

TIME-SERT®

TAPER SEAT SPARK PLUG REPAIR KIT DOMESTIC / GM, GMC, Chrysler & Others P/N 4412E-187



KIT CONTENTS:

- 1) Wrench
- 2) Mini wrench
- 3) Step-Tap
- 4) Driver
- 5) Seat Cutter
- 6) Sealer

Note: Use mini wrench for areas of limited clearance

Taper seat inserts			
Qty	Inch	MM	P/n
2	.400	10.0 mm	44183
2	.620	15.7 mm	44185
2	.945	24.0 mm	44187

Sealer 6020 required on external threads for taper seat inserts

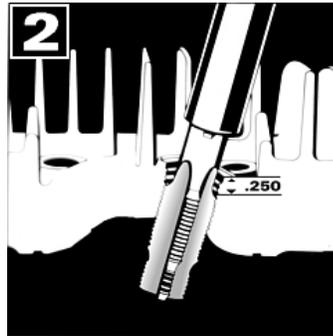
-WARNING-

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



Use WD40 for cutting or grease to help catch chips.
1) Using the wrench or mini wrench provided. Place wrench over tap and tap new threads.

Start the step tap into the hole keeping as straight as possible.



2. Continue to tap through until the cutting edges are approximately 1/4 inch below surface.

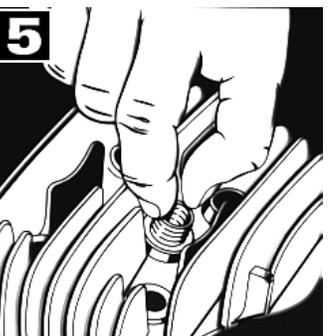
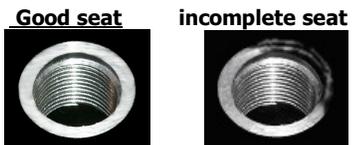
Leaving the tap 1/4 inch below the surface ensures that the seat cutter will not hit the back of the tap flutes.



3. Leave the step tap in the hole. Place the seat cutter over the shank. The seat cutter does 2 operations. First the seat cutter will cut the counter sink for the flange of the insert, then it cuts a seat.
APPROX 10 FULL TURNS WITH LITE DOWN PRESSURE.



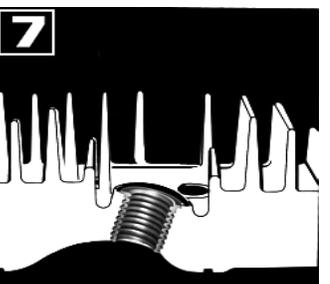
4. Using the wrench provided rotate the seat cutter. After a few turns lift the seat cutter to inspect the seat. Repeat operation until the seat is completely cleaned up. Remove the step tap from the hole.



5. Make sure the hole is clean and dry. Lubricate the driver tool with Time-Sert driver oil. Screw the insert onto the prepared hole. Note: If repairing deep holes Lubricate the driver tool with Time-Sert driver oil or 30wt Oil. **Screw the insert onto the driver then into the prepared hole.**



6. Note: Tapered Seat inserts silver plated and require sealer p/n 6020 on external threads. Using the wrench provided rotate the driver through the insert. When the insert is seated the driver will tighten up. With increased pressure continue to rotate the driver through the insert until it loosens up. Then back the driver tool out of the insert.



-Section View-

7. Repair complete. Solid steel threads are square to the Reconditioned seat, insuring a good spark plug seal.

Measuring length of insert. Measure from the (middle of taper for tapered seat) to the last thread. (Not to the end of the electrode). This will give you the correct length. This tooling also can be used for washer seat just order inserts separately.



<http://www.timesert.com/html/sparkplugreach.html>