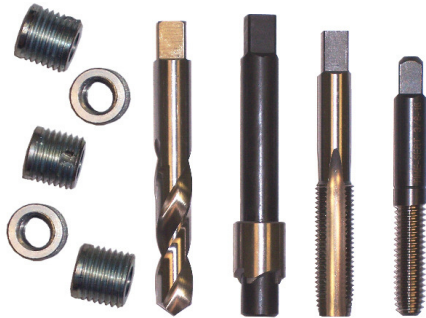


BIG-SERT®

THREAD REPAIR KIT

M5x0.8 P/N 5508



KIT CONTENTS

1. Drill
2. Counterbore
3. Tap
4. Install driver
5. (5) steel inserts

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

INSTRUCTIONS

STEP 1

Drill out old threads keeping drill square to the surface.
Our larger kit Drills may require a tap wrench.

STEP 2

Using a tap wrench or drill motor Counterbore the hole to full depth permitted by the tool. If using a drill motor use slow speed (50 rpm).

STEP 3

Using a tap wrench, Tap threads into full depth of drill hole.
Hold tap square to the surface of the hole. (Clean chips from hole)

STEP 4

OIL THE THREADS of the Install Driver.
Screw the insert onto the Driver. Apply loctite on external thread of insert. Screw insert into the prepared hole. When the head of the insert is seated the Driver tool will tighten up. Using a little more power continue to rotate the Driver tool until it loosens up. The Driver tool must slightly pass thru the bottom of the insert locking it in place.

Note: Blind holes

If doing a repair in a blind hole (one which does not pass thru) Place the Driver into the hole before installing the insert and mark the Driver tool at the point it cannot enter any further. This way you will have a visual mark of where the bottom of the hole is, and will prevent bottoming out of the Driver tool in the hole.