

Thread Repair Kit

Recoil Kits

Kits are available in both single size kits and range kits. Each kit consists of a high speed tap, tang break - off/insertion tool, a quantity of inserts, easy to follow instructions, and comes in a quality reusable metal box. A standard kit comes with an intermediate tap. M10, 12, 14, 18 spark plug have pilot nose taps.

BSF

SIZE	PART NO.	INSERTS PER KIT	DRILL SIZE
			MM INCH
3/16-22	30030	10	5.00 13/64
1/4-20	30040	10	6.60 17/64
5/16-22	30050	10	8.20 21/64
3/8-20	30060	10	9.80 25/64
7/16-18	30070	10	11.50 29/64
1/2-16	30080	10	13.00 33/64
9/16-18	30090	5	14.50 37/64
5/8-14	30100	5	16.20 41/64
3/4-12	30120	5	19.50 49/64
7/8-11	30140	5	22.50 57/64
1-10	30160	5	26.00 1 1/32
1 1/4-9	30200	5	32.50 1 9/32

BA

SIZE	PART NO.	INSERTS PER KIT	DRILL SIZE
			MM INCH
0 BA	30500	10	6.20
1 BA	30510	10	5.50
2 BA	30520	10	4.90
4 BA	30540	10	3.80
6 BA	30560	10	2.90

BSW

SIZE	PART NO.	INSERTS PER KIT	DRILL SIZE
			MM INCH
1/8-28	31020	10	9.50 3/8
1/4-18	31040	10	13.50 33/64
3/8-16	31060	5	17.00 21/32
1/2-14	31080	5	21.50 13/16
5/8-14	31100	5	23.50 59/64
3/4-14	31120	5	27.00 1 1/64
1-11	31160	5	33.50 1 9/32

BSC BRASS OR 26TPI

SIZE	PART NO.	INSERTS PER KIT	DRILL SIZE
			MM INCH
1/4-26	30640	10	6.60 17/64
5/16-26	30660	10	8.20 21/64
3/8-26	30680	10	9.80 25/64
7/16-26	30700	5	11.50 29/64
1/2-26	30690	5	13.00 1/2

METRIC COARSE

SIZE	PART NO.	INSERTS PER KIT	DRILL SIZE
			MM INCH
2-0-4	35020	10	2.10
2-2-45	35010	10	2.30 #42
2-5-45	35030	10	2.60 #37
3-5	35030	10	3.20 3/8
3-5-6	35030	10	3.70 #27
4-7	35040	10	4.20 15/64
5-8	35050	10	5.20 13/64
6-1	35060	10	6.30 1/4
7-1	35070	10	7.30 9/32
8-1.25	35080	10	8.30 21/64
9-1.25	35090	10	9.40 3/8
10-1.5	35100	10	10.40 13/32
11-1.5	35110	5	11.50 29/64
12-1.75	35120	5	12.50 31/64
13-1.75	35130	5	13.50 37/64
14-2	35140	5	14.50 21/32
15-2	35150	5	15.50 39/64
16-2	35160	5	16.50 47/64
18-2.5	35180	5	18.80 13/16
20-2.5	35200	5	20.80 13/16
22-2.5	35220	5	22.80 57/64
24-3	35240	5	24.80 31/32
27-3	35270	5	27.50 1 5/64
30-3.5	35300	5	30.50 1 9/16
36-3	35360-3	5	30.50 1 5/16
36-4	35360	4	36.50 7/16
39-4	35390	4	39.50 1 9/16
42-4.5	35420	4	42.50 1 11/16
42-4	35420-4	4	42.50 1 11/16

METRIC MEDIUM & FINE

SIZE	PART NO.	INSERTS PER KIT	DRILL SIZE
			MM INCH
8-1	37000	10	8.30 21/64
9-1	37000	10	9.30
10-1.25	37100	10	10.30 13/32
10-1.25K25	37101	10	10.30 13/32
11-1.25	37110	5	11.30 7/16
12-1.5	37120	5	12.30 31/64
13-1.5	37130	5	13.20 33/64
14-1.5	37140	5	14.20 9/16
15-1.5	37150	5	15.20 39/64
16-1.5	37160	5	16.50 21/32
18-2	37180	5	18.50 23/32
20-2	37200	5	20.50 15/16
22-2	37220	5	22.50 57/64
24-2	37240	5	24.50
27-2	37270	5	27.50 1 5/64
30-2	37300	5	30.50 1 3/16
36-3	37360	4	36.50 1 7/16
39-3	37390	4	39.50 1 9/16
42-3	37420	4	42.50 1 11/16

METRIC EXTRA FINE (NOT FOR SPARKPLUG)

SIZE	PART NO.	INSERTS PER KIT	DRILL SIZE
			MM INCH
10-1	38101	10	10.30 13/32
11-1	38110	5	11.30 7/16
12-1.25	38121	5	12.30 31/64
13-1.25	38130	5	13.20 33/64
14-1.25	38141	5	14.20 9/16
16-1.5*	38161	5	16.50 23/32
20-1.5	38200	5	20.50 13/16
22-1.5	38220	5	22.50 57/64
24-1.5	38240	5	24.50 29/32
26-1.5	38260	5	26.5 1 1/32
27-1.7	38270	5	27.5 1 5/64
30-1.5	38300	5	30.50 1 5/16
36-1.5	38360	4	36.50 1 7/16
39-2	38390	4	39.5 1 9/16
42-2	38420	4	42.5 1 11/16

*M10 EXTRA FINE IS A DIFFERENT SPEC AND THREAD FORM TO M10 SPARKPLUG

SPARKPLUG

SIZE	PART NO.	INSERTS PER KIT	NO DRILLING REQUIRED
10-1	39100	10	
12-1.25	39120	10	
14-1.25*	39140	10	EXTRACTOR TOOL
14-1.25	39142	5	SMALL TIN
18-1.5*	39180	5	

*INCLUDES EXTRACTING TOOL AND LARGE KIT BOX



Drill



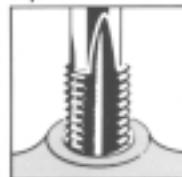
Drill to clear out the damaged thread (if necessary).

Install



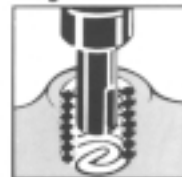
Wind insert in with light downward pressure until 1/4 to 1/2 turn below surface, driving tang towards bottom of the hole.

Tap



Thread insert tap supplied. Tap thread should match up with bolt.

Tang Removal



Remove tool and sit back on top of tang. Tap down sharply. Do not try to twist tang off. Sparkplug and large fine threads, use long nose pliers and pull tang out.

UNC

SIZE	PART NO.	INSERTS PER KIT	DRILL SIZE
			MM INCH
2-56	33520	10	2.30 3/32
3-48	33530	10	2.70 #56
4-40	33540	10	3.00 #51
5-40	33550	10	3.40 #29
6-32	33560	10	3.80 #25
8-32	33580	10	4.40 11/64
10-24	33600	10	5.10 13/64
12-24	33620	10	5.80 15/64
1/4-20	33640	10	6.70 17/64
5/16-18	33660	10	8.30 21/64
3/8-16	33680	10	9.40 25/64
7/16-14	33700	5	11.50 29/64
1/2-13	33720	5	13.00 17/32
9/16-12	33740	5	15.00 18/32
5/8-11	33100	5	16.50 21/32
11/16-11	33110	5	18.00 23/32
3/4-10	33120	5	19.80 25/32
7/8-9	33140	5	23.00 29/32
1-8	33160	5	26.00 1 1/32
1 1/8-7	33180	5	29.50 1 5/32
1 1/4-7	33200	5	33.00 1 9/32
1 3/8-6	33220	5	36.00 1 13/32
1 1/2-6	33240	4	39.00 1 17/32

BSW

SIZE	PART NO.	INSERTS PER KIT	DRILL SIZE
			MM INCH
1/8-40	32020	10	3.40 #29
5/32	ONLY 1/8-32 UNC AVAILABLE		
3/16-24	32030	10	5.00 13/64
7/32-24	USE UNC 12-24		
1/4-20	32040	10	6.70 17/64
5/16-18	32060	10	8.30 21/64
3/8-16	32080	10	9.90 25/64
7/16-14	32090	5	11.50 29/64
1/2-12	32080	5	13.00 17/32
9/16-12	32090	5	15.00 19/32
5/8-11	32100	5	16.50 21/32
3/4-10	32120	5	19.80 25/32
7/8-9	32140	5	23.00 29/32
1-8	32160	5	26.00 1 1/32
1 1/8-7	32180	5	29.50 1 5/32
1 1/4-7	32200	5	33.00 1 9/32
1 3/8-6	32220	5	36.00 1 13/32
1 1/2-6	32240	4	39.00 1 17/32

UNF (SAE)

SIZE	PART NO.	INSERTS PER KIT	DRILL SIZE
			MM INCH
3-56	34020	10	2.60 #37
4-48	34040	10	3.00 #51
6-40	34060	10	3.80 #25
8-36	34080	10	4.40 #17
10-32	34100	10	5.10 13/64
1/4-20	34040	10	6.60 17/64
5/16-24	34050	10	8.20 21/64
3/8-24	34060	10	9.80 25/64
7/16-20	34070	5	11.50 29/64
1/2-20	34080	5	13.00 33/64
9/16-18	34090	5	14.50 37/64
5/8-18	34100	5	16.30 41/64
3/4-16	34120	5	19.50 49/64
7/8-14	34140	5	22.50 57/64
1-12	34160	5	26.00 1 1/64
1-14	34160-14	3	26.00 1 1/64
1 1/8-12	34180	5	29.50 1 5/32
1 1/4-12	34200	5	32.50 1 9/32
1 3/8-12	34220	3	36.00 1 13/32
1 1/2-12	34240	3	39.00 1 17/32

SPECIALS

SIZE	PART NO.	INSERTS PER KIT	DRILL SIZE
			MM INCH
UMEP			
1/4-32	34040-32	10	6.6 17/64
			6.6 17/64
1/4-24	34040-24	10	11.5 29/64
7/16-18	34070-18	5	
CARBURETTOR			
7/8-20	34140-20	5	7/8
1-20	34160-20	5	1"
CUMMINS HEAD BOLT, GMC MAIN CAPS			
11/16-18	34110-18	5	18.0 45/64

8TPI UN SERIES

SIZE	PART NO.	INSERTS PER KIT	DRILL SIZE
			MM INCH
1 1/8-8	36180	5	26.50 1 1/8
1 1/4-8	36200	5	32.00 1 1/4
1 3/8-8	36220	5	36.00 1 3/8
1 1/2-8	36240	4	38.00 1 1/2
1 5/8-8	36260	4	41.00 1 5/8
1 3/4-8	36280	4	44.50 1 3/4
1 7/8-8	36300	4	47.50 1 7/8
2-8	36320	4	2"

NPT

SIZE	PART NO.	INSERTS PER KIT	DRILL SIZE
			MM INCH
1/8-27	36020	10	9.90 3/8
1/4-18	36040	10	13.50 33/64
3/8-16	36060	10	17.00 21/32
1/2-14	36080	5	21.50 13/16
3/4-14	36120	5	27.00 1 1/64
1-11 1/2	36160	5	33.50 1 9/32

RANGE KITS

INCLUDE A NUMBER OF POPULAR SIZES. SPECIALS CAN BE MADE TO SUIT YOUR CUSTOMER NEEDS.

* MOST POPULAR SIZES

PART NO.	INCLUDES
30500	BA 0, 1, 2, 4, 6
30600	BSF 1/4, 5/16, 3/8, 7/16, 1/2
31000	BSW 1/8, 1/4, 3/8, 1/2
32000	BSW 1/4, 5/16, 3/8, 7/16, 1/2
33000	UNC 1/4, 5/16, 3/8, 7/16, 1/2
33005	METRIC 8, 8, 10, 12, 14, 17, 20
33006	UNC 1/4, 5/16, 3/8, 7/16, M10, 25
34000	UNF 1/4, 5/16, 3/8, 7/16, 1/2
35	