauvage - MOGNARD - BP 21 - F.73410 ALBENS
Tel. +33 4 79 54 13 47 - Fax +33 4 79 54 11 29 - info@ameca-sa.fr



Free running Clay-Sert

**STEEL or STAINLESS STEEL – free running – standard quality
(UNC/UNF)**



Heavy duty / HD

Free Running					FITTING					REMOVAL	
REFERENCE		THREADING		Length	Ref. Tool	Ø Drill	Ø Milling C'Sink +0.10 -0.00	Tap before fitting		Drill	
STEEL	STAINLESS STEEL	internal 2B	external 2A					2B	Min. depth	Ø	Depth
9200065900	9210066300	8-32	5/16-18	.31	64700	« I »	.32	5/16-18	.37	7/32	1/8
9200065901	9210066301	10-24	3/8-16	.31	64701	« Q »	.38	3/8-16	.37	9/32	1/8
9200066101	9210066501	10-32		.31		« Q »	.38		.37	9/32	1/8
9200065902	9210066302	1/4-20	7/16-14	.37	64702	« X »	.44	7/16-14	.43	11/32	3/16
9200066102	9210066502	1/4-28		.37		« X »	.44		.43	11/32	3/16
9200065903	9210066303	5/16-18	1/2-13	.43	64703	.453	.51	1/2-13	.50	13/32	3/16
9200066103	9210066503	5/16-24		.43		.453	.51		.50	13/32	3/16
9200065904	9210066304	3/8-16	9/16-12	.50	64704	.516	.57	9/16-12	.56	15/32	3/16
9200066104	9210066504	3/8-24		.50		.516	.57		.56	15/32	3/16
9200065905	9210066305	7/16-14	5/8-11	.62	64705	.578	.63	5/8-11	.68	17/32	3/16
9200066105	9210066505	7/16-20		.62		.578	.63		.68	17/32	3/16
9200065906	9210066306	1/2-13	3/4-16	.69	64706	.641	.76	11/16-11NS	.68	19/32	3/16
9200066106	9210066506	1/2-20		.69		.641	.76		.68	19/32	3/16
9200065907	9210066307	9/16-12	3/4-16	.81	64707	.766	.76	13/16-16	.94	23/32	3/16
9200066107	9210066507	9/16-18		.81		.766	.76		.94	23/32	3/16
9200065908	9210066308	5/8-11	7/8-14	.87	64708	.828	.88	7/8-14	1.00	25/32	5/16
9200066108	9210066508	5/8-18		.87		.828	.88		1.00	25/32	5/16
9200065909	9210066309	3/4-10	1"1/8-12	1.12	64709	1.062	1.14	1"1/8-12	1.31	31/32	5/16
9200066109	9210066509	3/4-16		1.12		1.062	1.14		1.31	31/32	5/16
9200065910	9210066310	7/8-9	1"1/4-12	1.25	64710	1.187	1.27	1"1/4-12	1.44	1-3/32	5/16
9200066110	9210066510	7/8-14		1.25		1.187	1.27		1.44	1-3/32	5/16
9200065911	9210066311	1"-8	1"3/8-12	1.37	64711	1.312	1.39	1"3/8-12	1.56	1-7/32	5/16
9200066111	9210066511	1"-12				1.312	1.39			1-7/32	5/16
9200066112	-	1"-14				1.312	1.39			1-7/32	5/16
9200065913	-	1"1/8-7	1"1/2-12	1.62	64713	1.437	1.52	1"1/2-12	1.84	1-11/32	5/16
9200066113	-	1"1/8-12				1.437	1.52			1-11/32	5/16
9200065914	-	1"1/4-7	1"5/8-12	1.81	64714	1.562	1.64	1"5/8-12	2.06	1-15/32	5/16
9200066114	-	1"1/4-12				1.562	1.64			1-15/32	5/16
9200065916	-	1"1/2-6	1"7/8-12	2.00	64716	1.812	1.89	1"7/8-12	2.28	1-23/32	5/16
9200066116	-	1"1/2-12				1.812	1.89			1-23/32	5/16

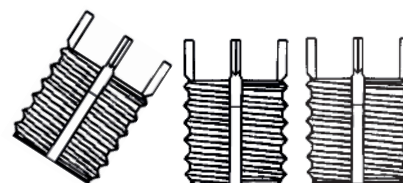
www.ameca-sa.fr

Z.I. le Sauvage - MOGNARD - BP 21 - F.73410 ALBENS
Tel. +33 4 79 54 13 47 - Fax +33 4 79 54 11 29 - info@ameca-sa.fr



Free running Clav-Sert

**STEEL or STAINLESS STEEL – free running – standard quality
(UNC/UNF)**



Extra-heavy duty / XHD

FREE RUNNING					FITTING					REMOVAL	
REFERENCE		THREADING		Length	Ref. Tool /	Ø Drilling /	Ø Milling C'Sink +0.10 -0.00	Tap before fitting		Drill	
STEEL	STAINLESS STEEL	internal 2B	external 2A					2B	Min. depth	Ø	Depth
9600065931	9610066331	6-32	5/16-18	.31	64731	« I »	.32	5/16-18	.37	7/32	1/8
9600065932	9610066332	8-32	3/8-16	.31	64732	« Q »	.38	3/8/16	.37	9/32	1/8
9600065933	9610066333	10-24	7/16-14	.31	64733	« X »	.44	7/16-14	.37	11/32	3/16
9600066133	9610066533	10-32		.31	64734	« X »	.44		.37	11/32	3/16
9600065934	9610066334	1/4-20	1/2-13	.37	64734	.453	.51	1/2-13	.44	13/32	3/16
9600066134	9610066534	1/4-28		.37		.453	.51		.44	13/32	3/16
9600065935	9610066335	5/16-18	9/16-12	.43	64735	.516	.57	9/16-12	.50	15/32	3/16
9600066135	9610066535	5/16-24		.43		.516	.57		.50	15/32	3/16
9600065936	9610066336	3/8-16	5/8-11	.50	64736	.578	.63	5/8-11	.56	17/32	3/16
9600066136	9610066536	3/8-24		.50		.578	.63		.56	17/32	3/16
9600065937	9610066337	7/16-14	3/4-16	.62	64737	.703	.70	3/4-16	.68	21/32	3/16
9600066137	9610066537	7/16-20		.62		.703	.70		.68	21/32	3/16
9600065938	9610066338	1/2-13	7/8-14	.68	64738	.828	.82	7/8-14	.75	25/32	3/16
9600066138	9610066538	1/2-20		.68		.828	.82		.75	25/32	3/16
9600065939	9610066339	9/16-12	7/8-14	.81	64739	.828	.88	7/8-14	.94	25/32	3/16
9600066139	9610066539	9/16-18		.81		.828	.88		.94	25/32	3/16
9600065940	9610066340	5/8-11	1"-12	.87	64740	.937	1.02	1"-12	1.00	27/32	5/16
9600066140	9610066540	5/8-18		.87		.937	1.02		1.00	27/32	5/16
9600065941	9610066341	3/4-10	1"1/4-12	1.12	64741	1.187	1.27	1"1/4-12	1.31	1-3/32	5/16
9600066141	9610066541	3/4-16		1.12		1.187	1.27		1.31	1-3/32	5/16
9600065942	9610066342	7/8-9	1"3/8-12	1.25	64742	1.312	1.39	1"3/8-12	1.44	1-7/32	5/16
9600066142	9610066542	7/8-14		1.25		1.312	1.39		1.44	1-7/32	5/16
9600065943	9610066343	1"-8	1"1/2-12	1.37	64743	1.437	1.52	1"1/2-12	1.56	1-11/32	5/16
9600066143	9610066543	1"-12		1.37		1.437	1.52		1.56	1-11/32	5/16

Inch sizes

www.ameca-sa.fr

Z.I. le Sauvage - MOGNARD - BP 21 - F.73410 ALBENS
Tel. +33 4 79 54 13 47 - Fax +33 4 79 54 11 29 - info@ameca-sa.fr





Repair kits

Clav-Sert

Indispensable for repairing defective taps, AMECA repair kits come with fitting tools (also available individually).

Kit heavy duty series (UNC thread)

- UNC steel, ref. 920 64951
- UNC ststeel, ref. 921 64961

Internal thread	Threading external	Number of inserts	Reference tool
10 – 24	3/8 – 16	5	64701
1/4 – 20	7/16 – 14	10	64702
5/16 – 18	1/2 – 13	10	64703
3/8 – 16	9/16 – 12	10	64704
1/2 – 13	3/4 – 16	10	64706
5/8 – 11	7/8 – 14	10	64708
3/4 – 10	1 – 1/8 – 12	5	64709

Kit heavy duty series (UNF thread)

- UNF steel, ref. 920 64952
- UNF st-steel, ref. 921 64962

Internal thread	Threading external	Number of inserts	Reference tool
10 – 32	3/8 – 16	5	64701
1/4 – 28	7/16 – 14	10	64702
5/16 – 24	1/2 – 13	10	64703
3/8 – 24	9/16 – 12	10	64704
1/2 – 20	3/4 – 16	10	64706
5/8 – 18	7/8 – 14	10	64708
3/4 – 16	1 – 1/8 – 12	5	64709

Kit light series (metric thread)

- Metric steel, ref. 910 64983
- Stainless-steel, ref. 91164993

Internal thread	Threading external	Number of inserts	Reference tool
M 5 X 0.8	M 8 X 1.25	8	64751
M 6 X 1.0	M 10 X 1.25	8	64752
M 8 X 1.25	M 12 X 1.25	6	64753
M 8 X 1.0		6	
M 10 X 1.5	M 14 X 1.50	4	64755
M 10 X 1.25		4	
M 12 X 1.75	M 16 X 1.50	3	64756
M 12 X 1.25		3	

AMECA, threaded insert specialist

AMECA

Z.I. le Sauvage - MOGNARD
B.P. 21 - F.73410 ALBENS

Tel. +33 4 79 54 13 47 - Fax +33 4 79 54 11 29
www.ameca-sa.fr - info@ameca-sa.fr

