

RECLAMATION OF TAPPED HOLES IN TRANSAXLE CASINGS

This information is provided for reclaiming damaged threads in the transaxle aluminium casings, using Heli-coil inserts.

When fitting Heli-coil inserts, it is essential that the correct size insert is used, as given in the chart, page 35.

All inserts must be positioned 1 to $1\frac{1}{2}$ pitches below the top face of the hole (see Fig. 58), except where otherwise stated.

Two taps are required, a roughing tap and a finishing, bottoming tap.

When using the finishing tap, it is important that the tap is run down to the specified depth and out again without backing off, i.e., do not reverse the direction of tap until the bottom of the hole is reached.

Always use a lubricant when tapping threads.

The chart gives full specifications for insert sizes, taps, inserting tools, etc., and the relevant information must be strictly adhered to for each application.

Refer to Section S for kit part numbers.

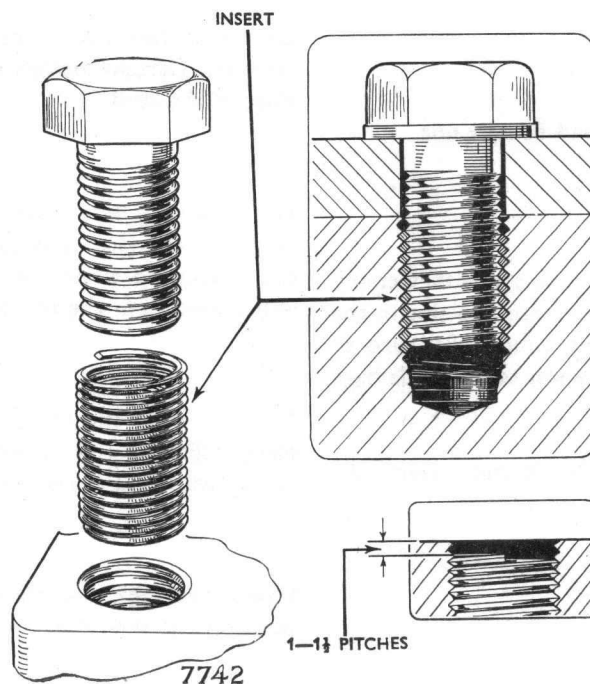


Fig. 58. Heli-coil insert