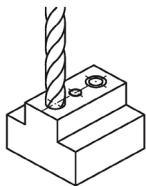
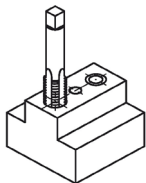


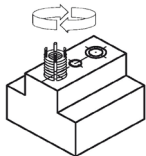
### Assembly



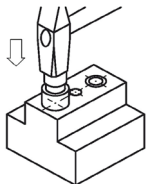
- 1.\***  
Drill the pilot hole or rebores the old thread with a starting taper (82°-100°)



- 2.\***  
Tap the required thread using a standard tap.



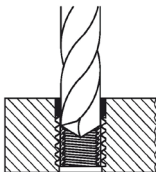
- 3.**  
Screw in the thread inserts. These should finish below the top surface of the material (0.3 to 0.7mm).



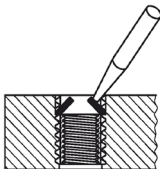
- 4.**  
Insert the keys using the supplied tool, tapping gently with a hammer.

*Steps 1+2. Refer to the parts table for the dimensions.*

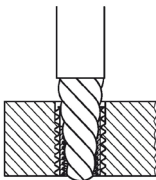
### Disassembly



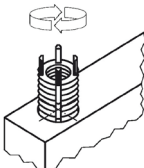
- 1.\***  
Rebores the remaining material between the keys and threads to the depth indicated



- 2.**  
Bend the keys towards the centre until they break



- 3.**  
Remove the thread inserts using the extraction tool



- 4.**  
Mount the new thread inserts in the original threads

*\* Steps 1. Refer to the parts table for the dimensions*