



THREAD REPAIR KIT

Before you begin, be sure to wear OSHA approved safety glasses.

DRILL: Screw the included ProBushing into the hole in the ProPlate overtop of the damaged bolt hole. Drill to adequate depth using drill supplied.

TAP: Remove the ProPlate from the engine head. Using shop air, blow the hole clear of debris. Then, position the ProTap into the top of the machined hole. Turn the ProTap clock-wise one full rotation (you will feel resistance on the tap as you turn it – never force the tap). Reverse your ratchet and turn the tap counter-clockwise $\frac{1}{2}$ a rotation. Using shop air and eye protection, blow down each of the four tap flutes clearing debris. Repeat this process until the tap stops at the bottom of the hole.

INSTALL:

1. Screw the insert onto the male threads of the insert tool.
2. Apply thread locking fluid to the threads of the insert (optional, *PMXTLF014 Thread Locking Fluid*).
3. Position the insert and tool squarely over the tapped hole.
4. Rotate the insert tool, exerting slight pressure against the work until the insert is engaged in the tapped hole. Continue to rotate the tool until the insert is located $\frac{1}{4}$ to $\frac{1}{2}$ turn below the work surface. Remove the insert tool by rotating counter-clockwise.

DRILL



TAP



INSTALL



FINISH



Productive Solutions for Challenging Repairs

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