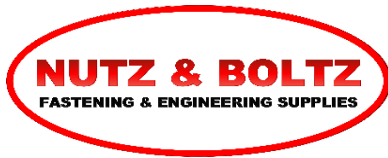
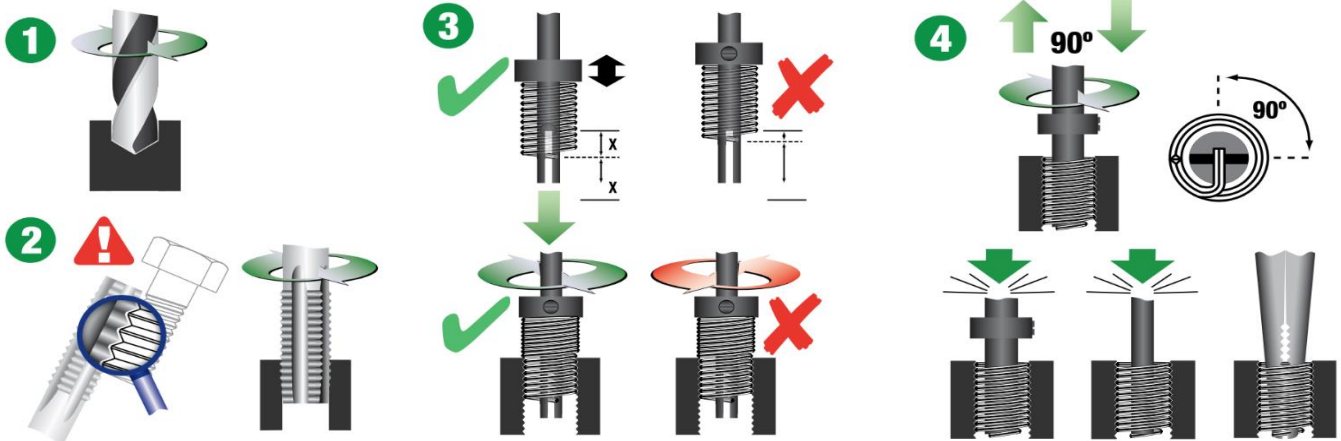


RECOILS



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MM	MM	INSTALLED LENGTH	
METRIC COARSE / METRIC FINE			
3.00	0.50	1.5D	4.50MM
4.00	0.70	1.5D	6.00MM
5.00	0.80	1.5D	7.50MM
6.00	1.00	1.5D	9.00MM
7.00	1.00	1.5D	10.50MM
8.00	1.25	1.5D	12.00MM
10.00	1.25	1.5D	15.00MM
10.00	1.50	1.5D	15.00MM
12.00	1.50	1.5D	18.00MM
12.00	1.75	1.5D	18.00MM
14.00	1.50	1.5D	21.00MM
14.00	2.00	1.5D	21.00MM
16.00	2.00	1.5D	24.00MM
MM	MM	INSTALLED LENGTH	
SPARK PLUG			
10.00	1.00		0.339"
			1/2"
12.00	1.25		1/2"
			3/4"
14.00	1.25		3/8"
			1/2"
			3/4"

1 Drill to clear the damaged thread with a standard twist drill. The required tapping drill size is shown on the front of each pack.
NOTE Spark Plug inserts utilise a pilot nose tap which does not require pre-drilling.

2 Use the specified tap to cut the holding thread into the cleared hole. When tapping a hole, it is recommended to use a suitable cutting lubricant.
NOTE Wire Thread inserts require the use of STI taps which are slightly oversize to provide the correct hole diameter. Always check that the thread and pitch of the tap are the same as the bolt or spark plug you wish to insert into the finished hole.

3 Loosen the grub screw and slide the collar along the insert tool shaft so that the tang on the insert is positioned half way up the insert tool slot.
NOTE Do not position tang at the very top or bottom of the insert tool slot.
 Use the installation tool to wind the insert into the threaded hole using light downward pressure until half a turn below the surface.
NOTE Do not work against the thread direction as the tang may break off.

4 Lift installation tool, rotate 90° and tap down sharply to break off wire thread insert tang. Use the tang break off tool to perform this function where supplied.
NOTE For spark plug and large inserts use long nose pliers to remove the tang.

You have successfully repaired your damaged thread. The new thread is normally stronger than the original.

INCH	TPI	INSTALLED LENGTH	
UNC			
No.6	32	1.5D	0.21"
No.8	32	1.5D	0.25"
No.10	24	1.5D	0.28"
1/4	20	1.5D	0.38"
5/16	18	1.5D	0.47"
3/8	16	1.5D	0.56"
7/16	14	1.5D	0.66"
1/2	13	1.5D	0.75"
9/16	12	1.5D	0.84"
5/8	11	1.5D	0.94"
3/4	10	1.5D	1.13"
UNF			
No.10	32	1.5D	0.28"
1/4	28	1.5D	0.38"
5/16	24	1.5D	0.47"
3/8	24	1.5D	0.56"
7/16	20	1.5D	0.66"
1/2	20	1.5D	0.75"
9/16	18	1.5D	0.84"
5/8	18	1.5D	0.94"
3/4	16	1.5D	1.13"