

**BEFORE**



**DRILLING**

Clear the damaged thread with the STI Drill.  
 Up to M 12 (1/2") the kits include the correct drill.  
 Please pay attention that for Fluteless Taps bigger holes are required.



**CHECK**

Check that thread and pitch of the tap and the bolt match.

**TAPPING**

Use the special V-COIL Taps for cutting the holding thread into the cleared hole. It is recommended to use a suitable cutting oil.



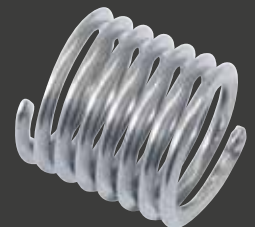
**INSERTING TOOL**

Screw the tangless V-COIL notch insert onto the inserting tool and make sure that the spring-loaded blade engages in the driver notch.  
 The insert can be picked up from both sides.  
 Then adjust the depth stop nut to the intended screw-in depth and fix it with the lock nut.



**INSTALL THE INSERT**

Screw in the insert with a light downward pressure in the direction of the thread up to the depth stop nut.  
 Then unscrew the inserting tool. The spring-loaded blade of the tool automatically retracts out of the driver notch and releases the insert.  
 There is no longer any need to break the tang.



**RESULT**

After completion of these operations, the tight and exact tolerances, as well as the shaping of the spring thread, result in a thread that is normally better and stronger than the original thread.



**Application:**

**Thread Armour Plating.** For material with low shear strength eg. aluminum-alloys and magnesium alloys. Used in machine-building, electrical, automotive medical and aerospace industries.

**Thread Repair** of damaged or worn-out threads. **Recovery** of rejected items.

**ALWAYS A NOTCH ABOVE**