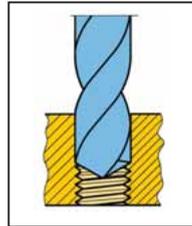
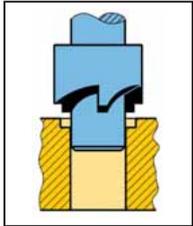


Installation Instructions

Metric Threads / UNC Threads

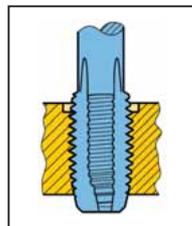
Phase 1

Drill out the damaged thread all the way to the bottom using a HSS drill bit **A**. Be sure to keep the borehole aligned.



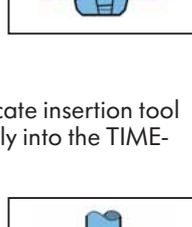
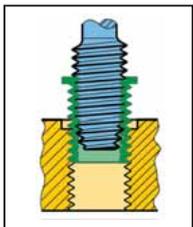
Phase 2

Machine the borehole with seat cutter **B** deep enough that the depth stop gets in contact with the workpiece.



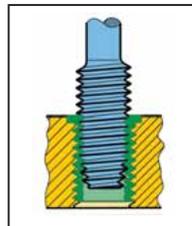
Phase 3

Using thread tap **C**, cut the thread for the TIME-SERT bush. Be sure to keep the borehole aligned.



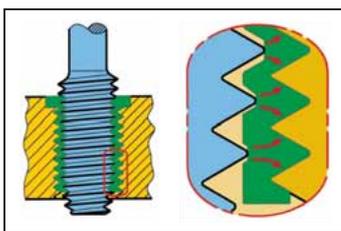
Phase 4

Blow out the shavings. Lubricate insertion tool **D** and screw in bush manually into the TIME-SERT thread.



Phase 5

Once the bush sits flush with the surface, the remaining threads are formed using the insertion tool **D**. The screw-in resistance increases noticeably.



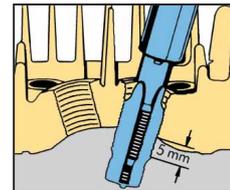
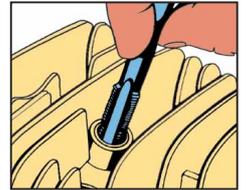
Phase 6

In this phase, the semi-finished threads of the bush are pressed outward. The insertion tool **D** presses excess material into the workpiece. The repair is complete when the tool can be turned with noticeably less resistance.

Spark Plug Threads

Phase 1

Screw in stepped tap **A** into the remaining thread.



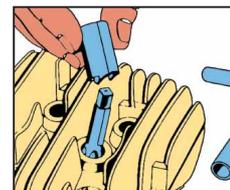
Phase 2

Snap socket wrench **D** onto stepped tap **A** and continue turning until the outer tap protrudes about 5 mm from the thread. In this way, the old thread is removed and the new one is cut in a single operation.



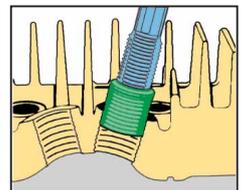
Phase 3

The stepped tap **A** remains in the thread. Slide the seat cutter **B** onto the stepped tap. Keep turning until the seat has been completely cut out. The entire seating surface must be bright.



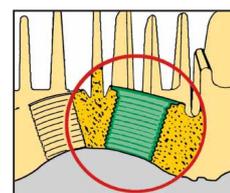
Phase 4

Blow out the shavings. Screw in TIME-SERT bush manually with a few turns - or using insertion tool **C**. Make sure to lubricate the insertion tool first.



Phase 5

Screw in the bush until it is seated securely using the lubricated insertion tool **C** and socket wrench **D**. The screw-in resistance will increase noticeably. Continue turning until the resistance drops noticeably.



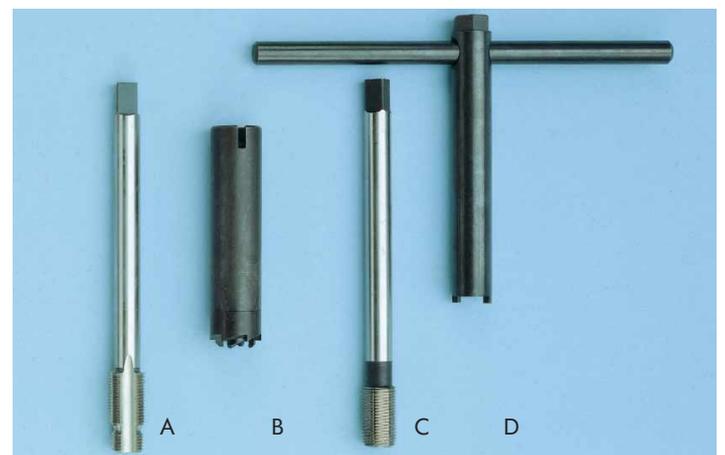
Phase 6

The repair is complete. The threaded bush is now compression proof and secured against unscrewing.



A HSS drill bit
B Seat cutter

C Tap
D Insertion tool



A Stepped tap
B Seat cutter

C Insertion tool
D Socket wrench