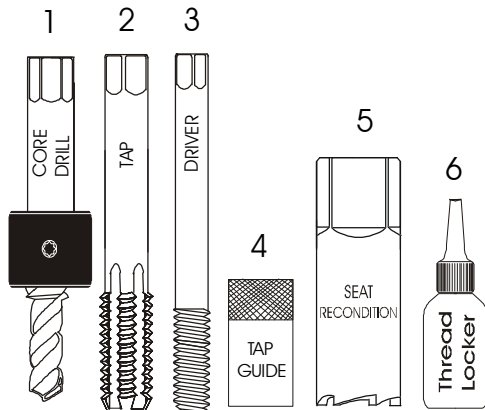


TIME-SERT®

P/n 1415A-PRO
M14x1.5 OIL PAN
THREAD REPAIR KIT



KIT CONTENTS

1. CORE DRILL
2. TAP
3. INSTALL DRIVER
4. TAP GUIDE
5. RECONDITIONER
6. THREAD LOCKER
7. 10 INSERTS
M14x1.5x12.7mm

Use Multi purpose grease when drill & tapping to help catch chips.

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

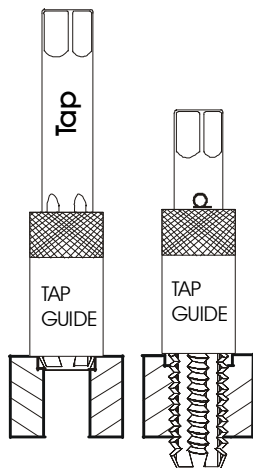
Tools required: (3/8 ratchet) (13mm socket) 7/16 (12-point socket) 3/8 (12-point socket)



Note: Use multi purpose grease when drilling.

1. Using a (13mm socket) Drill out old threads keeping core drill square to surface of hole. Continue drill until the stop collar touches the pan.

When stop collar touches the pan the counterbore is at the correct depth.

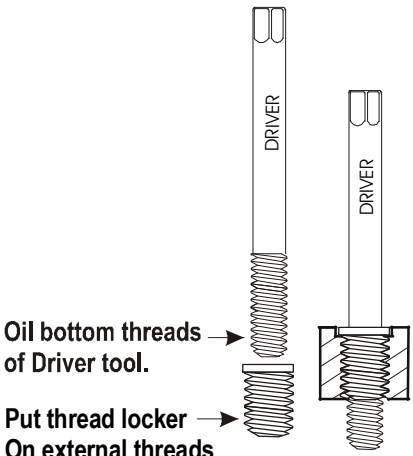
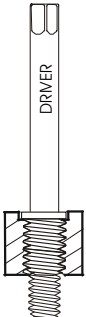
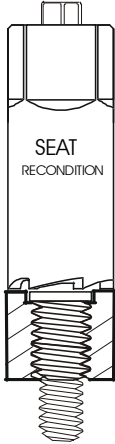



Note: Use multi purpose grease when tapping.

3. Using a 7/16 (12-point socket) TAP new threads to the full depth of hole using the TAP GUIDE included to ensure the threads are square to surface.

Note: Hold TAP GUIDE firmly. After 1 turn Inspect the TAP GUIDE to see it is still flush to the surface then continue to tap thru the hole.

Turn page over to Continue.

 <p>Oil bottom threads of Driver tool.</p> <p>Put thread locker On external threads of insert.</p>	<p>5. Using a few drops of 30wt motor oil. Oil the threads of the DRIVER TOOL</p> <p>Screw an insert onto the Driver.</p> <p>Put thread locker on external threads of insert.</p> <p>Screw insert into the prepared hole. Using a 3/8 (12-point socket) continue to rotate the driver thru the insert, the driver will start to tighten up as it expands the bottom few threads of the insert. Continue until the driver loosens up.</p> <p><u>Leave driver tool inside insert for next step.</u></p>
 <p>The last thread of driver is 1/8 or 3mm below surface</p>	<p>Leaving the driver 1/8 inch or 3mm below the surface ensures that the seat cutter will not hit the back of the driver threads.</p>
	<p>Note: Use 30wt motor oil or grease when cutting new seat.</p> <p><u>ONLY CLEAN THE SEAT DO NOT USE EXCESSIVE PRESSURE.</u></p> <p>When completed we always want the insert slightly BELOW the surface.</p> <p>6. Seat recondition.</p> <p>Using a 23mm socket rotate the seat cutter FULL 360 degrees rotations. After a few turns lift the seat cutter to inspect the seat. Repeat this operation until the seat is cleaned up.</p>
	<p>Remove tools repair complete.</p>