

TIME-SERT®

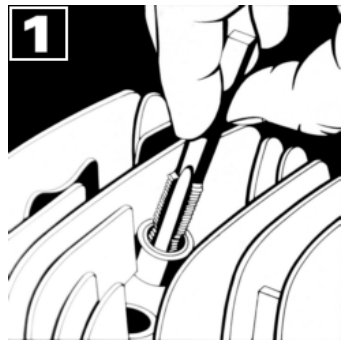
SPARK PLUG REPAIR KIT



KIT CONTENTS

1. Wrench
2. Step-Tap
3. Insert Driver
4. Seat Cutter
Inserts sold separately

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



1. Start the step tap into the hole to be repaired keeping as straight as possible.



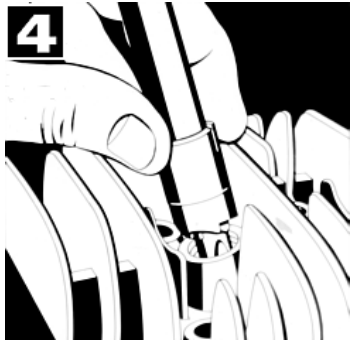
2. Using the wrench provided place wrench over tap and tap new threads. Continue to tap through until the cutting edges are approximately $\frac{1}{4}$ inch below surface.
Leaving the tap $\frac{1}{4}$ inch below the surface ensures that the seat cutter will not hit the back of the tap flutes.



3. Leave the step tap in the hole. Place the seat cutter over the shank.

The seat cutter does 2 operations. First the seat cutter will cut the countersink for the flange of the insert, then it cut a new seat for the sparkplug washer.

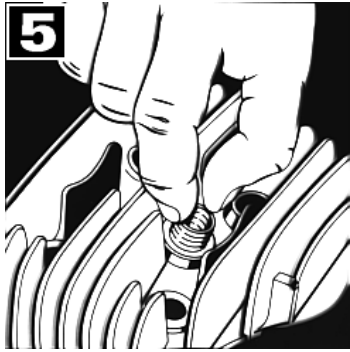
This operation is the same for tapered seat inserts.



4. Using the wrench provided rotate the seat cutter. After a few turns lift the seat cutter to inspect the seat. Repeat operation until the seat is completely cleaned up. Remove the step tap from the hole.

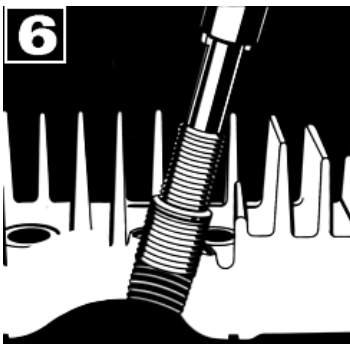
Good seat
Complete

Bad seat
1/2 incomplete



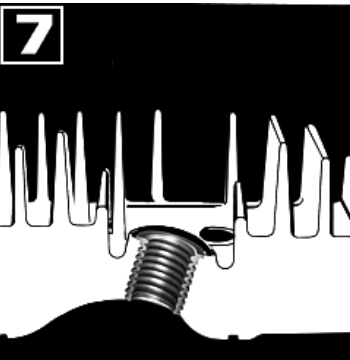
5. Make sure the hole is clean and dry. Lubricate the driver tool with Time-Sert driver oil. Screw the insert onto the prepared hole.

Note: If doing deep hole repairs Lubricate the driver tool with Time-Sert driver oil or 30wt Oil. Screw the insert onto the driver then into the prepared hole.



6. *Note: Tapered Seat inserts these inserts are silver plated and require sealer p/n 6020 on the outside of the insert.*

Using the wrench provided rotate the driver through the insert. When the insert is seated the driver will tighten up. With increased pressure continue to rotate the driver through the insert until it loosens up. Then back the driver tool out of the insert.



-Section View-

7. Repair is complete. Solid steel threads are square to the reconditioned seat, insuring a good spark plug seal.