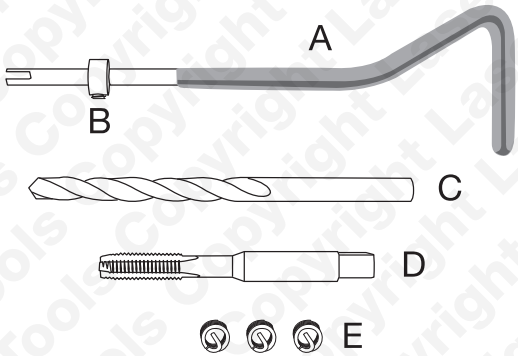
6007-6012

LASER®

Thread Repair Kits

A coil insert thread repair system that includes a drill bit, oversized tap, coil type insert and an insert driver tool.



A	Insert driver tool
B	Depth adjustment collar
C	High speed drill bit
D	Oversized tap
E	Thread coil inserts

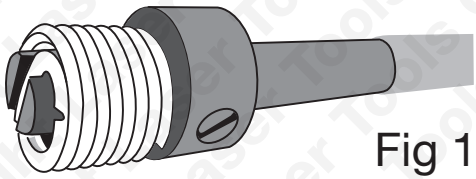


Fig 1

Instructions for use:

- Drill out remains of the damaged thread using the drill bit **(C)**.
- Fit the supplied tap **(D)** into a suitable tap holder (not supplied) and cut a new thread as deep as is required to ensure that the coil insert **(E)** does not protrude above the top surface of the component being repaired. Ensure a suitable cutting fluid is used and wind the tap back ½ a turn for every full turn clockwise to ensure the swarf is effectively cleared without damage to the newly cut thread.
- If working on a blind hole set the position of the depth adjustment collar **(B)** on the insertion driver tool **(A)** so that it engages the coil tang but will not bottom out before the insert is fully inserted (refer to Fig 1).
- Engage the tang on the thread insert with the slot on the insertion driver tool **(A)**.
- Wind the insert into the newly tapped hole to the required depth and remove the insertion tool.
- To break off the tang, use a suitable pin punch that is a sliding fit into the newly threaded hole and tap with a hammer to break the tang off. **Note:** when repairing threads that are open into an engine (for example a spark plug thread) use long nose pliers to break off the tang to avoid the tang entering the engine.

Please note: due to the nature of the tools in this kit the following components are considered consumable: C, D, E.