

# TIME-SERT®

## DRAIN PLUG REPAIR

### -WARNING-

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

Kit contains:  
Drill  
Counterbore  
Tap  
Tap guide  
Driver  
5 steel inserts



## INSTRUCTIONS



Use of a cutting fluid is recommended for drilling counterboring and tapping.

### STEP 1

Drill out old threads keeping drill square to the surface of the hole.



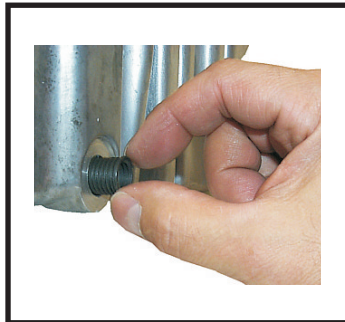
### STEP 2

Counterbore the hole to full depth permitted by the tool.



### STEP 3

Place the tap guide against the drain pan. Start the tap into the guide, turn the tap slowly while making sure the guide remains flat to surface.



### STEP 4

Blow chips out of the hole. Screw an insert a few turns into the tapped hole.

USE OIL ON THIS TOOL



### STEP 5

**OIL THREADS OF DRIVER**  
Screw the driver tool into the insert. When the flange of the insert is seated the driver will tighten up. Using a little more power continue to rotate the driver until it loosens up.



### COMPLETED REPAIR

The bottom few threads have been expanded locking the insert in place. You now have solid steel threads.