Operating Instructions for Threaded Inserts
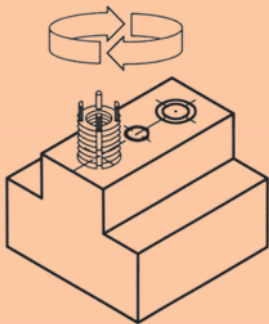
TOOLING COMPONENTS
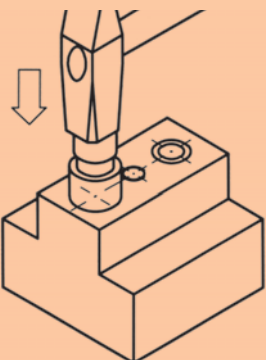
Installation Instructions
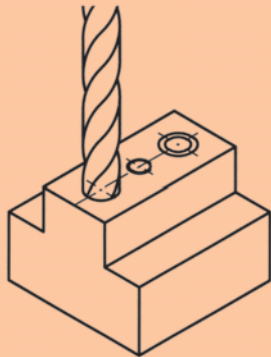
1.*
Rebore the old thread and countersink it (82°–100°)
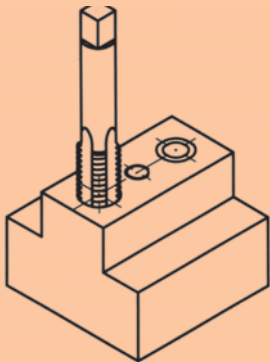
2.*
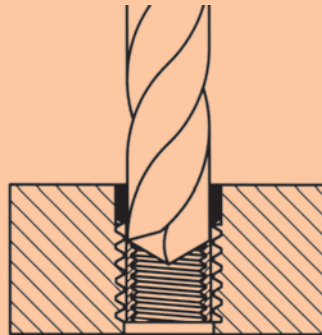Tap planned thread with a standard screw tap

3.
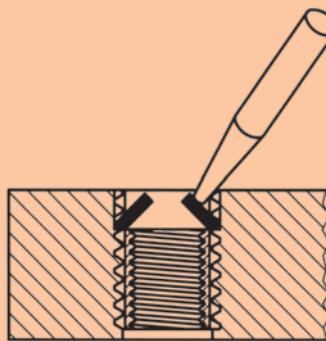Screw in the insert to just below the surface (0.3–0.7 mm)

4.
Drive in the locking pins by striking the assembly tool lightly with a hammer

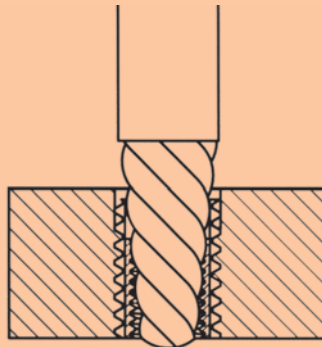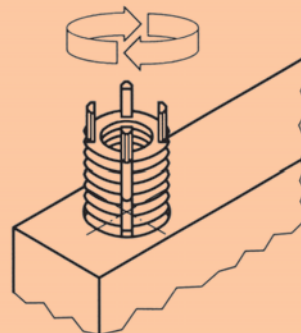* For steps 1 and 2 see table under installation of threaded inserts

Removal Instructions

1.*
Rebore the material between the locking pins and the internal thread to the specified depth

2.
Bend the locking pins inwards and break them off

3.
Remove the old insert with a screw extractor

4.
Install a new threaded insert in the original threaded hole

* For step 1 see table under removal of threaded inserts