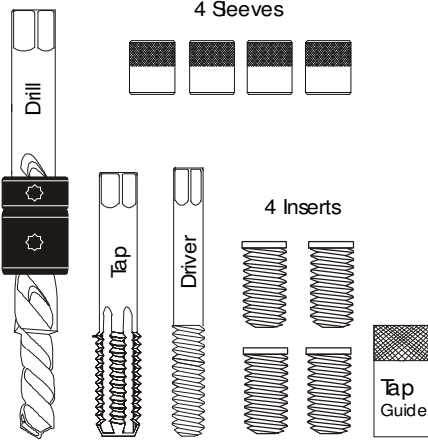


# TIME-SERT®

## M10x1.5 STARTER BOLT

### P/N 1380



P/N 1380

#### KIT CONTENTS

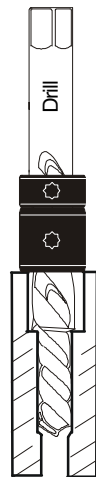
- 1) drill
- 2) Tap
- 3) Tap guide
- 4) Driver
- 5) 4 Inserts M10x1.5x20
- 6) 4 Sleeves EN-42385-67

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.

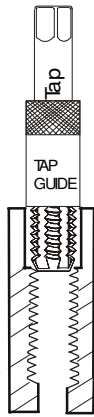
**Note: Be sure your hole is at least 1.500 inches or 39mm deep before starting the repair. Measure from the actual block surface to bottom of the hole.  
This tooling is used for starter holes that are recessed.**



**NOTE: DO NOT MOVE ANY COLLARS  
THEY ARE LOCKED IN PLACE**

Use WD40 for drilling

1. Use the Drill included to drill out the old threads until the black stop collar touches the surface.



Use WD40 for tapping

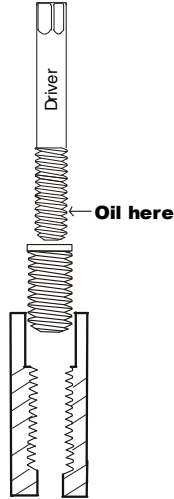
2. Use the tap guide with the Tap to keep tool square to surface and tap to the full depth of hole.

Watch that the guide remains flush to the surface and is not leaning up on one side or the other.

Keep the guide flat to the surface.

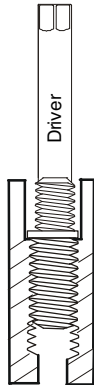
**USE CAUTION TO NOT BOTTOM THE TAP OUT IN THE HOLE.**

*Turn page over to continue*



Using a few drops of 30wt motor oil, Oil the bottom threads of the DRIVER.

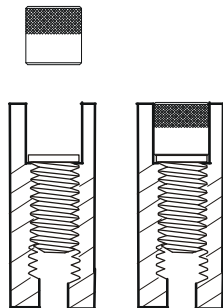
3. Screw an insert onto the driver then into the prepared hole.



**USE CAUTION TO NOT BOTTOM THE DRIVER TOOL OUT IN THE HOLE.**

**Note:** If you place the driver in the hole before installing the insert. You can Mark the tool so you know where the tool will touch bottom

- 4) The driver will start to tighten up as it expands the bottom few threads of the insert, continue turning until the driver loosens up, remove driver repair is complete.



5. Using an aluminum drift or brass hammer tap the sleeve into the hole with the Knurl side up. Sleeve should be level when finished.

The starter bolt will now be centered by the sleeve. Repair complete.