

TIME-SERT[®]

THREAD REPAIR KIT

:REAMER:

-WARNING-

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

Kit contains:
Reamer
Tap
Tap guide
Driver
5 steel inserts



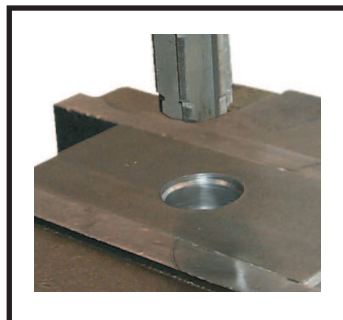
INSTRUCTIONS



Use of a cutting fluid is recommended for drilling counterboring and tapping.

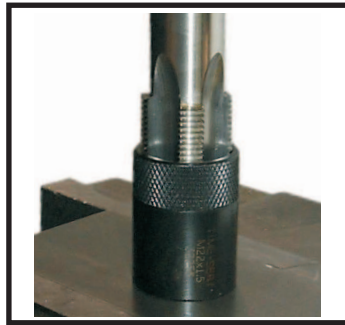
STEP 1

Drill out old threads keeping reamer square to the surface of the hole.



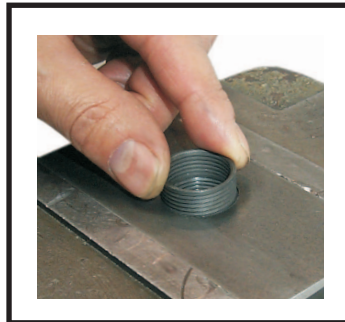
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Ream the hole until the stop collar touches surface. The reamer will also cut the countersink for the flange of the insert.



STEP 2

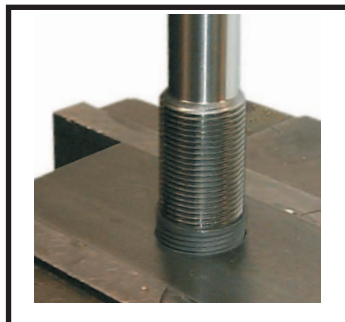
Place the tap guide against the surface. Start the tap into the guide, turn the tap slowly while making sure the guide remains flat to surface.



STEP 3

Blow chips out of the hole. Screw an insert a few turns into the tapped hole.

USE OIL ON THIS TOOL



STEP 4

OIL THREADS OF DRIVER
Screw the driver tool into the insert.
When the flange of the insert is seated the driver will tighten up. Using a little more power continue to rotate the driver until it loosens up.



COMPLETED REPAIR

The bottom few threads have been expanded locking the insert in place. You now have solid steel threads.