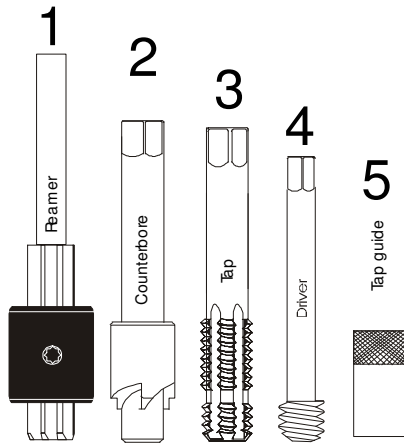


TIME-SERT®

THREAD REPAIR KIT

NAVISTAR DPF M14x1.5 p/n 12-235-03

<http://www.timesert.com>

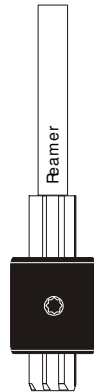


KIT CONTENTS

1. Reamer 12-235-03-01
2. Counterbore 12-235-03-02
3. Tap 12-235-03-03
4. Driver 12-235-03-04
5. Tap guide 12-235-03-05
6. Inserts 12-235-03-06 qty 10

Use cutting oil for drilling,
Counterbore & tapping.

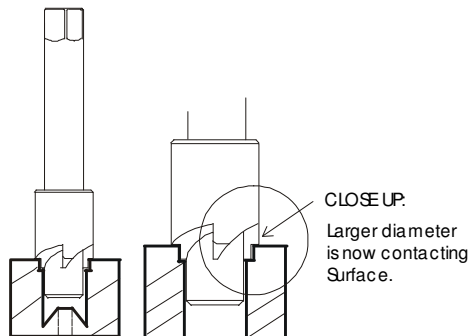
-WARNING-
Cutting tools may shatter if broken.
The wearing of safety glasses is
required in the vicinity of their use.



2. REAMER: Using a 1/2 drill motor
ream the hole at a medium speed
until the stop collar touches the top
of the bung.

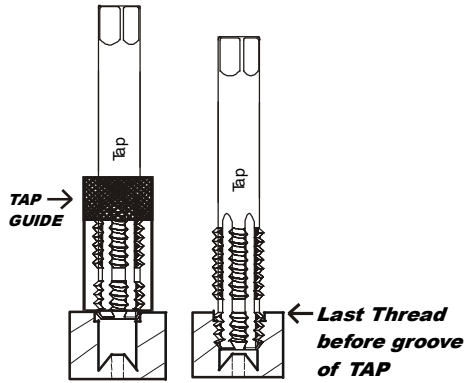
Ream hole using cutting oil.

Note:
collar set on reamer .400-.420 inches or
10.1mm-10.6mm from tip of reamer to
collar.



2. COUNTERBORE: the hole to the
full depth permitted by the tool.
The counterbore tool has 4 cutting
teeth and a larger diameter, which
is the stop.

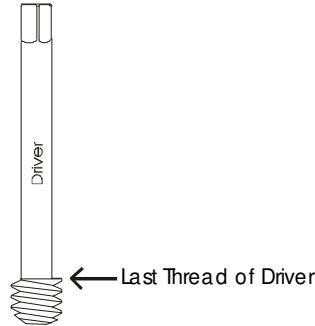
When the larger diameter contacts
the surface a full 360 degrees this
is the full depth.



3. TAP HOLE: Use the **TAP GUIDE** included to ensure the threads are square to surface.

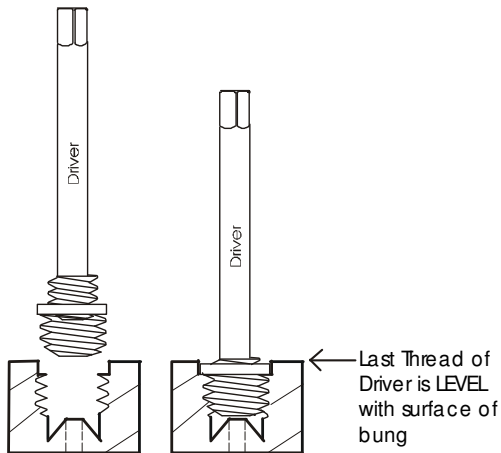
Note: Hold tap guide firmly. Watch that the tap guide remains flush when tapping.

Apply some down pressure as you rotate the tap. After starting the tap in the hole 2 or 3 turns remove the tap guide and **STOP** when the last thread **BEFORE GROOVE** is level with top of bung.



4. DRIVER:

On installation when the last thread of the driver is **LEVEL** with the surface of the bung this is the **STOP** depth. This is a visual aid to know where the bottom of the hole is. You do not want to bottom the driver tool out in the hole on installation as this could damage the taper flare at bottom of hole.



5. INSTALL INSERT: Using a few drops of insert driver oil or 30wt motor oil, Oil the threads of the **DRIVER**.

Screw an insert onto the Driver and into the prepared hole. When that **LAST** thread of the driver tool is level with the surface of the bung the insert will be fully expanded and locked in place.

Remove driver repair is complete.