

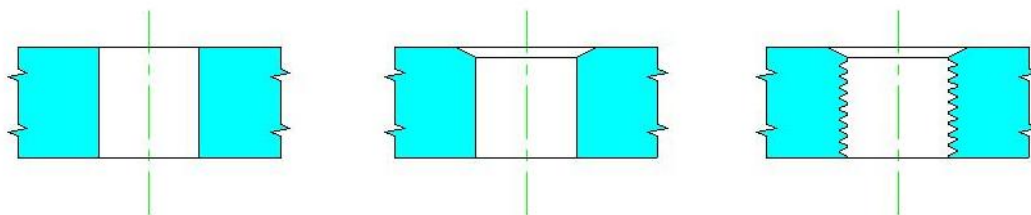
KEENSERTS® Studs

Installation, Removal & Broach

One-piece KEENSERTS® studs are supplied with KEES pre-assembled into dove-tailed slots at the factory, to eliminate the problems of selecting, stocking and assembling separate parts. The pre-positioned keys automatically set the stud at the proper depth below the surface of the parent material. Unlike conventional studs, there is no need to maintain critical depth tolerances — no chance of inadequate locking or deformation of internal threads due to miscalculations of depth. For critical edge distance applications, please consult our Customer Applications Engineers.

Stud Installation

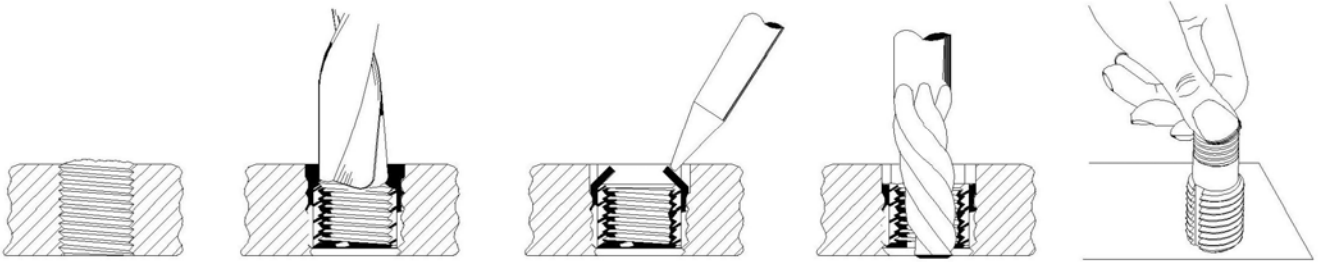
1. **Drill** with a **standard** drill, as listed for each part number.
2. **Countersink** with a **standard** countersink (82° to 100°).
3. **Tap** with a **standard** Unified Thread Series tap.
4. Screw in stud with fingers or installation tool. Stud is designed to stop at the correct depth below the surface of the casting.
5. Using the installation tool, drive in the KEES. The tool may be used with a hammer or held in an arbor press. The correct stud tool is tabulated with each type of stud in this catalog.



KEENSERTS® Studs Installation, Removal & Broach (Cont'd)

Stud Removal

1. Cut off the nut end at a point just above the surface.
2. Use standard drill and depth as listed for applicable stud, and drill to remove material between KEES.
3. Deflect KEES inward and break off.
4. Remove studs with E-Z Out type tool.
5. An identical stud can now be installed in the original hole. No re-work of the hole will be necessary.



Broaching Tool

Broaching Tools are coded in the following manner:

B	332	-4
Indicates Broaching Tool	Recommended Installation Tap-Drill Diameter	Number of Locking KEES in the Stud



Note: The smallest tap drill diameter for which broaching tools can be made is .213. Consult AFS Customer Applications Engineers for metric broaching tool information.