

Recoil helically-wound thread inserts are formed from 18-8 (Type 304) stainless steel rhomboidly shaped by cold rolling. The resultant wire in most sizes has a tensile strength of greater than 200,000 P.S.I. and a finish better than 32 micro inches. The wire is then wound to the shape of a spring thread, then when installed into Recoil tapped holes it provides a permanent, wear-resistant thread which in most cases exceeds the strength of the parent material.



INSTALLATION

** Includes drill bit in kit

Each kit consists of a high speed plug tap, tang break - off/insertion tool, a quantity of inserts, easy to follow instructions, and comes in a quality reusable box.

THREAD REPAIR KITS

INCH COARSE					
SIZE	PART No.	INSERTS PER KIT	DRILL SIZE MM	DRILL SIZE INCH	PRICE
6-32	33560-R	10	3.80	# 25	\$28.91
8-32	33580-R	10	4.40	11/64	29.12
10-24	33600-R	10	5.10	13/64	30.59
12-24	33628-R	** 10	5.80	15/64	30.84
1/4-20	33048-R	** 10	6.70	17/64	31.25
5/16-18	33058-R	** 10	8.30	21/64	33.40
3/8-16	33068-R	** 10	9.90	25/64	36.61
7/16-14	33078-R	** 5	11.50	29/64	38.23
1/2-13	33088-R	** 5	13.00	17/32	45.44
9/16-12	33090-R	5	15.00	19/32	56.83
5/8-11	33108-R	5	16.50	21/32	65.66
3/4-10	33128-R	5	19.80	25/32	80.04
7/8-9	33140-R	5	23.00	29/32	130.64
1-8	33160-R	5	26.00	1-1/32	164.36

INCH FINE					
SIZE	PART No.	INSERTS PER KIT	DRILL SIZE MM	DRILL SIZE INCH	PRICE
10-32	34600-R	10	5.10	13/64	\$33.78
12-28	34620-R	10	5.60	15/64	33.78
1/4-28	34040-R	10	6.60	17/64	34.12
5/16-24	34050-R	10	8.20	21/64	35.04
3/8-24	34068-R	** 10	9.80	25/64	38.91
7/16-20	34070-R	5	11.50	29/64	40.25
1/2-20	34088-R	** 5	13.00	33/64	47.44
9/16-18	34090-R	5	14.50	37/64	64.14
5/8-18	34100-R	5	16.30	41/64	69.41
3/4-16	34128-R	5	19.50	49/64	81.13
7/8-14	34140-R	5	22.50	57/64	150.53
1-14	34160-14-R	5	26.00	1-1/64	193.54

METRIC COARSE					
SIZE	PART No.	INSERTS PER KIT	DRILL SIZE MM	DRILL SIZE INCH	PRICE
6-1.0	35068-R	** 10	6.30	1/4	\$34.32
8-1.25	35088-R	** 10	8.30	21/64	36.25
10-1.0	38108-R	** 10	10.30	13/32	50.17
10-1.5	35108-R	** 10	10.30	13/32	38.78
11-1.5	35118-R	** 5	11.50	29/64	43.77
12-1.75	35128-R	** 5	12.30	31/64	47.66

INSERTS

INCH COARSE			
SIZE	PART No.	INSERTS REFILLS	PRICE
6-32	23563-R	10	\$3.94
8-32	23583-R	10	3.94
10-24	23603-R	10	3.94
12-24	23623-R	10	5.28
1/4-20	23043-R	10	3.94
5/16-18	23053-R	10	5.19
3/8-16	23063-R	10	6.13
7/16-14	23073-R	10	6.80
1/2-13	23083-R	10	9.95
9/16-12	23093-R	5	9.32
5/8-11	23103-R	5	11.92
3/4-10	23123-R	5	17.35
7/8-9	23143-R	3	13.83
1-8	23163-R	3	18.17

INCH FINE			
SIZE	PART No.	INSERTS REFILLS	PRICE
10-32	24603-R	10	\$3.94
12-28	24623-R	10	5.28
1/4-28	24043-R	10	3.94
5/16-24	24053-R	10	5.19
3/8-24	24063-R	10	6.13
7/16-20	24073-R	10	6.80
1/2-20	24083-R	10	9.95
9/16-18	24093-R	5	9.32
5/8-18	24103-R	5	11.92
3/4-16	24123-R	5	17.35
7/8-14	24143-R	3	13.83
1-14	24163-14-R	3	18.17

METRIC COARSE			
SIZE	PART No.	INSERTS REFILLS	PRICE
6-1.0	25063-R	10	\$3.94
8-1.25	25083-R	10	5.19
10-1.0	28103-R	10	6.56
10-1.5	25103-R	10	6.56
11-1.5	25113-R	10	9.00
12-1.75	25123-R	10	9.95

Drill



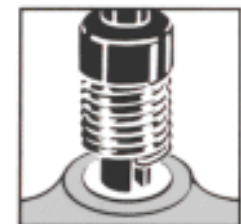
Drill to clear out the damaged thread (if necessary).

Tap



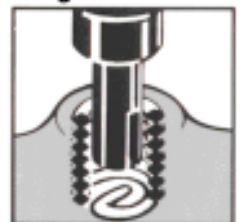
Thread insert tap supplied. Tap thread should match up with bolt.

Install



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

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.