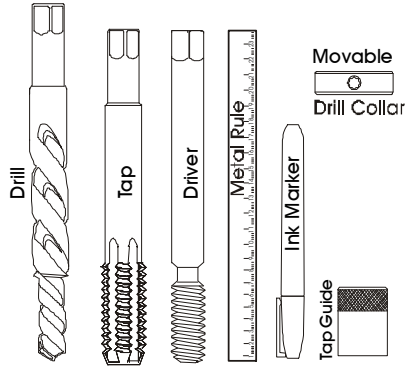


TIME-SERT®

CORE DRILL REPAIR KIT



KIT CONTENTS

1. Step Core Drill w/collar
2. Tap
3. Insert Driver
4. Tap guide
5. Inserts

Use WD40 for drilling & tapping

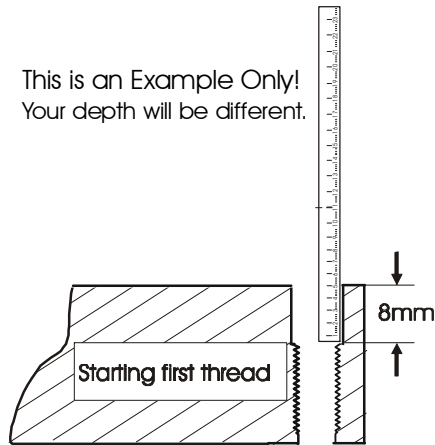
-WARNING-
Cutting tools may shatter if broken. The wearing of safety glasses is required in the vicinity of their use.

(Measuring for depth of hole)

The top of the insert must start at the same depth of the original starting thread. This is important because the rocker arm must fit back into the slot without hitting the insert.

- 1) Start by measuring to the first starting thread.

This is an Example Only!
Your depth will be different.

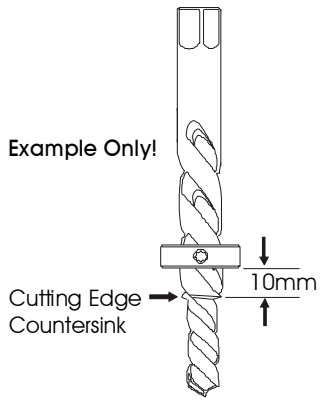
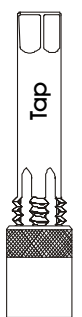
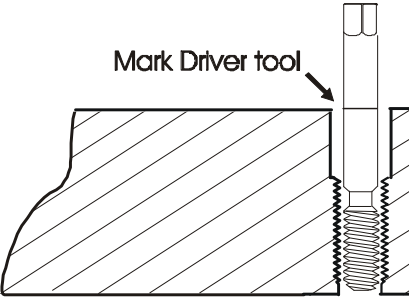
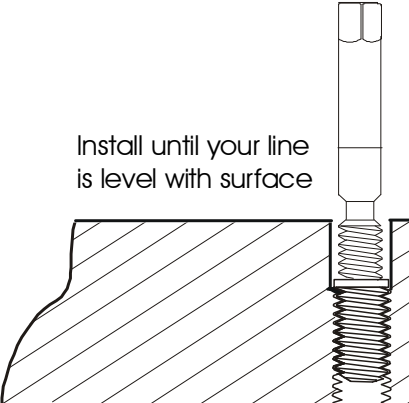


1. Using the metal rule measure from the top of the surface to the First starting thread.

EXAMPLE ONLY PICTURE:
For Example if your depth to the first starting thread is 8mm you must add 2mm for the flange of the insert. Mark your drill at 10mm to achieve the 8mm depth of the original thread.

You must add 2mm to YOUR measured depth of the hole you are working on.

Turn page over to continue

<p>Example Only!</p>  <p>Cutting Edge Countersink</p> <p>10mm</p>	<p>2. Mark your drill from the cutting edge countersink UP and secure the collar for the core drill. Drill your hole using WD40.</p> <p>EXAMPLE ONLY PICTURE for a 8mm depth hole. From <u>the cutting edge countersink</u>, set the movable collar at 10mm which will create a 8mm countersink and will later install the insert at the correct depth of 8mm.</p> <p>Again this is an example only.</p>
 <p>Tap</p>	<p>3. Tap to the full depth of hole. Use the TAP GUIDE included to ensure the threads are square to surface.</p> <p>Note: Hold down firmly. Watch that the tap guide remains flush when tapping.</p>
 <p>Mark Driver tool</p>	<p>4. Install Driver Before installing the insert with the driver tool. Place the driver in the hole to touch the bottom of hole and MARK the driver so you have 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.</p>
 <p>Install until your line is level with surface</p>	<p>5. Using a few drops of insert driver oil or 30wt motor oil Oil the threads of the DRIVER.</p> <p>Screw an insert onto the Driver and into the prepared hole. The driver will start to tighten up as it expands the bottom few threads of the insert, continue until the driver loosens up or you reach the MARK on the driver tool you put on previously in step 4.</p> <p>Remove driver repair is complete.</p>