



Introduction:

Jefferson Thread Repair kit creates a stronger internal thread in soft metals. Ideal for repairing damaged or stripped internal threads. Protects tapped threads against wear and damage. Set includes Drill bit, Thread tap, Insert installation and Lug breaking tool. Supplied with three different lengths of thread insert.

Specification:

Model No:	Replacement Inserts	Thread Lengths	Thread Size
JEFTRKM05-08	M5	3.5, 5, 7mm (5 of each)	M5 x 0.8mm
JEFTRKM06-10	M6	4, 6, 9 (5 of each)	M6 x 1mm
JEFTRKM08-125	M8	6, 9, 12mm (5 of each)	M8 x 1.25mm
JEFTRKM10-150	M10	7.5, 15mm (3 of each), 11mm (x4)	M10 x 1.5mm
JEFTRKM12-175	M12	9, 18mm (2 of each), 14mm (x4)	M12 x 1.75mm
JEFTRKM14-125	M14	10, 21mm (1 of each), 16mm (x3)	M14 x 1.25mm

Instructions:

1. Drill out the damaged thread using the correctly sized twist drill bit provided.
2. Tap drilled hole using screw tap provided.
3. Load thread insert into installation tool.
4. Screw insert into threaded hole.
5. Remove the tag from the insert using the breaking pin tool.
6. Thread is repaired and ready to use.

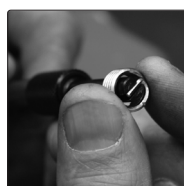
WARNING!
Wear safety eye protection when using this set.



STEP 1



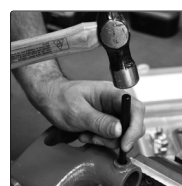
STEP 2



STEP 3



STEP 4



STEP 5



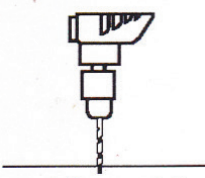

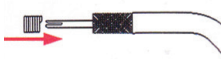

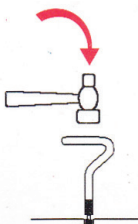
STEP 6

WARNING!

Ensure Health & Safety, local authority, and general workshop practice regulations are adhered to when using this equipment.

- Do not hold the workpiece by hand. Use clamps or a vice to secure the workpiece.
- Do not use the tool for any purpose other than that for which it is designed.
- Replace or repair damaged parts. Use genuine parts only. Unauthorised parts may be dangerous and will invalidate the warranty.
- Remove ill fitting clothing and wear appropriate protective clothing. Remove ties, loose jewellery, and contain and/or tie back long hair.
- Keep work area clean and uncluttered and ensure that there is adequate lighting.
- Maintain correct balance and footing. Ensure the floor is not slippery and wear non-slip shoes.
- DO NOT use tool when tired or under the influence of alcohol, drugs or intoxicating medication.
- Keep children and unauthorised persons away from the working area.
- Keep cutting tools lubricated at all times to ensure extended tool life, and also cleaner, more accurately formed threads.
- When not in use, return all parts to the case, and store in a safe, dry, childproof location.



	<p>1. Drilling. Drill out the damaged thread using the drill bit provided. Drill a sufficient depth to Accommodate the insert lenght and bolt or screw being used.</p>
	<p>2. Coil Threading-Tap. Using the coil tap provided, check the size on your shank to make sure you have the correct one. Tap the hole to a sufficient depth to accommodate the insert length and bolt or screw being used.</p>
	<p>3. Assembling Tool Choose the coil-installation shank size that you're going to use and are suitable for coil, insert the coil-installation shank into the ratchet screwdriver at first. Pick one coil and install it into the coil-installation shank; please notice if you put the tang of coil into the "U" shape of the coil-installation shank.</p>
	<p>4. Install the coil. Wind the coil insert into the hole until the depth-stop to get stuck.</p>
	<p>5 The driving tang of coil insert should be punched to eliminate their interference with the end of the assembled bolt. Their removal provides grater latitude in the depth location of the bolt.</p>