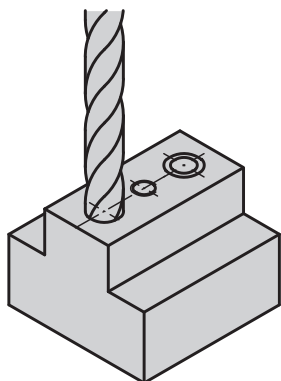
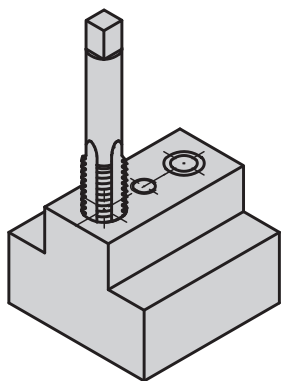


# Installing and removing threaded inserts

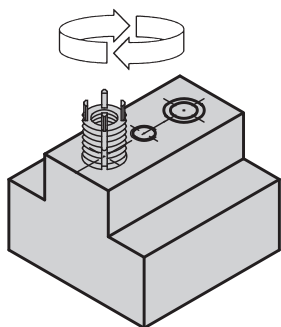
## Fitting instructions



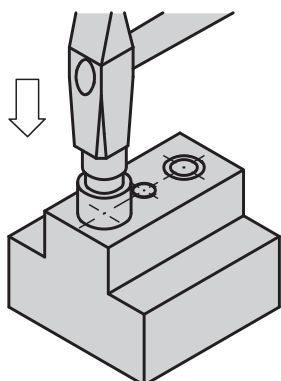
1.\*  
Rebore the old thread and countersink it ( $82^\circ - 100^\circ$ ).



2.\*  
Tap thread with a standard screw tap.



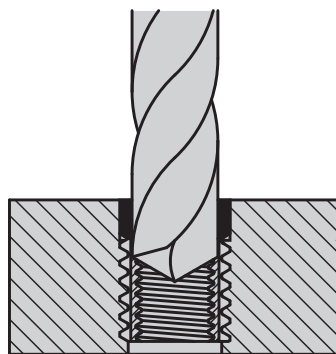
3.  
Screw in the insert to just below the surface (0.3 – 0.7 mm).



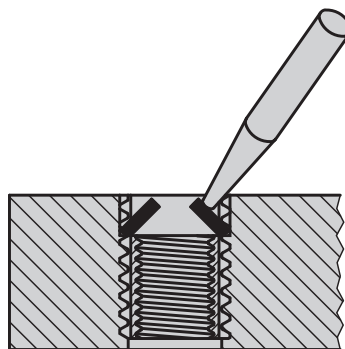
4.  
Drive in the locking pins by striking the assembly tool lightly with a hammer.

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

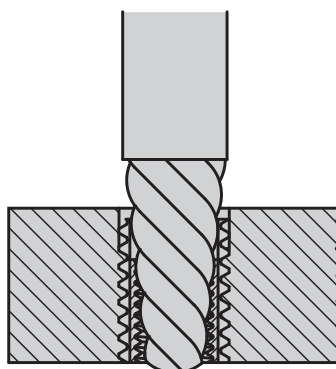
## Removal instructions



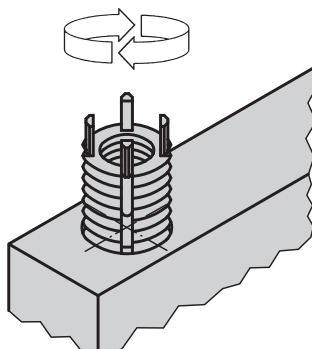
1.\*  
Rebore the material between the locking pins and the internal thread to the specified depth.



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 tables under "removal drilling depth"