

TIME-SERT®

DRAIN PLUG REPAIR

-WARNING-

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

Kit contains:
Drill
Counterbore
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 drill square to the surface of the hole.



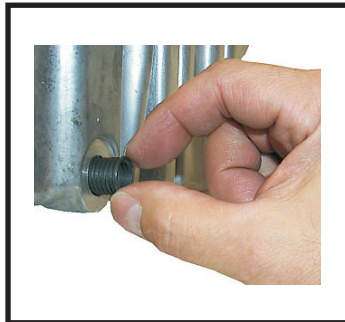
STEP 2

Counterbore the hole to full depth permitted by the tool.



STEP 3

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



STEP 4

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

USE OIL ON THIS TOOL



STEP 5

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.