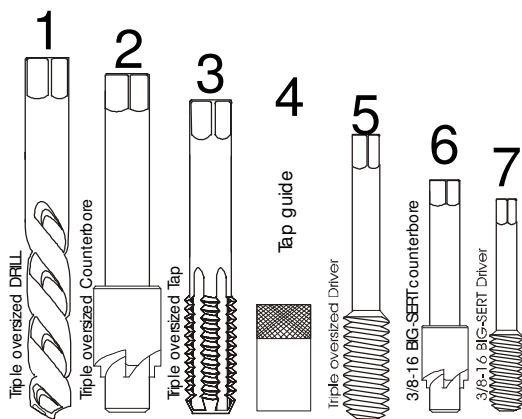


TIME-SERT®

M10x1.5 TRIPLE OVER SIZED

P/n 5015TOS

installs insert inside an insert



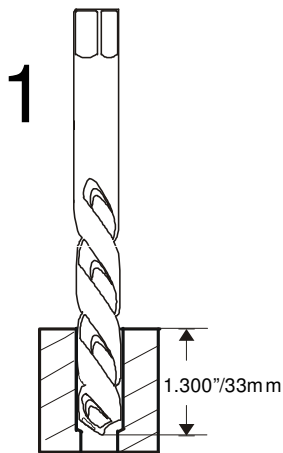
KIT CONTENTS

1. Drill 37/64 Oversized
 2. Cbore M14 Oversized
 3. M14 Tap Oversized
 4. M14 tap guide
 5. M14 Driver Oversized
 6. M10 Big-Sert Cbore
 7. M10 Big-Sert Driver
- M14x1.5x25mm insert p/n 14158
M10x1.5 Big-Sert p/n 50155
M10x1.5 BIG-SERT with dowel
P/n 50155WD
Loctite p/n 6020

Use WD40 for drilling & tapping

-WARNING-

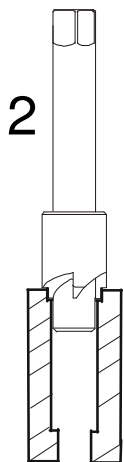
Cutting tools may shatter if broken. The wearing of safety glasses is required in the vicinity of their use.



Use WD40 for Drilling

1. Drill out hole to the full depth of the hole or at least 1.300 inches or 33mm.

Drilling at least 1.300 inches or 33mm deep will ensure the M14x1.5x25mm insert will be FLUSH when installed.

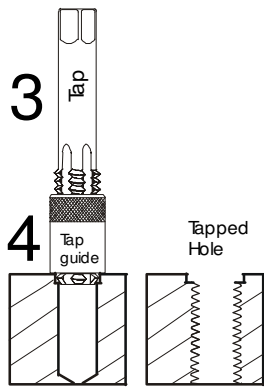


Use WD40 for counterbore

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.

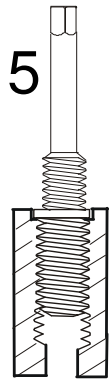
When the larger diameter contacts the surface a full 360 degrees this is the full depth.

Turn page over to continue



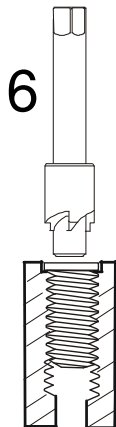
3. Use the TAP GUIDE included and TAP to the full depth of your drilled hole.

Note 4: Hold tap guide down firmly. Watch that the tap guide remains flush when tapping.



4. Using a few drops of insert driver oil or 30wt motor oil Oil the threads of the driver.

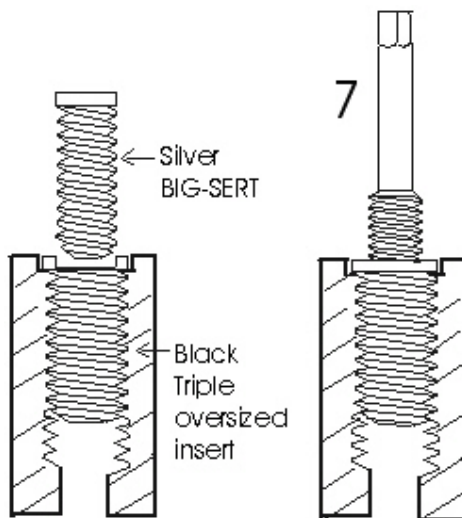
Screw the Black triple oversized insert on the driver, then place a ring of loctite on the bottom external threads of the insert. Screw the insert into the prepared hole, when the flange of the insert is seated the driver will tighten up, use a little more power to screw the driver through the insert until it loosens up. The driver will cold form the last few threads of the insert locking it in place. Remove driver tool.



Use WD40 for counterbore

5. Counterbore the hole to the full depth permitted by the tool.

Using the BIG-SERT M10 counterbore. Counterbore the black triple oversized insert.



4. Using a few drops of insert driver oil or 30wt motor oil Oil the threads of the DRIVER.

Screw the silver M10 BIG-SERT insert onto the M10 Driver then place a ring of loctite on the bottom external threads of the insert.

Screw the Big-sert insert into the triple oversized insert, when the flange of the insert is seated the driver will tighten up, use a little more power to screw the driver through the insert until it loosens up. The driver will cold form the last few threads of the insert locking it in place.

DO NOT BOTTOM THE DRIVER OUT IN THE HOLE. Remove driver repair is complete.