

BIG-SERT®

OVERSIZED M10x1.5 HEAD BOLT 6mm DEPTH P/N 1087BS

- WARNING -

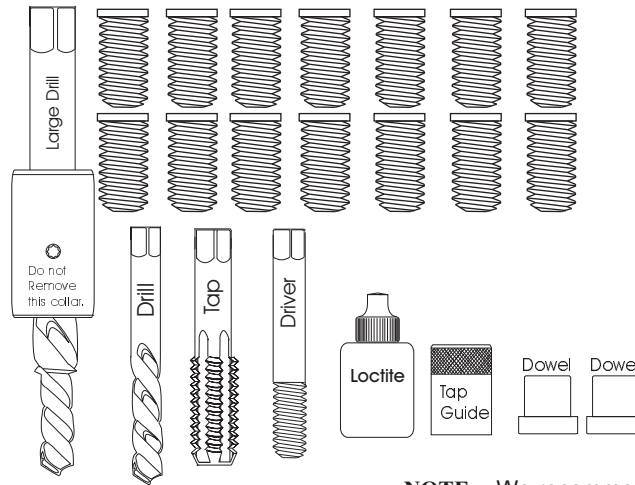
Cutting tools may shatter if broken.
The wearing of safety glasses is required in the vicinity of their use.

CUTTING FLUID

A Cutting fluid is necessary for drilling and tapping. (WD40)

DRILL MOTOR

The use of a half inch drill motor is recommended for drilling.



Tools:	Qty
Small Drill	1
Stop collar Drill	1
Tap	1
Driver	1
Tap guide	1
Alignment dowel	2
loctite	1
BIG-SERT Inserts	14
M10x1.5x24.5mm	

NOTE: We recommend using a long air nozzle to blow out all chips.

INSTRUCTIONS

STEP 1 SMALL DRILL (USE WD40 for Drilling)

USE A SUITABLE DRILL MOTOR, USE SMALL DRILL AND DRILL TO BOTTOM OF HOLE.

STEP 2 LARGE DRILL

USE LARGE DRILL WITH STOP COLLAR AND DRILL UNTIL STOP COLLAR TOUCHES BLOCK, CREATING COUNTERSINK FOR THE INSERTS.

STEP 3 TAP & GUIDE (USE WD40 for tapping)

USE A SUITABLE T-HANDLE WRENCH FOR TAPING HOLES. PLACE THE TAP GUIDE PROVIDED OVER THE HOLE TO BE REPAIRED. PLACE THE TAP IN THE GUIDE AND WATCH THAT THE GUIDE REMAINS FLUSH TO THE SURFACE. WHEN THE TAP HAS STARTED INTO THE HOLE YOU MAY REMOVE THE GUIDE AND CONTINUE TAPPING TO BOTTOM OF HOLE.

THIS WILL REQUIRE REMOVING THE TAP SEVERAL TIMES TO CLEAR CHIPS.

USE BRAKE OR CONTACT CLEANER THAT WILL NOT LEAVE AN OILY RESIDUE.

THE HOLE MUST BE CLEAN AND DRY. USE A FLASHLIGHT TO INSPECT THE HOLE FOR CHIPS AND CLEANLINESS.

STEP 4 DRIVER

USE INSERT DRIVER OIL or 30wt Motor oil (DO NOT USE WD40.)

USE A SUITABLE T-HANDLE WRENCH AND **OIL THE THREADS OF THE DRIVER TOOL**. SCREW AN INSERT ONTO THE DRIVER THEN PLACE A SMALL AMOUNT OF LOCTITE ON THE BOTTOM EXTERNAL THREADS OF THE INSERT. SCREW THE INSERT INTO THE PREPARED HOLE. WHEN THE FLANGE OF THE INSERT IS SEATED THE DRIVER WILL TIGHTEN UP, USE A LITTLE MORE POWER TO SCREW THE DRIVER THROUGH THE INSERT UNTIL IT LOOSENS UP. THE DRIVER TOOL WILL COLD FORM THE LAST FEW THREADS OF THE INSERT LOCKING IT IN PLACE. USE NEW ALIGNMENT DOWEL IN CORNER HOLES. **NOTE:** Be careful not to bottom the driver tool out in the hole!

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