

TIME-SERT®

SCREW THREAD INSERTS



THIN WALL
SELF LOCKING
SOLID BUSHING
POSITIVE PLACEMENT

TIME-SERT®

PROFESSIONAL THREAD REPAIR SYSTEM SCREW THREAD INSERTS AMERICAN & METRIC SIZES

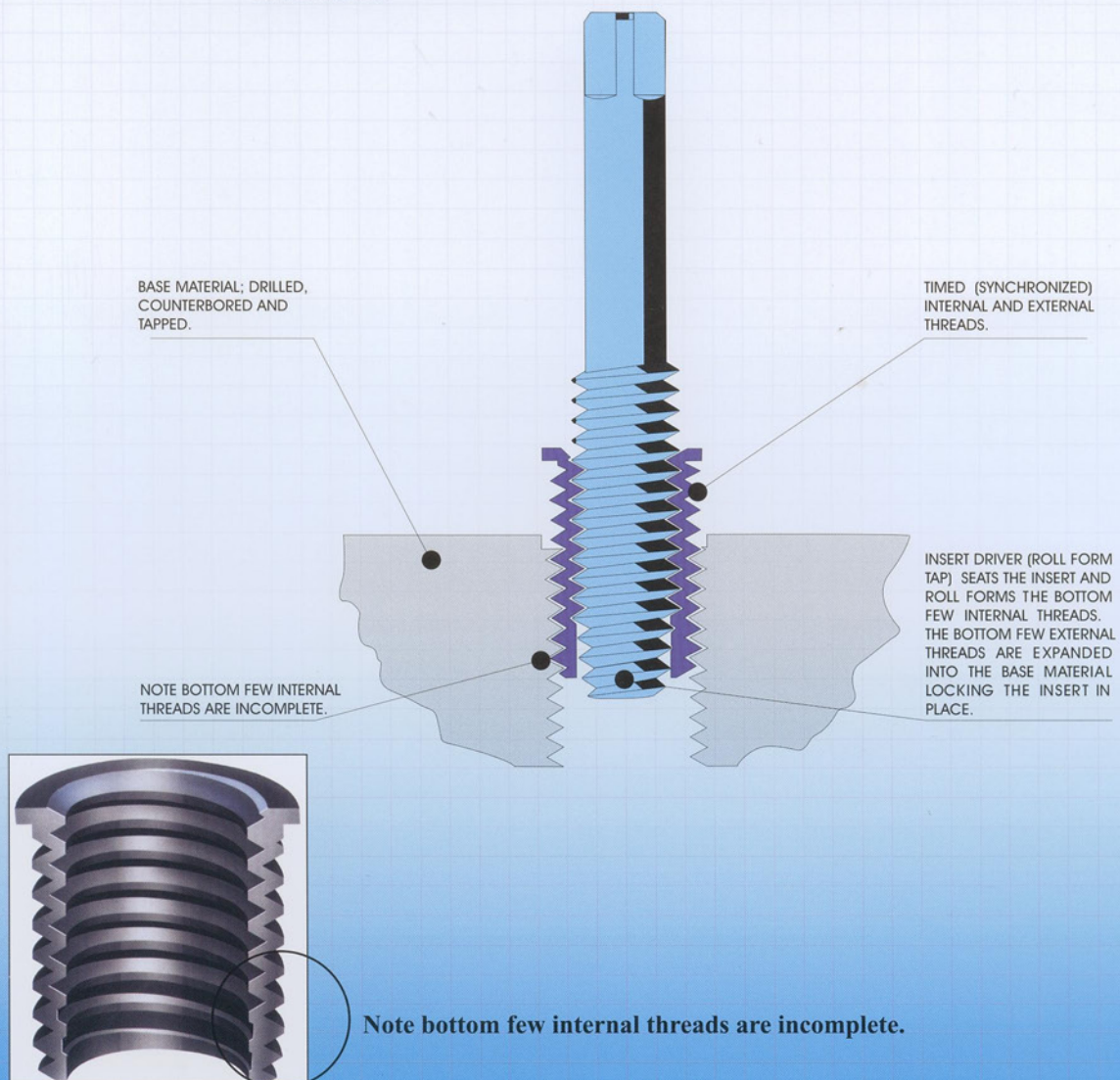
ADVANTAGES WHICH ARE CONVINCING:

TIME-SERT® is a solid bushing insert. This guarantees easy installation and allows for full load use of tapped hole, ensuring protection against stress and vibration.

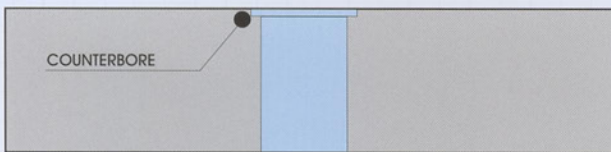
TIME-SERT® is thin walled due to synchronized internal external threads. Thin cross sectional area allows for installation in areas of limited space and clearance material.

TIME-SERT® has **positive placement**. Having a flange on the top of the insert will insure that the insert will have positive placement and cannot wind down into the newly repaired hole.

TIME-SERT® is self locking. On installation the bottom internal threads of the insert are cold rolled to expand the mating external threads into the base material locking the insert in place. Locking mechanism is at the bottom of the insert.



ENGINEERING DATA



Counterbores are flat bottom. We recommend step drills for production applications.

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

Oil must be used on the insert driver.

Tool kits are designed for a suitable tap wrench, or power tools such as: drill press, electric or air hand drills and tappers.

Carbon steel inserts are phosphate coated. Stainless steel inserts are 303 or equivalent.

TAPER PIPE

INSERT	DRILL		C.BORE		TAP
SIZE	DRILL	SIZE	MIN. DIA.	MIN. DEPTH	MAJOR DIA.
1/8-27	13/32	.406	.466	.055	.449
1/4-18	37/64	.578	.668	.075	.638
3/8-18	23/32	.718	.837	.075	.794
1/2-14	55/64	.859	1.000	90° CSK	.942
3/4-14	1 3/32	1.093	1.300	90° CSK	1.194

INCH

INSERT	DRILL		C.BORE		TAP
SIZE	DRILL	SIZE	MIN. DIA.	MIN. DEPTH	MAJOR DIA.
4 - 40	#31	.120	.170	.055	.147
6 - 32	#26	.147	.218	.070	.182
8 - 32	#17	.173	.241	.065	.208
10 - 24	13/64	.203	.288	.075	.247
10 - 32	13/64	.203	.274	.075	.234
12 - 24	#1	.228	.307	.075	.265
1/4 - 20	17/64	.265	.352	.075	.319
1/4 - 28	G	.261	.340	.075	.300
1/4 - 32	G	.261	.340	.075	.287
5/16 - 18	21/64	.328	.430	.085	.388
5/16 - 24	P	.323	.410	.080	.368
3/8 - 16	X	.397	.495	.085	.460
3/8 - 24	W	.386	.473	.080	.432
7/16 - 14	29/64	.453	.571	.110	.534
7/16 - 20	29/64	.453	.547	.085	.506
1/2 - 13	33/64	.515	.648	.110	.604
1/2 - 20	33/64	.515	.610	.085	.569
9/16 - 12	19/32	.593	.711	.130	.675
9/16 - 18	37/64	.578	.668	.110	.638
5/8 - 11	21/32	.656	.787	.135	.748
5/8 - 18	41/64	.640	.740	.110	.701
3/4 - 10	25/32	.781	.935	.135	.885
3/4 - 16	49/64	.765	.870	.110	.835

METRIC

INSERT	DRILL		C.BORE		TAP
SIZE	DRILL	SIZE	MIN. DIA.	MIN. DEPTH	MAJOR DIA.
M3 x 0.5	1/8	.125	.170	.055	.140
M4 x 0.7	# 19	.166	.226	.065	.194
M5 x 0.8	# 8	.199	.279	.075	.238
M6 x 1.0	D	.246	.319	.075	.290
M7 x 1.0	L	.290	.351	.075	.330
M8 x 1.0	P	.323	.409	.080	.369
M8 x 1.25	P	.323	.419	.080	.381
M9 x 1.25	U	.368	.440	.080	.422
M10 x 1.0	13/32	.406	.466	.080	.440
M10 x 1.25	13/32	.406	.500	.085	.463
M10 x 1.5	13/32	.406	.500	.085	.474
M11 x 1.25	29/64	.453	.542	.085	.503
M11 x 1.5	29/64	.453	.552	.085	.516
M12 x 1.25	31/64	.484	.560	.085	.540
M12 x 1.5	31/64	.484	.595	.085	.552
M12 x 1.75	1/2	.500	.605	.110	.567
M13 x 1.5	17/32	.531	.612	.085	.594
M14 x 2.0	37/64	.578	.685	.110	.660
M14 x 1.5	37/64	.578	.668	.110	.634
M16 x 1.5	21/32	.656	.743	.110	.713
M16 x 2.0	21/32	.656	.787	.115	.741
M18 x 1.5	23/32	.718	.837	.125	.794
M20 x 1.5	51/64	.797	.925	.120	.890
M22 x 1.5	7/8	.875	.950	.100	.940
M24 x 1.5	24.5	.963	1.030	.750	1.010

MASTER SETS

EACH SET CONTAINS 5 COMPLETE
TOOL KITS AND 20 INSERTS OF
EACH SIZE (TOTAL 100 INSERTS)

MINI MASTER

EACH SET CONTAINS 3 COMPLETE
TOOL KITS AND 20 INSERTS OF
EACH SIZE (TOTAL 60 INSERTS)

INCH

METRIC

COARSE	FINE
1/4-20	1/4-28
5/16-18	5/16-24
3/8-16	3/8-24
7/16-14	7/16-20
1/2-13	1/2-20
CARBON STEEL PART NO. 0010	CARBON STEEL PART NO. 0020
STAINLESS STEEL PART NO. 0011	STAINLESS STEEL PART NO. 0021

COARSE	FINE
M5 x 0.8	M5 x 0.8
M6 x 1.0	M6 x 1.0
M8 x 1.25	M8 x 1.25
M10 x 1.5	M10 x 1.25
M12 x 1.75	M12 x 1.5
CARBON STEEL PART NO. 1000	CARBON STEEL PART NO. 1001
STAINLESS STEEL PART NO. 1002	STAINLESS STEEL PART NO. 1003

INCH

METRIC

COARSE	FINE
1/4-20	1/4-28
5/16-18	5/16-24
3/8-16	3/8-24
CARBON STEEL PART NO. 1203	CARBON STEEL PART NO. 1204
STAINLESS STEEL PART NO. 1205	STAINLESS STEEL PART NO. 1206

COARSE	FINE
M6 x 1.0	M6 x 1.0
M8 x 1.25	M8 x 1.25
M10 x 1.5	M10 x 1.25
CARBON STEEL PART NO. 1201	CARBON STEEL PART NO. 1202
STAINLESS STEEL PART NO. 1207	STAINLESS STEEL PART NO. 1208



METRIC THREAD REPAIR KITS AND INSERTS

KIT CONTENTS

Drill Counterbore
Cutting tap Insert driver
Five (5) steel inserts



Bold text are insert lengths supplied in kits

METRIC KITS		INSERT LENGTH		INSERTS	
SIZE	PART NO	MM	INCHES	CARBON STEEL PART NO.	STAINLESS STEEL PART NO.
M3x0.5	1305	4.3	.169	13051	13052
		6.0	.240	13053	13054
M4x0.7	1407	4.0	.157	14077	—
		6.0	.240	14071	14072
		8.0	.320	14073	14074
M5x0.8	1508	7.6	.300	15081	15082
		10.0	.400	15083	15084
		12.0	.470	15085	—
M6x1.0	1610	8.0	.315	16105	16106
		9.4	.370	16101	16102
		12.0	.470	16103	16104
		17.0	.669	16107	—
		19.0	.748	16109	—
M7x1.0	1710	10.0	.400	17101	—
		14.0	.550	17103	—
		18.0	.708	17105	—
		20.0	.800	17107	—
M8x1.0	1810	7.5	.295	18100	—
		11.7	.460	18101	—
M8x1.25	1812	8.0	.315	—	18128
		9.0	.360	181210	—
		10.0	.400	18125	—
		11.7	.460	18121	18122
		14.0	.550	18129	18126
		16.2	.640	18123	18124
		18.0	.708	18127	181226
		20.0	.800	181213	181224
M8x1.75 GM Rare	1817	16.2	.640	18173	—
M9x1.25	1912	9.0	.360	19120	—
		13.0	.510	19121	—
		18.0	.710	19123	—
		22.0	.866	19127	—
M10x1.0	1010	6.2	.244	10100	—
		8.0	.315	10105	—
		9.0	.360	10101	10102
		15.0	.600	10103	10104
M10x1.25	1012	9.0	.354	10127	—
		14.0	.550	10121	10122
		16.2	.650	10123	10124
		20.0	.800	10125	10126
		25.0	.984	10129	—
M10x1.5	1015	9.4	.370	10157	—
		11.0	.433	101511	—
		14.0	.550	10151	10152
		17.0	.669	101517	—
		20.0	.800	10153	10154
		22.0	.866	101522	—
		24.5	.960	10155	—
M11x1.25	1112	22.0	.870	11123	—
		28.0	1.100	11121	—
M11x1.5	1115	16.0	.630	11151	—
		22.0	.870	11153	—
		30.0	1.180	11155	—

Bold text are insert lengths supplied in kits

METRIC KITS		INSERT LENGTH		INSERTS	
SIZE	PART NO	MM	INCHES	CARBON STEEL PART NO.	STAINLESS STEEL PART NO.
M12x1.25	1212	9.0	.360	12121	—
		11.0	.430	12129	—
		15.0	.600	12123	12124
		24.0	.950	12125	12126
M12x1.5	1215	6.7	.263	12157	—
		9.2	.360	12151	—
		16.2	.640	12153	12152
		24.0	.950	12155	12154
		30.0	1.180	12159	12160
M12x1.75	1217	10.0	.400	12177	—
		12.0	.472	12170	—
		16.2	.640	12171	12172
		24.0	.950	12173	12174
		30.0	1.180	12179	—
M13x1.5	1315	14.0	.551	13151	—
		19.0	.748	13153	—
		24.0	.950	13155	—
M14x1.5	1415	6.6	.260	14151	—
		9.4	.370	14153	—
		12.7	.500	14155	—
M14x2.0	1420	17.8	.700	14157	—
		24.0	.950	14158	—
		28.0	1.100	14159	—
		12.0	.472	14201	—
		18.0	.710	14203	—
M16x1.5	1615	24.0	.950	14205	—
		30.0	1.180	14207	—
		7.0	.270	16151	16150
		12.7	.500	16153	16152
M16x2.0	1620	24.0	.950	16155	16154
		32.0	1.250	16157	—
		16.0	.630	16200	16202
		24.0	.950	16201	16204
M18x1.5	1815	32.0	1.250	16203	16206
		38.0	1.496	16205	—
		10.0	.400	18151	—
		15.0	.590	18157	—
		18.3	.720	18153	—
M20x1.5	2015	27.0	1.060	18155	—
		9.0	.354	20150	—
		12.0	.472	20151	—
		17.0	.669	20153	—
M22x1.5	2215C	30.0	1.180	20155	—
		10.0	.400	22151	—
		15.0	.590	22153	—
M24x1.5	2415C	20.0	.800	22155	—
		7.6	.300	24150	—
		10.0	.400	24151	—
		15.0	.590	24153	—
		20.0	.800	24155	—
M24x1.5	2415C	30.0	1.180	24157	—
		10.0	.400	24151	—
		15.0	.590	24153	—

INCH THREAD REPAIR KITS AND INSERTS

KIT CONTENTS

Drill Counterbore
Cutting tap Insert driver
Five (5) steel inserts



Bold text are insert lengths supplied in kits

INCH KITS		INSERT LENGTH		INSERTS	
SIZE	PART NO.	INCHES	MM	CARBON STEEL PART NO.	STAINLESS STEEL PART NO.
4-40	0440	.200	5.0	04401	04402
6-32	0632	.250	6.3	06321	06322
8-32	0832	.250 .320	6.3 8.0	08321 08323	08322 08324
10-24	0024	.240 .300 .370	6.1 7.6 9.4	00240 00241 00243	00246 00242 00244
10-32	0032	.240 .300 .370	6.1 7.6 9.4	00320 00321 00323	00326 00322 00324
12-24	0124	.300 .370 .472	7.6 9.4 12.0	01241 01243 01245	01242 01244 01246
1/4-20	0140	.280 .380 .500 .750 1.000	7.1 9.4 12.7 19.0 25.4	01400 01401 01403 01405 01407	— 01402 01404 01408 01409
1/4-28	0148	.280 .380 .500	7.1 9.4 12.7	01480 01481 01483	01486 01482 01484
1/4-32	0142	.180 .250 .380 .500	4.5 6.3 9.4 12.7	01421 01423 01425 01427	01422 01424 01426 01428
5/16-18	0561	.350 .450 .620 .750	8.9 11.4 15.7 19.0	05610 05611 05613 05615	05617 05612 05614 05616
5/16-24	0562	.350 .450 .620 .750	8.9 11.4 15.7 19.0	05620 05621 05623 05625	— 05622 05624 —
3/8-16	0381	.312 .400 .520 .620 .750 .900 1.000 1.200	7.9 10.0 13.2 15.7 19.0 22.8 25.4 30.4	03818 03819 03811 03813 03815 038190 03810 03817	038182 038192 03812 03814 03816 — 038102 —
3/8-24	0382	.300 .350 .520 .750	7.6 8.9 13.2 19.0	— 03825 03821 03823	03820 — 03822 03824

Bold text are insert lengths supplied in kits

INCH KITS		INSERT LENGTH		INSERTS	
SIZE	PART NO.	INCHES	MM	CARBON STEEL PART NO.	STAINLESS STEEL PART NO.
7/16-14	0761	.400	10.0	07610	—
		.600	15.2	07611	07612
		.870	22.0	07613	07614
		1.000	25.4	076135	07619
		1.250	31.7	07615	07618
		1.500	38.0	07617	—
7/16-20	0762	.250	6.3	07629	—
		.370	9.4	076320	—
		.480	12.2	07627	—
		.600	15.2	07621	07622
		.870	22.0	07623	07624
		1.000	25.4	076231	—
		1.370	34.7	07625	—
1/2-13	0121	.400	10.0	01217	—
		.650	16.5	01211	01212
		1.000	25.4	01213	01214
		1.250	31.7	01219	—
		1.500	38.0	01215	—
1/2-20	0122	.400	10.0	01225	—
		.500	12.7	01220	—
		.650	16.5	01221	01222
		1.000	25.4	01223	01224
		1.370	34.7	01227	—
9/16-12	0961	.750	19.0	09611	—
		1.120	28.4	09615	—
		1.500	38.0	09617	—
9/16-18	0968	.350	8.9	09687	—
		.450	11.4	09685	—
		.750	19.0	09681	—
		1.120	28.4	09683	—
5/8-11	0581	.500	12.7	05810	—
		.850	21.6	05811	05812
		1.250	31.7	05813	05814
		1.500	38.0	03415	—
5/8-18	0588	.320	8.1	05881	—
		.450	11.4	05887	—
		.850	21.6	05883	—
		1.250	31.7	05885	—
3/4-10	0341	.750	19.0	03415	—
		1.100	28.0	03411	—
		1.500	38.0	03413	—
3/4-16	0346	.650	16.5	03460	—
		1.100	28.0	03461	—
		1.500	38.0	03463	—

DRAIN PAN APPLICATIONS

All kits include all the tools plus 5 inserts and tap guide.



Drain Pans Kits

1/2-13 Drain Pan

Kit Part number 0121C Insert Part No.01217
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts .400 length

1/2-20 Aluminum Drain Pan

Kit Part number 0122A Insert Part No.01225
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts .400 length

FORD Drain Pan

1/2-20 "TIN PANS ONLY"
Kit Part number 0765 Insert Part No.07629
This kit reduces the hole size from "1/2-20 to 7/16-20"
Contains: Cbore, Driver tools, 5 inserts, 5 drain plugs with washers

3/4-16 Drain Pan

Kit Part number 0346C Insert Part No.03460
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts .650 length

3/4-10 Drain Pan

Kit Part number 0341C Insert Part No.03415
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts .750 length

M10x1.5 Drain Pan

Kit Part number 1015A Insert Part No.10157
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts 9.4mm length

M12x1.25 Drain Pan

Kit Part number 1212C Insert Part number12121
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts 9mm length

M12x1.5 Drain Pan

Kit Part number 1215C Insert Part No.12151
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts 9.2mm length

M12x1.75 Drain Pan

Kit Part number 1217C Insert Part No.12170
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts 12mm length

M14x1.5 Volkswagen, Chrysler...

Same as the 1415C but has a longer insert 12.7mm
Kit Part number 1415A Insert Part No.14155
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts 12.7mm length

M14x1.5 "Aluminum Pans"

Kit Part number 1415C Insert Part No.14153
This kit can restore any aluminum drain pan back to it's original size
Contains:Drill, Cbore,Tap, Driver, Tapguide, 5 inserts 9.4mm length

Honda and Acura Drain Pan Repair "Tin Pans Only"

Kit Part number 1485 Insert Part No.12151
This kit reduces the hole size from M14 x 1.5 to M12 x 1.5

M14x1.25 Drain Pan

Kit Part number 14125A Insert Part No.44127
Contains:Drill, Cbore,Tap, Driver, Tap guide,5 inserts 11mm length

M16x1.5 Drain Pan

Kit Part number 1615C Insert Part No.16153
Contains:Drill, Cbore,Tap, Driver, Tap guide,5 inserts 12.7mm length

M18x1.5 Drain Pan

Kit Part number 1815C Insert Part No.18151
Contains:Drill, Cbore,Tap, Driver, Tap guide,5 inserts 10mm length

M20x1.5 Drain Pan

Kit Part number 2015A Insert Part No.20151
Contains:Drill, Cbore,Tap, Driver, Tap guide,5 inserts 12mm length

M22x1.5 Drain Pan

Kit Part number 2215C Insert Part No.22151
Contains:Drill, Cbore,Tap, Driver, Tap guide,5 inserts 10mm length

M24x1.5 Drain Pan

Kit Part number 2415C Insert Part No.24150 VW touareg length
Contains:Drill, Cbore,Tap, Driver, Tap guide,5 inserts 7.6mm length

SPARK PLUG KITS



4412
Standard repair



Spark plug kits do not contain inserts, order separately.

4412E
Deep hole repair

KIT CONTENTS
Step Tap
Wrench
Seat Cutter
Insert driver

FORD TRITON

Note: FORD TRITON M14x1.25 repair use P/N **5553** kit comes with all tools and 5 inserts
Also used for 1.9 / 3.8 / 4.6 / 5.4 Liter engines
Triton 3 Valve M16x1.5 use part #3221

SEAT RECONDITION KIT

Used for worn or damaged seats
this kit is only intended to clean up seats.



KIT CONTENTS
Wrench
Driver
Seat cutter

Washer Seat
PART NO. 4412SRW

Taper Seat
PART NO. 4412SRT

SPECIAL SEAT CUTTERS

For use on some taper seat spark plug repairs that have limited access to the spark plug hole.

M14 x 1.25 PART NO. 44196
M18 x 1.5 PART NO. 48196
M14 x 1.25 Extended PART NO. 44196E

INSERT DRIVER OIL

This oil is superior for installing inserts. PART NO. 6010

SEAT Recondition cutters

These seat cutters can only be used with kit 4412 and 4412E.

For reconditioning of worn or damaged seats.



Washer Seat PART NO. 44197 Taper Seat PART NO. 44198

WASHER SEAT



Washer seat spark plugs seal with a washer on plug.

TAPER SEAT



Sealer must be used when installing taper seat inserts.

SPARK PLUG TYPES

WASHER SEAT INSERTS

TAPER SEAT INSERTS

KIT SIZE	PART NO.	LENGTH		PART NO.	LENGTH		PART NO.
		MM	INCHES		MM	INCHES	
1/4-32 RC engines	0142SP	4.5	.180	01421			
M10 x 1.0 Standard Kit	4010	9.0	.360	40101			
M10 x 1.0 Deep Hole Kit	4010E	15.0	.600	40103			
M12 x 1.25 Standard Kit	4212	9.0	.360	42121			
M12 x 1.25 Deep Hole Kit	4212E	15.0	.600	42123	21.0	.827	42126
M14 x 1.25 Standard Kit	4412	7.0	.270	44121	7.0	.270	44181
		8.0	.320	44123	10.0	.400	44183
		9.4	.370	44125			
		11.0	.430	44127			
		13.5	.530	44113			
M14 x 1.25 Deep Hole Kit	4412E	15.0	.600	44129	15.7	.620	44185
		16.8	.660	44111	16.8	.660	44186
		23.0	.905	44112	24.0	.950	44187
M18 x 1.5	4815	10.0	.400	48151	10.0	.400	48181
		18.3	.720	48153			
7/8-18	4718	11.0	.430	47181			
		20.0	.780	47183			
		24.5	1.000	47185			

M14x1.25 Aluminum Inserts	WASHER SEAT		PART NO.	TAPER SEAT		PART NO.
	MM	INCHES		MM	INCHES	
Aluminum Inserts For kits 4412 & 4412E	7.0	.270	44121A	7.0	.270	44181A
	8.0	.320	44123A	10.0	.400	44183A
	9.4	.370	44125A	13.5	.530	44184A
	11.0	.430	44127A	15.7	.620	44185A
	13.5	.530	44113A	16.8	.660	44186A
	15.0	.600	44129A	24.0	.950	44187A
	16.8	.660	44111A			
	23.0	.905	44112A			

Sealer required for all Taper seat inserts. p/n 6020

SEAT CUTTER GUIDE

For use when the step tap cannot be threaded deep enough to allow use of the seat cutter.

M14 x 1.25 PART NO. 44195



COPPER ANTI-SEIZE

Recommended for use on spark plug with aluminum insert. PART NO. 37229



SEALER

This sealer must be used when installing taper seat inserts. PART NO. 6020

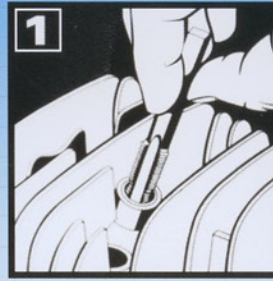


SPARK PLUG THREAD REPAIR

The following instructions for kit part numbers 4412 and 4412E.

KIT CONTENTS
Step Tap
Wrench
Seat Cutter
Insert driver

Spark plug kits do not contain inserts, order separately.



Start the step tap into the hole to be repaired keeping as straight as possible.



Use the wrench provided, place wrench over tap and tap new threads. Continue to tap through until the cutting edges are approximately $\frac{1}{4}$ inch below surface. Leaving the tap $\frac{1}{4}$ inch below the surface ensures that the seat cutter will not hit the back of the tap flutes.



Leave the step tap in the hole. Place the seat cutter over the shank. The seat cutter does two operations. First the seat cutter will cut the countersink for the flange of the insert, then it cuts a new seat for the sparkplug washer.

This operation is the same for the taper seat inserts.



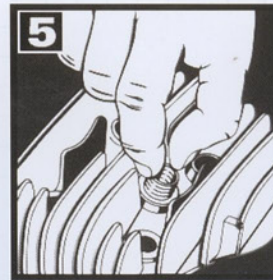
Using the wrench rotate the seat cutter. After a few turns lift the seat cutter to inspect the seat. Repeat operation until the seat is completely cleaned up. Remove the step tap from the hole.



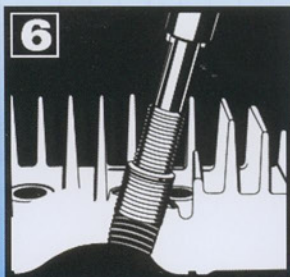
Good Seat Complete



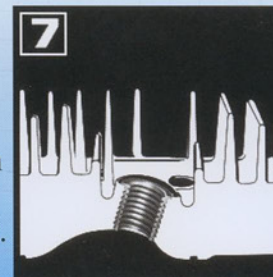
Bad Seat incomplete



Make sure the hole is clean and dry. Lubricate the driver tool with Time-Sert driver oil. Screw the insert onto the prepared hole. If doing deep hole repairs: Lubricate the driver tool with Time-Sert driver oil or 30wt Oil. Screw the insert onto the driver then into the prepared hole.



Using the wrench provided rotate the driver into the insert. When the insert is seated the driver will tighten up. With increased pressure continue to rotate the driver through the insert until it loosens up. Then back the driver tool out of the insert.



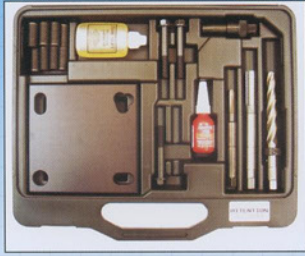
Repair is complete. Solid steel threads are square to the reconditioned seat, insuring a good spark plug seal.

Note: Taper seat inserts

These inserts are silver plated and require sealer p/n 6020 on the outside of the insert.

MANUFACTURER KITS

GENERAL MOTORS



NORTH STAR 4.0/4.6 HEAD BOLT M11x1.5 HEAD BOLT

Kit Part No. J-42385-500 Insert Part No. 11155

NORTH STAR 4.0/4.6 Oversize M11x1.5 HEAD BOLT BIG-SERT Second repair

Kit P/N. J-42385-500BS Insert P/N J-42385-507BS

L850 or "ECOTEC" 2.2 liter 4 cylinder

J-42385-500 kit with
J-42385-871 Bushing Insert P/N 11155

NORTH STAR MAINBEARING 4.0/4.6 M10x1.5 MAIN BEARING

Kit Part No. J-42385-300 Insert Part No. J-42385-514

NORTH STAR 2000 HEAD BOLT

M11x1.5 There are 2 depths of holes for this block

Kit Part No. J-42385-2000 Insert Part No. 11155

North Star 2004 HEAD BOLT M11x2.0 PV8 LH2 4.6 liter LXR

Kit Part number J-42385-2030 Insert Part No. 112030

LL8 Straight 6 M11x2.0 Head Bolt

2002 -2004 GMC Envoy

2002-2004 Trail blazer

Kit Part No. 4001 Insert Part No. 112030

PV6 M11x1.5 Head bolt LX5 3.5L

1999-2002 Oldsmobile Intrigue

2001-2002 Oldsmobile Aurora

Kit Part No. 6001 Insert Part No. 11155

General Motors GEN3

M11x2.0 HEAD BOLT

1997-2004 C5 Corvette base model

1998-2002 Chevrolet Camaro Z28, SS

1998-2002 Pontiac Firebird Formula and Trans-Am

2004 Pontiac GTO

1999-2005 Holden Commodore as an option

1999-2005 Holden Statesman/Caprice

2001-2005 Holden Monaro

Kit Part number J-42385-100 Insert p/n 112030

M10x 2.0 Main Bearing kit 5.7 V8 LS

Kit Part number J-42385-120 Insert p/n 102022

M12x1.75 Drain plug

This kit will repair most GM aluminum drain pans

Repairs : 1999-2004 CK Engine ASM V8/ LR4/4.8V,LM7/

5.3T,LQ4/6.0U / 2003-2005 ST1 Engine / ASM-4.3L V6/ LU3/4.3X

Kit contains:

Drill, Cbore, Tap, Driver, Tapguide, 5 inserts 12mm length

Kit Part number 1217C Insert p/n 12170

HONDA



HONDA D16 HEAD BOLT

M10x1.25 Headbolt

1996-2000 Civic 1988-1991 Civic/CRX 1992-1995 Civic/Del Sol

Kit Part No. 4160 Insert Part No. 10129

HONDA Odyssey HEAD BOLT

M12x1.5 Headbolt

For threads that start at approx. 51mm "Includes"

1999-2005 Odyssey 2003-2005 Pilot 1998-2005 Accord V6

1997-2003 3.0-3.2 CL 1999-2005 3.2TL 2001- 2005 MDX

2005 RL

Kit Part No. 7220 Insert Part No. 12159

Honda Civic Hybrid Head Bolt

M9x1.25 2003-2005

Kit Part No. 9210 Insert Part No. 19127

HONDA/ACURA HEAD BOLT

M11x1.5 for threads that start at approx. 57mm

Honda B16 2002-2005 CR-V 2003-2005 Accord L4

2003-2005 Element 1999-2005 Civic SI 2002-2005 RSX

1986-2001 Integra 1986-1995 Legend 1991-2005 NSX

1996-2004 RL

Kit Part No. 7111 Insert Part No. 11155

HONDA/ACURA HEAD BOLT Oversize

M11x1.5 BIG-SERT Second repair

Honda B16 2002-2005 CR-V 2003-2005 Accord L4

2003-2005 Element 1999-2005 Civic SI 2002-2005 RSX

1986-2001 Integra 1986-1995 Legend 1991-2005 NSX

1996-2004 RL

Kit Part No. 7111BS Insert Part No. J-42385-507BS

HONDA MOTORS Special Kit 1/8-28 BSBP

Kit Part No. 0128 Insert Part number 01281

Honda and Acura

M14x1.5 "TIN Pans Only"

This kit reduces the hole size from M14 x 1.5 to M12 x 1.5

Kit Part number 1485 Insert Part No.12151

Honda and Acura

M14x1.5 "Aluminum Pans"

This kit can restore any aluminum drain pan back to it's original size

Kit Part number 1415C Insert Part No.14153

Honda & Acura M10x1.25

Alternator bolt thread repair

M10x1.25 Alternator bolt

1999-2005 Odyssey 2003-2005 Pilot 1998-2005 Accord V6

1997-2003 3.0-3.2 CL 1999-2005 3.2TL 2001- 2005 MDX

2005 RL Kit Part number 1012C Insert Part No. 10125

MANUFACTURER KITS

FORD

FORD SPARKPLUG REPAIR M14x1.25 Triton 2 and 4 valve 1.9/3.8/4.6/5.4 liter engines



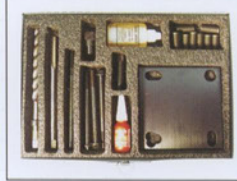
Kit Part No. 5553
Insert Part No 51459

FORD SPARKPLUG REPAIR M16x1.5 3 Valve Heads



Kit Part No. 3221
Insert Part No 32214

FORD HEAD BOLT 4.6/5.4 M11x1.5 HEAD BOLT



Kit Part No. 6111
Insert Part No. 11155

TOYOTA

Universal M11x1.5 head bolt kit



Kit Part No. 2200
Insert Part No 11155

We do not have a specific kit for Toyota head bolt. We commonly sell the Universal M11x1.5 for the Camry and Rav4 & Scion models which use the M11x1.5 head bolt.

Harley Davidson

3/8-16 x 1.000 used in Harley Davidson Head Bolt Where depth of hole is 1.250 deep.



Kit Part No. 0381D
Insert Part No 03810

VOLKSWAGEN

VOLKSWAGEN Touareg Drain Pan kit M24x1.5



Kit Part No. 2415C
Insert Part No. 24150

V.W & PORSCHE CASE KIT FOR M10 x 1.5 CASE STUDS Kit Part No. 1085 Insert Part No. 10155



M14x1.5 Drain Pan Repair Contains:Drill, Cbore,Tap, Driver, Tapguide and 5 inserts of a 12.7mm length Kit Part number 1415A Insert Part No.14155



Optional Tap Guide Plate
VW and Porsche 911 style.
This plate is placed on top
of the cylinder to ensure a
straight tapped hole.



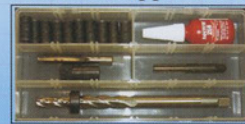
Plate Part No. 31084

VW SOLEX Carburetor
M8x1.0 Kit P/N 1881

VW SOLEX Carburetor
M11x1.0 Kit P/N 1181

BMW

M10x1.5 24.5mm Head bolt application



Kit Part No. 1087
Insert Part No 10155

This tooling will install a M10x1.5x24.5mm length insert in a 6mm deep countersink.

SPECIAL APPLICATIONS

DIESEL INJECTOR M24 x 2.0 THREAD REPAIR KIT



Kit Part No. 2420
Insert Part No. 24201

BENDIX AIRCRAFT WHEEL 1/4-28 THREAD REPAIR KIT



Kit Part No. 01488
Insert Part No. 014888

BENDIX AIRCRAFT WHEEL 1/4-28 OVERSIZED THREAD REPAIR KIT



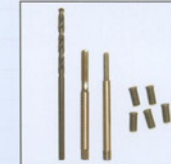
Kit Part No. 01489
Insert Part No. 014899

10x1.5 30mm Flush Surface kit



Kit Part No. 1015D30
Insert Part No. 10159

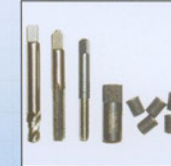
M6x1.0 Extended kit



This tooling has no counterbore. The hole must be at least 8mm or .315 inches for the tap to access the hole.

Kit Includes
6" extension drill, 4" tap, 4" driver,
5 inserts of a 17mm length.
Kit Part number 1610E2

M8x1.25 CORE KIT



The core drill included will allow a special 11.7mm length no flange insert to be installed deeper than a standard kit.

Kit Includes
Core drill, tap, driver, tap guide,
5 inserts of the 11.7mm no flange
Kit Part number 1812CORE

M8x1.25 CORE KIT Extended

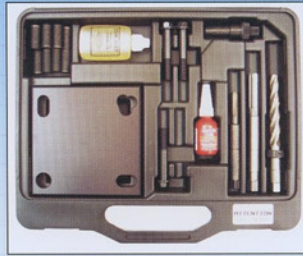


The core drill included will allow a 16.2mm length insert to be installed deeper than the standard kit.

Kit Includes
Core drill, tap, driver,
5 inserts of the no flange
16.2mm length.
Kit Part number 1812ECORE

UNIVERSAL HEAD BOLT KITS

Universal head bolt kits can be used in any application of bolt size listed below.
A simple tool setup is all that is required.



Universal M10x1.5 head bolt

Kit Part No.7580 Insert Part No. 10155
Includes 10 inserts of a M10x1.5x24.5mm length

Universal M10x1.25 head bolt

Kit Part No.6250 Insert Part No. 10129
Includes 10 inserts of a M10x1.25x25mm length

Universal M11x1.5 head bolt

Kit Part No.11110 Insert Part No. 11155
Includes 10 inserts of a M11x1.5x30mm length

Universal M11x1.25 head bolt

Kit Part No.11125 Insert Part No. 11121
Includes 10 inserts of a M11x1.25x28mm length

Universal M12x1.5 head bolt

Kit Part No.4800 Insert Part No. 12159
Includes 10 inserts of a M12x1.5x30mm length

Universal M12x1.25 head bolt

Kit Part No.4700 Insert Part No. 12127
Includes 10 inserts of a M12x1.25x30mm length

Universal M12x1.75 head bolt

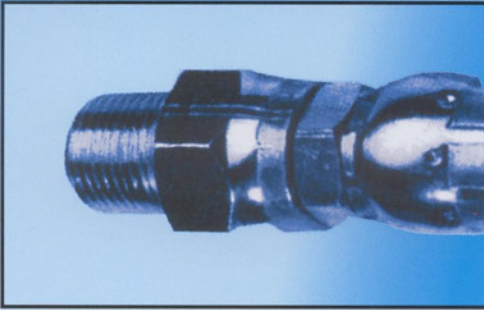
Kit Part No.4900 Insert Part No. 12179
Includes 10 inserts of a M12x1.75x30mm length

Universal head bolt kits also available in oversize "BIG-SERT" versions.

TAPER PIPE THREAD KITS

National Pipe Taper Thread (NPT)

CARBON STEEL



KIT SIZE	PART NO.	INSERT PART NO.
1/8-27	0127	01271
1/8-28 <i>BSBP Honda Motors</i>	0128	01281
1/4-18	0118	01181
3/8-18	0318	03181
1/2-14	0214	02141
3/4-14	0414	04141



STAINLESS STEEL

KIT SIZE	PART NO.	INSERT PART NO.
1/8-27	0127S	01272
1/4-18	0118S	01182
3/8-18	0318S	03182
1/2-14	0214S	02142

NOTE: The 1/2-14 and 3/4-14 pipe kits do not have a counterbore

These kits **do not** include counterbore's.

Yes, the insert will stick up slightly without a counterbore but being a pipe application there should be no problem as the pipe fitting will not contact the flange of the insert. This is noted in the instructions and you may optionally use a standard 90 degree countersink to get the flange flush if so desired.

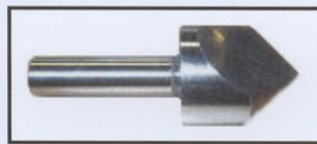
Time-Sert does sell these tools separately if needed.

90 degree CounterSink for the 1/2-14 taper pipe kit p/n 22145.

Description: 90 degree countersink 1" diameter

90 degree CounterSink for the 3/4-14 taper pipe kit p/n 24145.

Description: 90 degree countersink 1 1/2 " diameter



USEFUL TOOLS

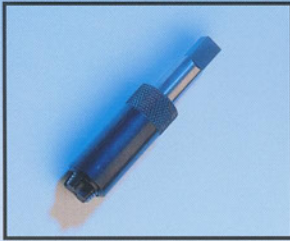
TAP GUIDES

AMERICAN TAP GUIDES

SIZE	PART NO.
1/4-20	31420
1/4-28	31420
5/16-18	35168
5/16-24	35168
3/8-16	33816
3/8-24	33824
7/16-14	37164
7/16-20	37162
1/2-13	31213
1/2-20	31225
3/4-10	33415
3/4-16	33416

METRIC TAP GUIDES

SIZE	PART NO.
M6 x 1.0	36105
M8 x 1.25	38125
M10 x 1.0	30105
M10 x 1.5	30155
M10 X 1.25	30125
M12 X 1.5	32155
M12 X 1.25	32125
M12 X 1.75	32175
M14 X 1.5	34155
M16 X 1.5	36155
M18 X 1.5	38155
M20 x 1.5	30215
M22 x 1.5	32255
M24 x 1.5	32455

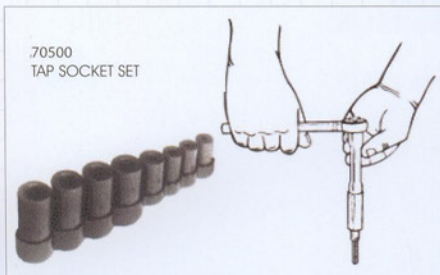


Tap guides insure that the threads are square to the surface of the hole.



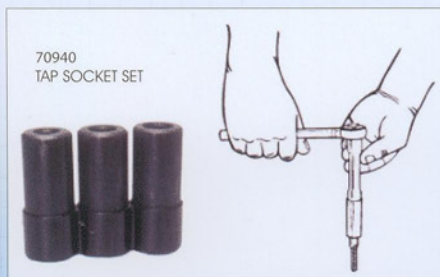
The lower portion of the tap guide should remain as square as possible to the engine surface. Turn the tap slowly while making sure the guide remains flush.

TAP SOCKET SETS



For Use in Restricted Areas

Ideal for use in areas where a T handle won't fit. Set of 8 sockets fits all number and fractional M.C.T.I. standard taps thru 1/2". Also fits 1/8" NPT taps and metric tapsthru 12mm manufactured to M.C.T.I. Standards. Sockets contained on a vinyl holder. Time-Sert taps 4mm to 12mm metric / 4-40 to 1/2 inch Sockets #1 thru #4 use 1/4 drive, rest use 3/8 drive.

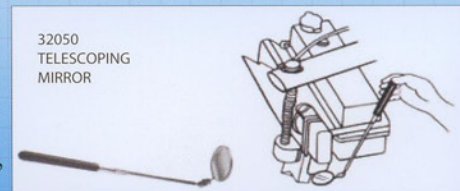


Three Larger Sizes in a Convenient Set

The three largest tap sockets, are now packaged in a three piece set. Ideal for use where a T handle won't fit, especially in restricted areas. For larger, fractional M.C.T.I. standard taps. #9 socket is 5/8" (16mm), #10 is for 11/16" (18mm) and #11 is for 3/4". Sockets contained in a vinyl holder. Time-Sert taps 13mm to 16mm metric 5/8 to 3/4 inch. use 1/2 drive socket.



Lightweight, Compact, LED Light. Depress the pocket clip to illuminate. The bright LED bulb lasts up to 100,000 hours. Comes equipped with 2 common replaceable 3 volt batteries, CR2016. Overall length 4 1/2".



2 1/4" diameter mirror swivels to any position. Length extends from 10" to 14"

USEFUL TOOLS

TAP WRENCHES



STRAIGHT TAP WRENCH

Straight Tap Wrench, Length 5 Inches, Hand Taps Capacity 1/16 to 1/4 Inch, Taps M1.5 to M6 wrench number 00 **P/N C67201**

Straight Tap Wrench, Length 11 Inches, Hand Taps Capacity 5/32 to 1/2 Inch, Taps M4 to M12 Time-Sert taps 4-40 - 7/16 Inch, M3 - M11 Metric wrench number 5 **P/N C67202**

Straight Tap Wrench, Length 15 Inches, Hand Taps Capacity 5/32 to 3/4 Inch, Taps M4 to M19 Time-Sert taps 1/4 - 9/16 Inch, M5 - M14 Metric wrench number 6 **P/N C67203**

Straight Tap Wrench, Length 19 Inches, Hand Taps Capacity 1/4 to 1-1/8 Inch, Taps M12 to M28 wrench number 7 **P/N C67204**

Straight Tap Wrench, Length 40 Inches, Hand Taps Capacity 3/4 to 1-5/8 Inch, Taps M19 to M40 wrench number 8 **P/N C67205**



T-HANDLE WRENCH

T-handle wrench, Length 2-3/4 Hand Taps Capacity 1/16" to 1/4" Inch Taps M1.5 to M6 . Time-Sert taps M3 - M5 wrench number T11 **P/N C67208**

T-HANDLE WRENCH

T-handle wrench, Length 3-5/8 Hand Taps Capacity 7/32" to 1/2" Inch Taps M5 to M12 Time-Sert taps M5 - M11 wrench number T12 **P/N C67209**

SCREW EXTRACTORS

73406
SCREW EXTRACTOR



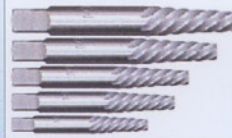
Removes broken bolts 5/8 to 7/8.
If removing a Time-Sert insert, this tool will remove inserts from 1/2 to 9/16 inch or 12mm to 14mm metric.

73307
SCREW EXTRACTOR



Removes broken bolts 7/8 to 1-1/8.
If removing a Time-Sert insert, this tool will remove inserts from 5/8 to 3/4 inch or 16mm to 20mm metric.

73415
SCREW EXTRACTORS



5 pc set 3/32 to 5/8
If removing a Time-Sert insert, this set will remove inserts from 4-40 to 7/16 or 4mm to 11mm metric.

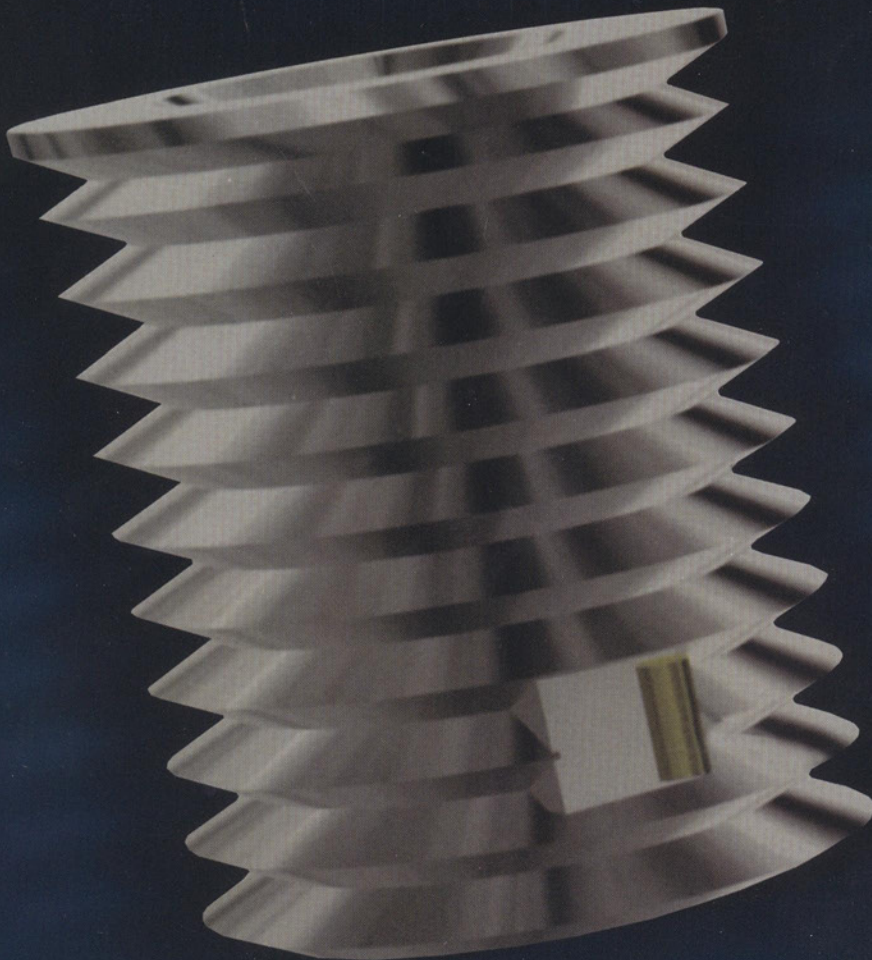
73308
SCREW EXTRACTOR



Removes broken bolts 1-1/8 to 1-3/8.
If removing a Time-Sert insert, this tool will remove our 3/4 pipe insert.

BIG-SERT[®]

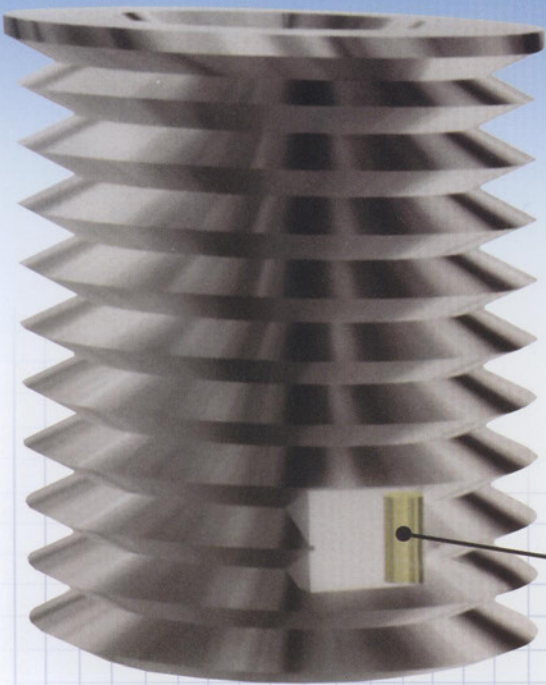
OVERSIZED REPAIRS



SCREW THREAD INSERTS

BIG-SERT®

OVERSIZED REPAIRS



BIG-SERT® IS A HEAVY WALL SOLID BUSHING. EASY TO INSTALL WITH POSITIVE PLACEMENT.

BIG-SERT® GIVES INCREASED LOAD PROTECTION FOR CRITICAL USE.

BIG-SERT® WILL REPAIR OVERSIZE HOLES WHICH HAVE PREVIOUSLY BEEN REPAIRED.

SOCKET WITH A METAL PIN

NOTE: BOTTOM FEW INTERNAL THREADS ARE INCOMPLETE. THE INSERT DRIVER (ROLL FORM TAP) SEATS THE INSERT AND COMPLETES THE BOTTOM THREADS. THIS PUSHES THE PIN OUT TO CONTACT THE THREADED HOLE. BACK OUT OF THE INSERT IS PREVENTED BY THE CAM LOCK EFFECT OF THE PIN.

KIT CONTENTS

DRILL
COUNTERBORE
TAP
INSERT DRIVER
FIVE (5) STEEL INSERTS



ENGINEERING DATA

INCH

INSERT SIZE	DRILL		C. BORE		TAP
	DRILL	SIZE	MIN. DIA.	MIN. DEPTH	MAJOR DIA.
1/4-20	7.8mm	.307	.355	.050	.359
1/4-28	L	.290	.330	.055	.330
5/16-18	13/32	.406	.474	.085	.474
5/16-24	13/32	.406	.474	.085	.474
3/8-16	31/64	.484	.552	.085	.552
3/8-24	31/64	.484	.552	.085	.552
7/16-14	37/64	.578	.634	.085	.634
7/16-24	37/64	.578	.634	.085	.634
1/2-13	41/64	.640	.701	.085	.701
1/2-20	41/64	.640	.701	.085	.701

METRIC

INSERT SIZE	DRILL		C. BORE		TAP
	DRILL	SIZE	MIN. DIA.	MIN. DEPTH	MAJOR DIA.
M5x0.8	D	.246	.290	.050	.290
M6x1.0	L	.290	.330	.085	.330
M8x1.25	13/32	.406	.474	.085	.474
M10x1.25	31/64	.484	.552	.085	.552
M10x1.5	31/64	.484	.552	.085	.552
M12x1.5	37/64	.578	.634	.085	.634
M12x1.75	37/64	.578	.634	.085	.634

KITS AND INSERTS

INCH

KIT		INSERT LENGTH		INSERTS
SIZE	PART#	INCHES	MM	PART#
1/4-20	5420	.380	9.4	54201
		.500	12.7	54203
1/4-28	5448	.380	9.4	54481
		.500	12.7	54483
5/16-18	5561	.450	11.4	55611
		.620	15.7	55613
5/16-24	5562	.450	11.4	55621
		.620	15.7	55623
3/8-16	5381	.520	13.2	53811
		.750	19.0	53813
3/8-24	5382	.520	13.2	53821
		.750	19.0	53823
7/16-14	5761	.600	15.2	57611
		.870	22.0	57613
7/16-20	5762	.600	15.2	57621
		.870	22.0	57623
1/2-13	5121	.650	16.5	51211
		1.00	25.4	51213
1/2-20	5122	.650	16.5	51221
		1.00	25.4	51223

METRIC

KIT		INSERT LENGTH		INSERTS
SIZE	PART#	INCHES	MM	PART#
M5x0.8	5508	.300	7.6	55081
		.394	10.0	55083
M6x1.0	5610	.370	9.4	56101
		.470	12.0	56103
M8x1.25	5812	.460	11.7	58121
		.640	16.2	58123
M10x1.25	5012	.550	14.0	50121
		.800	20.0	50123
M10x1.5	5015	.550	14.0	50151
		.800	20.0	50153
M12x1.5	5215	.960	24.5	50155
		.640	16.2	52121
M12x1.75	5217	.950	24.0	52123
		.640	16.2	52171
		.950	24.0	52173

SPARK PLUG M14 X 1.25



KIT PART NO. 5141

SEALER FOR HIGH TEMPERATURES MUST BE USED WHEN INSTALLING BIG-SERT SPARK PLUG INSERTS. PART NO. 6020

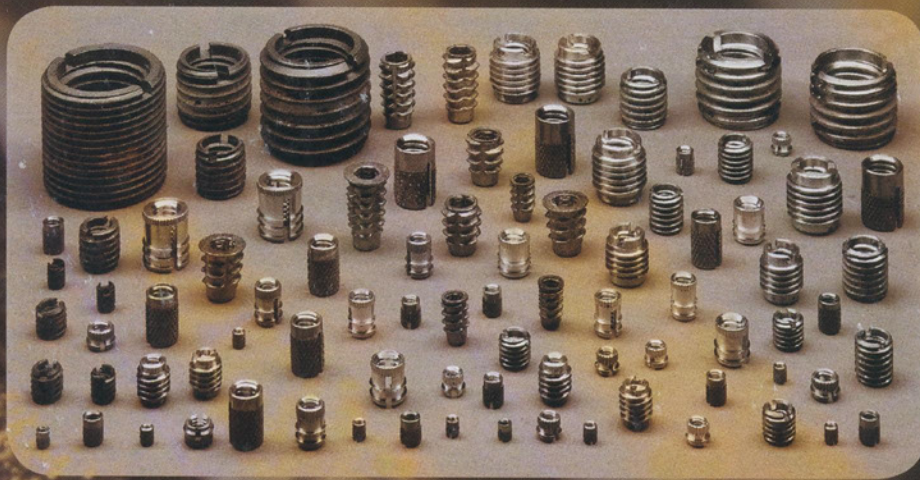
KIT	INSERTS		WASHER SEAT	TAPERED SEAT
	LENGTH		PART NO.	PART NO.
	INCHES	MM		
5141	.370	9.4	51401	n/a
	.430	11.0	51403	51453
5141E Extended	.600	15.0	51405	51455
	.660	16.8	51407	51457

KIT	FORD TRITON	WASHER SEAT	TAPERED SEAT
5553	.660	16.8	n/a
KIT	FORD ZTECH		Z-TECH
5554	.950	24.0	n/a
			51460

THE OUTSIDE OF THE BIG-SERT INSERT IS M18X1.5. THE STRIPPED HOLE MUST NOT BE LARGER THAN 16.3MM OR .640 INCHES.

EZ LOK

THREADED INSERTS



FOR STRONG THREADS IN:

METAL

WOOD

PLASTIC



STRONG THREADS MADE EASY

ALL E-Z LOK INSERTS INSTALL WITH STANDARD TOOLS
NO SPECIAL DRILLS... NO SPECIAL TAPS... NO SPECIAL INSTALLATION TOOLS

E-Z LOK external threads are standard size and pitch to permit use of standard drills and taps. No special tap sizes or installation tools are required.

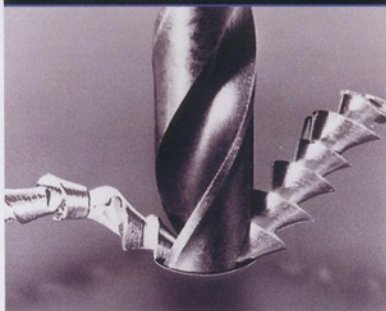
E-Z LOK inserts will not back out or vibrate loose. Immediately upon installation, microencapsulated adhesive begins to set and the newly installed insert can be fastened to within minutes. In addition, the adhesive seals against liquids and gases to pressures of 6,000 psi, and bonds to virtually all metals.

EASY REMOVAL Use a standard screw and bolt extractor to back out a damaged insert and then replace it with a new insert. Removal is simply a matter of overcoming the resistance to torque-out which has been produced by the thread locking material.



Power drive tools are available for high volume installation... See insert tables for catalog numbers and sizes.

Drill hole with standard drill.



Tap hole with standard tap.



Turn E-Z LOK home flush with bolt.



WHAT'S THE DIFFERENCE?



Q: What's the difference between E-Z LOK and coil threaded inserts?

A: There are two primary differences: design and installation.

Design

As the name implies, coil inserts are steel wire coiled in a spring-like design. E-Z LOK threaded inserts are screw machined out of solid steel.

Installation

To install a coil insert, you must have a special drill, special tap, and special installation tool. If a tap breaks or the installation tool is misplaced, the coil inserts can't be installed until a new tap or installation tool is purchased. E-Z LOK threaded inserts have standard size/pitch threads so they can be installed using standard tools probably already in your toolbox. For example, to install an E-Z LOK 329-5 (which has a 1/2-13 external thread), you would simply drill the hole with a standard 27/64 drill and then tap the hole with a standard 1/2-13 tap. Once that's done, the insert is threaded into the hole like an ordinary fastener using a screwdriver, bolt and jam nut, or an E-Z LOK drive tool.

COARSE THREAD SIZES

EZ-LOK Part No.	Internal Thread	External Thread	Length in.	Tap Drill Size	Tap Size	Minimum Full Thread Depth	Drive Tool Catalog No.
329-004	4-40	10-32	.250	5/32	10-32	9/32	—
329-006	6-32	1/4-20	.280	7	1/4-20	11/32	500-006
329-008	8-32	5/16-18	.290	F	5/16-18	7/16	500-1
329-3	10-24	3/8-16	.406	5/16	3/8-16	15/32	500-2
329-4	1/4-20	7/16-14	.437	23/64	7/16-14	1/2	500-3
329-5	5/16-18	1/2-13	.484	27/64	1/2-13	9/16	500-4
329-6	3/8-16	9/16-12	.515	31/64	9/16-12	19/32	500-5
329-7	7/16-14	5/8-11	.656	17/32	5/8-11	23/32	500-6
329-8	1/2-13	3/4-10	.656	21/32	3/4-10	3/4	500-7
329-801	1/2-13	3/4-10	1.000	21/32	3/4-10	3/4	500-7
329-9	9/16-12	3/4-10	.656	21/32	3/4-10	3/4	500-7
329-10	5/8-11	7/8-9	.687	49/64	7/8-9	13/16	500-8
329-1018	5/8-11	7/8-9	1.125	49/64	7/8-9	1-1/4	500-8
329-12	3/4-10	1-8	.781	7/8	1-8	7/8	500-9
329-14	7/8-9	1-1/4-7	1.125	1-7/64	1-1/4-7	1-1/4	—
329-16	1-8	1-3/8-12	1.250	1-9/32	1-3/8-12	1-3/8	—

FINE THREAD SIZES

EZ-LOK Part No.	Internal Thread	External Thread	Length in.	Tap Drill Size	Tap Size	Minimum Full Thread Depth	Drive Tool Catalog No.
329-332	10-32	3/8-16	.406	5/16	3/8-16	15/32	500-2
329-428	1/4-28	7/16-14	.437	23/64	7/16-14	1/2	500-3
329-524	5/16-24	1/2-13	.484	27/64	1/2-13	9/16	500-4
329-624	3/8-24	9/16-12	.515	31/64	9/16-12	19/32	500-5
329-720	7/16-20	5/8-11	.656	17/32	5/8-11	23/32	500-6
329-820	1/2-20	3/4-10	.656	21/32	3/4-10	3/4	500-7
329-918	9/16-18	3/4-10	.656	21/32	3/4-10	3/4	500-7
329-10F	5/8-18	7/8-9	.687	49/64	7/8-9	13/16	500-8
329-1216	3/4-16	1-8	.781	7/8	1-8	7/8	500-9
329-1414	7/8-14	1-1/4-7	1.125	1-7/64	1-1/4-7	1-1/4	—
329-1614	1-14	1-3/8-12	1.250	1-9/32	1-3/8-12	1-3/8	—

THIN WALL — COARSE THREAD SIZES

EZ-LOK Part No.	Internal Thread	External Thread	Length in.	Tap Drill Size	Tap Size	Minimum Full Thread Depth	Drive Tool Catalog No.
319-3	10-24	5/16-18	.312	I	5/16-18	.375	500-2
319-4	1/4-20	3/8-16	.375	Q	3/8-16	.437	500-3
319-5	5/16-18	7/16-14	.437	X	7/16-14	.500	500-4
319-6	3/8-16	1/2-13	.500	29/64	1/2-13	.560	500-5
319-7	7/16-14	9/16-12	.560	33/64	9/16-12	.620	500-6
319-8	1/2-13	5/8-11	.620	37/64	5/8-11	.680	500-7

THIN WALL — FINE THREAD SIZES

EZ-LOK Part No.	Internal Thread	External Thread	Length in.	Tap Drill Size	Tap Size	Minimum Full Thread Depth	Drive Tool Catalog No.
319-332	10-32	5/16-18	.312	I	5/16-18	.375	500-2
319-428	1/4-28	3/8-16	.375	Q	3/8-16	.437	500-3
319-524	5/16-24	7/16-14	.437	X	7/16-14	.500	500-4
319-624	3/8-24	1/2-13	.500	29/64	1/2-13	.560	500-5
319-720	7/16-20	9/16-12	.560	33/64	9/16-12	.620	500-6
319-820	1/2-20	5/8-11	.620	37/64	5/8-11	.680	500-7

EXTRA HEAVY WALL — COARSE THREAD SIZES

EZ-LOK Part No.	Internal Thread	External Thread	Length in.	Tap Drill Size	Tap Size	Minimum Full Thread Depth	Drive Tool Catalog No.
335-4	1/4-20	1/2-13	.484	27/64	1/2-13	9/16	500-3
335-5	5/16-18	9/16-12	.515	31/64	9/16-12	19/32	500-4
335-6	3/8-16	5/8-11	.656	17/32	5/8-11	23/32	500-5
335-8	1/2-13	7/8-9	.687	49/64	7/8-9	13/16	—
335-10	5/8-11	1-8	.781	7/8	1-8	7/8	—

METRIC THREAD SIZES — METRIC INTERNAL/METRIC EXTERNAL

EZ-LOK Part No.	Internal Thread	External Thread	Length	Tap Drill Size	Tap Size	Minimum Full Thread Depth	Drive Tool Catalog No.
450-3	M3-0.5	M6-1.0	6.5mm	5.1mm	M6-1.0	7.8mm	—
450-4	M4-0.7	M8-1.25	7.5mm	6.9mm	M8-1.25	9.0mm	500-1
450-5	M5-0.8	M8-1.25	7.5mm	6.9mm	M8-1.25	9.0mm	500-1
450-6	M6-1.0	M10-1.5	10.5mm	8.6mm	M10-1.5	12.0mm	500-3
450-8	M8-1.25	M12-1.75	12.5mm	10.4mm	M12-1.75	14.5mm	500-4
450-10	M10-1.5	M16-2.0	17.0mm	14.0mm	M16-2.0	19.0mm	500-5
450-12	M12-1.75	M16-2.0	17.0mm	14.0mm	M16-2.0	19.0mm	500-6
450-16	M16-2.0	M24-3.0	20.0mm	21.0mm	M24-3.0	24.0mm	500-8
450-20	M20-2.5	M36-4.0	30.0mm	33.0mm	M36-4.0	35.0mm	—

METRIC THREAD SIZES — U.S. INTERNAL/METRIC EXTERNAL

EZ-LOK Part No.	Internal Thread	External Thread	Length	Tap Drill Size	Tap Size	Minimum Full Thread Depth	Drive Tool Catalog No.
550-006	6-32	M6-1.0	6.5 mm	5.1mm	M6-1.0	7.8mm	—
550-008	8-32	M8-1.25	7.5 mm	6.9mm	M8-1.25	9.0mm	500-1
550-1024	10-24	M8-1.25	7.5 mm	6.9mm	M8-1.25	12.0mm	500-2
550-1032	10-32	M8-1.25	7.5 mm	6.9mm	M8-1.25	12.0mm	500-2
550-1420	1/4-20	M10-1.5	10.5 mm	8.6mm	M10-1.5	14.5mm	500-3
550-5	5/16-18	M12-1.75	12.5 mm	10.4mm	M12-1.75	14.5mm	500-4
550-6	3/8-16	M16-2.0	17.0 mm	14.0mm	M16-2.0	19.0mm	500-5
550-8	1/2-13	M16-2.0	17.0 mm	14.0mm	M16-2.0	19.0mm	500-7

METRIC THREAD SIZES — METRIC INTERNAL/U.S. EXTERNAL

EZ-LOK Part No.	Internal Thread	External Thread	Length	Tap Drill Size	Tap Size	Minimum Full Thread Depth	Drive Tool Catalog No.
650-6	M6-1.0	3/8-16	.406	5/16	3/8-16	15/32	500-3
650-8	M8-1.25	1/2-13	.484	27/64	1/2-13	9/16	500-4
65010	M10-1.50	9/16-12	.515	31/64	9/16-12	19/32	500-5
650-10F	M10-1.25	9/16-12	.515	31/64	9/16-12	19/32	500-5
650-12	M12-1.75	3/4-10	.656	21/32	3/4-10	3/4	500-6
650-14	M14-2.0	7/8-9	.687	49/64	7/8-9	13/16	500-7
650-16	M16-2.0	1-8	.781	7/8	1-8	7-8	500-8

AUTOMOTIVE DESIGNS

EZ-LOK Part No.	Internal Thread	External Thread	Length	Tap Drill Size	Tap Size	
SPARK PLUG SIZES						
329-1008	M10-1.0	9/16-18	.453	33/64	9/16-18	
329-1208	M12-1.25	5/8-18	.453	37/64	5/8-18	
329-1212	M12-1.25	5/8-18	.703	37/64	5/8-18	
750-14	M14-1.25	M18-1.5	11.5mm	16.5mm	M18-1.5	
329-1406	M14-1.25	3/4-16	.328	11/16	3/4-16	
329-1408	M14-1.25	3/4-16	.453	11/16	3/4-16	
329-1412	M14-1.25	3/4-16	.703	11/16	3/4-16	
329-1808	M18-1.5	1-12	.453	59/64	1-12	
VW CASE SAVERS						
330-10 (Open)	M10-1.50	9/16-12	1.000	31/64	9/16-12	
330-11 (Closed)	M10-1.50	9/16-12	1.000	31/64	9/16-12	

COARSE THREAD SIZES IN STAINLESS STEEL

EZ-LOK Part No.	Internal Thread	External Thread	Length in.	Tap Drill Size	Tap Size	Minimum Full Thread Depth	Drive Tool Catalog No.
303-004	4-40	10-32	.250	5/32	10-32	9/32	—
303-006	6-32	1/4-20	.280	7	1/4-20	11/32	—
303-008	8-32	5/16-18	.290	F	5/16-18	7/16	500-1
303-3	10-24	3/8-16	.406	5/16	3/8-16	15/32	500-2
303-4	1/4-20	7/16-14	.437	23/64	7/16-14	1/2	500-3
303-5	5/16-18	1/2-13	.484	27/64	1/2-13	9/16	500-4
303-6	3/8-16	9/16-12	.515	31/64	9/16-12	19/32	500-5
303-7	7/16-14	5/8-11	.656	17/32	5/8-11	23/32	500-6
303-8	1/2-13	3/4-10	.656	21/32	3/4-10	3/4	500-7
303-10	5/8-11	7/8-9	.687	49/64	7/8-9	13/16	500-8
303-12	3/4-10	1-8	.781	7/8	1-8	7/8	500-9

FINE THREAD SIZES IN STAINLESS STEEL

EZ-LOK Part No.	Internal Thread	External Thread	Length in.	Tap Drill Size	Tap Size	Minimum Full Thread Depth	Drive Tool Catalog No.
303-332	10-32	3/8-16	.406	5/16	3/8-16	15/32	500-2
303-428	1/4-28	7/16-14	.437	23/64	7/16-14	1/2	500-3
303-524	5/16-24	1/2-13	.484	27/64	1/2-13	9/16	500-4
303-624	3/8-24	9/16-12	.515	31/64	9/16-12	19/32	500-5
303-720	7/16-20	5/8-11	.656	17/32	5/8-11	23/32	500-6
303-820	1/2-20	3/4-10	.656	21/32	3/4-10	3/4	500-7

METRIC THREAD SIZES IN STAINLESS STEEL — METRIC INTERNAL/METRIC EXTERNAL

EZ-LOK Part No.	Internal Thread	External Thread	Length	Tap Drill Size	Tap Size	Minimum Full Thread Depth	Drive Tool Catalog No.
453-3	M3-0.5	M6-1.0	6.5mm	5.1mm	M6-1.0	7.8mm	—
453-4	M4-0.7	M8-1.25	7.5mm	6.9mm	M8-1.25	9.0mm	500-1
453-5	M5-0.8	M8-1.25	7.5mm	6.9mm	M8-1.25	9.0mm	500-1
453-6	M6-1.0	M10-1.5	10.5mm	8.6mm	M10-1.5	12.0mm	500-3
453-8	M8-1.25	M12-1.75	12.5mm	10.4mm	M12-1.75	14.5mm	500-4
453-10	M10-1.5	M16-2.0	17.0mm	14.0mm	M16-2.0	19.0mm	500-5
453-12	M12-1.75	M16-2.0	17.0mm	14.0mm	M16-2.0	19.0mm	500-6
453-16	M16-2.0	M24-3.0	20.0mm	21.0mm	M24-3.0	24.0mm	500-8

METRIC THREAD SIZES IN STAINLESS STEEL — METRIC INTERNAL/U.S. EXTERNAL

EZ-LOK Part No.	Internal Thread	External Thread	Length	Tap Drill Size	Tap Size	Minimum Full Thread Depth	Drive Tool Catalog No.
653-6	M6-1.0	3/8-16	.406	5/16	3/8-16	15/32	500-3
653-8	M8-1.25	1/2-13	.484	27/64	1/2-13	9/16	500-4
653-10	M10-1.50	9/16-12	.515	31/64	9/16-12	19/32	500-5
653-10F	M10-1.25	9/16-12	.515	31/64	9/16-12	19/32	500-5
653-12	M12-1.75	3/4-10	.656	21/32	3/4-10	3/4	500-6
653-14	M14-2.0	7/8-9	.687	49/64	7/8-9	13/16	500-7
653-16	M16-2.0	1-8	.781	7/8	1-8	7/8	500-8

INSTALLATION VIDEO



VISIT OUR WEBSITE AT WWW.EZLOK.COM TO VIEW A VIDEO DEMONSTRATING THE EASY 1-2-3 INSTALLATION OF E-Z LOK THREADED INSERTS



Prepackaged kits containing a range of sizes are available.

Note: Because E-Z LOK inserts install with standard tools, our kits contain only inserts. Drills and taps are not included.

CARBON STEEL THREAD INSERTS FOR METAL

Kit Type	Kit Number	Quantity of Inserts	Insert Part Number	Internal Thread	External Thread
Coarse Thread #10 to 7/16"	EZ C107	10	329-3	10-24	3/8-16
		10	329-4	1/4-20	7/16-14
		10	329-5	5/16-18	1/2-13
		10	329-6	3/8-16	9/16-12
		8	329-7	7/16-14	5/8-11
Coarse Thread #10 to 1/2"	EZ C108	10	329-3	10-24	3/8-16
		10	329-4	1/4-20	7/16-14
		10	329-5	5/16-18	1/2-13
		10	329-6	3/8-16	9/16-12
		6	329-8	1/2-13	3/4-10
Coarse Thread 1/2" to 1"	EZ C816	6	329-8	1/2-13	3/4-10
		7	329-10	5/8-11	7/8-9
		7	329-12	3/4-10	1-8
		2	329-16	1-8	1-3/8-12
Fine Thread #10 to 7/16"	EZ F107	10	329-332	10-32	3/8-16
		10	329-428	1/4-28	7/16-14
		10	329-524	5/16-24	1/2-13
		10	329-624	3/8-24	9/16-12
		8	329-720	7/16-20	5/8-11
Fine Thread #10 to 1/2"	EZ F108	10	329-332	10-32	3/8-16
		10	329-428	1/4-28	7/16-14
		10	329-524	5/16-24	1/2-13
		10	329-624	3/8-24	9/16-12
		6	329-820	1/2-20	3/4-10
		6	329-820	1/2-20	3/4-10
Fine Thread 1/2" to 1"	EZ F816	7	329-820	1/2-20	3/4-10
		7	329-10F	5/8-18	7/8-9
		7	329-1216	3/4-16	1-8
		2	329-1614	1-14	1-3/8-12

CARBON STEEL THREAD INSERTS FOR METAL — METRIC

Kit Type	Kit Number	Quantity of Inserts	Insert Part Number	Internal Thread	External Thread
M3-0.5 to M8-1.25	EZ M100	10	450-3	M3-0.5	M6-1.0
		10	450-4	M4-0.7	M8-1.25
		10	450-5	M5-0.8	M8-1.25
		10	450-6	M6-1.0	M10-1.5
		10	450-8	M8-1.25	M12-1.75
M8-1.25 to M16-2.0	EZ M200	10	450-8	M8-1.25	M12-1.75
		10	450-10	M10-1.5	M16-2.0
		8	450-12	M12-1.75	M16-2.0
		5	450-16	M16-2.0	M24-3.0
		10	550-3	10-24	M10-1.5
Coarse Thread #10 to 1/2"	EZ M508	10	550-4	1/4-20	M12-1.75
		10	550-5	5/16-18	M12-1.75
		10	550-6	3/8-16	M16-2.0
		6	550-8	1/2-13	M16-2.0
		10	650-6	M6-1.0	3/8-16
Metric Thread M6 to M12	EZ M612	10	650-8	M8-1.25	1/2-13
		10	650-10	M10-1.5	9/16-12
		6	650-12	M12-1.75	3/4-10

STAINLESS STEEL THREAD INSERTS FOR METAL

Kit Type	Kit Number	Quantity of Inserts	Insert Part Number	Internal Thread	External Thread
Coarse Thread 303 Stainless #10 to 1/2"	EZ C303	10	303-3	10-24	3/8-16
		10	303-4	1/4-20	7/16-14
		10	303-5	5/16-18	1/2-13
		10	303-6	3/8-16	9/16-12
		6	303-8	1/2-13	3/4-10
Fine Thread 303 Stainless #10 to 1/2"	EZ F303	10	303-332	10-32	3/8-16
		10	303-428	1/4-28	7/16-14
		10	303-524	5/16-24	1/2-13
		10	303-624	3/8-24	9/16-12
		6	303-820	1/2-20	3/4-10
M3-0.5 to M8-1.25	EZ M103	10	453-3	M3-0.5	M6-1.0
		10	453-4	M4-0.7	M8-1.25
		10	453-5	M5-0.8	M8-1.25
		10	453-6	M6-1.0	M10-1.5
		10	453-8	M8-1.25	M12-1.75
M8-1.25 to M16-2.0	EZ M203	10	453-8	M8-1.25	M12-1.75
		10	453-10	M10-1.5	M16-2.0
		8	453-12	M12-1.75	M16-2.0
		5	453-16	M16-2.0	M24-3.0
		10	653-6	M6-1.0	3/8-16
Metric Thread M6 to M12	EZ M613	10	653-8	M8-1.25	1/2-13
		10	653-10	M10-1.5	9/16-12
		6	653-12	M12-1.75	3/4-10

ULTRASONIC INSERTS—TAPERED

DESIGNED FOR USE IN THERMOPLASTICS

- TAPERED DESIGN REDUCES INSTALLATION TIME
- INSTALL ULTRASONICALLY OR WITH HEAT DRIVER
- SUPERIOR TORQUE/PULL OUT RESISTANCE
- UNC AND METRIC THREADS
- SINGLE AND DOUBLE VANE



TAPERED SINGLE VANE

Part Number.	Internal Thread	Overall Length (L)	Insert Diameter (W)	Pilot Diameter (N)	Rec. Hole Size* (D)	Rec. Hole Size* (S)	Minimum Wall Thickness
TH-002-SV	2-56	.115	.136	.122	.123	.118	.080
TH-004-SV	4-40	.135	.172	.157	.159	.153	.093
TH-006-SV	6-32	.150	.220	.203	.206	.199	.116
TH-008-SV	8-32	.185	.250	.230	.234	.226	.133
TH-124-SV	10-24	.225	.296	.272	.277	.267	.159
TH-132-SV	10-32	.225	.296	.272	.277	.267	.159
TH-420-SV	1/4-20	.300	.375	.354	.363	.349	.194
TH-428-SV	1/4-28	.300	.375	.354	.363	.349	.194
TH-518-SV	5/16-18	.335	.469	.439	.448	.431	.245
TH-316-SV	3/8-16	.375	.563	.530	.540	.523	.293
TH-324-SV	3/8-24	.375	.563	.530	.540	.523	.293
TH-M25-SV	M2.5-0.4	.135	.172	.157	.159	.153	.093
TH-M30-SV	M3-0.5	.150	.220	.203	.206	.199	.116
TH-M40-SV	M4-0.7	.185	.250	.230	.234	.226	.133
TH-M50-SV	M5-0.8	.265	.328	.308	.315	.303	.171
TH-M60-SV	M6-1.0	.300	.375	.354	.363	.349	.194

* Hole size requirements may vary depending on a number of factors, including material and tools. We recommend that you test your particular application before ordering. We gladly supply free samples.

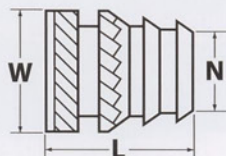
TAPERED DOUBLE VANE

Part Number.	Internal Thread	Overall Length (L)	Insert Diameter (W)	Pilot Diameter (N)	Rec. Hole Size* (D)	Rec. Hole Size* (S)	Minimum Wall Thickness
DV-002-TH	2-56	.188	.136	.115	.123	.107	.080
DV-004-TH	4-40	.219	.172	.144	.159	.141	.093
DV-006-TH	6-32	.250	.220	.190	.206	.185	.116
DV-008-TH	8-32	.312	.250	.212	.234	.208	.133
DV-124-TH	10-24	.375	.297	.251	.277	.246	.159
DV-132-TH	10-32	.375	.297	.251	.277	.246	.159
DV-420-TH	1/4-20	.500	.375	.332	.363	.321	.194
DV-428-TH	1/4-28	.500	.375	.332	.363	.321	.194
DV-518-TH	5/16-18	.562	.469	.406	.448	.401	.245
DV-316-TH	3/8-16	.625	.563	.493	.540	.488	.293
DV-M25-TH	M2.5-0.4	.219	.172	.144	.159	.141	.093
DV-M30-TH	M3-0.5	.250	.220	.190	.206	.185	.116
DV-M40-TH	M4-0.7	.312	.250	.212	.234	.208	.133
DV-M50-TH	M5-0.8	.438	.328	.283	.315	.278	.171
DV-M60-TH	M6-1.0	.500	.375	.332	.363	.321	.194

* Hole size requirements may vary depending on a number of factors, including material and tools. We recommend that you test your particular application before ordering. We gladly supply free samples.

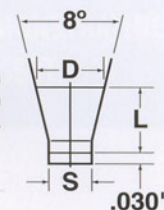


Single Vane



Double Vane

Hole depth should be a minimum of .030" greater than the length of the insert in blind holes.



ULTRASONIC INSERTS—STRAIGHT

DESIGNED FOR USE IN THERMOPLASTICS

- STRAIGHT DESIGN PERMITS THINNER BOSS WALLS
- INSTALL ULTRASONICALLY OR WITH HEAT DRIVER
- SUPERIOR TORQUE/PULL OUT RESISTANCE
- FLUSH AND FLANGED DESIGNS



STRAIGHT FLUSH

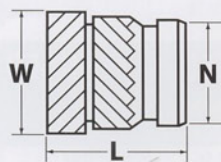
Part Number.	Internal Thread	Overall Length (L)	Insert Diameter (W)	Head Diameter (H)	Pilot Diameter (N)	Rec. Hole Size*	Minimum Wall Thickness
HI-002-WH	2-56	.157	.141	N/A	.123	.126	.051
HI-004-WH	4-40	.226	.181	N/A	.154	.157	.063
HI-006-WH	6-32	.281	.214	N/A	.185	.189	.071
HI-008-WH	8-32	.321	.248	N/A	.218	.220	.083
HI-124-WH	10-24	.375	.278	N/A	.249	.252	.102
HI-132-WH	10-32	.375	.278	N/A	.249	.252	.102
HI-420-WH	1/4-20	.500	.341	N/A	.312	.315	.130
HI-428-WH	1/4-28	.500	.341	N/A	.312	.315	.130
HI-518-WH	5/16-18	.500	.403	N/A	.374	.378	.177
HI-524-WH	5/16-24	.500	.403	N/A	.374	.378	.177
HI-316-WH	3/8-16	.500	.494	N/A	.465	.469	.236
HI-324-WH	3/8-24	.500	.494	N/A	.465	.469	.236

* Hole size requirements may vary depending on a number of factors, including material and tools. We recommend that you test your particular application before ordering. We gladly supply free samples. ."

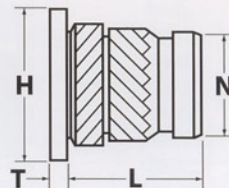
STRAIGHT FLANGED

Part Number.	Internal Thread	Overall Length (L+T)	Insert Diameter (W)	Head Diameter (H)	Pilot Diameter (N)	Rec. Hole Size*	Minimum Wall Thickness
FL-256-HI	2-56	.178	.141	.187	.123	.126	.051
FL-440-HI	4-40	.250	.181	.218	.154	.157	.063
FL-632-HI	6-32	.311	.214	.250	.185	.189	.071
FL-832-HI	8-32	.357	.248	.281	.218	.220	.083
FL-124-HI	10-24	.418	.278	.312	.249	.252	.102
FL-132-HI	10-32	.418	.278	.312	.249	.252	.102
FL-420-HI	1/4-20	.553	.341	.375	.312	.315	.130
FL-428-HI	1/4-28	.553	.341	.375	.312	.315	.130
FL-518-HI	5/16-18	.553	.403	.437	.374	.378	.177
FL316-HI	3/8-16	.563	.494	.551	.465	.469	.236

* Hole size requirements may vary depending on a number of factors, including material and tools. We recommend that you test your particular application before ordering. We gladly supply free samples.



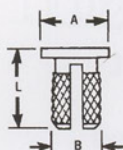
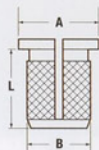
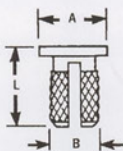
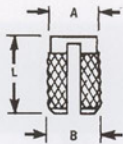
Flush



Flanged

FOR CORED OR DRILLED HOLES IN PLASTIC

Diamond-knurled press inserts are designed to replace molded-in inserts and threads in thermoset plastics.



- INSTALL COLD
- SHARPLY REDUCE THE COST OF MOLDINGS
- CUT REJECT WASTE CAUSED BY MISALIGNED AND FAULTY INSERTS
- ELIMINATE THE NEED TO "CHASE" THREADS AFTER MOLDING
- INSTALL PROPERLY WITHOUT A PRECISE HOLE DEPTH

BRASS — FLUSH

EZ-LOK Part No.	Internal Thread	A ±.010"	B ±.010"	L ±.010"	Starting Hole Size*
240-000-BR	0-80	.094	.104	.125	.094 (3/32)
240-002-BR	2-56	.125	.135	.156	.125 (1/8)
240-004-BR	4-40	.156	.166	.188	.156 (5/32)
240-006-BR	6-32	.187	.199	.250	.188 (3/16)
240-008-BR.250	8-32	.218	.230	.250	.219 (7/32)
240-008-BR	8-32	.218	.230	.313	.219 (7/32)
240-332-BR.250	10-32	.250	.262	.250	.250 (1/4)
240-332-BR	10-32	.250	.262	.375	.250 (1/4)
240-3-BR	10-24	.250	.262	.375	.250 (1/4)
240-4-BR	1/4-20	.312	.326	.500	.313 (5/16)
240-5-BR	5/16-18	.375	.389	.563	.375 (3/8)
240-6-BR	3/8-16	.437	.451	.625	.438 (7/16)
240-M3-BR	M3-0.5	.156	.166	.188	.156 (5/32)
240-M3.5-BR	M3.5-0.6	.187	.199	.250	.188 (3/16)
240-M4-BR	M4-0.7	.218	.230	.313	.219 (7/32)
240-M5-BR	M5-0.8	.250	.262	.375	.250 (1/4)
240-M6-BR	M6-1.0	.312	.326	.500	.313 (5/16)

BRASS — FLANGED

EZ-LOK Part No.	Internal Thread	A ±.010"	B ±.010"	L ±.010"	Starting Hole Size*
260-002-BR	2-56	.187	.135	.156	.125 (1/8)
260-004-BR	4-40	.218	.166	.188	.156 (5/32)
260-006-BR	6-32	.249	.199	.250	.188 (3/16)
260-008-BR	8-32	.280	.230	.313	.219 (7/32)
260-332-BR	10-32	.312	.262	.375	.250 (1/4)
260-4-BR	1/4-20	.375	.326	.500	.313 (5/16)
260-5-BR	5/16-18	.437	.389	.563	.375 (3/8)
260-6-BR	3/8-16	.500	.451	.625	.438 (7/16)

BRASS — FLANGED — REVERSED SLOT

EZ-LOK Part No.	Internal Thread	A ±.010"	B ±.010"	L ±.010"	Starting Hole Size*
260-002-RS	2-56	.187	.135	.156	.125 (1/8)
260-004-RS	4-40	.218	.166	.188	.156 (5/32)
260-006-RS	6-32	.249	.199	.250	.188 (3/16)
260-008-RS	8-32	.280	.230	.313	.219 (7/32)
260-332-RS	10-32	.312	.262	.375	.250 (1/4)
260-4-RS	1/4-20	.375	.326	.500	.313 (5/16)

STAINLESS STEEL — FLUSH

EZ-LOK Part No.	Internal Thread	A ±.010"	B ±.010"	L ±.010"	Starting Hole Size*
240-002-CR	2-56	.125	.135	.156	.125 (1/8)
240-004-CR	4-40	.156	.166	.188	.156 (5/32)
240-006-CR	6-32	.187	.199	.250	.188 (3/16)
240-008-CR	8-32	.218	.230	.313	.219 (7/32)
240-332-CR	10-32	.250	.262	.375	.250 (1/4)
240-4-CR	1/4-20	.312	.326	.500	.313 (5/16)
240-5-CR	5/16-18	.375	.389	.563	.375 (3/8)
240-6-CR	3/8-16	.437	.451	.625	.438 (7/16)

STAINLESS STEEL — FLANGED

EZ-LOK Part No.	Internal Thread	A ±.010"	B ±.010"	L ±.010"	Starting Hole Size*
260-002-CR	2-56	.187	.135	.156	.125 (1/8)
260-004-CR	4-40	.218	.166	.188	.156 (5/32)
260-006-CR	6-32	.249	.199	.250	.188 (3/16)
260-008-CR	8-32	.280	.230	.313	.219 (7/32)
260-332-CR	10-32	.312	.262	.375	.250 (1/4)
260-4-CR	1/4-20	.375	.326	.500	.313 (5/16)

* Hole size requirements may vary depending on a number of factors, including material and tools. We recommend that you test your particular application before ordering. We gladly supply free samples.



External knife threads provide superior holding power in hard and soft woods, particle board and all wood products. Use wherever field assembly or disassembly could lead to thread erosion or stripping. The long pilot ensures straight driving into a drilled hole. Install with screwdriver, bolt and nut, tapping head, or E-Z LOK driving tool.



BRASS KNIFE THREAD INSERTS — FOR HARD WOOD

EZ-LOK Part No.	Internal Thread	Length	Major Diameter External Thread	Hole* Size	Drive Tool Catalog Number
400-004	4-40	.375	.350	1/4"	—
400-006	6-32	.375	.350	1/4"	500-006
400-008	8-32	.375	.350	1/4"	500-1
400-3	10-24	.500	.453	3/8"	500-2
400-332	10-32	.500	.453	3/8"	500-2
400-4	1/4-20	.500	.453	3/8"	500-3
400-428	1/4-28	.500	.453	3/8"	500-3
400-5	5/16-18	.625	.600	1/2"	500-4
400-524	5/16-24	.625	.600	1/2"	500-4
400-6	3/8-16	.625	.600	1/2"	500-5
400-624	3/8-24	.625	.600	1/2"	500-5
400-M3	M3-0.5	.375	.350	1/4"	500-006
400-M4	M4-0.7	.375	.350	1/4"	500-1
400-M5	M5-0.8	.500	.453	3/8"	500-2
400-M6	M6-1.0	.500	.453	3/8"	500-3
400-M8	M8-1.25	.625	.600	1/2"	500-4

STAINLESS STEEL KNIFE THREAD INSERTS — FOR WOOD

EZ-LOK Part No.	Internal Thread	Length	Major Diameter External Thread	Hole* Size	Drive Tool Catalog Number
400-008-CR	8-32	.375	.350	1/4"	500-1
400-3-CR	10-24	.500	.453	3/8"	500-2
400-4-CR	1/4-20	.500	.453	3/8"	500-3

*Hole size requirements may vary depending on material and tools. We recommend that you test before ordering. We gladly supply free samples.



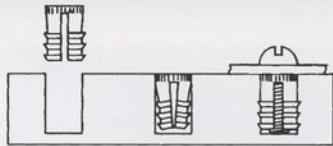
DIE CAST HEX DRIVE THREAD INSERTS — FOR SOFT WOOD/MDF/PARTICLE BOARD

EZ-LOK Part No.	Design	Internal Thread	Length	Hole* Size	Hex Dimensions	Drive Tool Catalog Number
800832-10	Flush	8-32	10mm	6mm	M4	8500
801024-13	Flush	10-24	13mm	7mm	M5	8600
801032-13	Flush	10-32	13mm	7mm	M5	8600
801420-13	Flush	1/4-20	13mm	9mm	M6	9000
801420-20	Flush	1/4-20	20mm	9mm	M6	9000
851618-20	Flush	5/16-18	20mm	11mm	M8	9100
851618-25	Flush	5/16-18	25mm	11mm	M8	9100
800610-13	Flush	M6-1.0	13mm	9mm	M6	9000
800610-20	Flush	M6-1.0	20mm	9mm	M6	9000
808125-13	Flush	M8-1.25	13mm	11mm	M8	9100
808125-20	Flush	M8-1.25	20mm	11mm	M8	9100
900832-10	Flanged	8-32	10mm	6mm	M4	8500
901024-11	Flanged	10-24	11mm	7mm	M5	8600
901024-20	Flanged	10-24	20mm	7mm	M5	8600
901032-11	Flanged	10-32	11mm	7mm	M5	8600
901032-13	Flanged	10-32	13mm	7mm	M5	8600
901032-20	Flanged	10-32	20mm	7mm	M5	8600
901420-13	Flanged	1/4-20	13mm	9mm	M6	9000
901420-20	Flanged	1/4-20	20mm	9mm	M6	9000
901420-25	Flanged	1/4-20	25mm	9mm	M6	9000
951618-13	Flanged	5/16-18	13mm	11mm	M8	9100
951618-25	Flanged	5/16-18	25mm	11mm	M8	9100
903816-13	Flanged	3/8-16	13mm	12mm	M10	9200
903816-25	Flanged	3/8-16	25mm	12mm	M10	9200
900610-13	Flanged	M6-1.0	13mm	9mm	M6	9000
900610-20	Flanged	M6-1.0	20mm	9mm	M6	9000
908125-13	Flanged	M8-1.25	13mm	11mm	M8	9100
908125-20	Flanged	M8-1.25	20mm	11mm	M8	9100

*Hole size requirements may vary depending on material and tools. We recommend that you test before ordering. We gladly supply free samples.

An inexpensive insert for use in ready-to-assemble furniture, drawer pulls and wherever ease of assembly or avoidance of thread stripping is desired. Install with hex drive wrench or E-Z LOK drive tool.





Finseats provide strong metal threads in wood, composition board and thermoplastics such as nylon, polystyrene, cellulose acetate and cyclocac. By distributing stress over a greater surface area, firm permanent fastening is ensured. The fins give higher holding strength in softer materials. Available with one, two or three fins for varying material thickness, Finseats prevent splintering, splitting and thread pullout.

		170 SERIES 170-006, 170-008, 170-332				270 SERIES 270-006, 270-008, 270-332, 270-3, 270-4				370 SERIES 370-332, 370-4, 370-5			
Thread Size	Dash Number	A	B	C	Starting Hole Size	A	B	C	Starting Hole Size	A	B	C	Starting Hole Size
6-32	—006	.210	.237	.189	.205 (#5)	.210	.237	.189	.205 (#5)	—	—	—	—
8-32	—008	.236	.263	.215	.234 (15/64)	.236	.263	.215	.234 (15/64)	—	—	—	—
10-32	—332	.263	.290	.242	.261 (G)	.263	.290	.242	.261 (G)	.347	.368	.318	.344 (11/32)
10-24	—3	—	—	—	—	.263	.290	.242	.261 (G)	—	—	—	—
1/4-20	—4	—	—	—	—	.330	.357	.309	.328 (21/64)	.409	.431	.381	.406 (13/32)
5/16-18	—5	—	—	—	—	—	—	—	—	.471	.493	.443	.469 (15/32)



THREAD KITS Co. INDUSTRIAL PRODUCT CATALOG



- **Perma-Coil® Helically Coiled Inserts**
- **Perma-Coil® Thread Repair Kits**
- **S.T.I. Taps & Tooling**
- **Tangless® Inserts**
- **Perma-Kee Solid Inserts**
- **Time-Sert®**
- **Perma-Rivet**

IND2014



THREAD KITS CO.

Founded in 1984, Thread Kits Company is a leading global manufacturer and supplier of quality thread repair products for nearly 30 years. Our original product —Perma-Coil—is a registered trademark name in the U.S. and several foreign countries, and has become a recognized name in the automotive, industrial, aerospace and production rebuilder industries.

At Thread Kits Company , we pride ourselves on producing a quality product, with prompt, courteous service and providing Our customers with reasonable prices.

Perma-Coil® Inserts



TANGED INSERTS

- **Meets or exceeds all applicable military, aerospace and commercial standards**
- **Complete range of unified and metric sizes, locking and free-running, bulk and strip feed**
- **Minimize thread wear**
- **Reduce installed costs**
- **Quality and Reliability**



Helically- coiled Perma-Coil® Inserts are coiled from 304 stainless steel wire with a diamond-shaped cross section to create a precision screw thread. Designed to be slightly oversized in diameter, they compress as they are inserted into the prepared hole to achieve maximum surface contact with parent thread. Each coil automatically adjusts to create maximum contact with each individual thread members, This combination of tension and friction securely grips the wall of the parent material providing a strong permanent thread.

Strong, lightweight and highly wear resistant, Perma-Coil inserts are available in Locking or Free-Running form. Selections include unified coarse, fine threads, metric inserts, spark plug and pipe thread, in bulk or strip feed reels.



INSERT MATERIALS:

- ⇒ **304 Stainless Steel** (standard) satisfies most application requirements for strength corrosion resistance and temperature capability per AS7245 spec for normal applications to 800°F.
- ⇒ **Phosphor Bronze** is ideal for salt water applications and has superior corrosion resistance per AS7247 spec.
- ⇒ **Inconel-750** is for higher temperature capability and reliability applications. Environments up to 1000°F per AS7246 spec.
- ⇒ **Other Materials Available**, please inquire.

PLATINGS AND COATINGS:

- * **Dry Film Lubricant** per AS5272.
- * **Silver** per AMS2410,2411 or 2412.
- * **Cadium** per AMS-QQ-P416
- * **Coatings** available please inquire.

Perma-Coil® Thread Repair Kit & Combo Kit



Perma-Coil® Kits contain all the necessary tools to repair stripped, worn or damaged threads. Our Inserts are designed and Perma-Coil kits are available in inch, metric, spark plug and pipe thread series. All kits have a quantity of inserts, high quality carbon steel tap and an metal threaded installation tool. Kit is also available as a combo kit offering a high speed steel tap as part of the combo.



HIGH SPEED STEEL S.T.I. TAP

Perma-Coil® S.T.I. Taps

STRAIGHT FLUTE PLUG



BOTTOMING



SPIRAL POINT PLUG



SPIRAL FLUTE BOTTOM-



Perma-Coil S.T.I. (Screw Thread Insert) Taps are designed specifically to create internal threads that will accommodate a Perma-Coil Insert. Perma-Coil S.T.I. Taps can be used in a range of materials including aluminum, magnesium, steel, plastics and other matters. Kit taps are available in high quality carbon steel as well as high speed steel. High speed steel taps are available in four styles.





Perma-Coil® Tooling

Manual Tools



KIT TOOL



TANG BREAK-OFF

Perma-Coil® offer a complete line of tooling, gages , tang-break-off tools and extracting tools.. For production runs, prototype work, salvage and repair to complete the needs for your application.



THREAD GAGE



EXTRACTING TOOL



HAND INSTALLTION TOOL

Power Tools



FRONT END ASSEMBLY

For higher volume production, we offer Electric & Pneumatic power to



ELECTRIC MANDREL



PNEUMATIC POWER TOOL



ELECTRONIC POWER INSTALLATION TOOL

Tangless® Inserts & Tooling

Tangless Inserts®



- **FOD-Free Design: No tangs to break off, retrieve or lose.**
- **Approved for use on military programs by NASM8846, NAS1130, and NA0276.**
- **Cost Reduction: Significantly decreases installation and inspection time.**
- **Bi-Directional design eliminates insert orientation requirements.**
- **Quick, non-destructive removal prevents damage to the parent material.**

NASM8846, and were added to NASM8846, the procurement standard for helical coil inserts to give you the option to use the Tangless design on military programs. Paragraph 6.3.1 of NASM8846 states “The decision to select tanged inserts or tangless inserts shall be made by the design activity.”

Tangless® Inserts are designed to replace tanged helical coil inserts as specified in NASM122076 and NASM124651 series (standard thread) and NASM21209 (locking thread); they install in standard STI tapped holes per MS33537. Installed inserts provide a finished thread meeting the requirements of FED-STD H28/2 and accept standard bolts or screws (MIL-S-7742) or UNJ (MIL-S-8879).

TANGLESS® TOOLS

Tangless® Inserts may be installed by hand or power tooling with the same mandrel assembly

- Tooling utilizes a “blade” that applies torque to a notch in the end of the coil of installation
- Installation depth can be adjusted easily for virtually any application.
- Driving blades (pawls) are replaceable and increase the overall life of the tool.(One pawl fits all systems)



*Tangless® is a registered trademark of Advanex Inc.



Perma-KEE SOLID INSERTS



THREAD REPAIR INSERTS



Perma-Kee keylocking threaded inserts are used to quickly repair stripped, damaged or worn out threads. Threaded insert products are also used in original equipment where they strengthen threads in soft metal like magnesium or aluminum.

Our threaded inserts are easy to install and remove. No specialty drills, taps or pre-winder tools are required. The keys are driven down into the threads of the surrounding base material, locking the insert in place.

- Solid, one-piece threaded insert construction provides a high degree of pull-out strength
- Keys supply a positive mechanical lock against rotation

[Easy threaded insert installation and removal](#)

- Installed with standard drills and taps
- No pre-winder tool required
- No tang to break off
- May be used in many types of material

[MS/NAS Style threaded inserts](#) are produced to the following standards:

MS51830	NAS1395	NA0149
MS51831	NA0146	NA0150
MS51832	NA0147	NA0151
MS51394	NA0148	

- Miniature, Lightweight, Heavy Duty and Extra Heavy Duty threaded insert types with Non-locking and Self-locking internal threads
- Full range of Inch and Metric sizes in coarse or fine pitch threads
- Inserts for [specific uses](#) are available in floating, blind end, solid and cast-in configurations.
- [Industrial Style Threaded](#) inserts can be purchased in bulk quantities or kits.



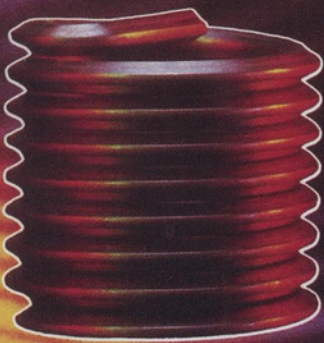
TIME-SERT® PRODUCTS AVAILABLE
PLEASE INQUIRE ABOUT CATALOG



PERMA-RIVET PRODUCTS AVAILABLE
PLEASE INQUIRE ABOUT CATALOG



THREAD KITS CO.



PERMA-COIL[®]

**HELICALLY COILED INSERTS
AND THREAD REPAIR KITS**

PERMA-COIL® Thread Repair Kits, Insert Packs

Perma-Coil® helically coiled inserts are made of stainless steel wire that has been rolled to a carefully controlled thread form. When installed, Perma-Coil® inserts adjust to a tapped hole, becoming a functional thread with a strength exceeding the original.

Perma-Coil® inserts and repair kits are designed to repair stripped threads in a variety of metals. Aluminum, aluminum alloys, steel, and cast iron. If the original threads can be stripped, Perma-Coil® inserts can repair them. By following the detailed instructions enclosed in every Perma-Coil® kit, even an inexperienced do-it-yourselfer can repair stripped threads, permanently.

INSERT PACKS
Thread Repair
Inserts Only



COARSE & METRIC
THREAD REPAIR KITS
Thread Repair Inserts
Tap
Installation Tool

FINE THREAD
REPAIR KITS
Thread Repair Inserts
Tap
Insert Prewinder
Installation Tool



MECHANIC'S MASTER THREAD REPAIR KITS

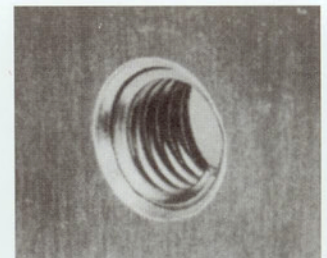
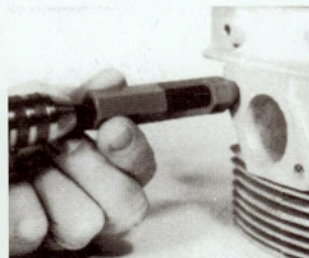
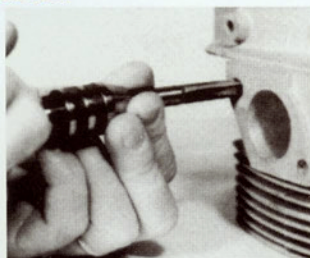
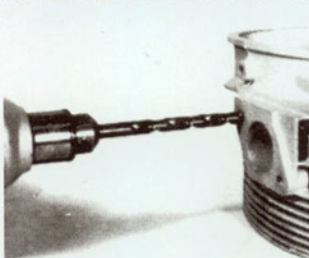
These kits, designed for the professional mechanic, Perma-Coil® contain the most popular sizes used in automotive and light truck applications. Each kit contains 30 Perma-Coil® helically coiled inserts, 5 taps, and 5 installation tools. (Fine thread kits contain 5 pre-winding tools. Metric thread kits contain 3 prewinding tools.)

FINE COARSE METRIC



<p>1208 FMK Mechanic's Master Fine Thread Repair Kit</p>	<p>1208 CMK Mechanic's Master Coarse Thread Repair Kit</p>	<p>1221 MMK Mechanic's Master Metric Thread Repair Kit <i>(Fits most popular European and Japanese metric thread sizes)</i></p>
<p>Thread Size 1/4 - 28 5/16 - 24 3/8 - 24 7/16 - 20 1/2 - 20</p>	<p>Thread Size 1/4 - 20 5/16 - 18 3/8 - 16 7/16 - 14 1/2 - 13</p>	<p>Thread Size 5 x 0.8mm 6 x 1.0mm 8 x 1.25mm 10 x 1.25mm 10 x 1.5mm</p>

THREAD REPAIR MADE EASY



1. Drill out damaged threads.
2. Tap new threads.
3. Install new Perma-Coil® insert. (Prewinding tool shown is used for fine thread applications only.)
4. Remove tang from insert. You now have a permanently repaired thread.

PERMA-PLUG[®]

SPARK PLUG REPAIR KIT

Can Be Used With Taper Seat Or Gasket Type Spark Plugs.

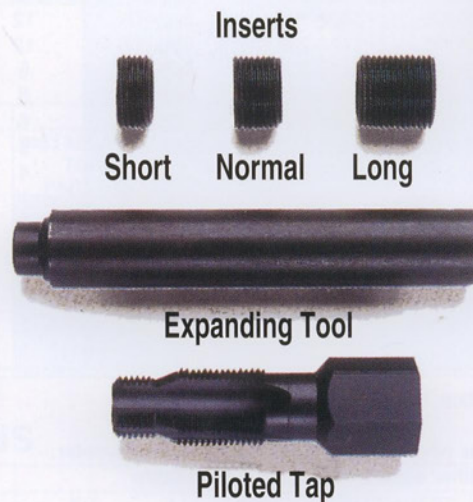


▲ Works in Aluminum and Cast Iron

▲ No Drilling Needed

▲ Easy Installation

▲ Permanent Repair



COMPLETE DISPLAY CENTER: Part No. 1400-1

Display Contents:

Description	Part No.	Qty
M14 - 1.25 Perma Plug Kit	2200 - 14	3
M14 - 1.25 x 3/8" Short Reach Insert	2214 - S	4
M14 - 1.25 x 1/2" Normal Reach Insert	2214 - N	4
M14 - 1.25 x 3/4" Long Reach Insert	2214 - L	4

COMPLETE KIT				KIT CONTENTS AND REPLACEMENT PARTS				
Size	Kit P/N	Reach	Insert Per Kit	Tap P/N	Tool P/N	Reach	Insert Pkg P/N	Insert Qty.
M14 - 1.25	2200 - 14	Short	1			Short	2214 - S	1
		Normal	1	2258 - 14	2294 - 14	Normal	2214 - N	1
		Long	1			Long	2214 - L	1

INDIVIDUAL THREAD REPAIR KITS

INCH SERIES - COARSE

THREAD SIZE	REPAIR KITS*		REPLACEMENT PARTS				BULK INSERTS	DRILL SIZE
	REPAIR KIT* PART NO.	INSERTS PER PACK	KIT TOOL	KIT TAP	PACKAGED** INSERTS	QTY. INSERTS	PERMA-COIL® PART NUMBER	
4-40	1208-014	12	1172-014	1428-014	208-014	12	208 C04-0168	1/8
5-40	1208-015	12	1172-015	1428-015	208-015	12	208 C05-0188	9/64
6-32	1208-016	12	1182-016	1428-016	208-016	12	208 C06-0207	5/32
8-32	1208-018	12	1182-018	1428-018	208-018	12	208 C08-0246	11/64
10-24	1208-101	12	1182-101	1428-101	208-101	12	208 C1-0285	13/64
12-24	1208-102	12	1182-102	1428-102	208-102	12	208 C2-0324	15/64
1/4-20	1208-104	12	1182-104	1428-104	208-104	12	208 C4-0375	17/64
5/16-18	1208-105	12	1182-105	1428-105	208-105	12	208 C5-0469	21/64
3/8-16	1208-106	12	1182-106	1428-106	208-106	12	208 C6-0562	25/64
7/16-14	1208-107	6	1182-107	1428-107	208-107	6	208 C7-0656	29/64
1/2-13	1208-108	6	1182-108	1428-108	208-108	6	208 C8-0750	17/32
9/16-12	1208-109	6	1182-109	1428-109	208-109	6	208 C9-0844	19/32
5/8-11	1208-110	6	1182-110	1428-110	208-110	6	208 C10-0938	21/32
3/4-10	1208-112	4	1182-112	1428-112	208-112	4	208 C12-1125	25/32
7/8-9	3208-C14	6	1182-114	1043-14CP3	108-114	1	208-C14-1312	29/32
1-8	3208-C16	6	1182-116	1043-16CP3	108-116	1	208-C16-1500	1 1/32
1 1/8-7	3208-C18	5	1182-118	1043-18CP3	108-118	1	208 C18-1688	1 11/64
1 1/4-7	3208-C20	4	1182-120	1043-20CP3	108-120	1	208-C20-1875	1 19/64
1 3/8-6	3208-C22	4	1182-122	1043-22CP3	108-122	1	208 C22-2062	1 27/64
1 1/2-6	3208-C24	4	1182-124	1043-24CP3	108-124	1	208 C24-2250	1 35/64

INCH SERIES - FINE

10-32	1208-201	12	1172-201	1428-201	208-201	12	208 F1-0285	13/64
1/4-28	1208-204	12	1172-204	1428-204	208-204	12	208 F4-0375	17/64
5/16-24	1208-205	12	1172-205	1428-205	208-205	12	208 F5-0469	21/64
3/8-24	1208-206	12	1172-206	1428-206	208-206	12	208 F6-0562	25/64
7/16-20	1208-207	6	1172-207	1428-207	208-207	6	208 F7-0656	29/64
1/2-20	1208-208	6	1172-208	1428-208	208-208	6	208 F8-0750	33/64
9/16-18	1208-209	6	1172-209	1428-209	208-209	6	208 F9-0844	37/64
5/8-18	1208-210	6	1172-210	1428-210	208-210	6	208 F10-0938	41/64
3/4-16	1208-212	4	1172-212	1428-212	208-212	4	208 F12-1125	49/64
7/8-14	3208-F14	6	1039-14F	1043-14FP3	108-214	1	208 F14-1312	57/64
1-14	3208-F164	6	1039-164F	1043-164FP3	108-2164	1	208 F164-1500	1 1/64
1-12	3208-F16	6	1039-16F	1043-16FP3	108-216	1	208 F16-1500	1 1/64
1 1/8-12	3208-F18	5	1039-18F	1043-18FP3	108-218	1	208 F18-1688	1 5/32
1 1/4-12	3208-F20	4	1039-20F	1043-20FP3	108-220	1	208 F20-1875	1 9/32
1 3/8-12	3208-F22	4	1039-22F	1043-22FP3	108-222	1	208 F22-2062	1 13/32
1 1/2-12	3208-F24	4	1039-24F	1043-24FP3	108-224	1	208 F24-2250	1 17/32

* Perma-Coil® repair kits include: Inserts, Installation Tool, and Tap

** Perma Coil® insert packs contain inserts only

The above packs and insert bags contain inserts whose length is 1-1/2 times their diameter.

(For example, the 1/4-20 inserts is 3/8" long.) Other sizes and lengths are available

SPARK PLUG SERIES - WIRE TYPE INSERTS

The Perma-Coil® spark plug series includes a full range of individually packaged kits and inserts. They have application in all types of engines and are available in 10, 12, 14, and 18mm sizes. Each kit includes the appropriate reamer/tap and installation tool for all sizes except the 18mm. For the 18mm, you choose the reach and quantity of Perma-Coil® stainless steel inserts required.

Do not use Perma-Coil® wire spark plug inserts to repair taper seat spark plug ports.

THREAD SIZE	REACH	KIT PART NO.	INSERT PER KIT	INSERT PACK PART NO.	INSERTS PER PACK	TAP PART NO.	TOOL PART NO.	BULK INSERT PART NO.
10-1.0mm	1/2"	1210-410*	—	410-500	6	1458-100	1094-100	SP1010-01-0500
12-1.25mm	1/2"	1212-412*	—	412-500	6	1458-123	1094-123	SP1213-01-0500
	3/4"	—	—	412-750	6	—	—	SP1213-01-0750
14-1.25mm	3/8"	1214-414*	—	414-375	6	1458-143	1094-143	SP1413-01-0375
	7/16"	—	—	414-438	6	—	—	SP1413-01-0438
	1/2"	—	—	414-500	6	—	—	SP1413-01-0500
	3/4"	—	—	414-750	6	—	—	SP1413-01-0750
18-1.50mm	1/2"	1218-500	6	418-500	6	1458-185	1094-185	SP1815-01-0500

* NOTE: 10mm, 12mm, and 14mm spark plug kits contain tap and installation tool ONLY - NO inserts in kit.

Purchase packages of inserts separately. Same tools are applicable regardless of insert reach.

METRIC SERIES - COARSE

THREAD SIZE	REPAIR KITS*		REPLACEMENT PARTS				BULK INSERTS	DRILL SIZE
	REPAIR KIT* PART NO.	INSERTS PER PACK	KIT TOOL	KIT TAP	PACKAGED** INSERTS	QTY. INSERTS	PERMA-COIL® PART NUMBER	
M3 X 0.5	1221-303	12	1287-303	1448-303	206-303	12	206 M3C-0045	1/8
M4 X 0.7	1221-304	12	1287-304	1448-304	206-304	12	206 M4C-0060	11/64
M5 X 0.8	1221-305	12	1287-305	1448-305	206-305	12	206 M5C-0075	13/64
M6 X 1	1221-306	12	1287-306	1448-306	206-306	12	206 M6C-0090	1/4
M7 X 1	1221-307	12	1289-307	1448-307	206-307	12	206 M7C-0105	9/32
M8 X 1.25	1221-308	12	1289-308	1448-308	206-308	12	206 M8C-0120	21/64
M9 X 1.25	1221-309	12	1289-309	1448-309	206-309	12	206 M9C-0135	3/8
M10 X 1.5	1221-310	12	1289-310	1448-310	206-310	12	206-M10C-0150	13/32
M11 X 1.5	1221-311	6	1289-311	1448-311	106-311	6	206 M11C-0165	29/64
M12 X 1.75	3221-M12C	6	1289-312	5043-120CP4	106-312	6	206 M12C-0180	31/64
M14 X 2	3221-M14C	6	1289-314	5043-140CP4	106-314	6	206 M14C-0210	37/64
M16 X 2	3221-M16C	6	1289-316	5043-160CP4	106-316	6	206 M16C-0240	21/32
M18 X 2.5	3221-M18C	6	1289-318	5043-180CP4	106-318	6	206 M18C-0270	47/64
M20 X 2.5	3221-M20C	6	1289-320	5043-200CP4	106-320	6	206 M20C-0300	13/16

METRIC SERIES - FINE

M8 X 1.0	1221-M8F	6	1287-608	1448-608	106-608	6	206 M8F-0120	21/64
M10 X 1.0	1221-M1010	6	1287-61010	1448-61010	106-61010	6	206 M1010-0150	13/32
M10 X 1.25	3221-M10F	12	1287-610	1448-610	106-610	12	206 M10F-0150	13/32
M11 X 1.0	1221-M11F	6	1287-611	1448-611	106-611	6	206 M11F-0165	7/16
M11X1.25	1221-M1125	6	1287-61125	1448-61125	106-61125	6	206 M1125-0165	29/64
M12 X 1.25	3221-M12F	6	1287-612	5043-120FP4	106-612	6	206 M12F-0180	31/64
M12 X 1.5	3221-M1215	6	1287-61215	5043-1215FP4	106-61215	6	206 M1215-0180	31/64
M14 X 1.5	3221-M14F	6	1287-614	5043-140FP4	106-614	6	206 M14F-0210	9/16
M16 X 1.5	3221-M16F	6	1287-616	5043-160FP4	106-616	6	206 M16F-0240	21/32

PIPE THREAD SERIES

THREAD SIZE	REPAIR PACKS		REPLACEMENT PARTS				BULK INSERTS	DRILL SIZE
	PIPE THREAD INSERT KIT NO.	INSERTS PER PACK	INSTALLATION TOOL PART NO.	TAP PART NO.	INSERT BAG NO.	INSERTS PER BAG	PERMA-COIL® PART NUMBER	
1/8-27	3218-2	12	1189-2	1188-2P	318-2	12	218-2	3/8
1/4-18	3218-4	12	1189-4	1188-4P	318-4	12	218-4	33/64
3/8-18	3218-6	10	1189-6	1188-6P	318-6	10	218-6	21/32
1/2-14	3218-8	10	1189-8	1188-8P	318-8	10	218-8	13/16
3/4-14	3218-12	10	1189-12	1188-12P	318-12	10	218-12	1 1/64
1-11 1/2	3218-16	6	1189-16	1188-16P	318-16	6	218-16	1 9/32

SPECIAL APPLICATIONS

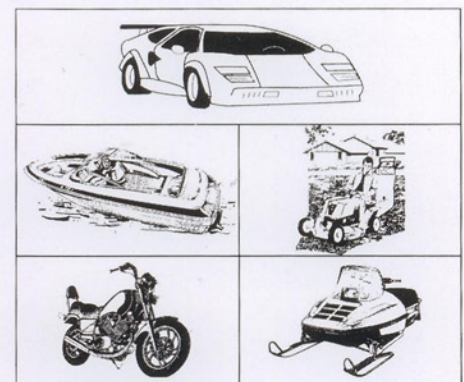
THREAD SIZE	REPAIR KITS*		REPLACEMENT PARTS				BULK INSERTS	DRILL SIZE
	REPAIR KIT* PART NO.	INSERTS PER PACK	KIT TOOL	KIT TAP	PACKAGED** INSERTS	QTY. INSERTS	PERMA-COIL® PART NUMBER	
7/8-20	3208-1420	10	1037-1420	1043-1420P2	208-1420	1	208 1420-0330	57/64
1-20	3208-1620	10	1037-1620	1043-1620P2	208-1620	1	208 1620-0325	1 1/64
11/16-16	3424-1250	9	1424-1	1043-1116	324-1116-1250	3	208 1116-1250	45/64
1/4-24	1208-404	12	1182-404	1428-404	208-404	12	208 424-0500	17/64
3/8-20	1208-406	6	1172-406	1428-406	208-406	6	208 620-0375	25/64

SPECIFICATIONS

Perma-Coil® inserts and tools meet all applicable industrial and military specifications. They may be used on all military and government trucks, aircraft and other vehicles covered by MS 21208 and MS 21209; also NAS 1222 specifications for helically coiled wire inserts.

WHERE?

Use Perma-Coil® Replacement Kits to repair threads on your car, boat, lawn equipment, motorcycle, snowmobile and other recreational vehicles, appliances, plumbing and heating equipment and anywhere metal threads become stripped, crossed or otherwise damaged.





1208-5

COMPLETE DISPLAY CENTER NO. 1208-5 INCH COARSE AND SPARK PLUGS

INCLUDES ONE EACH:

1208-104	1/4-20	REPAIR KIT
1208-105	5/16-18	REPAIR KIT
1208-106	3/8-16	REPAIR KIT
1208-107	7/16-14	REPAIR KIT
1208-108	1/2-13	REPAIR KIT
2200-14*	M14x 1.25	REPAIR KIT

INSERT PACKS

208-104	1/4-20	INSERT PACK
208-105	5/16-18	INSERT PACK
208-106	3/8-16	INSERT PACK
208-107	7/16-14	INSERT PACK
208-108	1/2-13	INSERT PACK
2214-S*	14mm x 3/8	INSERT PACK
2214-N*	14mm x 1/2	INSERT PACK
2214-L*	14mm x 3/4	INSERT PACK

*SOLID TYPE PERMA-PLUG INSERTS



1221-3

DISPLAY CENTER NO. 1221-3 METRIC THREADS

INCLUDES ONE EACH:

1221-305	M5 x .8	REPAIR KIT
1221-306	M6 x 1.0	REPAIR KIT
1221-308	M8 x 1.25	REPAIR KIT
1221-310	M10 x 1.5	REPAIR KIT
3221-M10F	M10 x 1.25	REPAIR KIT
3221-M12C	M12 x 1.75	REPAIR KIT
3221-M12F	M12 x 1.25	REPAIR KIT

INSERT PACKS

206-305	M5 x .8	INSERT PACK
206-306	M6 x 1.0	INSERT PACK
206-308	M8 x 1.25	INSERT PACK
206-310	M10 x 1.5	INSERT PACK
106-610	M10 x 1.25	INSERT PACK
106-312	M12 x 1.75	INSERT PACK
106-612	M12 x 1.25	INSERT PACK



1208-1

**COMPLETE DISPLAY CENTER: 1208-1
INCH COARSE THREADS**

INCLUDES ONE EACH:

1208-014	4-40	REPAIR KIT
1208-015	5-40	REPAIR KIT
1208-016	6-32	REPAIR KIT
1208-018	8-32	REPAIR KIT
1208-101	10-24	REPAIR KIT
1208-102	12-24	REPAIR KIT
1208-104	1/4-20	REPAIR KIT
1208-105	5/16-18	REPAIR KIT
1208-106	3/8-16	REPAIR KIT
1208-107	7/16-14	REPAIR KIT
1208-108	1/2-13	REPAIR KIT
1208-109	9/16-12	REPAIR KIT
1208-110	5/8-11	REPAIR KIT
1208-112	3/4-10	REPAIR KIT

INSERT PACKS

208-014	4-40	INSERT PACK
208-015	5-40	INSERT PACK
208-016	6-32	INSERT PACK
208-018	8-32	INSERT PACK
208-101	10-24	INSERT PACK
208-102	12-24	INSERT PACK
208-104	1/4-20	INSERT PACK
208-105	5/16-18	INSERT PACK
208-106	3/8-16	INSERT PACK
208-107	7/16-14	INSERT PACK
208-108	1/2-13	INSERT PACK
208-109	9/16-12	INSERT PACK
208-110	5/8-11	INSERT PACK
208-112	3/4-10	INSERT PACK



1208-2

**DISPLAY CENTER NO. 1208-2
INCH FINE THREADS**

INCLUDES ONE EACH:

1208-201	10-32	REPAIR KIT
1208-204	1/4-28	REPAIR KIT
1208-205	5/16-24	REPAIR KIT
1208-206	3/8-24	REPAIR KIT
1208-207	7/16-20	REPAIR KIT
1208-208	1/2-20	REPAIR KIT
1208-210	5/8-18	REPAIR KIT

INSERT PACKS

208-201	10-32	INSERT PACK
208-204	1/4-28	INSERT PACK
208-205	5/16-24	INSERT PACK
208-206	3/8-24	INSERT PACK
208-207	7/16-20	INSERT PACK
208-208	1/2-20	INSERT PACK
208-210	5/8-18	INSERT PACK

LOCALLY REBUILT INSERTS
IN THE THREAD REPAIR KITS

KITS

Size	Helicoil® #	Perma-Coil® #
INCH SERIES - COARSE		
12-24	5521-1	1208-102
8-32	5521-2	1208-018
10-24	5521-3	1208-101
1/4-20	5521-4	1208-104
5/16-18	5521-5	1208-105
3/8-16	5521-6	1208-106
7/16-14	5521-7	1208-107
1/2-13	5521-8	1208-108
9/16-12	5521-9	1208-109
5/8-11	5521-10	1208-110
3/4-10	5521-12	1208-112
INCH SERIES - FINE		
10-32	5528-3	1208-201
1/4-28	5528-4	1208-204
5/16-24	5528-5	1208-205
3/8-24	5528-6	1208-206
7/16-20	5528-7	1208-207
1/2-20	5528-8	1208-208
5/8-18	5528-10	1208-210
METRIC SERIES - COARSE		
M5 x 0.8	5546-5	1221-305
M6 x 1.0	5546-6	1221-306
M8 x 1.25	5546-8	1221-308
M10 x 1.5	5546-10	1221-310
M12 x 1.75	5546-12	3221-M12C
METRIC SERIES - FINE		
M10 x 1.25	5543-10	3221-M10F
M12 x 1.25	5543-12	3221-M12F
SPARK PLUG SERIES (Wire Type)		
M14 x 1.25	5523-14	1214-414
M18 x 1.25	5523-18	1218-500
SPARK PLUG SERIES (Solid Type)		
M14 x 1.25	5334-14	2200-14

INSERT PACKAGES

Helicoil® #	Perma-Coil® #
INCH SERIES - COARSE	
R1185-1	208-102
R1185-2	208-018
R1185-3	208-101
R1185-4	208-104
R1185-5	208-105
R1185-6	208-106
R1185-7	208-107
R1185-8	208-108
R1185-9	208-109
R1185-10	208-110
R1185-12	208-112
INCH SERIES - FINE	
R1191-3	208-201
R1191-4	208-204
R1191-5	208-205
R1191-6	208-206
R1191-7	208-207
R1191-8	208-208
R1191-10	208-210
METRIC SERIES - COARSE	
R1084-5	206-305
R1084-6	206-306
R1084-8	206-308
R1084-10	206-310
R1084-12	106-312
METRIC SERIES - FINE	
R4649-10	106-610
R4649-12	106-612
SPARK PLUG SERIES (Wire Type)	
R512	414-375
R513-10	414-750
R513-13	414-500
R514-6	418-500
SPARK PLUG SERIES (Solid Type)	
R5326-L	2214-L
R5326-N	2214-N
R5326-S	2214-S

THREAD KITS CO.

Perma-Rivet[®]

BLIND RIVETS AND TOOLS



Installation

Perma-Rivets® consist of two parts: **(A) rivet body** and **(B) setting mandrel**. In operation, the mandrel is pulled back to expand the rivet body and form a tight vibration-free faster. The mandrel breaks off automatically after the rivet is set.



1. After selecting the proper rivet, drill a hole corresponding to the diameter of the rivet through the materials to be fastened. When using counter-sunk head rivets a 120° countersunk bit is required. Use Perma-Rivet® Part No. P60928 for countersink drilling.
2. Open the handle of the rivet tool and insert the rivet mandrel in the nosepiece of the tool.
3. Place the rivet body in the predrilled hole. Then squeeze the rivet tool handles until the rivet mandrel breaks off.

Rivet Materials

In order to meet a variety of requirements for strength, corrosion and rust consideration and application materials, Perma-Rivets® are offered in specific materials and material combinations.

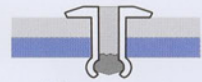
Type	Application
All Steel	High strength: Use with steel
Aluminum	Lightweight: Use with aluminum, areas susceptible to rust & corrosion.
Alum./Steel	Combines features of both materials
All Stainless	Very high strength: Use with stainless & steel. Prevents corrosion or rust.
Stainless/Steel	Very high strength. Applications where corrosion resistance is not a major factor.
Copper	Electrical conductivity.

Selecting the Correct Perma-Rivet®

Thread Kits Company offers a full line of headed rivets for general consumer and industrial applications. The materials and manufacturing processes used to head rivet bodies increase their shear and tensile values over a stamped eyelet-style rivet. Perma-Rivets® are used to fasten together two or more pieces of material of varying thickness. The rivet body alloy, in addition to being chosen for strength requirements, should also be selected for compatibility with the material to be joined to avoid galvanic corrosion caused by coupling dissimilar metals.

Rivet Styles

Open End



Designed for a wide range of applications, they resemble conventional tubular rivets when set, but retain the mandrel within the rivet body for added strength. Open end rivets are available in a variety of materials in buttonhead, countersunk or large flange head styles

Closed End



Specially configured with a cup shaped end that forms a tight seal, Perma-Rivet® closed end rivets are much stronger than open end rivets. They are available in button head, and countersunk head styles.

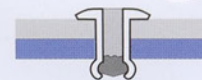
T-Rivets



Made for structural and high stress applications. They feature a hardened steel mandrel which splits the rivet body into a trifurcated shape. This provides high clamping strength even in thin or fragile material.

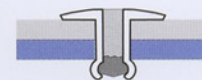
Head Styles

Buttonhead



Low profile design and neat appearance, this style is very versatile and most commonly used. The head size is twice the diameter of the rivet body. It provides enough bearing surface for all applications except soft or brittle material.

Large Flange



Features twice the under-head bearing surface as the buttonhead style. It is ideal for fastening soft or brittle materials to a rigid backing surface.

Countersunk



Designed with a 120° head profile for flush surface mounting applications.

Displays

Perma-Rivet Thrift Pack Display P/N P5835

Part No.	Code No.	Grip Range	Rivet Diameter	Display Quantity	Package Quantity
Steel Rivet / Steel Mandrel					
P57438	SB4-2	1/16 - 1/8	1/8	5	25
P57442	SB4-4	3/16 - 1/4	1/8	5	20
P57446	SB4-6	5/16 - 3/8	1/8	5	15
Aluminum Rivet / Aluminum Mandrel					
P57473	AB4-2A	1/16 - 1/8	1/8	5	25
P57477	AB4-4A	3/16 - 1/4	1/8	5	20
P57480	AB4-6A	5/16 - 3/8	1/8	5	15
P57487	AB6-2A	Up to 1/8	3/16	5	15
P57488	AB6-4A	1/8 - 1/4	3/16	5	15
P57490	AB6-6A	1/4 - 3/8	3/16	5	15
Back Up Plates					
P57660	SS-8	1/8 Hole	Steel	3	40
P57661	AS-8	1/8 Hole	Aluminum	3	30
P57662	AS-10	3/16 Hole	Aluminum	3	30
Tools					
P39000	GR12			4	

P5835



P5856

Perma-Rivet Shop Pack Display P/N P5856

Part No.	Code No.	Grip Range	Rivet Diameter	Display Quantity
Steel Rivet / Steel Mandrel				
P59438	SB4-2	1/16 - 1/8	1/8	3
P59439	SC4-2	1/16 - 1/8	1/8	2
P59442	SB4-4	3/16 - 1/4	1/8	6
P59443	SC4-4	3/16 - 1/4	1/8	3
P59446	SB4-6	5/16 - 3/8	1/8	4
P59447	SB4-8	3/8 - 1/2	1/8	3
Aluminum Rivet / Aluminum Mandrel				
P59473	AB4-2A	1/16 - 1/8	1/8	2
P59477	AB4-4A	3/16 - 1/4	1/8	4
P59480	AB4-6A	5/16 - 3/8	1/8	2
P59488	AB6-4A	1/8 - 1/4	3/16	3
P59490	AB6-6A	1/4 - 3/8	3/16	2
Tools				
P39000	GR12			2

Note: Shop pack boxes contain 100 Perma-Rivets

Perma-Rivet Plastic Rivet Display P/N P5870

Part No.	Grip Range	Rivet Diameter	Display Qty.	Package Qty.
P57712	.059 - .177	5.0mm	2	25
P57714	.118 - .177	5.0mm	2	25
P57715	.118 - .236	5.0mm	2	25
P57720	.236 - .394	5.0mm	2	25
P57721	.157 - .335	6.0mm	2	25
P57732	.157 - .236	6.3mm	2	25
P57735	.157 - .236	6.3mm	2	25
P57736	.157 - .394	6.3mm	2	25
P57737	.157 - .394	6.3mm	2	25
P57741	.315 - .472	6.3mm	2	25
P57747	.098 - .197	6.6mm	2	25
P57748	.098 - .197	6.6mm	2	25
P57752	.098 - .236	7.0mm	2	25
Tools				
P48005	KL-2 Plastic Rivet Setter		4	



P5870



All Perma-Rivet® sizes are available in 100-piece Shop Packs and 500-piece Pro Packs. Back-up washers are available in 100-piece Shop Packs and Thrift Packs.

Rivet Dia	Head Dia	Grip Range	Plated Steel Rivet Steel Mandrel			Stainless Steel Rivet Steel Mandrel			Stainless Steel Rivet Stainless Steel Mandrel		
			Code No.	100 pc. Shop Pack No.	500 pc. Pro Pack No.	Code No.	100 pc. Shop Pack No.	500 pc. Pro Pack No.	Code No.	100 pc. Shop Pack No.	500 pc. Pro Pack No.
OPEN END RIVETS											
3/32	3/16	Up to 1/8	SB3-2	P59435	P60435						
	3/16	1/8 to 1/4	SB3-4	P59436	P60436						
1/8	1/4	1/32 to 1/16	SB4-1	P59437	P60437						
	1/4	1/16 to 1/8	SB4-2	P59438	P60438	SSB4-2	P59560	P60560	SSB4-2S	P59540	P60540
	.220	1/16 to 1/8	SC4-2	P59439	P60439						
	3/8	1/16 to 1/8	SBL4-2	P59440	P60440						
	1/4	1/8 to 3/16	SB4-3	P59441	P60441	SSB4-3	P59561	P60561	SSB4-3S	P59541	P60541
	.220	1/8 to 3/16									
	1/4	3/16 to 1/4	SB4-4	P59442	P60442	SSB4-4	P59562	P60562	SSB4-4S	P59542	P60542
	.220	3/16 to 1/4	SC4-4	P59443	P60443						
	3/8	3/16 to 1/4	SBL4-4	P59444	P60444						
	1/4	1/4 to 5/16	SB4-5	P59445	P60445						
5/32	1/4	5/16 to 3/8	SB4-6	P59446	P60446	SSB4-6	P59563	P60563	SSB4-6S	P59543	P60543
	1/4	3/8 to 1/2	SB4-8	P59447	P60447	SSB4-8	P59573	P60573	SSB4-8S	P59544	P60544
	5/16	1/16 to 1/8	SB5-2	P59448	P60448	SSB5-2	P59564	P60564	SSB5-2S	P59545	P60545
	5/16	1/8 to 3/16	SB5-3	P59449	P60449						
	5/16	3/16 to 1/4	SB5-4	P59450	P60450	SSB5-4	P59565	P60565	SSB5-4S	P59546	P60546
	5/16	1/4 to 3/8	SB5-6	P59451	P60451	SSB5-6	P59566	P60566	SSB5-6S	P59547	P60547
	5/16	3/8 to 1/2									
	3/8	1/16 to 1/8	SB6-2	P59453	P60453	SSB6-2	P59567	P60567	SSB6-2S	P59548	P60548
	3/8	1/8 to 1/4	SB6-4	P59454	P60454	SSB6-4	P59568	P60568	SSB6-4S	P59549	P60549
	5/8	1/8 to 1/4	SBL6-4	P59455	P60455						
3/16	3/8	1/4 to 3/8	SB6-6	P59456	P60456	SSB6-6	P59569	P60569	SSB6-6S	P59550	P60550
	5/8	1/4 to 3/8	SBL6-6	P59457	P60457						
	3/8	3/8 to 1/2	SB6-8	P59458	P60458	SSB6-8	P59570	P60570	SSB6-8S	P59551	P60551
	5/8	3/8 to 1/2	SBL6-8	P59459	P60459						
	3/8	1/2 to 5/8	SB6-10	P59460	P60460						
	5/8	1/2 to 5/8	SBL6-10	P59461	P60461						
	3/8	5/8 to 3/4	SB6-12	P59462	P60462						
	5/8	5/8 to 3/4	SBL6-12	P59463	P60463						
	1/2	1/16 to 1/4	SB8-4	P59464	P60464						
	1/2	1/4 to 3/8	SB8-6	P59465	P60465						
1/4	1/2	3/8 to 1/2	SB8-8	P59466	P60466						
	1/2	5/8 to 3/4	SB8-12	P59467	P60467						
CLOSED END RIVETS											
1/8	.236	1/16 to 1/8									
	.236	1/8 to 3/16									
	.236	3/16 to 1/4									
	.236	3/16 to 1/4									
	.236	1/4 to 5/16									
	.236	3/8 to 1/2									
5/32	5/16	1/16 to 1/8									
	5/16	1/8 to 3/16									
	5/16	1/8 to 3/16									
	5/16	1/16 to 1/4									
	5/16	3/16 to 5/16									
3/16	3/8	1/8 to 1/4	SB6-4CLD	P59640	P60640						
	3/8	1/4 to 3/8									
	3/8	3/8 to 1/2									
1/4	1/2	1/8 to 1/4	SB8-4CLD	P59642	P60642						
	1/2	1/4 to 3/8									
T-RIVETS											
1/4	.510	1/32 to 9/64									
	.510	9/64 to 3/16									
	.510	33/64 to 5/8									



Perma-Rivet® CODE EXPLANATION - EXAMPLE: CODE NO. **ABL6-4A**

A	BL	6	4	A
Rivet Material	Head Style	Rivet Diameter	Max. Grip Length	Mandrel Material
A - Aluminum S - Carbon Steel SS - Stainless Steel	B - Buttonhead BL - Buttonhead, Large Flange C - Countersunk	in 32nds of an inch 6/32 - 3/16"	in 16ths of an inch 4/16 - 1/4"	A - Aluminum S - Stainless Steel CLD - Closed End Blank - Steel

Ordering Information

Rivet Dia	Head Dia	Grip Range	Aluminum Rivet Aluminum Mandrel			Aluminum Rivet Steel Mandrel			Copper Rivet Steel Mandrel		
			Code No.	100 pc. Shop Pack No.	500 pc. Pro Pack No.	Code No.	100 pc. Shop Pack No.	500 pc. Pro Pack No.	Code No.	100 pc. Shop Pack No.	500 pc. Pro Pack No.
OPEN END RIVETS											
3/32	3/16	Up to 1/8	AB3-2A	P59470	P60470	AB3-2	P59503	P60503			
	3/16	1/8 to 1/4	AB3-4A	P59471	P60471	AB3-4	P59504	P60504			
1/8	1/4	1/32 to 1/16	AB4-1A	P59472	P60472	AB4-1	P59505	P60505	CB4-2	P59571	P60571
	1/4	1/16 to 1/8	AB4-2A	P59473	P60473	AB4-2	P59506	P60506			
	.220	1/16 to 1/8	AC4-2A	P59474	P60474	AC4-2	P59507	P60507			
	3/8	1/16 to 1/8	ABL4-2A	P59475	P60475	ABL4-2	P59508	P60508			
	1/4	1/8 to 3/16	AB4-3A	P59476	P60476	AB4-3	P59509	P60509			
	.220	1/8 to 3/16				AC4-3	P59510	P60510	CB4-4	P59572	P60572
	1/4	3/16 to 1/4	AB4-4A	P59477	P60477	AB4-4	P59511	P60511			
	.220	3/16 to 1/4				AC4-4	P59512	P60512			
	3/8	3/16 to 1/4	ABL4-4A	P59478	P60478	ABL4-4	P59513	P60513			
	1/4	1/4 to 5/16	AB4-5A	P59479	P60479	AB4-5	P59514	P60514			
1/4	5/16 to 3/8	AB4-6A	P59480	P60480	AB4-6	P59515	P60515				
1/4	3/8 to 1/2	AB4-8A	P59481	P60481	AB4-8	P59516	P60516				
5/32	5/16	1/16 to 1/8	AB5-2A	P59482	P60482	AB5-2	P59517	P60517			
	5/16	1/8 to 3/16	AB5-3A	P59483	P60483	AB5-3	P59518	P60518			
	5/16	3/16 to 1/4	AB5-4A	P59484	P60484	AB5-4	P59519	P60519			
	5/16	1/4 to 3/8	AB5-6A	P59485	P60485	AB5-6	P59520	P60520			
	5/16	3/8 to 1/2	AB5-8A	P59486	P60486	AB5-8	P59521	P60521			
3/16	3/8	1/16 to 1/8	AB6-2A	P59487	P60487	AB6-2	P59522	P60522			
	3/8	1/8 to 1/4	AB6-4A	P59488	P60488	AB6-4	P59523	P60523			
	5/8	1/8 to 1/4	ABL6-4A	P59489	P60489	ABL6-4	P59524	P60524			
	3/8	1/4 to 3/8	AB6-6A	P59490	P60490	AB6-6	P59525	P60525			
	5/8	1/4 to 3/8	ABL6-6A	P59491	P60491	ABL6-6	P59526	P60526			
	3/8	3/8 to 1/2	AB6-8A	P59492	P60492	AB6-8	P59527	P60527			
	5/8	3/8 to 1/2	ABL6-8A	P59493	P60493	ABL6-8	P59528	P60528			
	3/8	1/2 to 5/8	AB6-10A	P59494	P60494	AB6-10	P59529	P60529			
	5/8	1/2 to 5/8	ABL6-10A	P59495	P60495	ABL6-10	P59530	P60530			
	3/8	5/8 to 3/4	AB6-12A	P59496	P60496	AB6-12	P59531	P60531			
5/8	5/8 to 3/4	ABL6-12A	P59497	P60497	ABL6-12	P59532	P60532				
1/4	1/2	1/16 to 1/4	AB8-4A	P59498	P60498	AB8-4	P59533	P60533			
	1/2	1/4 to 3/8	AB8-6A	P59499	P60499	AB8-6	P59534	P60534			
	1/2	3/8 to 1/2				AB8-8	P59535	P60535			
	1/2	5/8 to 3/4	AB8-12A	P59500	P60500	AB8-12	P59536	P60536			
CLOSED END RIVETS											
1/8	.236	1/16 to 1/8	AB4-2ACLD	P59620	P60620	AB4-2CLD	P59590	P60590			
	.236	1/8 to 3/16				AB4-3CLD	P59604	P60604			
	.236	3/16 to 1/4	AB4-4ACLD	P59621	P60621	AD4-4CLD	P59592	P60592			
	.236	3/16 to 1/4				AC4-4CLD	P59593	P60593	CB4-5CLD	P59644	P60644
	.236	1/4 to 5/16				AB4-5CLD	P59608	P60608			
	.236	3/8 to 1/2				AB4-8CLD	P59595	P60595			
5/32	5/16	1/16 to 1/8				AB5-2CLD	P59596	P60596			
	5/16	1/8 to 3/16				AB5-3CLD	P59609	P60609			
	5/16	1/8 to 3/16				AC5-3CLD	P59607	P60607			
	5/16	1/16 to 1/4	AB5-4ACLD	P59622	P60622						
	5/16	3/16 to 5/16				AB5-5CLD	P59597	P60597			
3/16	3/8	1/8 to 1/4	AB6-4ACLD	P59624	P60624	AB6-4CLD	P59599	P60599			
	3/8	1/4 to 3/8				AB6-6CLD	P59605	P60605			
	3/8	3/8 to 1/2				AB6-8CLD	P59601	P60601			
1/4	1/2	1/8 to 1/4				AB8-4CLD	P59606	P60606			
	1/2	1/4 to 3/8				AB8-6CLD	P59603	P60603			
T-RIVETS											
1/4	.510	1/32 to 9/64				AD8-140T	P59580	P60580			
	.510	9/64 to 3/16				AD8-187T	P59581	P60581			
	.510	33/64 to 5/8				AD8-620T	P59582	P60582			

BACK-UP WASHERS					
Hole Size	Material	Code No.	100 pc. Pack		
			Part No.	Part No.	Pkg./Qty.
1/8	Steel	SS-8	P59660	P57660	40
1/8	Aluminum	AS-8	P59661	P57661	30
3/16	Aluminum	AS-10	P59662	P57662	30

Back-up washers are .056" - .062" thick. They are used when fastening soft materials or to compensate for oversize holes where access to both sides of work is possible





Thrift Packs

Perma-Rivet® offers nine of the most popular size rivets, packaged in a sturdy, clear plastic, resealable clamshell. Great for do-it-yourself use.



Perma-Rivet® THRIFT PACKS - OPEN END RIVETS

Rivet Diameter	Head Diameter	Grip Range	Steel Rivet Steel Mandrel		Aluminum Rivet Aluminum Mandrel		Package Quantity
			Part No.	Code No.	Part No.	Code No.	
1/8	1/4	1/16 - 1/8	P57438	SB4-2	P57473	AB4-2A	25
	1/4	3/16 - 1/4	P57442	SB4-4	P57477	AB4-4A	20
	1/4	5/16 - 3/8	P57446	SB4-6	P57480	AB4-6A	15
3/16	3/8	Up to 1/8			P57487	AB6-2A	15
	3/8	1/8 - 1/4			P57488	AB6-4A	15
	3/8	1/4 - 3/8			P57490	AB6-6A	15

SPECIAL APPLICATION RIVETS

Rivet Diameter	Head Diameter	Application	Steel Rivet Steel Mandrel		Aluminum Rivet Aluminum Mandrel		Aluminum Rivet Steel Mandrel		Stainless Steel Rivet Steel Mandrel	
			P/N	Code No.	P/N	Code No.	P/N	Code No.	P/N	Code No.
SHOP PACKS - 100 PER BOX										
1/8	1/4	Aluminum Trim Channel Rivet			P59477	AB4-4A				
1/4	.510	Window Regulator Rivet					P59580	AD8-140T		
1/4	.510	Outside Door Handle Rivet					P59581	AD8-187T		
1/4	.510	Glass Stop Rivet					P59582	AD8-620T		
5/32	5/16	Swivel Emblem Trunk Lock Rivet					P59607	AC5-3CLD		
1/4	1/2	Bumper Rivet	P59800	SB8-4038						
3/16	3/8	Bumper Fascia Rivet	P59801	SB6-6025						
1/8	13/64	Std. Aluminum Trim Clip Rivet			P59802	ABN4-3A				
1/8	13/64	Long Aluminum Trim Clip Rivet			P59803	ABN4-4A				
1/8	13/64	Std. Stainless Trim Clip Rivet							P59804	SSBN4-3
1/8	.318	Rear Window Gasket Rivet					P59805	ABL4-3318		
1/8	1/4	Multi Purpose Rivet					P59806	ABL4-3		
PRO PACKS - 500 PER BOX										
1/8	1/4	Aluminum Trim Channel Rivet			P60477	AB4-4A				
1/4	.510	Window Regulator Rivet					P60580	AD8-140T		
1/4	.510	Outside Door Handle Rivet					P60581	AD8-187T		
1/4	.510	Glass Stop Rivet					P60582	AD8-620T		
5/32	5/16	Swivel Emblem Trunk Lock Rivet					P60607	AC5-3CLD		
1/4	1/2	Bumper Rivet	P60800	SB8-4038						
3/16	3/8	Bumper Fascia Rivet	P60801	SB6-6025						
1/8	13/64	Std. Aluminum Trim Clip Rivet			P60802	ABN4-3A				
1/8	13/64	Long Aluminum Trim Clip Rivet			P60803	ABN4-4A				
1/8	13/64	Std. Stainless Trim Clip Rivet							P60804	SSBN4-3
1/8	.318	Rear Window Gasket Rivet					P60805	ABL4-3318		
1/8	1/4	Multi Purpose Rivet					P60806	ABL4-3		

Plastic Perma-Rivets®

Plastic Perma-Rivets® are the same precision-moulded all-nylon rivets used on today's automobiles, both for original equipment and replacement parts. They are ideal for non-conductive and non-corrosive environments. Plastic Perma-Rivets® fasten plastic-to-plastic, plastic-to-metal and plastic-to-fiberglass. As they set, three "legs" form to securely lock the components in place and prevent pullout, leaving an attractive finished appearance.



- Precision-moulded, all-nylon
- Secure lock prevents pull-out
- Fasten plastic-to-plastic, plastic-to-metal or plastic-to-fiberglass

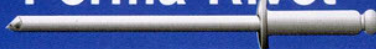
PLASTIC RIVET ORDERING INFORMATION

Part No.	Rivet Diameter	Suggested Drill Size	Grip Range	Head Diameter	Replaces OEM Plastic Rivet Part Number
P57712	5.0mm	7/32	.059 - .177	.472	GM 20423647, Ford N803170S, Ford N804189S
P57714	5.0mm	7/32	.118 - .177	.472	AMC 8934202855, Ford N804863S, Chry 34202855, Chry 6500859
P57715	5.0mm	7/32	.118 - .236	.472	AMC 8934202652, Chry 6500899, GM 20432975, Ford N804343S VW 175-853-577
P57720	5.0mm	7/32	.236 - .394	.472	Chry 6500898, Chry 6500982
P57721	6.0mm	1/4	.157 - .335	.512	GM - BOC 25524005
P57732	6.3mm	1/4	.157 - .236	.669	Chry 4370132, GM 14070914
P57735	6.3mm	1/4	.157 - .394	.669	Chry 6500911, GM 14063981, GM-CPC 15506827, GM-T&B 15506921, Ford/Mazda KA01500Z1, Ford N803043S
P57736	6.3mm	1/4	.157 - .394	.512	GM 20452072, Ford N803862S
P57737	6.3mm	1/4	.157 - .394	.669	AMC 8934201631, AMC 8934201835
P57741	6.3mm	1/4	.315 - .472	.661	Chry 4370138, Ford N804675S
P57747	6.6mm	9/32	.098 - .197	.512	GM 20421672
P57748	6.6mm	9/32	.098 - .197	.709	GM 20433026, VW 175-853-577A
P57752	7.0mm	5/16	.098 - .236	.709	GM 1019689, GM-CPC 10087278

KL-2 Plastic Rivet Setter / P48005

This long-reach tool is exactly what is needed for today's hard to reach spots, especially in automotive applications such as flexible bumpers, wheel wells, license plate brackets and bumper reinforcements. In addition to the tool's long reach, it offers one-stroke setting and a universal nosepiece that sets all plastic rivets.





GR-12 / P39000



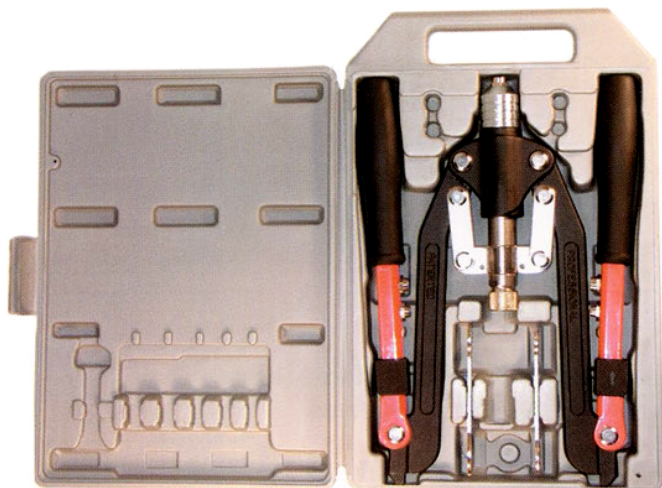
The GR-12 is our most popular rivet tool providing both quality and durability. The high leverage handles are designed to have superior pulling power along with it easy one hand operation. The GR-12 sets rivets up to 3/16" diameter and comes with four interchangeable nosepieces (3/32", 1/8", 5/32", 3/16") and wrench. Replacement jaws sold separate.

Pivot-Head S401 / P39005

The S401 Pivot-Head rivet tool features a 360° rotating head designed for easy access to hard to reach applications. This patented tool is constructed of hardened steel and cast aluminum for longer life. The S401 also includes built-in threaded nosepiece storage holes and a service wrench. The S401 sets up to 3/16" steel rivets. Replacement jaws sold separate.



H1 / P39010



The H1 professional grade rivet tool is our most powerful hand riveter, taking the hard work out of setting large diameter blind rivets. With its unique collapsible handle design, the H1 handles extend to provide excellent leverage and permits working a foot beyond natural reach. The H1 easily sets from 1/8" to 1/4" diameter Perma-Rivets in all alloys. Furnished with standard nosepieces to set up to 1/4", wrenches and plastic storage case. Replacement parts sold separate.

TC702 / P39040

The TC702 is a perfect medium-duty tool for the do-it-yourselfer or occasional user, setting all 1/8" - 5/32" steel, and 3/16" all aluminum Perma-Rivets. Nosepieces and wrench included. No replacement parts available.

