

# TIME-SERT®

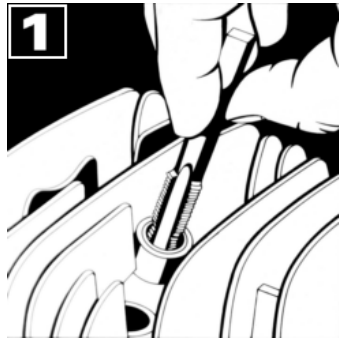
## SPARK PLUG REPAIR KIT



### KIT CONTENTS

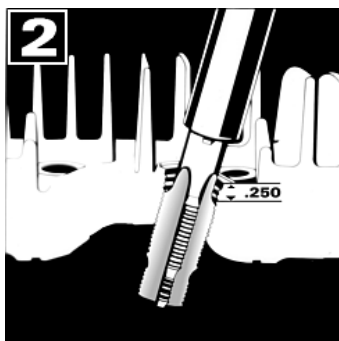
1. Wrench
2. Step-Tap
3. Insert Driver
4. Seat Cutter  
Inserts sold separately

**-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. Start the step tap into the hole to be repaired keeping as straight as possible.



2. Using the wrench provided place wrench over tap and tap new threads. Continue to tap through until the cutting edges are approximately 1/4" inch or 6mm below surface.

Leaving the tap 1/4" inch or 6mm below the surface ensures that the seat cutter will not hit the back of the tap flutes.

When finished tapping new threads remove wrench from tap.

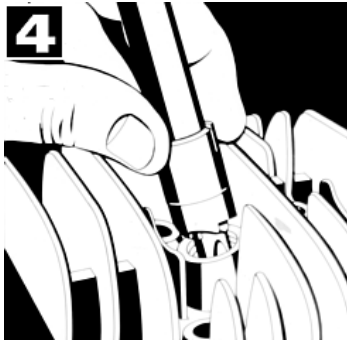


Use WD40 for cutting or grease to help catch chips.

3. Leave the step tap in the hole. Place the seat cutter over the Shank of tap.

The seat cutter does 2 operations. First the seat cutter will cut the countersink for the flange of the insert, then it cuts a new seat for the sparkplug washer.

This operation is the same for tapered seat inserts.

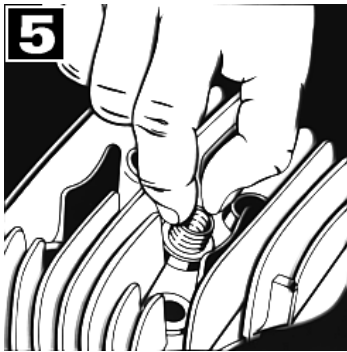


4. Using the wrench provided rotate the seat cutter. After a few turns lift the seat cutter to inspect the seat. Repeat operation until the seat is completely cleaned up. Remove the step tap from the hole.

Good seat  
Complete

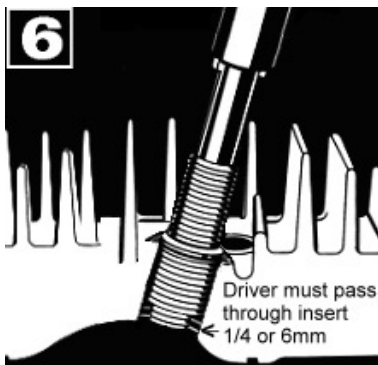


Bad seat  
1/2 incomplete



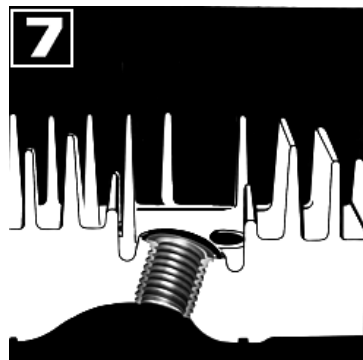
5. Make sure the hole is clean and dry. Lubricate the driver tool with Time-Sert driver oil or 30 wt motor oil. Screw an insert into the prepared hole.

**Note:** If doing deep hole repairs 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 are silver Plated and require sealer p/n 6020 on the outside of the insert.

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 1/4" or 6mm until it loosens up. Then back the driver tool out of the insert. **USE CAUTION DO NOT SCREW THE DRIVER ALL THE WAY THRU THE INSERT AS WE DO NOT WANT THE DRIVER TO DROP INTO THE HEAD.**



**-Section View-**

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