

TIME-SERT®

M8x1.0 Solex Valve Seat Recondition Kit p/n 1882

SPECIAL INSTRUCTIONS

This recondition kit is used in conjunction with the M8x1.0 Solex Kit p/n 1881 when the solenoid valve seat is damaged.

- 1) **Drill** out old threads using drill located in kit p/n 1881 blow out chips after drilling. **Note: Do not counterbore the hole at this point.**
- 2) **Tap** new threads, be sure to keep tap straight using tap located in kit p/n 1881.
- 3) Screw in guide bushing located in this package into the newly tapped hole.
- 4) Use the reamer located in this package and lightly ream the seat to clean up.
- 5) **Counterbore** the hole. This tool has a cone shaped tip which stops on the valve seat. This establishes the correct shoulder depth for the insert. Blow out chips.
- 6) **Oil the threads of the driver tool.** Screw the insert onto the driver. Put a bead of loc-tite on the outside threads of the insert. This will seal the insert against external leaks. Now 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. Be careful not to bottom the driver tool in the hole.

The bottom inside incomplete threads of the insert are now fully formed. This has expanded the bottom few outside threads into the tapped hole, thus locking the insert in place. Remove driver tool, repair complete.