INSTRUCTIONS

Use of a cutting fluid is recommended for drilling counterboring and tapping.

**STEP 1**

Drill out old threads keeping drill square to the surface of the hole.

**STEP 2**

Counterbore the hole to full depth permitted by the tool.

- **WARNING** -

Cutting Tools may shatter if broken. The wearing of safety glasses is required in the vicinity of their use.
STEP 3
Place the tap guide against the drain pan. Start the tap into the guide, turn the tap slowly while making sure the guide remains flat to surface.

STEP 4
Blow chips out of the hole. Screw an insert a few turns into the tapped hole.

STEP 5
OIL THREADS OF DRIVER
Screw the driver tool into the insert. When the flange of the insert is seated the driver will tighten up. Using a little more power continue to rotate the driver until it loosens up.

COMPLETED REPAIR
The bottom few threads have been expanded locking the insert in place. You now have solid steel threads.