

# As good as new!

## TIME-SERT® Thread Repair Kits

GM approved for use in  
aluminum engine blocks  
& other components.

**T**hread 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



SPX Corporation  
655 Eisenhower Drive  
Owatonna MN 55060-0995  
Phone 507-455-7000  
Customer Service/Order Entry 1-800-533-6127  
Visit OTC on the Internet: <http://www.otctools.com>

# Thread Repair Kits

## 6300 General Thread Repair Kit

- 6301 Drill, M6 x 1.0
- 6302 Counterbore, M6 x 1.0
- 6303 Tap, M6 x 1.0
- 6304 Driver, M6 x 1.0
- 6305 Inserts (4), M6 x 1.0 x 12mm
- 6306 Drill, M8 x 1.25
- 6307 Counterbore, M8 x 1.25
- 6308 Tap, M8 x 1.25
- 6309 Driver, M8 x 1.25
- 6310 Inserts (10), M8 x 16.2 mm
- 6311 Drill, M10 x 1.5
- 6312 Counterbore, M10 x 1.5
- 6313 Tap, M10 x 1.5
- 6314 Driver, M10 x 1.5
- 6315 Inserts (10), M10 x 1.5 x 20mm
- 6316 Inserts (2), M10 x 1.5 x 17mm
- 6317 Driver Oil
- 6318 Loc-Tite 277 Threadlocker



No. 6300



Nos. 6410, 6375,  
6455, & 6435

## 6410 National Fine Master Kit

- 6317 Driver Oil
- 6372 Drill, 1/4 - 28
- 6373 Counterbore, 1/4 - 28
- 6374 Tap, 1/4 - 28
- 6406 Driver, 1/4 - 28
- 6407 Inserts (10), 1/4 - 28 Long
- 6408 Inserts (10), 1/4 - 28 Short
- 6409 Drill, 5/16 - 24
- 6411 Counterbore, 5/16 - 24
- 6412 Tap, 5/16 - 24
- 6413 Driver, 5/16 - 24
- 6414 Inserts (10), 5/16 - 24 Long
- 6415 Inserts (10), 5/16 - 24 Short
- 6416 Drill, 3/8 - 24
- 6417 Counterbore, 3/8 - 24
- 6418 Tap, 3/8 - 24
- 6419 Driver, 3/8 - 24
- 6420 Inserts (10), 3/8 - 24 Long
- 6421 Inserts (10), 3/8 - 24 Short
- 6422 Drill, 1/2 - 20
- 6423 Counterbore, 1/2 - 20
- 6424 Tap, 1/2 - 20
- 6425 Driver, 1/2 - 20
- 6426 Inserts (10), 1/2 - 20 Long
- 6427 Inserts (10), 1/2 - 20 Short
- 6428 Drill, 7/16 - 20
- 6429 Counterbore, 7/16 - 20
- 6430 Tap, 7/16 - 20
- 6431 Driver, 7/16 - 20
- 6432 Inserts (10), 7/16 - 20 Long
- 6433 Inserts (10), 7/16 - 20 Short

## 6455 Metric Fine Master Kit

- 6301 Drill, M6 x 1.0
- 6302 Counterbore, M6 x 1.0
- 6303 Tap, M6 x 1.0
- 6304 Driver, M6 x 1.0
- 6306 Drill, M8 x 1.25
- 6307 Counterbore, M8 x 1.25
- 6308 Tap, M8 x 1.25
- 6309 Driver, M8 x 1.25
- 6310 Inserts (10), M8 x 16.2 mm
- 6317 Driver Oil
- 6434 Inserts (10), M8 x 1.25 Short
- 6436 Inserts (10), M6 x 1.0 Short
- 6437 Drill, M5 x 0.8
- 6438 Counterbore, M5 x 0.8
- 6439 Tap, M5 x 0.8
- 6440 Driver, M5 x 0.8
- 6441 Inserts (10), M5 x 0.8 Long
- 6442 Inserts (10), M5 x 0.8 Short
- 6451 Inserts (10), M6 x 1.0 Long
- 6453 Drill, M12 x 1.5
- 6454 Counterbore, M12 x 1.5
- 6456 Tap, M12 x 1.5
- 6457 Driver, M12 x 1.5
- 6458 Inserts, M12 x 1.5 Long
- 6459 Inserts (10), M12 x 1.5 Short
- 6460 Drill, M10 x 1.25
- 6461 Counterbore, M10 x 1.25
- 6462 Tap, M10 x 1.25
- 6463 Driver, M10 x 1.25
- 6464 Inserts (10), M10 x 1.25 Long
- 6465 Inserts (10), M10 x 1.25 Short

## 6375 National Coarse Master Kit

- 6317 Driver Oil
- 6376 Drill, 1/4 - 20
- 6377 Counterbore, 1/4 - 20
- 6378 Tap, 1/4 - 20
- 6379 Driver, 1/4 - 20
- 6380 Inserts (10), 1/4 - 20 Long
- 6381 Drill, 5/16 - 18
- 6382 Counterbore, 5/16 - 18
- 6383 Tap, 5/16 - 18
- 6384 Driver, 5/16 - 18
- 6385 Inserts (10), 5/16 - 18 Long
- 6386 Drill, 3/8 - 16
- 6387 Counterbore, 3/8 - 16
- 6388 Tap, 3/8 - 16
- 6389 Driver, 3/8 - 16
- 6390 Inserts (10), 3/8 - 16 Long
- 6391 Drill, 1/2 - 13
- 6392 Counterbore, 1/2 - 13
- 6393 Tap, 1/2 - 13
- 6394 Driver, 1/2 - 13
- 6395 Inserts (10), 1/2 - 13 Long
- 6396 Drill, 7/16 - 14
- 6397 Counterbore, 7/16 - 14
- 6398 Tap, 7/16 - 14
- 6399 Driver, 7/16 - 14
- 6400 Inserts (10), 7/16 - 14 Long
- 6401 Inserts (10), 1/4 - 20 Short
- 6402 Inserts (10), 5/16 - 18 Short
- 6403 Inserts (10), 3/8 - 16 Short
- 6404 Inserts (10), 1/2 - 13 Short
- 6405 Inserts (10), 7/16 - 14 Short

## 6435 Metric Coarse Master Kit

- 6301 Drill, M6 x 1.0
- 6302 Counterbore, M6 x 1.0
- 6303 Tap, M6 x 1.0
- 6304 Driver, M6 x 1.0
- 6306 Drill, M8 x 1.25
- 6307 Counterbore, M8 x 1.25
- 6308 Tap, M8 x 1.25
- 6309 Driver, M8 x 1.25
- 6310 Inserts (10), M8 x 16.2 mm long
- 6311 Drill, M10 x 1.5
- 6312 Counterbore, M10 x 1.5
- 6313 Tap, M10 x 1.5
- 6314 Driver, M10 x 1.5
- 6317 Driver Oil
- 6434 Inserts (10), M8 x 1.25 Short
- 6436 Inserts (10), M6 x 1.0 Short
- 6437 Drill, M5 x 0.8
- 6438 Counterbore, M5 x 0.8
- 6439 Tap, M5 x 0.8
- 6440 Driver, M5 x 0.8
- 6441 Inserts (10), M5 x 0.8 Long
- 6442 Inserts (10), M5 x 0.8 Short
- 6443 Drill, M12 x 1.75
- 6444 Counterbore, M12 x 1.75
- 6445 Tap, M12 x 1.75
- 6446 Driver, M12 x 1.75
- 6447 Inserts (10), M12 x 1.75 Long
- 6448 Inserts (10), M12 x 1.75 Short
- 6449 Inserts (10), M10 x 1.5 Long
- 6450 Inserts (10), M10 x 1.5 Short
- 6451 Inserts (10), M6 x 1.0 Long

## 6320 Cylinder Head/Main Bearing Kit

- 6317 Driver Oil
- 6318 Loc-Tite 277 Threadlocker
- 6319 Bushing Head Bolt Fixture
- 6321 Head Bolt Alignment Pin
- 6322 Head Bolt Repair Fixture
- 6323 Main Bolt Repair Fixture
- 6324 Main Bolt Fixture Bushing
- 6325 Main Bolt Alignment Pin
- 6326 Attachment Bolt (Head)
- 6327 Head Bolt Step Drill
- 6328 Head Bolt Tap, M11 x 1.5
- 6329 Head Insert Driver
- 6330 Head Inserts (10), M11 x 1.5 x 30mm
- 6331 Main Attachment Bolt
- 6332 Main Bolt Step Drill
- 6333 Main Bolt Tap, M10 x 1.5
- 6334 Main Insert Driver
- 6335 Main Inserts (4), M10 x 1.0 x 22mm



## 6345 Cylinder Head/Main Bearing Cap Bolt Kit

- 6317 Driver Oil
- 6318 Loc-Tite 277 Threadlocker
- 6336 Core Drill M10 x 2.0
- 6337 Tap, M10 x 2.0
- 6338 Driver, M10 x 2.0
- 6339 Inserts (4), M10 x 2.0 x 22mm
- 6341 Drill, Core M11 x 2.0
- 6342 Tap, M11 x 1.0
- 6343 Driver, M11 x 2.0
- 6344 Inserts (10), M11 x 2.0 x 30mm



## 6350 Fixture/Hardware Thread Repair Kit

- 6319 Head Bolt Bushing Fixture
- 6321 Head Bolt Alignment Pin
- 6322 Head Bolt Repair Fixture
- 6323 Main Bolt Repair Fixture
- 6324 Bushing Main Bolt Fixture
- 6325 Main Bolt Alignment Pin
- 6346 Head Attachment Bolt (Long)
- 6347 Head Attachment Bolt (Short)
- 6348 Main Bearing Attachment Bolt (Long)
- 6349 Main Bearing Attachment Bolt (Short)
- 6351 Stop Collar Insert, M10 x 1.5
- 6352 Head Bolt Drill Stop Collar
- 6353 Main Bearing Drill Stop Collar

