



GENERAL THREAD REPAIR PROCEDURES

A heli-coil can be used to repair a stripped thread in a casting. The procedure is simple and the repair is permanent.

TOOLS REQUIRED:

Heli-Coil Insert Tool
Heli-Coil Tap
Tap Wrench
Drill Bit (for metal)
Electric Drill
Center Punch

For Heat Shield Spacers, Thermostat Handles, Secondary Air Tube Cover Machine Screws:

13/64" drill bit
#10-24 heli-coil tap
#10-24 heli-coil insert tool

For Interior Plates and Main Cast Panels

9/32" drill bit
1/4"-20 heli-coil tap
1/4"-20 heli-coil insert tool.

MATERIALS:

1 heli-coil insert per hole.

PROCEDURE:

1. Drill the hole larger using the appropriate size drill.
2. Tap the hole using the heli-coil tap and tap wrench.
3. Thread the heli-coil into the insert tool so that the tang (prong) on the heli-coil is facing outward.
4. Using the insert tool, thread the heli-coil into the hole.
5. Unwind the heli-coil insert tool from the hole.
6. Break off the tang of the heli-coil, using a center punch.
7. Thread the machine screw into the heli-coil.