TIME-SERT®

SCREW THREAD INSERTS

THIN WALL
SELF LOCKING
SOLID BUSHING
POSITIVE PLACEMENT

MADE IN USA

TIME-SERT®

PROFESSIONAL THREAD REPAIR SYSTEM
SCREW THREAD INSERTS AMERICAN & METRIC SIZES

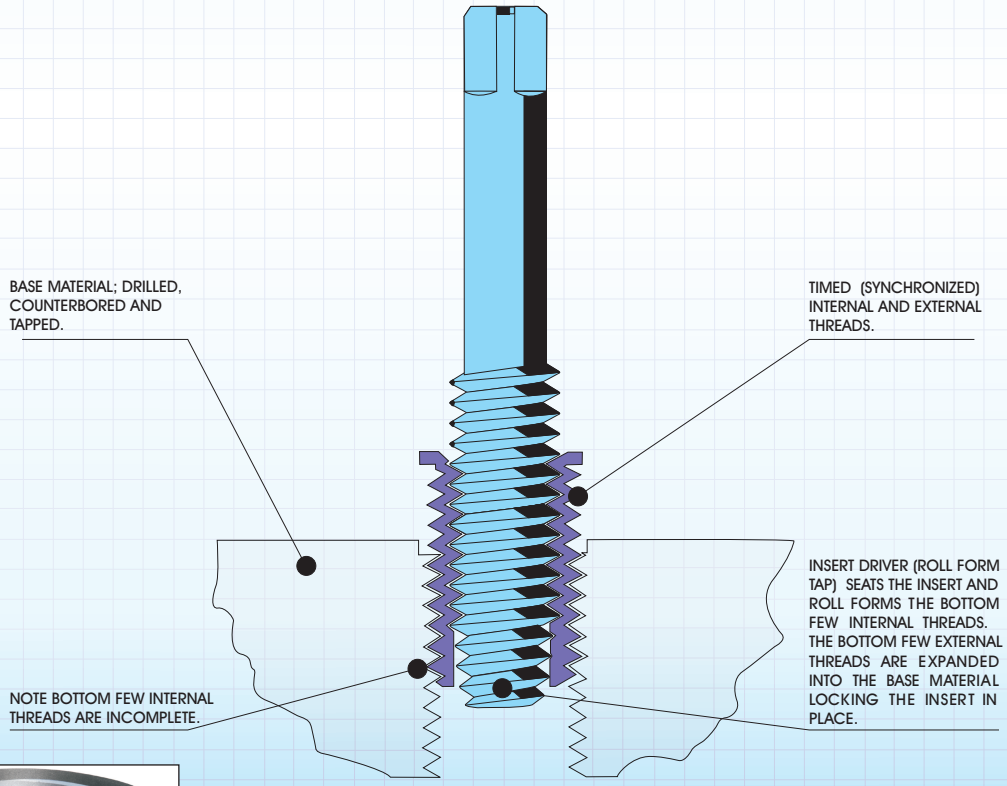
ADVANTAGES WHICH ARE CONVINCING:

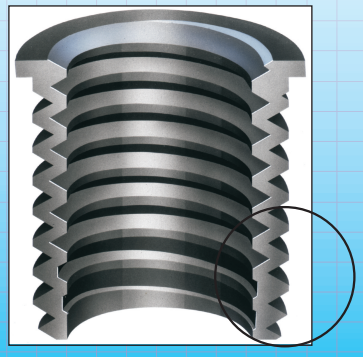
TIME-SERT® is a **solid bushing** insert. This guarantees easy installation and allows for full load use of tapped hole, ensuring protection against stress and vibration.

TIME-SERT® is **thin walled** due to synchronized internal external threads. Thin cross sectional area allows for installation in areas of limited space and clearance material.

TIME-SERT® has **positive placement.** Having a flange on the top of the insert will insure that the insert will have positive placement and cannot wind down into the newly repaired hole.

TIME-SERT® is **self locking**. On installation the bottom internal threads of the insert are cold rolled to expand the mating external threads into the base material locking the insert in place. Locking mechanism is at the bottom of the insert.





Note bottom few internal threads are incomplete.

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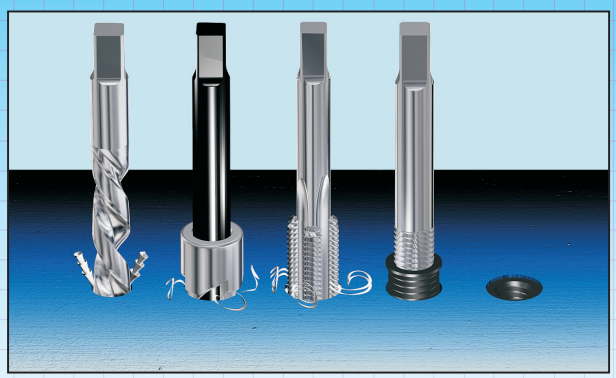
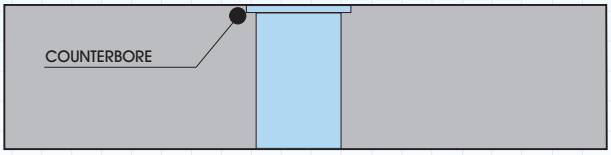
ENGINEERING DATA





Counterbores are flat bottom. We recommend step drills for production applications.

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

Oil must be used on the insert driver.

Tool kits are designed for a suitable tap wrench, or power tools such as: drill press, electric or air hand drills and tappers.

Carbon steel inserts are phosphate coated. Stainless steel inserts are 303 or equilvalent.

TAPER PIPE

INSERT	DRILL		C.BORE		TAP
SIZE	DRILL	SIZE	MIN. DIA.	MIN. DEPTH	MAJOR DIA.
1/8-27	13/32	.406	.466	.055	.449
1/4-18	37/64	.578	.668	.075	.638
3/8-18	23/32	.718	.837	.075	.794
1/2-14	55/64	.859	1.000	90° CSK	.942
3/4-14	1 3/32	1.093	1.300	90° CSK	1.194

INCH

INSERT	DRILL		C.BORE		TAP
SIZE	DRILL	SIZE	MIN. DIA.	MIN. DEPTH	MAJOR DIA.
4 - 40	#31	.120	.170	.055	.147
6 - 32	#26	.147	.218	.070	.182
8 - 32	#17	.173	.241	.065	.208
10 - 24	13/64	.203	.288	.075	.247
10 - 32	13/64	.203	.274	.075	.234
12 - 24	#1	.228	.307	.075	.265
1/4 - 20	17/64	.265	.352	.075	.319
1/4 - 28	G	.261	.340	.075	.300
5/16 - 18	21/64	.328	.430	.085	.388
5/16 - 24	P	.323	.410	.080	.368
3/8 - 16	X	.397	.495	.085	.460
3/8 - 24	W	.386	.473	.080	.432
7/16 - 14	29/64	.453	.571	.110	.534
7/16 - 20	29/64	.453	.547	.085	.506
1/2 - 13	33/64	.515	.648	.110	.604
1/2 -20	33/64	.515	.610	.085	.569
9/16 - 12	19/32	.593	.711	.130	.675
9/16 -18	37/64	.578	.668	.110	.638
5/8 - 11	21/32	.656	.787	.135	.748
5/8 - 18	41/64	.640	.740	.110	.701
3/4 - 10	25/32	.781	.935	.135	.885
3/4 - 16	49/64	.765	.870	.110	.835

METRIC

INSERT	DRILL		C.BORE		TAP
SIZE	DRILL	SIZE	MIN. DIA.	MIN. DEPTH	MAJOR DIA.
M3 x 0.5	1/8	.125	.170	.055	.140
M4 x 0.7	# 19	.166	.226	.065	.194
M5 x 0.8	# 8	.199	.279	.075	.238
M6 x 1.0	D	.246	.319	.075	.290
M7 x 1.0	L	.290	.351	.075	.330
M8 x 1.0	P	.323	.409	.080	.369
M8 x 1.25	P	.323	.419	.080	.381
M9 x 1.25	U	.368	.440	.080	.422
M10 x 1.0	13/32	.406	.466	.080	.349
M10 x 1.25	13/32	.406	.500	.085	.463
M10 x 1.5	13/32	.406	.500	.085	.474
M11 x 1.25	29/64	.453	.542	.085	.503
M11 x 1.5	29/64	.453	.552	.085	.516
M12 x 1.25	31/64	.484	.560	.085	.540
M12 x 1.5	31/64	.484	.595	.085	.552
M12 x 1.75	1/2	.500	.605	.110	.567
M13 x 1.5	17/32	.531	.612	.085	.594
M14 x 2.0	37/64	.578	.685	.110	.660
M14 x 1.5	37/64	.578	.668	.110	.634
M16 x 1.5	21/32	.656	.743	.110	.713
M16 x 2.0	21/32	.656	.787	.115	.741
M18 x 1.5	23/32	.718	.837	.125	.794
M20 x 1.5	51/64	.797	.925	.120	.890
M22 x 1.5	7/8	.875	.950	.100	.940
M24 x 1.5	24.5	.963	1.030	.750	1.010

MASTER SETS

EACH SET CONTAINS 5 COMPLETE TOOL KITS AND 20 INSERTS OF EACH SIZE (TOTAL 100 INSERTS)

INCH

COARSE	FINE
1/4-20	1/4-28
5/16-18	5/16-24
3/8-16	3/8-24
7/16-14	7/16-20
1/2-13	1/2-20
CARBON STEEL PART NO. 0010	CARBON STEEL PART NO. 0020
STAINLESS STEEL PART NO. 0011	STAINLESS STEEL PART NO. 0021

METRIC

COARSE	FINE
M5 x 0.8	M5 x 0.8
M6 x 1.0	M6 x 1.0
M8 x 1.25	M8 x 1.25
M10 x 1.5	M10 x 1.25
M12 x 1.75	M12 x 1.5
CARBON STEEL PART NO. 1000	CARBON STEEL PART NO. 1001
STAINLESS STEEL PART NO. 1002	STAINLESS STEEL PART NO. 1003

MINI MASTER

EACH SET CONTAINS 3 COMPLETE TOOL KITS AND 20 INSERTS OF EACH SIZE (TOTAL 60 INSERTS)

INCH

COARSE	FINE
1/4-20	1/4-28
5/16-18	5/16-24
3/8-16	3/8-24
CARBON STEEL PART NO. 1203	CARBON STEEL PART NO. 1204
STAINLESS STEEL PART NO. 1205	STAINLESS STEEL PART NO. 1206

METRIC

COARSE	FINE
M6 x 1.0	M6 x 1.0
M8 x 1.25	M8 x 1.25
M10 x 1.5	M10 x 1.25
CARBON STEEL PART NO. 1201	CARBON STEEL PART NO. 1202
STAINLESS STEEL PART NO. 1207	STAINLESS STEEL PART NO. 1208

METRIC THREAD REPAIR KITS AND INSERTS

KIT CONTENTS

Drill Counterbore
Cutting tap Insert driver
Five (5) steel inserts

Bold text are insert lengths supplied in kits

METRIC KITS		INSERT LENGTH		INSERTS CARBON STEEL	INSERTS STAINLESS STEEL
SIZE	PART NO	MM	INCHES	PART NO.	PART NO.
M3x0.5	1305	**4.3**	**.169**	13051	13052
		6.0	.240	13053	13054
M4x0.7	1407	**4.0**	**.157**	14077	—
		6.0	**.240**	14071	14072
		8.0	.320	14073	14074
M5x0.8	1508	**7.6**	**.300**	15081	15082
		10.0	.400	15083	15084
		12.0	.470	15085	—
M6x1.0	1610	8.0	.315	16105	16106
		9.4	**.370**	16101	16102
		12.0	.470	16103	16104
		17.0	.669	16107	—
		19.0	.748	16109	—
M7x1.0	1710	**10.0**	**.400**	17101	—
		14.0	.550	17103	—
M8x1.0	1810	7.5	.295	18100	—
		11.7	**.460**	18101	—
M8x1.25	1812	8.0	.315	—	18128
		9.0	.360	181210	—
		11.7	**.460**	18121	18122
		14.0	.550	18129	—
		16.2	.640	18123	18124
		18.0	.708	18127	—
M8x1.75 GM Rare	1817	16.2	**.640**	18173	—
M9x1.25	1912	**13.0**	**.510**	19121	—
		18.0	.710	19123	—
		22.0	.866	19127	—
M10x1.0	1010	6.2	.244	10100	—
		8.0	.315	10105	—
		9.0	.360	10101	—
		15.0	**.600**	10103	—
M10x1.25	1012	9.0	.354	10127	—
		14.0	.550	10121	10122
		16.2	**.650**	10123	—
		20.0	.800	10125	10126
		25.0	.984	10129	—
M10x1.5	1015	9.4	.370	10157	—
		11.0	.433	101511	—
		14.0	**.550**	10151	10152
		17.0	.669	101517	—
		20.0	.800	10153	10154
		22.0	.866	101522	—
		24.5	.960	10155	—
M11x1.25	1112	**22.0**	**.870**	11123	—
		28.0	1.100	11121	—
M11x1.5	1115	**16.0**	**.630**	11151	—
		22.0	.870	11153	—
		30.0	1.180	11155	—

Bold text are insert lengths supplied in kits

METRIC KITS		INSERT LENGTH		INSERTS CARBON STEEL	INSERTS STAINLESS STEEL
SIZE	PART NO	MM	INCHES	PART NO.	PART NO.
M12x1.25	1212	9.0	.360	12121	—
		11.0	.430	12129	—
		15.0	**.600**	12123	12124
		24.0	.950	12125	12126
M12x1.5	1215	6.7	.263	12157	—
		9.2	.360	12151	—
		16.2	**.640**	12153	12152
		24.0	.950	12155	12154
		30.0	1.180	12159	12160
M12x1.75	1217	10.0	.400	12177	—
		12.0	.472	12170	—
		16.2	**.640**	12171	12172
		24.0	.950	12173	12174
		30.0	1.180	12179	—
M13x1.5	1315	14.0	.551	13151	—
		19.0	**.748**	13153	—
		24.0	.950	13155	—
		28.0	1.102	13157	—
M14x1.5	1415	6.6	.260	14151	—
		9.4	.370	14153	—
		12.7	.500	14155	—
		17.8	**.700**	14157	—
		24.0	.950	14158	—
		28.0	1.100	14159	—
M14x2.0	1420	12.0	.472	14201	—
		18.0	**.710**	14203	—
		24.0	.950	14205	—
		30.0	1.180	14207	—
M16x1.5	1615	7.0	.270	16151	—
		12.7	**.500**	16153	—
		24.0	.950	16155	—
M16x2.0	1620	16.0	.630	16200	16202
		24.0	**.950**	16201	16204
		32.0	1.250	16203	16206
M18x1.5	1815	10.0	.400	18151	—
		18.3	**.720**	18153	—
		27.0	1.060	18155	—
M20x1.5	2015	9.0	.354	20150	—
		12.0	.472	20151	—
		17.0	**.669**	20153	—
		30.0	1.180	20155	—
M22x1.5	2215C	**10.0**	**.400**	22151	—
		15.0	.590	22153	—
		20.0	.800	22155	—
M24x1.5	2415C	**7.6**	**.300**	24150	—
		10.0	.400	24151	—
		15.0	.590	24153	—
		20.0	.800	24155	—
		30.0	1.200	24157	—

INCH THREAD REPAIR KITS AND INSERTS

KIT CONTENTS

Drill Counterbore
Cutting tap Insert driver
Five (5) steel inserts

Bold text are insert lengths supplied in kits

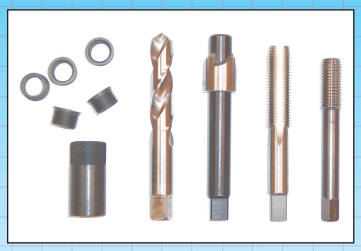
INCH KITS		INSERT LENGTH		INSERTS CARBON STEEL	INSERTS STAINLESS STEEL
SIZE	PART NO.	INCHES	MM	PART NO.	PART NO.
4-40	0440	**.200**	**5.0**	04401	04402
6-32	0632	**.250**	**6.3**	06321	06322
8-32	0832	**.250**	**6.3**	08321	08322
		.320	8.0	08323	08324
10-24	0024	.240	6.1	00240	00246
		.300	**7.6**	00241	00242
		.370	9.4	00243	00244
10-32	0032	.240	6.1	00320	——
		.300	**7.6**	00321	00322
		.370	9.4	00323	00324
12-24	0124	.300	7.6	01241	01242
		.370	**9.4**	01243	01244
		.472	12.0	01245	01246
1/4-20	0140	.280	7.1	01400	——
		.380	**9.4**	01401	01402
		.500	12.7	01403	01404
1/4-28	0148	.280	7.1	01480	01486
		.380	**9.4**	01481	01482
		.500	12.7	01483	01484
5/16-18	0561	.350	8.9	05610	——
		.450	**11.4**	05611	05612
		.620	15.7	05613	05614
		.750	19.0	05615	——
5/16-24	0562	.350	8.9	05620	——
		.450	**11.4**	05621	05622
		.620	15.7	05623	05624
		.750	19.0	05625	——
3/8-16	0381	.312	7.9	03818	038182
		.400	10.0	03819	038192
		.520	**13.2**	03811	03812
		.620	15.7	03813	03814
		.750	19.0	03815	03816
		.900	22.8	038190	——
		1.000	25.4	03810	038102
		1.200	30.4	03817	——
3/8-24	0382	.300	7.6	——	03820
		.350	8.9	03825	——
		.520	**13.2**	03821	03822
		.750	19.0	03823	03824

Bold text are insert lengths supplied in kits

INCH KITS		INSERT LENGTH		INSERTS CARBON STEEL	INSERTS STAINLESS STEEL
SIZE	PART NO.	INCHES	MM	PART NO.	PART NO.
7/16-14	0761	.400	10.0	07610	——
		.600	**15.2**	07611	07612
		.870	22.0	07613	07614
		1.000	25.4	076135	07619
		1.250	31.7	07615	07618
		1.500	38.0	07617	——
7/16-20	0762	.250	6.3	07629	——
		.370	9.4	076320	——
		.480	12.2	07627	——
		.600	**15.2**	07621	07622
		.870	22.0	07623	07624
		1.370	34.7	07625	——
1/2-13	0121	.400	10.0	01217	——
		.650	**16.5**	01211	01212
		1.000	25.4	01213	01214
		1.250	31.7	01219	——
		1.500	38.0	01215	——
1/2-20	0122	.400	10.0	01225	——
		.500	12.7	01220	——
		.650	**16.5**	01221	01222
		1.000	25.4	01223	01224
		1.370	34.7	01227	——
9/16-12	0961	**.750**	**19.0**	09611	——
		1.120	28.4	09615	——
9/16-18	0968	.350	8.9	09687	——
		.450	11.4	09685	——
		.750	**19.0**	09681	——
		1.120	28.4	09683	——
5/8-11	0581	.500	12.7	05810	——
		.850	**21.6**	05811	05812
		1.250	31.7	05813	05814
5/8-18	0588	.320	8.1	05881	——
		.450	11.4	05887	——
		.850	**21.6**	05883	——
		1.250	31.7	05885	——
3/4-10	0341	.750	19.0	03415	——
		1.100	**28.0**	03411	——
		1.500	38.0	03413	——
3/4-16	0346	.650	16.5	03460	——
		1.100	**28.0**	03461	——
		1.500	38.0	03463	——

DRAIN PAN APPLICATIONS

All kits include all the tools plus 5 inserts and tap guide.



Drain Pans Kits

1/2-13 Drain Pan
Kit Part number 0121C Insert Part No.01217
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts .400 length

1/2-20 Aluminum Drain Pan
Kit Part number 0122A Insert Part No.01225
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts .400 length

FORD Drain Pan
1/2-20 "TIN PANS ONLY"
Kit Part number 0765 Insert Part No.07629
This kit reduces the hole size from "1/2-20 to 7/16-20"
Contains: Cbore, Driver tools, 5 inserts, 5 drain plugs with washers

3/4-16 Drain Pan
Kit Part number 0346C Insert Part No.03460
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts .650 length

M10x1.5 Drain Pan
Kit Part number 1015A Insert Part No.10157
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts 9.4mm length

M12x1.25 Drain Pan
Kit Part number 1212C Insert Part number12121
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts 9mm length

M12x1.5 Drain Pan
Kit Part number 1215C Insert Part No.12151
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts 9.2mm length

M12x1.75 Drain Pan
Kit Part number 1217C Insert Part No.12170
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts 12mm length

M14x1.5 Volkswagen,Chrylser...
Same as the 1415C but has a longer insert 12.7mm
Kit Part number 1415A Insert Part No.14155
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts 12.7mm length

M14x1.5 "Aluminum Pans"
Kit Part number 1415C Insert Part No.14153
This kit can restore any aluminum drain pan back to it's original size
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts 9.4mm length

Honda and Acura Drain Pan Repair
"Tin Pans Only"
Kit Part number 1485 Insert Part No.12151
This kit reduces the hole size from M14 x 1.5 to M12 x 1.5

M14x1.25 Drain Pan
Kit Part number 14125A Insert Part No.44127
Contains:Drill, Cbore,Tap, Driver, Tap guide,5 inserts 11mm length

M16x1.5 Drain Pan
Kit Part number 1615C Insert Part No.16153
Contains:Drill, Cbore,Tap, Driver, Tap guide,5 inserts 12.7mm length

M18x1.5 Drain Pan
Kit Part number 1815C Insert Part No.18151
Contains:Drill, Cbore,Tap, Driver, Tap guide,5 inserts 10mm length

M20x1.5 Drain Pan
Kit Part number 2015A Insert Part No.20151
Contains:Drill, Cbore,Tap, Driver, Tap guide,5 inserts 12mm length

M22x1.5 Drain Pan
Kit Part number 2215C Insert Part No.22151
Contains:Drill, Cbore,Tap, Driver, Tap guide,5 inserts 10mm length

M24x1.5 Drain Pan
Kit Part number 2415C Insert Part No.24150 VW touareg length
Contains:Drill, Cbore,Tap, Driver, Tap guide,5 inserts 7.6mm length

SPARK PLUG KITS

4412
Standard repair

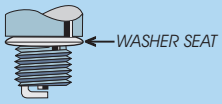
Spark plug kits do not contain inserts, order separately.

4412E
Deep hole repair

KIT CONTENTS
Step Tap
Wrench
Seat Cutter
Insert driver

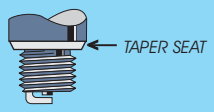
SPARK PLUG TYPES

WASHER SEAT



Washer seat spark plugs seal with a washer on plug.

TAPER SEAT



Sealer must be used when installing taper seat inserts.

KIT SIZE	PART NO.	WASHER SEAT INSERTS LENGTH MM	INCHES	PART NO.	TAPER SEAT INSERTS LENGTH MM	INCHES	PART NO.
M10 X 1.0 Standard Kit	4010	9.0	.360	40101			
M10 X 1.0 Deep Hole Kit	4010E	15.0	.600	40103			
M12 X 1.25	4212	9.0	.360	42121			
		15.0	.600	42123			
		17.5	.690	42125			
M14 X 1.25 Standard Kit	4412	7.0	.270	44121	7.0	.270	44181
		8.0	.320	44123	10.0	.400	44183
M14 X 1.25 Deep Hole Kit	4412E	9.4	.370	44125			
		11.0	.430	44127			
4412E kit has extended tools for better reach when repairing Sparkplugs in holes 6" deep or more.		13.5	.530	44113			
		15.0	.600	44129	15.7	.620	44185
		16.8	.660	44111	16.8	.660	44186
		23.0	.905	44112	24.0	.950	44187
M18 X 1.5	4815	10.0	.400	48151	10.0	.400	48181
		18.3	.720	48153			
7/8-18	4718	11.0	.430	47181			
		20.0	.780	47183			
		24.5	1.000	47185			

M14x1.25 Aluminum Inserts	WASHER SEAT MM	INCHES	PART NO.	TAPER SEAT MM	INCHES	PART NO.
Aluminum Inserts For kits 4412 & 4412E	7.0	.270	44121A	7.0	.270	44181A
	8.0	.320	44123A	10.0	.400	44183A
	9.4	.370	44125A	13.5	.530	44184A
	11.0	.430	44127A	15.7	.620	44185A
	13.5	.530	44113A	16.8	.660	44186A
	15.0	.600	44129A	24.0	.950	44187A
	16.8	.660	44111A			
	23.0	.905	44112A			

SPECIAL SEAT CUTTERS

For use on some taper seat spark plug repairs that have limited access to the spark plug hole.

M14 x 1.25 PART NO. 44196
M18 x 1.5 PART NO. 48196
M14 x 1.25 Extended PART NO. 44196E

SEAT CUTTER GUIDE

For use when the step tap cannot be threaded deep enough to allow use of the seat cutter.

M14 x 1.25 PART NO. 44195

SEALER

This sealer must be used when installing taper seat inserts. **PART NO. 6020**

INSERT DRIVER OIL

This oil is superior for installing inserts. **PART NO. 6010**

COPPER ANTI- SEIZE

Recommended for use on spark plug with aluminum insert.
PART NO. 37229

FORD TRITON

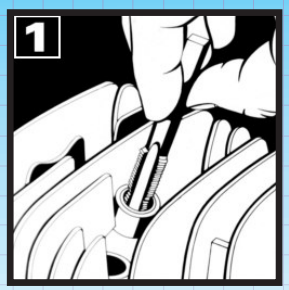
Note: FORD TRITON M14x1.25 repair use P/N **5553** kit comes with all tools and 5 inserts
Also used for 1.9 / 3.8 / 4.6 / 5.4 Liter engines
Triton 3 Valve M16x1.5 use part #3221

SPARK PLUG THREAD REPAIR

The following instructions for kit part numbers 4412 and 4412E.

KIT CONTENTS
Step Tap
Wrench
Seat Cutter
Insert driver

Spark plug kits do not contain inserts, order separately.



Start the step tap into the hole to be repaired keeping as straight as possible.

Use the wrench provided, place wrench over tap and tap new threads. Continue to tap through until the cutting edges are approximately ¼ inch below surface.
Leaving the tap 1/4 inch below the surface ensures that the seat cutter will not hit the back of the tap flutes.

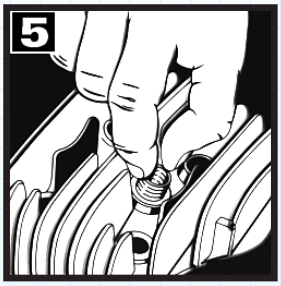
Leave the step tap in the hole. Place the seat cutter over the shank. The seat cutter does two operations. First the seat cutter will cut the countersink for the flange of the insert, then it cuts a new seat for the sparkplug washer.

This operation is the same for the taper seat inserts.

Using the wrench rotate the seat cutter. After a few turns lift the seat cutter to inspect the seat. Repeat operation until the seat is completely cleaned up. Remove the step tap from the hole.

Good Seat Complete

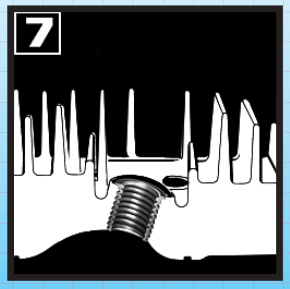
Bad Seat incomplete



Make sure the hole is clean and dry. Lubricate the driver tool with Time-Sert driver oil. Screw the insert onto the prepared hole.
If doing deep hole repairs: Lubricate the driver tool with Time-Sert driver oil or 30wt Oil. Screw the insert onto the driver then into the prepared hole.

Using the wrench provided rotate the driver into the insert. When the insert is seated the driver will tighten up. With increased pressure continue to rotate the driver through the insert until it loosens up. Then back the driver tool out of the insert.

Note: Taper seat inserts
These inserts are silver plated and require sealer p/n 6020 on the outside of the insert.



Repair is complete.
Solid steel threads are square to the reconditioned seat, insuring a good spark plug seal.

MANUFACTURER KITS

GENERAL MOTORS

NORTH STAR 4.0/4.6 HEAD BOLT
M11x1.5 HEAD BOLT
Kit Part No. J-42385-500 Insert Part No. 11155

NORTH STAR 4.0/4.6 Oversize
M11x1.5 HEAD BOLT BIG-SERT Second repair
Kit P/N. J-42385-500BS Insert P/N J-42385-507BS

L850 or "ECOTEC" 2.2 liter 4 cylinder
J-42385-500 kit with
J-42385-871 Bushing Insert P/N 11155

NORTH STAR MAINBEARING 4.0/4.6
M10x1.5 MAIN BEARING
Kit Part No. J-42385-300 Insert Part No. J-42385-514

NORTH STAR 2000 HEAD BOLT
M11x1.5 There are 2 depths of holes for this block
Kit Part No. J-42385-2000 Insert Part No. 11155

North Star 2004 HEAD BOLT
M11x2.0 PV8 LH2 4.6 liter LXR
Kit Part number J-42385-2030 Insert Part No. 112030

LL8 Straight 6 M11x2.0 Head Bolt
2002 -2004 GMC Envoy
2002-2004 Trail blazer
Kit Part No. 4001 Insert Part No. 112030

PV6 M11x1.5 Head bolt LX5 3.5L
1999-2002 Oldsmobile Intrigue
2001-2002 Oldsmobile Aurora
Kit Part No. 6001 Insert Part No. 11155

General Motors GEN3
M11x2.0 HEAD BOLT
1997-2004 C5 Corvette base model
1998-2002 Chevrolet Camaro Z28, SS
1998-2002 Pontiac Firebird Formula and Trans-Am
2004 Pontiac GTO
1999-2005 Holden Commodare as an option
1999-2005 Holden Statesman/Caprice
2001-2005 Holden Monaro
Kit Part number J-42385-100 Insert p/n 112030

M10x 2.0 Main Bearing kit 5.7 V8 LS
Kit Part number J-42385-120 Insert p/n 102022

M12x1.75 Drain plug
This kit will repair most GM aluminum drain pans
Repairs : 1999-2004 CK Engine ASM V8/ LR4/4.8V,LM7/ 5.3T,LQ4/6.0U / 2003-2005 ST1 Engine / ASM-4.3L V6/ LU3/4.3X
Kit contains:
Drill, Cbore,Tap, Driver, Tapguide, 5 inserts 12mm length
Kit Part number 1217C Insert p/n 12170

HONDA

HONDA D16 HEAD BOLT
M10x1.25 Headbolt
1996-2000 Civic 1988-1991 Civic/CRX 1992-1995 Civic/Del Sol
Kit Part No. 4160 Insert Part No. 10129

HONDA Odyssey HEAD BOLT
M12x1.5 Headbolt
For threads that start at approx. 51mm "Includes"
1999-2005 Odyssey 2003-2005 Pilot 1998-2005 Accord V6
1997-2003 3.0-3.2 CL 1999-2005 3.2TL 2001- 2005 MDX
2005 RL
Kit Part No. 7220 Insert Part No. 12159

Honda Civic Hybrid Head Bolt
M9x1.25 2003-2005
Kit Part No. 9210 Insert Part No. 19127

HONDA/ACURA HEAD BOLT
M11x1.5 for threads that start at approx. 57mm
Honda B16 2002-2005 CR-V 2003-2005 Accord L4
2003-2005 Element 1999-2005 Civic SI 2002-2005 RSX
1986-2001 Integra 1986-1995 Legend 1991-2005 NSX
1996-2004 RL
Kit Part No. 7111 Insert Part No. 11155

HONDA/ACURA HEAD BOLT Oversize
M11x1.5 BIG-SERT Second repair
Honda B16 2002-2005 CR-V 2003-2005 Accord L4
2003-2005 Element 1999-2005 Civic SI 2002-2005 RSX
1986-2001 Integra 1986-1995 Legend 1991-2005 NSX
1996-2004 RL
Kit Part No. 7111BS Insert Part No.J-42385-507BS

HONDA MOTORS Special Kit 1/8-28 BSBP
Kit Part No. 0128 Insert Part number 01281

Honda and Acura
M14x1.5 "TIN Pans Only"
This kit reduces the hole size from M14 x 1.5 to M12 x 1.5
Kit Part number 1485 Insert Part No.12151

Honda and Acura
M14x1.5 "Aluminum Pans"
This kit can restore any aluminum drain pan back to it's original size
Kit Part number 1415C Insert Part No.14153

Honda & Acura M10x1.25
Alternator bolt thread repair
M10x1.25 Alternator bolt
1999-2005 Odyssey 2003-2005 Pilot 1998-2005 Accord V6
1997-2003 3.0-3.2 CL 1999-2005 3.2TL 2001- 2005 MDX
2005 RL Kit Part number 1012C Insert Part No. 10125

MANUFACTURER KITS

FORD

FORD SPARKPLUG REPAIR
M14x1.25 Triton 2 and 4 valve
1.9/3.8/4.6/5.4 liter engines

Kit Part No. 5553
Insert Part No 51459

FORD SPARKPLUG REPAIR
M16x1.5 3 Valve Heads

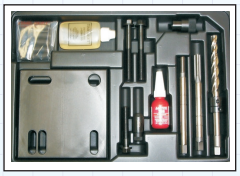
Kit Part No. 3221
Insert Part No 32214

FORD HEAD BOLT 4.6/5.4
M11x1.5 HEAD BOLT

Kit Part No. 6111
Insert Part No. 11155

TOYOTA

Universal M11x1.5 head bolt kit



Kit Part No. 11110
Insert Part No 11155

We do not have a specific kit for Toyota head bolt.
We commonly sell the Universal M11x1.5 for the Camry and Rav4 models which use the M11x1.5 head bolt.

Harley Davidson

3/8-16 x 1.000 used in
Harley Davidson Head Bolt
Where depth of hole is 1.250 deep.

Kit Part No. 0381D
Insert Part No 03810

VOLKSWAGEN

VOLKSWAGEN Touareg
Drain Pan kit M24x1.5

Kit Part No. 2415C
Insert Part No. 24150

V.W &PORSCHE CASE
KIT FOR M10 x 1.5 CASE STUDS
Kit Part No. 1085 Insert Part No. 10155

M14x1.5 Drain Pan Repair
Contains:Drill, Cbore,Tap, Driver, Tapguide and 5 inserts of a 12.7mm length
Kit Part number 1415A Insert Part No.14155

Optional Tap Guide Plate
VW and Porsche 911 style.
This plate is placed on top of the cylinder to ensure a straight tapped hole.

Plate Part No. 31084

VW SOLEX Carburetor
M8x1.0 Kit P/N 1881

VW SOLEX Carburetor
M11x1.0 Kit P/N 1181

BMW

M10x1.5 24.5mm
Head bolt application

Kit Part No. 1087
Insert Part No 10155

This tooling will install a M10x1.5x24.5mm length insert in a 6mm deep countersink.

SPECIAL APPLICATIONS

DIESEL INJECTOR
M24 x 2.0 THREAD REPAIR KIT

Kit Part No. 2420
Insert Part No. 24201

BENDIX AIRCRAFT WHEEL
1/4-28 THREAD REPAIR KIT

Kit Part No. 01488
Insert Part No. 014888

BENDIX AIRCRAFT WHEEL
1/4-28 OVERSIZED THREAD REPAIR KIT

Kit Part No. 01489
Insert Part No. 014899

10x1.5 30mm Flush Surface kit

Kit Part No. 1015D30
Insert Part No. 10159

M6x1.0 Extended kit

This tooling has no counterbore. The hole must be at least 8mm or .315 inches for the tap to access the hole

Kit Includes
6" extension drill, 4" tap, 4" driver, 5 inserts of a 17mm length.
Kit Part number 1610E2

M8x1.25 CORE KIT

The core drill included will allow a special 11.7mm length no flange insert to be installed deeper than a standard kit.

Kit Includes
Core drill, , tap, driver, tap guide, 5 inserts of the 11.7mm no flange
Kit Part number 1812CORE

M8x1.25 CORE KIT Extended

The core drill included will allow a 16.2mm length insert to be installed deeper than the standard kit.

Kit Includes
Core drill, tap, driver, 5 inserts of the no flange 16.2mm length.
Kit Part number 1812ECORE

UNIVERSAL HEAD BOLT KITS

Universal head bolt kits can be used in any application of bolt size listed below.
A simple tool setup is all that is required.

Universal M10x1.5 head bolt
Kit Part No.7580 Insert Part No. 10155
Includes 10 inserts of a M10x1.5x24.5mm length

Universal M10x1.25 head bolt
Kit Part No.6250 Insert Part No. 10129
Includes 10 inserts of a M10x1.25x25mm length

Universal M11x1.5 head bolt
Kit Part No.11110 Insert Part No. 11155
Includes 10 inserts of a M11x1.5x30mm length

Universal M11x1.25 head bolt
Kit Part No.11125 Insert Part No. 11121
Includes 10 inserts of a M11x1.25x28mm length

Universal M12x1.5 head bolt
Kit Part No.4800 Insert Part No. 12159
Includes 10 inserts of a M12x1.5x30mm length

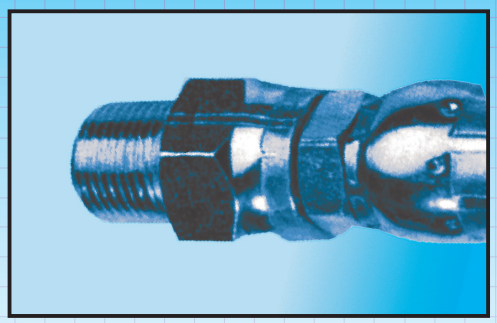
Universal M12x1.25 head bolt
Kit Part No.4700 Insert Part No. 12127
Includes 10 inserts of a M12x1.25x30mm length

Universal M12x1.75 head bolt
Kit Part No.4900 Insert Part No. 12179
Includes 10 inserts of a M12x1.75x30mm length

Universal head bolt kits also available in oversize “BIG-SERT” versions.

TAPER PIPE THREAD KITS

National Pipe Taper Thread (NPT)



CARBON STEEL

KIT SIZE	PART NO.	INSERT PART NO.
1/8-27	0127	01271
1/8-28 BSBP Honda Motors	0128	01281
1/4-18	0118	01181
3/8-18	0318	03181
1/2-14	0214	02141
3/4-14	0414	04141

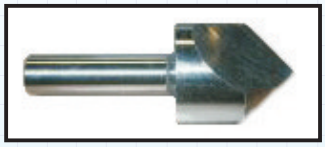
STAINLESS STEEL

KIT SIZE	PART NO.	INSERT PART NO.
1/8-27	0127S	01272
1/4-18	0118S	01182
3/8-18	0318S	03182
1/2-14	0214S	02142

NOTE: The 1/2-14 and 3/4-14 pipe kits do not have a counterbore

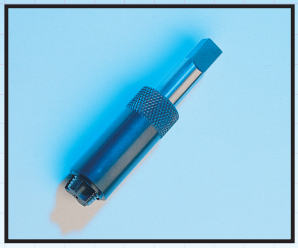
These kits **do not** include counterbore's.
Yes, the insert will stick up slightly without a counterbore but being a pipe application there should be no problem as the pipe fitting will not contact the flange of the insert. This is noted in the instructions and you may optionally use a standard 90 degree countersink to get the flange flush if so desired.

Time-Sert does sell these tools separately if needed.
90 degree CounterSink for the 1/2-14 taper pipe kit p/n 22145.
Description: 90 degree countersink 1" diameter
90 degree CounterSink for the 3/4-14 taper pipe kit p/n 24145.
Description: 90 degree countersink 1 1/2 " diameter



USEFUL TOOLS

TAP GUIDES



Tap guides insure that the threads are square to the surface of the hole.

The lower portion of the tap guide should remain as square as possible to the engine surface. Turn the tap slowly while making sure the guide remains flush.

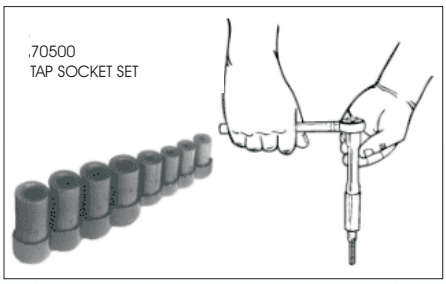
AMERICAN TAP GUIDES

SIZE	PART NO.
1/4-20	31420
1/4-28	31420
5/16-18	35168
5/16-24	35168
3/8-16	33816
3/8-24	33824
7/16-14	37164
7/16-20	37162
1/2-13	31213
1/2-20	31225
3/4-10	33415
3/4-16	33416

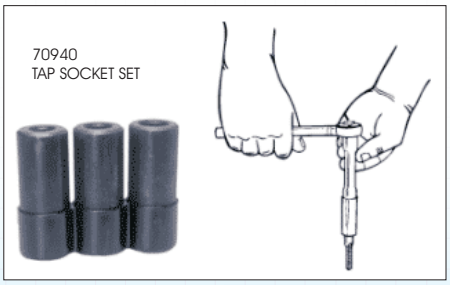
METRIC TAP GUIDES

SIZE	PART NO.
M6 x 1.0	36105
M8 x 1.25	38125
M10 x 1.0	30105
M10 x 1.5	30155
M10 X 1.25	30125
M12 X 1.5	32155
M12 X 1.25	32125
M12 X 1.75	32175
M14 X 1.5	34155
M16 X 1.5	36155
M18 X 1.5	38155
M20 x 1.5	30215
M22 x 1.5	32255
M24 x 1.5	32455

TAP SOCKET SETS

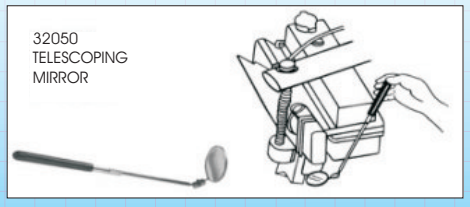


For Use in Restricted Areas
Ideal for use in areas where a T handle won't fit. Set of 8 sockets fits all number and fractional M.C.T.I. standard taps thru 1/2". A lso fits 1/8" NPT taps and metric tapsthru 12mm manufactured to M.C.T.I. Standards. Sockets contained on a vinyl holder. Time-Sert taps 4mm to 12mm metric / 4-40 to 1/2 inch Sockets #1 thru #4 use 1/4 drive, rest use 3/8 drive.



Three Larger Sizes in a Convenient Set
The three largest tap sockets, are now packaged in a three piece set. Ideal for use where a T handle won't fit, especially in restricted areas. For larger, fractional M.C.T.I. standard taps. #9 socket is 5/8" (16mm), #10 is for 11/16" (18mm) and #11 is for 3/4". Sockets contained in a vinyl holder. Time-Sert taps 13mm to 16mm metric 5/8 to 3/4 inch. use 1/2 drive socket.

Lightweight, Compact, LED Light. Depress the pocket clip to illuminate. The bright LED bulb lasts up to 100,000 hours. Comes equipped with 2 common replaceable 3 volt batteries, CR2016. Overall length 4 ½".



2 1/4" diameter mirror swivels to any position. Length extends from 10" to 14".

USEFUL TOOLS

TAP WRENCHES

STRAIGHT TAP WRENCH

Straight Tap Wrench, Length 5 Inches, Hand Taps
Capacity 1/16 to 1/4 Inch, Taps M1.5 to M6
wrench number 00 **P/N C67201**

Straight Tap Wrench, Length 11 Inches, Hand Taps
Capacity 5/32 to 1/2 Inch, Taps M4 to M12
Time-Sert taps 4-40 - 7/16 Inch, M3 - M11 Metric
wrench number 5 **P/N C67202**

Straight Tap Wrench, Length 15 Inches, Hand Taps
Capacity 5/32 to 3/4 Inch, Taps M4 to M19
Time-Sert taps 1/4 - 9/16 Inch, M5 - M14 Metric
wrench number 6 **P/N C67203**

Straight Tap Wrench, Length 19 Inches, Hand Taps
Capacity 1/4 to 1-1/8 Inch, Taps M12 to M28
wrench number 7 **P/N C67204**

Straight Tap Wrench, Length 40 Inches, Hand Taps
Capacity 3/4 to 1-5/8 Inch, Taps M19 to M40
wrench number 8 **P/N C67205**

T-HANDLE WRENCH

T- handle wrench, Length 2-3/4
Hand Taps Capacity 1/16” to 1/4”
Inch Taps M1.5 to M6 .
Time-Sert taps M3 - M5
wrench number T11 **P/N C67208**

T-HANDLE WRENCH
T- handle wrench, Length 3-5/8
Hand Taps Capacity 7/32” to 1/2”
Inch Taps M5 to M12
Time-Sert taps M5 - M11
wrench number T12 **P/N C67209**

SCREW EXTRACTORS

Removes broken bolts 5/8 to 7/8.
If removing a Time-Sert insert, this tool will remove inserts from 1/2 to 9/16 inch or 12mm to 14mm metric.

5 pc set 3/32 to 5/8
If removing a Time-Sert insert, this set will remove inserts from 4-40 to 7/16 or 4mm to 11mm metric.

Removes broken bolts 7/8 to 1-1/8.
If removing a Time-Sert insert, this tool will remove inserts from 5/8 to 3/4 inch or 16mm to 20mm metric.

Removes broken bolts 1-1/8 to 1-3/8.
If removing a Time-Sert insert, this tool will remove our 3/4 pipe insert.

TIME FASTENER
COMPANY INC.
5301 -G LONGLEY LANE
RENO NEVADA 89511
PHONE (775) 829-1026
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FAX (775) 829-1989
www.timesert.com

January 2009