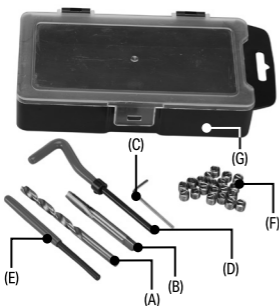


# METRIC THREAD REPAIR KIT

**21714, 21715, 21721, 82631, 21723, 21744, 03711**

Read this manual in full before attempting to use this product and retain it for later use.  
Always use the latest version of the manual.

Stock No.	Part No.	Tap size	Drill bit size (mm)	Hex key size (mm)	Thread inserts included
21714	DHCK-A	M5 x 0.8mm	5.2	2	20
21715	DHCK-A	M6 x 1.0mm	6.2	2	20
21721	DHCK-A	M8 x 1.25mm	8.3	2	20
82631	DHCK-A	M9 x 1.25mm	9.3	2	20
21723	DHCK-A	M10 x 1.5mm	10.3	2	10
21744	DHCK-A	M12 x 1.75mm	12.4	2	10
03711	DHCK-A	M14 x 1.25mm	14.3	2	10



- A. 1 x HSS drill bit  
B. 1 x HSS tapping tool  
C. 1 x Hex key  
D. 1 x Insert tool  
E. 1 x Lug breaking tool  
F. Thread inserts  
G. 1 x Case

## 1. Health and Safety Information

- Inspect the product thoroughly for damage before every use; **DO NOT** use it if it is damaged.
- **ALWAYS** wear eye protection.
- This manual is supplied as a guide only.
  - Assess any other precautions that must be taken before use with each specific workpiece.
  - Where the workpiece is part of a larger tool or machine, refer to the manufacturer's manual for the correct procedure for use.
- Keep the work area clean and well lit, with bystanders at a safe distance.
- Secure the workpiece during operation.



**WARNING!** This product requires the use of additional tools (not supplied). Read and adhere to all Health and Safety information and operating instructions associated with the chosen tools before use.

## 2. Operating Instructions

1. Drill out the damaged thread using the appropriate drill bit (A) (supplied) – Fig. 1.  
**Important:** Some fixings may need to be removed by a specialist engineer. Draper Tools accepts no responsibility for the incorrect removal of broken fixings and fasteners.
2. Use a thread gauge (not supplied) to ensure that the thread and pitch of the new fastener are compatible with the thread insert (F) – Fig. 2.
3. Fix the tapping tool (B) into a tap wrench (not supplied) and cut a new thread into the cleared hole – Fig. 3.  
**Important:** Use of an appropriate cutting oil is recommended. Clear the tapping tool of chips after use.
4. Use the adjustable ring of the insert tool (D) to set the depth at which the thread insert will be positioned and use the hex key (C) to lock it in place – Fig. 4.  
**Important:** When inserted, the thread insert should be positioned roughly a half-turn below the surface.
5. With the thread insert tang positioned at the bottom, push the insert tool through the top of the thread insert and locate the tang in the tang slot.

6. With the insert tool at the correct angle, wind the thread insert into the hole using light downward pressure until the set depth is reached and then remove the insert tool – Fig. 5.



**CAUTION! DO NOT** work against the direction of the thread as this may damage the insert tang.

7. Position the lug breaking tool (E) above the insert thread tang and strike it to break the tang – Fig. 6.

## 3. Care and Disposal

- Clean all parts of the product before and after each use, and before storing.
- Do not use damaged or defective tools with this product.
- Store the product in a clean and dry location, out of reach of children.

At the end of its working life, or when it can no longer be repaired, dispose of this product according to local regulations.



Wear eye and face protection

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Fig. 1

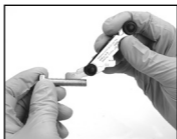


Fig. 2



Fig. 3



Fig. 4



Fig. 5



Fig. 6

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