

TAPSERTS

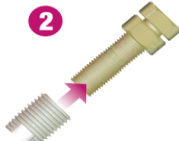
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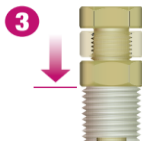
tapsert® INSTALLATION



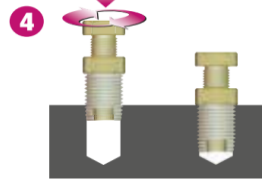
1 Drill hole to recommended size as shown in the selection table.



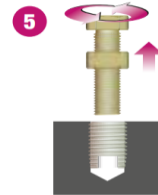
2 Thread the Tapsert on to the bolt ensuring the slot side is down. The insert should be flush with the end of the bolt.



3 Thread the nut down the bolt until it sits firmly against the top of the Tapsert.



4 To ensure the Tapsert installation is straight apply downward pressure on the assembly.
If using an open ended wrench apply downward pressure to the bolt head whilst turning the nut to wind the Tapsert in. Alternatively if using a socket for installation apply downward pressure to the socket.
The Tapsert is installed when the nut is flush with the top of the parent material.



5 Loosen the nut with an open ended wrench and wind the nut and bolt assembly out of the Tapsert.
Congratulations - you have successfully created a new thread.

NOTE Tapping fluid should be used to aid installation.

THREAD TYPE	INTERNAL	EXTERNAL (SELF-TAPPING)	TAPSERT LENGTH	Min Hole DRILL SIZE	Max Hole DRILL SIZE
METRIC	M2.5-0.45	M4.5-0.5	6mm	4mm	4.3mm
	M3-0.5	M5-0.5	6mm	4.5mm	4.8mm
	M4-0.7	M6.5-0.75	8mm	6mm	6.2mm
	M5-0.8	M8-1.0	10mm	7.5mm	7.6mm
	M6-1.0	M10-1.5	14mm	9mm	9.4mm
	M8-1.25	M12-1.5	15mm	11mm	11.4mm
	M10-1.5	M14-1.5	18mm	13mm	13.4mm
	M12-1.75	M16-1.5	22mm	15mm	15.4mm
	M14-2.0	M18-1.5	24mm	17mm	17.4mm
	M16-2.0	M20-1.5	22mm	19mm	19.4mm
	M18-2.5	M22-1.5	24mm	21mm	21.4mm
	M20-2.5	M26-1.5	27mm	25mm	25.4mm
	M22-2.5	M26-1.5	30mm	25mm	25.4mm
M24-3.0	M30-1.5	30mm	29mm	29.4mm	
SPARK PLUG	M14-1.25	M17.7-1.25	9mm	17mm	17.4mm
	M14-1.25	M17.7-1.25	15mm	17mm	17.4mm

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UNC	UNC 4-40	M5-0.5	6mm	4.5mm	4.8mm
	UNC 6-32	M6-0.75	8mm	5.5mm	5.7mm
	UNC 8-32	M6.5-0.75	8mm	6mm	6.2mm
	UNC 10-24 (3/16)	M8-1.0	10mm	7.5mm	7.6mm
	UNC 1/4-20	M10-1.5	14mm	9mm	9.4mm
	UNC 5/16-18	M12-1.5	15mm	11mm	11.4mm
	UNC 3/8-16	M14-1.5	18mm	13mm	13.4mm
	UNC 7/16-14	M16-1.5	22mm	15mm	15.4mm
	UNC 1/2-13	M18-1.5	22mm	17mm	17.4mm
	UNC 5/8-11	M20-1.5	22mm	19mm	19.4mm
	UNF	UNF 10-32 (3/16)	M8-1.0	10mm	7.5mm
UNF 1/4-28		M10-1.5	14mm	9mm	9.4mm
UNF 5/16-24		M12-1.5	15mm	11mm	11.4mm
UNF 3/8-24		M14-1.5	18mm	13mm	13.4mm
UNF 7/16-20		M16-1.5	22mm	15mm	15.4mm
UNF 1/2-20		M18-1.5	22mm	17mm	17.4mm
UNF 5/8-18		M20-1.5	22mm	19mm	19.4mm