Thread repair is nothing new but new aluminum engine blocks and components present a different challenge. GM studies have shown that Time-Sert, solid threaded inserts, are superior to wound, spring-type inserts in certain high strength applications. Threads in aluminum are rolled for greater strength but they can be easily cross-threaded or pulled out if a fastener is over-torqued. Thread repair kits from OTC will create a new, stronger hole that matches the original thread size so the original fastener can be used.

- Classified as Essential for GM dealers to achieve consistent repairs across vehicle lines.
- These solid bushing inserts install easily and completely fill the tapped hole to protect against damage from stress or vibrations.
- This is the only thread repair system with rolled threads; matching the threads in aluminum engine blocks and other components.
- Easily withstand highest engine temperatures without losing their shape.
- Inserts are thin-walled due to synchronized internal and external threads. Can be installed in areas of limited space and clearance material.
- Bottom internal threads are cold rolled to expand the mating external threads into the base material. Insert is firmly locked into place.
- Thread repair kits include drills, taps, installation tools and an assortment of inserts for each thread size.

Drill, tap, counter sink and install. That's all you do for permanent repairs!

No. 6410
Kit shown
### Thread Repair Kits

#### 6300 General Thread Repair Kit
- **Drill, M6 x 1.0**
- **Counterclock, M6 x 1.0**
- **Driver, M6 x 1.0**
- **Inserts (4), M6 x 1.0 x 12mm**
- **Drill, M8 x 1.25**
- **Counterclock, M8 x 1.25**
- **Inserts (10), M8 x 16.2 mm**
- **Counterclock, M10 x 1.5**
- **Tap, M10 x 1.5**
- **Driver, M8 x 1.25**
- **Inserts (10), M10 x 1.5 x 20mm**
- **Inserts (2), M10 x 1.5 x 17mm**
- **Driver Oil**
- **Loc-Tite 277 Threadlocker**

#### 6410 National Fine Master Kit
- **Driver Oil**
- **Drill, 1/4 – 28**
- **Counterclock, 1/4 – 28**
- **Tap, 1/4 – 28**
- **Driver, 1/4 – 28**
- **Inserts (10), 1/4 – 28 Long**
- **Inserts (10), 1/4 – 28 Short**
- **Drill, 5/16 – 24**
- **Counterclock, 5/16 – 24**
- **Tap, 5/16 – 24**
- **Driver, 5/16 – 24**
- **Inserts (10), 5/16 – 24 Long**
- **Inserts (10), 5/16 – 24 Short**
- **Drill, 3/8 – 24**
- **Counterbore, 3/8 – 24**
- **Tap, 3/8 – 24**
- **Driver, 3/8 – 24**
- **Inserts (10), 3/8 – 24 Long**
- **Inserts (10), 3/8 – 24 Short**
- **Drill, 1/2 – 20**
- **Counterbore, 1/2 – 20**
- **Tap, 1/2 – 20**
- **Driver, 1/2 – 20**
- **Inserts (10), 1/2 – 20 Long**
- **Inserts (10), 1/2 – 20 Short**
- **Driver Oil**

#### 6455 Metric Fine Master Kit
- **Drill, M6 x 1.0**
- **Counterclock, M6 x 1.0**
- **Tap, M6 x 1.0**
- **Driver, M6 x 1.0**
- **Drill, M6 x 1.25**
- **Counterclock, M6 x 1.25**
- **Tap, M6 x 1.25**
- **Driver, M6 x 1.25**
- **Inserts (10), M6 x 16.2 mm**
- **Inserts (10), M6 x 1.0 Short**
- **Drill, M5 x 0.8**
- **Counterclock, M5 x 0.8**
- **Tap, M5 x 0.8**
- **Driver, M5 x 0.8**
- **Inserts (10), M5 x 0.8 Long**
- **Inserts (10), M5 x 0.8 Short**
- **Drill, M12 x 1.5**
- **Counterbore, M12 x 1.5**
- **Tap, M12 x 1.5**
- **Driver, M12 x 1.5**
- **Inserts (10), M10 x 1.25 Long**
- **Inserts (10), M10 x 1.25 Short**
- **Driver Oil**

#### 6435 Metric Coarse Master Kit
- **Drill, M6 x 1.0**
- **Counterclock, M6 x 1.0**
- **Tap, M6 x 1.0**
- **Driver, M6 x 1.0**
- **Drill, M8 x 1.25**
- **Counterclock, M8 x 1.25**
- **Tap, M8 x 1.25**
- **Driver, M8 x 1.25**
- **Inserts (10), M8 x 16.2 mm long**
- **Inserts (10), M8 x 1.0 Long**
- **Drill, M12 x 1.5**
- **Counterbore, M12 x 1.5**
- **Tap, M12 x 1.5**
- **Driver, M12 x 1.5**
- **Inserts (10), M5 x 0.8 Long**
- **Inserts (10), M5 x 0.8 Short**
- **Drill, M12 x 1.75**
- **Counterbore, M12 x 1.75**
- **Tap, M12 x 1.75**
- **Driver, M12 x 1.75**
- **Inserts (10), M10 x 1.5 Long**
- **Inserts (10), M10 x 1.5 Short**
- **Driver Oil**

#### 6375 National Coarse Master Kit
- **Driver Oil**
- **Drill, 1/4 – 20**
- **Counterclock, 1/4 – 20**
- **Tap, 1/4 – 20**
- **Driver, 1/4 – 20**
- **Inserts (10), 1/4 – 20 Long**
- **Drill, 5/16 – 18**
- **Counterclock, 5/16 – 18**
- **Tap, 5/16 – 18**
- **Driver, 5/16 – 18**
- **Inserts (10), 5/16 – 18 Long**
- **Drill, 3/8 – 16**
- **Counterbore, 3/8 – 16**
- **Tap, 3/8 – 16**
- **Driver, 3/8 – 16**
- **Inserts (10), 3/8 – 16 Long**
- **Drill, 1/2 – 13**
- **Counterbore, 1/2 – 13**
- **Tap, 1/2 – 13**
- **Driver, 1/2 – 13**
- **Inserts (10), 1/2 – 13 Long**
- **Drill, 7/16 – 14**
- **Counterbore, 7/16 – 14**
- **Tap, 7/16 – 14**
- **Driver, 7/16 – 14**
- **Inserts (10), 7/16 – 14 Long**
- **Inserts (10), 1/4 – 20 Short**
- **Drill, 7/8 – 14**
- **Counterbore, 7/8 – 14**
- **Tap, 7/8 – 14**
- **Driver, 7/8 – 14**
- **Inserts (10), 7/8 – 14 Long**
- **Inserts (10), 3/8 – 16 Long**
- **Inserts (10), 1/2 – 13 Short**
- **Inserts (10), 7/16 – 14 Short**

#### 6320 Cylinder Head/Main Bearing Kit
- **Driver Oil**
- **Loc-Tite 277 Threadlocker**
- **Inserts (10), M10 x 1.5 x 20mm**
- **Head Insert Driver**
- **Head Inserts (10), M11 x 1.5 x 30mm**
- **Head Bolt Repair Fixture**
- **Main Bolt Repair Fixture**
- **Main Bolt Repair Fixure**
- **Main Bolt Alignment Pin**
- **Attachment Bolt (Head)**
- **Head Bolt Step Drill**
- **Head Bolt Tap, M11 x 1.5**
- **Head Insert Driver**
- **Main Bolt Insert Driver**
- **Main Insert Driver**

#### 6345 Cylinder Head/Main Bearing Cap Bolt Kit
- **Driver Oil**
- **Loc-Tite 277 Threadlocker**
- **Core Drill M10 x 2.0**
- **Tap, M10 x 2.0**
- **Driver, M10 x 2.0**
- **Inserts (4), M10 x 2.0 x 22mm**
- **Inserts (10), M11 x 2.0 x 20mm**
- **Drill, Core M11 x 2.0**
- **Tap, M11 x 1.0**
- **Driver, M11 x 2.0**
- **Inserts (10), M11 x 2.0 x 30mm**

#### 6350 Fixture/Hardware Thread Repair Kit
- **Head Bolt Bushing Fixture**
- **Head Bolt Alignment Pin**
- **Head Bolt Repair Fixture**
- **Main Bolt Repair Fixture**
- **Bushing Main Bolt Fixture**
- **Main Bolt Alignment Pin**
- **Head Attachment Bolt (Long)**
- **Main Bearing Attachment Bolt (Long)**
- **Main Bearing Attachment Bolt (Short)**
- **Main Bearing Drill Stop Collar**
- **Main Bearing Drill Stop Collar**

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**Legend:**
- Nos. 6410, 6375, 6455, & 6435
- No. 6300

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**Note:**
- Litho in USA
- 8/99(99-54)
- 247-2

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**SPX OTC**