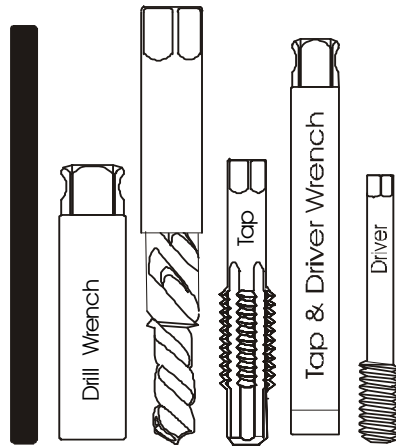
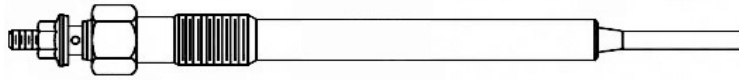


TIME-SERT®

GLOW PLUG REPAIR KIT

M10x1.25 DURAMAX 6.6 DIESEL

2001 - 2004.5 6.6L Duramax also fits the first generation LLY
Glow plug thread starts approx 1/4" or 6mm below top of plug.



PART NUMBER KIT 4024

KIT CONTENTS

1. Core Drill Wrench
2. Core Drill
4. Step Tap
3. Wrench Tap/Driver
5. Driver tool
6. (5) Inserts

Use WD40 for drilling & tapping

-WARNING-

Cutting tools may shatter if broken. The wearing of safety glasses is required in the vicinity of their use.

(Preparing hole)

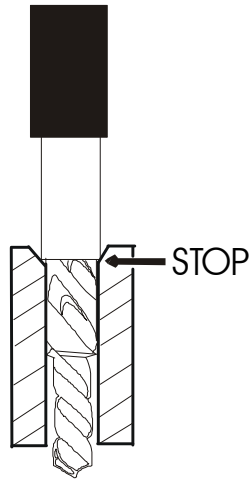
Before we begin, tape the straw provided or a piece of hose long enough to reach the bottom of hole, and use a shop vac for chip removable.

Using a small quarter size piece of tissue, roll up into a ball and drop down glow plug hole. This will help prevent chips from going into the chamber. The tissue will later be vacuumed out after drilling and tapping.



1. Place the core drill into the large wrench and tighten the set screw. Use WD40 for drilling.

Turn page over to continue

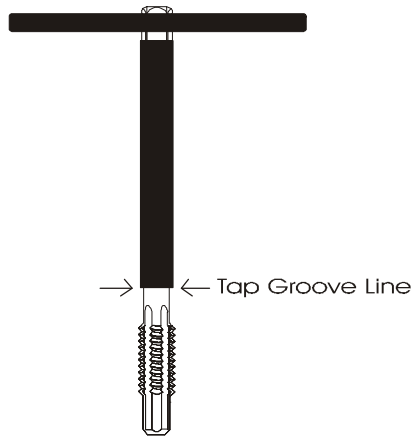


Continued from step 1
Drill close-up:

Core drill the hole until the larger diameter stops at the top of the existing countersink.

Vacuum chips from hole.

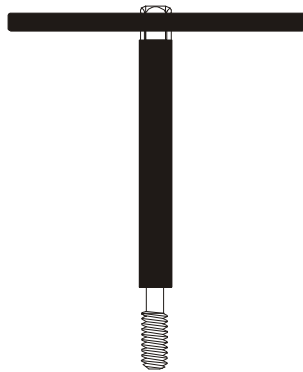
Use another small quarter size piece of tissue, roll up into a ball and drop down glow plug hole.



2. Place the tap into the small wrench and tighten setscrew. Use WD40 for tapping.

Tap until "Groove line" touches the head.

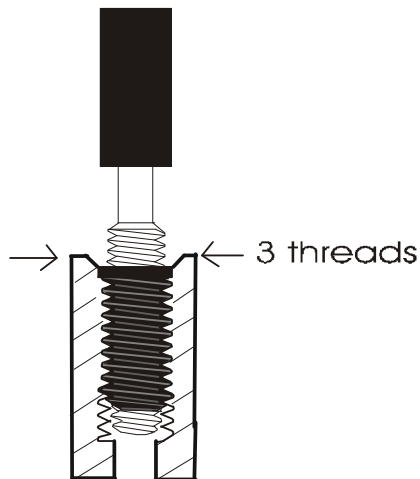
Vacuum chips as needed. Use brake cleaner to clean out oil residue after tapping.



3. Place the install driver into the wrench, tighten setscrew.

Oil the bottom threads of the install driver.

Use Time-Sert install driver oil p/n 6010 or 30wt motor oil.



4. Screw the insert onto the driver and into the prepared hole. While screwing the insert into the hole the driver will tighten up, continue screwing the driver thru the insert until it loosens up, this is approx. 3 threads showing.

The driver must pass slightly through the insert to expand the last few threads of the insert locking it in place.

Back driver tool out of insert.
Repair Complete.

Use copper anti-seize on the threads of the glow plug and use the correct torque specs when installing new glow plug.

