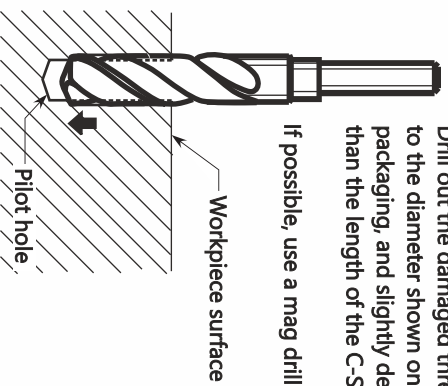


Instructions

Step 1

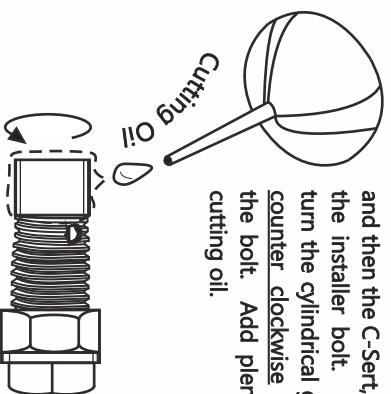
Drill out the damaged threads to the diameter shown on the packaging, and slightly deeper than the length of the C-Sert.

If possible, use a mag drill.



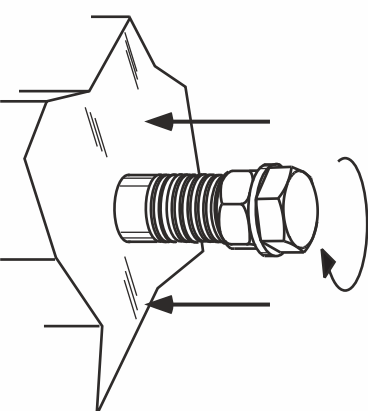
Step 2

Put the washer and nut, and then the C-Sert, onto the installer bolt. Next, turn the cylindrical guide counter clockwise onto the bolt. Add plenty of cutting oil.



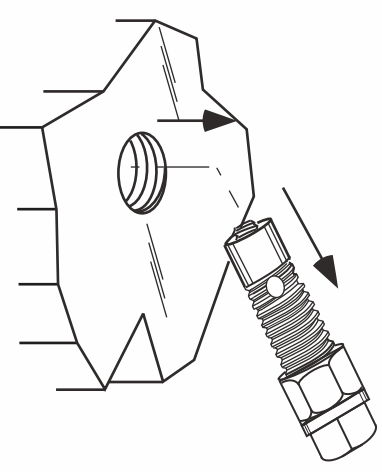
Step 3

Place the C-Sert assembly into the pilot hole, as deep as it will go. Turn the assembly clockwise just 2 or 3 full turns to form guide threads.



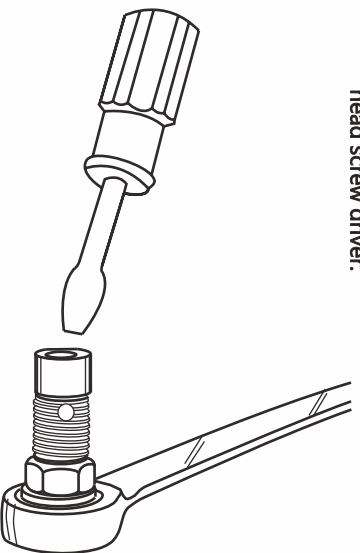
Step 4

Back the C-Sert assembly out of the pilot hole.



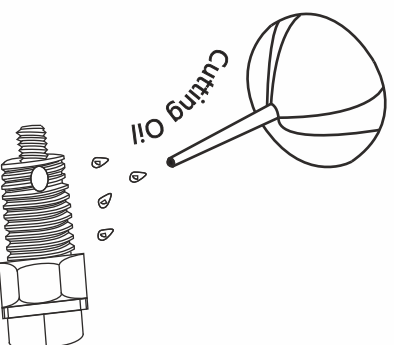
Step 5

Hold the bolt head with a wrench, and break the cylindrical guide free with a flat head screw driver.



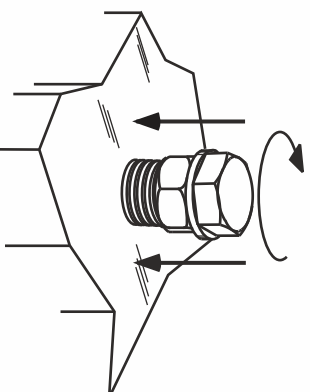
Step 6

Apply cutting oil to the C-Sert.



Step 7

Turn the C-Sert in manually so that it follows the pilot threads that you did in Step 3. Then turn the C-Sert in steadily until the installation nut shoulders up against the surface of the workpiece.



Step 8

When the nut has shouldered up against the surface of the workpiece, secure it well with a wrench, and then with a second wrench remove the installer bolt. Break up the chips inside the C-Sert and blow them out.

