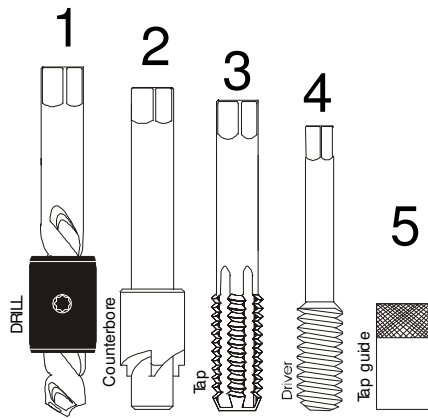


TIME-SERT®

THREAD REPAIR KIT

NAVISTAR DPF M12x1.25 p/n 12-235-02

<http://www.timesert.com>



KIT CONTENTS

1. Drill 12-235-02-01
2. Counterbore 12-235-02-02
3. Tap 12-235-02-03
4. Driver 12-235-02-04
5. Tap guide 12-235-02-05
6. Inserts 12-235-02-06 Qty 10

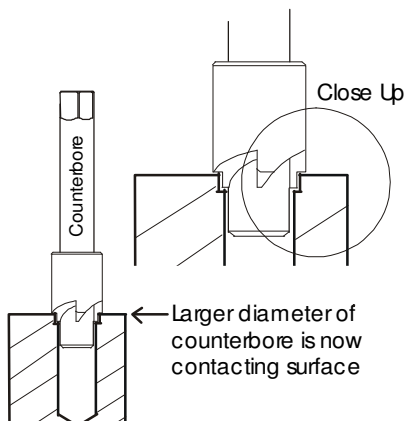
Use WD40 when drill & tapping

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



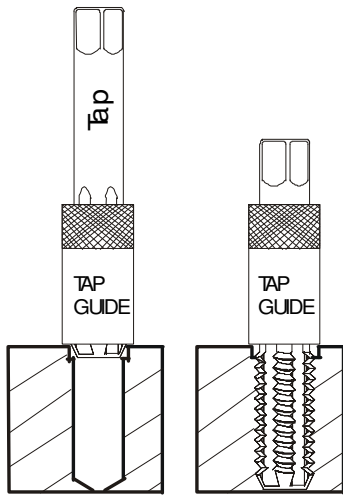
1. DRILL the hole to the full depth permitted by the stop collar.

Note:
collar set on drill .540-.560 inches or
13.7mm-14.2mm from drill tip.



2. COUNTERBORE the hole to the full depth permitted by the tool. The counterbore tool has 4 cutting teeth and a larger diameter which is the stop.

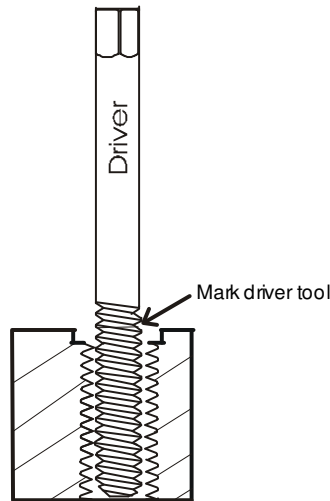
When the larger diameter contacts the surface a full 360 degrees this is the full depth.



We recommend using a "tap wrench" when tapping holes.

3. TAP new threads to the full depth of hole. Use the TAP GUIDE included to ensure the threads are square to surface.

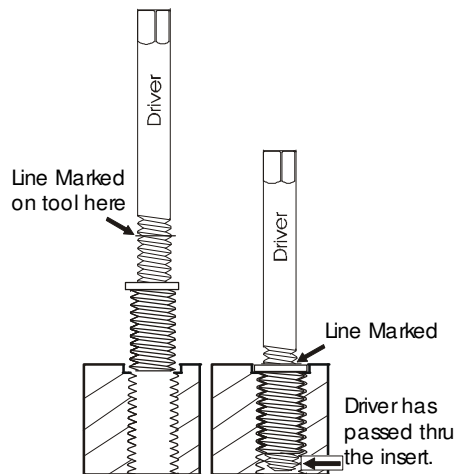
Note: Hold tap guide firmly. Watch that the tap guide remains flush when tapping.



4. DRIVER TOOL

Before installing the insert with the driver tool. Place the driver in the hole to touch the bottom of hole and MARK the driver so you have a visual Mark to know where the bottom of the hole is. You do not want to bottom the driver tool out in the hole on installation.

The driver needs to pass thru the insert a short distance to fully form the threads.



We recommend using a "tap wrench" when installing inserts

5. Oil threads of DRIVER TOOL
Using a few drops of insert driver oil or 30wt motor oil. Screw an insert onto the Driver and into the prepared hole. While screwing the driver thru the insert, the driver will start to tighten up as it expands the bottom few threads of the insert.

Continue until the driver loosens up OR you reach the MARK on the driver tool you MARKED previously. This way you will not bottom the driver tool out in the hole. Remove driver repair is complete.