

BIG-SERT®

ADD ON KIT

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ADD ON KIT

BIG-SERT M10x1.5 BMW 3&5 SERIES HEAD BOLT ADD-ON KIT

NOTE: This tooling is used in conjunction with p/n 1090 standard kit
P/n 1090BSAO

- WARNING -

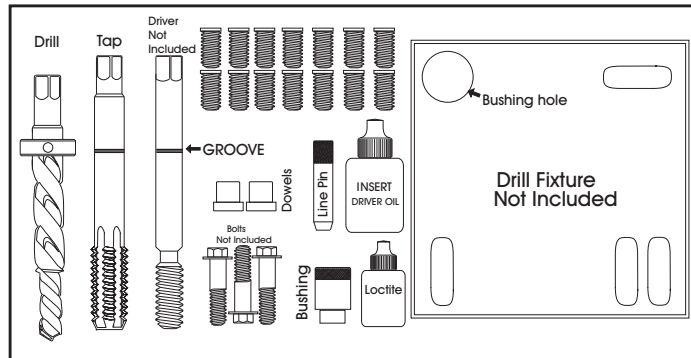
Cutting tools may shatter if broken. The wearing of safety glasses is required in the vicinity of their use.

CUTTING FLUID

A Cutting fluid is necessary for drilling and tapping. (WD40)

DRILL MOTOR

The use of a half inch drill motor is recommended for drilling.



Tools needed:	Part no.
Drill fixture	Not Included ←
Drill bushing	J-42385-307BS
Alignment pin	J-42385-308BS
Bolts (3)	Not Included ←
Step drill	31091BS
Tap	31092BS
Insert driver	Not Included ←
Inserts (14)	50155
Dowels (2)	7588BS
loctite	6020
Driver oil	6010

INSTRUCTIONS

This tooling will install inserts at 6mm depth

STEP 1

PLACE LARGEST HOLE IN DRILL FIXTURE OVER THE HOLE TO BE REPAIRED. PLACE BUSHING IN FIXTURE, THEN PLACE LINE UP PIN IN BUSHING TO PICK UP HOLE. DO NOT FORCE PIN INTO HOLE. USE BOLTS AND TIGHTEN TO SECURE FIXTURE IN PLACE. REMOVE LINE PIN. Note: Drill fixture and bolts not included and are found in kit p/n 1090.

STEP 2 Use WD40 for Drilling

USE A SUITABLE DRILL MOTOR AND STEP DRILL THE HOLE UNTIL THE STOP COLLAR ON THE DRILL LINES UP WITH THE TOP OF THE DRILL BUSHING. THIS WILL REQUIRE REMOVING DRILL AND BUSHING SEVERAL TIMES TO CLEAR CHIPS. CLEAN OUT ALL CHIPS.

NOTE: If drill bushing turns while drilling hole, Remove drill and drill bushing, Clean out all chips.
We recommend using a long air nozzle 6" or longer to blow out all chips.

STEP 3 Use WD40 for Tapping

TAP THROUGH THE DRILL BUSHING UNTIL THE GROOVE ON THE TAP LINES UP WITH THE TOP OF THE DRILL BUSHING. THIS WILL REQUIRE REMOVING THE TAP AND BUSHING SEVERAL TIMES TO CLEAR CHIPS. CLEAN ALL CHIPS USING BRAKE OR CONTACT CLEANER THAT WILL NOT LEAVE AN OILY RESIDUE, THE HOLE MUST BE CLEAN AND DRY. USE A FLASHLIGHT TO INSPECT THE HOLE FOR CHIPS AND CLEANLINESS.

STEP 4 Note: Driver tool not included and is found in p/n 1090 kit.

LEAVE FIXTURE PLATE AND BUSHING ON FOR STEP 4

USE DRIVER OIL ON TOOL (DO NOT USE WD40.)

OIL THE THREADS OF THE INSERT DRIVER. SCREW AN INSERT ONTO THE DRIVER, APPLY A SMALL AMOUNT OF LOCTITE ON THE BOTTOM OUTSIDE THREADS ON THE INSERT AND SCREW THE INSERT INTO THE PREPARED HOLE. WHEN THE HEAD OF THE INSERT IS SEATED THE DRIVER WILL TIGHTEN UP, USE A LITTLE MORE POWER TO SCREW THE DRIVER THROUGH THE INSERT UNTIL THE GROOVE OF THE DRIVER LINES UP WITH THE TOP OF THE BUSHING. REMOVE FIXTURE PLATE REPAIR IS COMPLETE. USE HEAD ALIGNMENT DOWELS IN CORNER HOLES AS ORIGINAL.

Please check for the latest torque specifications before assembling the engine.
Improper torque of the head can lead to thread failure. NEW HEAD BOLTS ARE REQUIRED