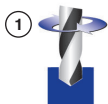


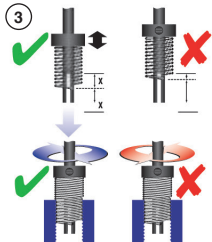
Powercell thread inserts allow threads to be reinforced or repaired and result in greater strength. In new applications they can be used to reinforce lighter materials. For repairs, they are used to restore damaged threads to an as-new condition.



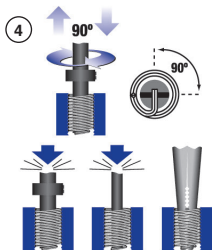
- ① Drill to clear the damaged thread with a standard twist drill. Thread Repair Kits up to M12 include the correct size drill. The required drill size is shown on the front of the packaging.



- ② Use the specified tap to cut the holding thread into the prepared hole. When tapping a hole, it is recommended to use a suitable cutting lubricant.
Note: Thread inserts require the use of STI (Screw thread insert) taps which are slightly oversized to provide the correct hole diameter. Always check that the thread and pitch of the tap are the same as the bolt that will be used in the finished hole.



- ③ Loosen the grub screw and slide the collar along the insert tool shaft so that the tang on the insert is positioned half way up the insert tool slot.
Note: Do not position the tang at the very top or bottom of the insert tool slot.
Use the installation tool to wind the insert into the threaded hole using a light downward pressure until it is half a turn below the surface.
Note: Do not rotate in the opposite direction to the thread direction as the tang may break.



- ④ Lift installation tool, rotate 90° and tap down sharply to break off the thread insert tang. Use the tang break off tool to perform this function where supplied.

Note: For larger inserts use long nosed pliers to remove the tang.

The damaged thread has now successfully been repaired and will normally be stronger than the original.