powercoil®

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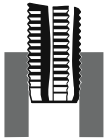
1 DRILL

Drill to clear the damaged thread with a standard twist drill. Thread Repair Kits up to M12 (1/2") include the correct size drill. The required tapping drill size is shown on the front of this pack.

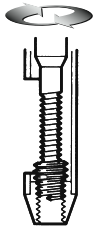
Note: Spark Plug inserts utilise a pilot nose tap which does not require pre-drilling.



2 TAP

Use the specified tap to cut the holding thread into the cleared hole. When tapping a hole, it is recommended to use a suitable lubricant.

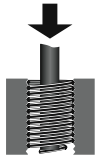
Note: Wire Thread inserts require the use of STI taps which are slightly oversize to provide the correct hole diameter. Always check that the thread and pitch of the tap are the same as the bolt you wish to insert into the finished hole.



3 INSERT

Unwind mandrel and place insert into chamber with tang towards nozzle. Rotate the pre-winder handle clockwise to wind the mandrel into the insert until end of mandrel engages with tang. Use gentle downward pressure until insert engages in threaded nozzle. Continue winding until insert reaches end of nozzle. Place tool squarely over tapped hole and continue winding until insert is transferred from tool to workpiece. Rotate handle counterclockwise to wind mandrel out of the installed insert.

Note: Note: Once insert is engaged in nozzle use no downward pressure.



4 SNAP

Insert a tang break off tool and tap down sharply to break off wire thread insert tang.

Note: For spark plug and large inserts use long nose pliers to remove the tang.

4 DONE!

You have succesfully repaired your damaged thread. The new thread is normally stronger than the original.