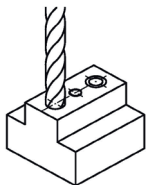
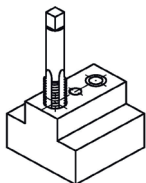


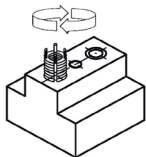
Assembly



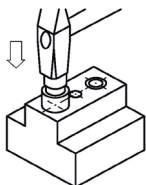
- 1.*
Drill the pilot hole or rebores the old thread with a starting taper (82°-100°)



- 2.*
Tap the required thread using a standard tap.



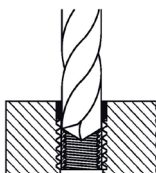
3.
Screw in the thread inserts. These should finish below the top surface of the material (0.3 to 0.7mm).



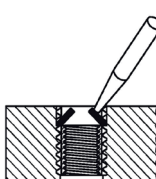
4.
Knock in the tongs using the supplied tool, tapping gently with a hammer.

Steps 1+2. Refer to the parts table for the dimensions.

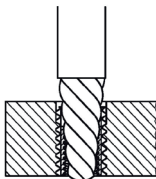
Disassembly



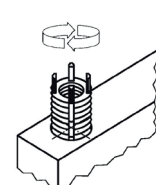
- 1.*
Rebores the remaining material between the keys and threads to the depth indicated



2.
Bend the tongs towards the centre until they break



3.
Remove the thread inserts using the extraction tool



4.
Mount the new thread inserts in the original threads

*Steps 1. Refer to the parts table for the dimensions