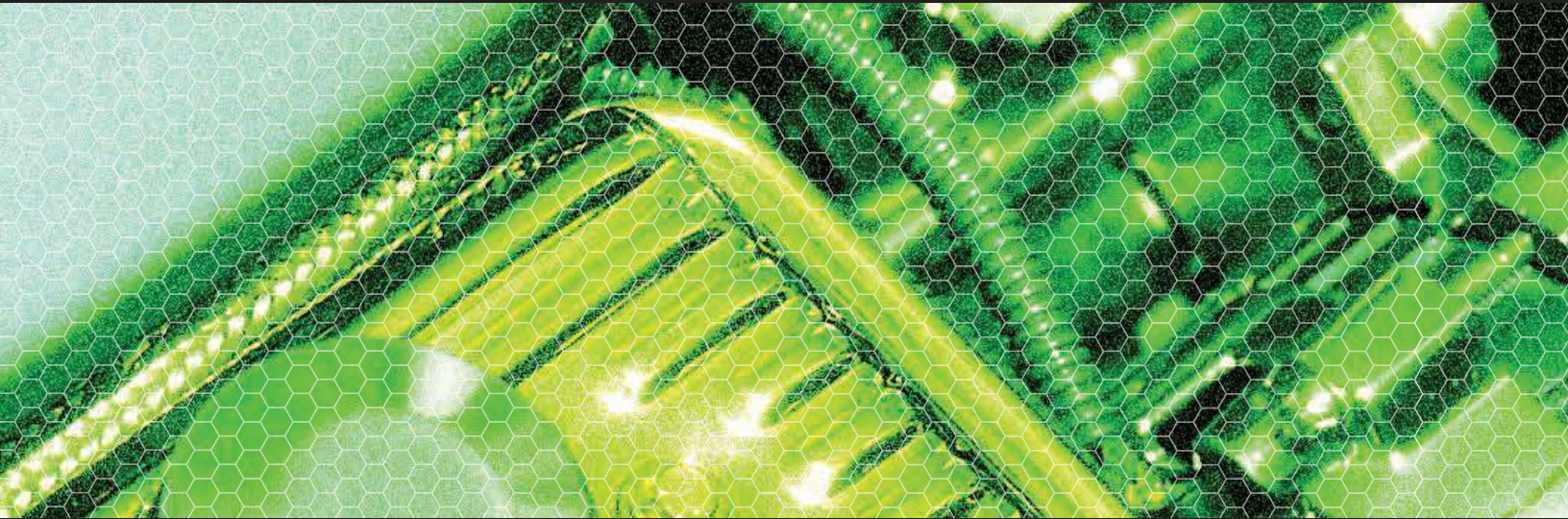
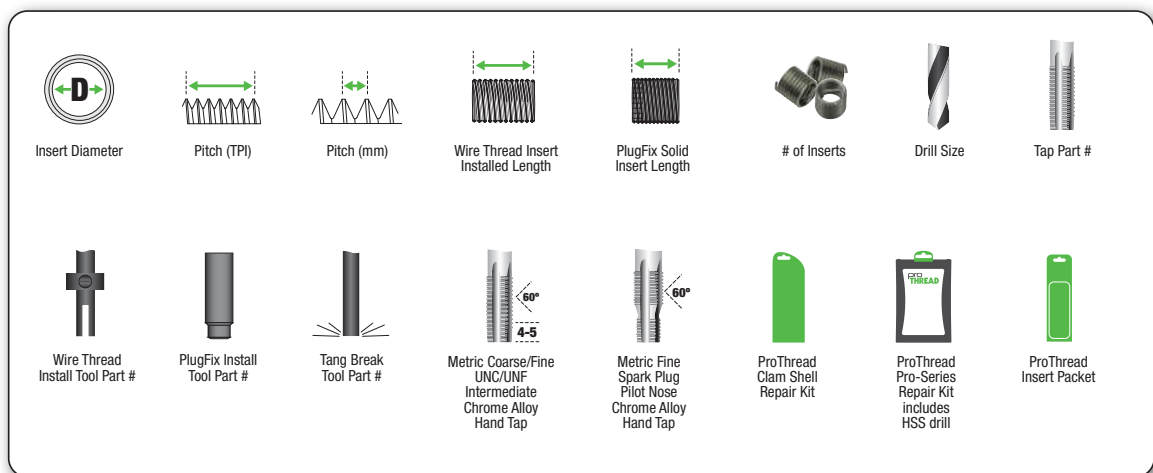


pro
THREAD



THREAD REPAIR SOLUTIONS
FOR THE AUTOMOTIVE AFTERMARKET

BUYER'S GUIDE 08/2015



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ProThread	PlugFix Solid Insert Repair Kit	2
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STANDARD TERMS & CONDITIONS – EFFECTIVE AUGUST 2015

Manufactured from high quality chromium nickel stainless steel, ProThread Wire Thread Inserts provide high strength internal threads that resist the effects of temperature and corrosion. Their unique design ensures superior threads whose compound performance cannot be reproduced by any other single fastening method. Wire Thread inserts are much lighter and less expensive than any other equivalent type of thread insert and because of their compact size they can generally be incorporated into existing designs where no previous provision has been made.

Features & Benefits

For many years, helically coiled wire thread inserts have been vastly underestimated. The popular misconception that they were only designed for the repair of damaged threads has given this unique fastener a false image.

They are much lighter and less expensive than any other equivalent type of thread insert and, because of their compact size, can generally be introduced into existing designs where no previous provision has been made. Unlike many other economic measures, their introduction increases quality and performance while reducing overall product cost. Their introduction may result in the use of thinner sections or lighter parent materials without sacrificing thread strength.

They protect tapped threads against failures due to stripping, seizing, corrosion and wear. ProThread wire thread inserts are produced from austenitic stainless steel wire which is work hardened to a tensile strength above 200,000 psi and a hardness of Rc 43-50. The inserts have an exceedingly smooth surface finish which virtually eliminates friction-induced thread erosion.

The continuous helically coiled design negates the need for thick wall structures to support the internal and external threads - the diamond profile wire coil is the thread. ProThread wire thread inserts can be installed in reduced size bosses or flanges and within constricted areas - saving space and weight while providing high strength. A boss radius equal to the nominal bolt diameter is usually sufficient. A complete range of installation tools are available to suit specific production techniques.

Strength

Due to their flexibility, wire thread inserts create internal threads which have a much improved distribution of residual stress loading when compared with conventional tapped holes, where 75% of the shearing forces are carried by the first three threads in the tapped hole. The flexibility of wire thread inserts help to compensate for pitch and flank angle errors, inherent in normal tapped holes, and significantly enhances the load bearing capacity by deflecting the residual forces into a helical hoop stress which is dispersed into the wall of the tapped hole. This enables the design to be confidently based on the bolt strength utilizing smaller and shorter threads even when used in low strength materials. The high tensile coils of a wire thread insert undergo a diameter reduction during installation. The outward spring-like force of the coils "locks" the insert into place. Each coil can flex independently to contact the greatest amount of parent material thread surface. Both static and dynamic load bearing capabilities are improved.

Eliminate Stress

Virtually no stress is introduced into the parent material because there is no staking, locking, swaging or keying in place. The outward "spring action" of the insert holds it in place.

Wear Resistance

The combination of material hardness and the brilliant surface finish of wire thread inserts creates internal threads in which wear due to thread friction is virtually eliminated. This is of particular value in applications requiring repeated assembly & disassembly. The low frictional coefficient ensures that virtually all of the applied assembly torque is converted into clamping load, thus providing threads that stay tight.

PAYMENT TERMS: Net 30 days, no further credit after 45 days

FREIGHT: F.O.B. Noblesville, IN

Freight Prepaid on orders over \$400 net

MINIMUM ORDER: \$25 Net for open account, No minimum for next day air, or credit card orders

PRICING: Prices are based on purchases of standard package quantities shown.

RETURNED GOODS/CREDIT POLICY:

1. Authorization for return of goods must be approved by our Customer Service representative. If there has been a shipping error, please contact us and we will issue a Return Goods Authorization immediately. **CARTONS THAT DO NOT CARRY AN RGA NUMBER WILL NOT BE ACCEPTED.**
2. Annual inventory adjustments will be negotiated individually, and would apply only to standard stock items that do not require any repackaging.
3. Items that must be repackaged are not eligible for return/credit.
4. Credit for returned goods will be processed on the basis of the prices paid, and must be substantiated by invoice copy.
5. Freight charges for returned goods (other than shipper mistakes) are to be paid by the distributor.
6. Credit for all returns is subject to inspection and acceptance.

PRICES & TERMS SUBJECT TO CHANGE WITHOUT NOTICE

NOTICE: The material presented here is for guidance only. The user assumes full responsibility for determining the suitability of our products for a particular application. Requests for more information are welcome.

DISCLAIMER: SELLER MAKES NO WARRANTY WHATSOEVER, EXPRESSED OR IMPLIED AND ALL IMPLIED WARRANTIES OF MERCHANTABILITY FOR A PARTICULAR PURPOSE ARE DISCLAIMED AND EXCLUDED FROM ALL TRANSACTIONS AND SHALL NOT APPLY TO GOODS SOLD.

REMEDY: Our obligation is limited to the repair or replacement for defective parts or, at our option, the refund of the purchase price. IN NO EVENT SHALL THE SELLER BE LIABLE FOR ANY INCIDENTAL, SPECIAL OR CONSEQUENTIAL DAMAGES, OR ANY DAMAGES IN THE NATURE OF PENALTIES.

KITS
CLAM

GROUP	PROC
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	FREE RUNNING
PACKAGING	CLAM SHELL



THREAD REPAIR KITS – CLAM SHELL

MM	MM	INSTALLED LENGTH	PART #	#	MM	PART #	PART #
METRIC COARSE / METRIC FINE							
5.00	0.80	1.5D	7.50MM	3	5.2*	3597-508I	3500-HIT8-GB
6.00	1.00	1.5D	9.00MM	3	6.3*	3597-61I	3500-HIT9-GB
8.00	1.25	1.5D	12.00MM	3	8.3*	3597-8125I	3500-HIT11-GB
10.00	1.25	1.5D	15.00MM	3	10.3*	3597-10125I	3500-HIT13-GB
10.00	1.50	1.5D	15.00MM	3	10.4*	3597-1015I	3500-HIT13-GB
12.00	1.50	1.5D	18.00MM	3	12.4*	3597-1215I	3500-HIT15-GB
12.00	1.75	1.5D	18.00MM	3	12.5*	3597-12175I	3500-HIT15-GB

MM	MM	INSTALLED LENGTH	PART #	#	MM	PART #	PART #
SPARK PLUG							
12.00	1.25	-	1/2"	2	-	3597-12125PN	3500-HIT15-GB
			3/4"	2			
14.00	1.25	-	3/8"	2	-	3597-14125PN	3500-HIT17-GB
			1/2"	2			
			3/4"	2			

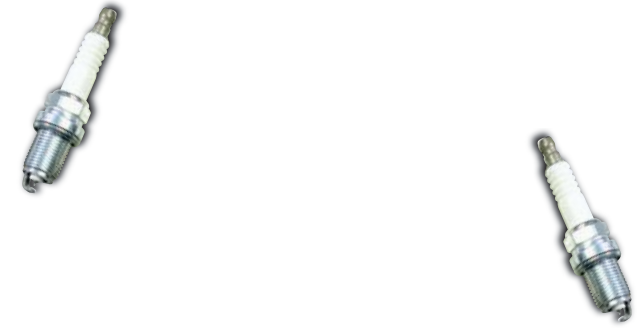
INCH	TPI	INSTALLED LENGTH	PART #	#	MM	PART #	PART #
UNC							
No.6	32	1.5D	0.21"	3	3.7*	3597-632I	3500-HIT5-GB
No.8	32	1.5D	0.25"	3	4.4*	3597-832I	3500-HIT6-GB
No.10	24	1.5D	0.28"	3	5.1*	3597-1024I	3500-HIT7-GB
1/4	20	1.5D	0.38"	3	6.7*	3597-1420I	3500-HIT9-GB
5/16	18	1.5D	0.47"	3	8.3*	3597-51618I	3500-HIT10-GB
3/8	16	1.5D	0.56"	3	9.9*	3597-3816I	3500-HIT13-GB
7/16	14	1.5D	0.66"	3	11.6*	3597-71614I	3500-HIT14-GB
1/2	13	1.5D	0.75"	3	13.0*	3597-1213I	3500-HIT15-GB
UNF							
No.10	32	1.5D	0.28"	3	5.1*	3597-1032I	3500-HIT8-GB
1/4	28	1.5D	0.38"	3	6.7*	3597-1428I	3500-HIT9-GB
5/16	24	1.5D	0.47"	3	8.3*	3597-51624I	3500-HIT11-GB
3/8	24	1.5D	0.56"	3	9.8*	3597-3824I	3500-HIT13-GB
7/16	20	1.5D	0.66"	3	11.5*	3597-71620I	3500-HIT14-GB
1/2	20	1.5D	0.75"	3	13.0*	3597-1220I	3500-HIT15-GB

INCH	TPI	INSTALLED LENGTH	PART #	#	MM	PART #	PART #
UNC							
No.6	32	1.5D	0.21"	3	3.7*	3597-632I	3500-HIT5-GB
No.8	32	1.5D	0.25"	3	4.4*	3597-832I	3500-HIT6-GB
No.10	24	1.5D	0.28"	3	5.1*	3597-1024I	3500-HIT7-GB
1/4	20	1.5D	0.38"	3	6.7*	3597-1420I	3500-HIT9-GB
5/16	18	1.5D	0.47"	3	8.3*	3597-51618I	3500-HIT10-GB
3/8	16	1.5D	0.56"	3	9.9*	3597-3816I	3500-HIT13-GB
7/16	14	1.5D	0.66"	3	11.6*	3597-71614I	3500-HIT14-GB
1/2	13	1.5D	0.75"	3	13.0*	3597-1213I	3500-HIT15-GB
UNF							
No.10	32	1.5D	0.28"	3	5.1*	3597-1032I	3500-HIT8-GB
1/4	28	1.5D	0.38"	3	6.7*	3597-1428I	3500-HIT9-GB
5/16	24	1.5D	0.47"	3	8.3*	3597-51624I	3500-HIT11-GB
3/8	24	1.5D	0.56"	3	9.8*	3597-3824I	3500-HIT13-GB
7/16	20	1.5D	0.66"	3	11.5*	3597-71620I	3500-HIT14-GB
1/2	20	1.5D	0.75"	3	13.0*	3597-1220I	3500-HIT15-GB

GROUP	PROC
INSERT TYPE	SOLID KNURLED
PACKAGING	CLAM SHELL

SPARK PLUG – PLUG FIX

MM	MM	INSERT LENGTH	PART #	#	MM	PART #	PART #
14.00	1.25	-	3/8"	2	-	3599-14125PN	3599-14125SWG
			1/2"	2			
			3/4"	2			



IMPORTANT
It is recommended that when repairing the thread on spark plug ports that you remove the head. If you do not remove the head it is essential that you protect the engine from the ingress of chips and swarf generated by the tapping process.



STI Pilot Nose Taps are used to repair damaged threads and do not require the drilling of a pilot hole. These taps use the existing thread as a guide in tapping a straight hole. STI Pilot Nose Taps are most commonly used to tap holes for the repair of spark plug threads.

*Tapping drill not included in thread repair kit.

GROUP	PROC
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	FREE RUNNING
PACKAGING	KIT BOX



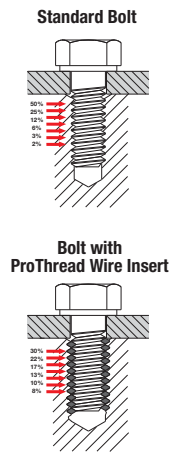
KITS
BOX

THREAD REPAIR KITS – KIT BOX

MM	MM	INSTALLED LENGTH	PART #	#	MM	PART #	PART #	PART #
METRIC COARSE / METRIC FINE								
3.00	0.50	1.5D	4.50MM	20	3.2	3597-305K	3500-HIT4-GB	3500-TB4-GB
4.00	0.70	1.5D	6.00MM	20	4.2	3597-407K	3500-HIT6-GB	3500-TB6-GB
5.00	0.80	1.5D	7.50MM	20	5.2	3597-508K	3500-HIT8-GB	3500-TB8-GB
6.00	1.00	1.5D	9.00MM	20	6.3	3597-61K	3500-HIT9-GB	3500-TB9-GB
8.00	1.25	1.5D	12.00MM	20	8.3	3597-8125K	3500-HIT11-GB	3500-TB12-GB
10.00	1.25	1.5D	15.00MM	15	10.3	3597-10125K	3500-HIT13-GB	3500-TB13-GB
10.00	1.50	1.5D	15.00MM	15	10.4	3597-1015K	3500-HIT13-GB	3500-TB13-GB
12.00	1.50	1.5D	18.00MM	10	12.4	3597-1215K	3500-HIT15-GB	3500-TB15-GB
12.00	1.75	1.5D	18.00MM	10	12.4	3597-12175K	3500-HIT15-GB	3500-TB15-GB
14.00	1.50	1.5D	21.00MM	10	14.4*	3597-1415K	3500-HIT16-GB	-
14.00	2.00	1.5D	21.00MM	10	14.3*	3597-142K	3500-HIT16-GB	-
16.00	2.00	1.5D	24.00MM	10	16.5*	3597-162K	3500-HIT18-GB	-

MM	MM	INSTALLED LENGTH	PART #	#	MM	PART #	PART #	PART #
SPARK PLUG								
10.00	1.00	-	0.339"	5	-	3597-101PN	3500-HIT13-GB	3500-TB13-GB
			1/2"	5				
12.00	1.25	-	1/2"	5	-	3597-12125PN	3500-HIT15-GB	3500-TB15-GB
			3/4"	5				
14.00	1.25	-	3/8"	5	-	3597-14125PN	3500-HIT17-GB	-
			1/2"	5				
			3/4"	5				

INCH	TPI	INSTALLED LENGTH	PART #	#	MM	PART #	PART #	PART #
UNC								
No.6	32	1.5D	0.21"	20	3.8	3597-632I	3500-HIT5-GB	3500-TB5-GB
No.8	32	1.5D	0.25"	20	4.4	3597-832I	3500-HIT6-GB	3500-TB6-GB
No.10	24	1.5D	0.28"	20	5.2	3597-1024I	3500-HIT7-GB	3500-TB8-GB
1/4	20	1.5D	0.38"	20	6.7	3597-1420I	3500-HIT9-GB	3500-TB9-GB
5/16	18	1.5D	0.47"	20	8.3	3597-51618I	3500-HIT10-GB	3500-TB12-GB
3/8	16	1.5D	0.56"	15	9.9	3597-3816I	3500-HIT13-GB	3500-TB12-GB
7/16	14	1.5D	0.66"	15	11.6	3597-71614I	3500-HIT14-GB	3500-TB14-GB
1/2	13	1.5D	0.75"	10	13.0	3597-1213I	3500-HIT15-GB	3500-TB15-GB
9/16	12	1.5D	0.84"	10	15.0*	3597-91612I	3500-HIT16-GB	-
5/8	11	1.5D	0.94"	10	16.5*	3597-5811I	3500-HIT18-GB	-
3/4	10	1.5D	1.13"	5	19.8*	3597-3410I	3500-HIT20-GB	-
UNF								
No.10	32	1.5D	0.28"	20	5.1	3597-1032I	3500-HIT8-GB	3500-TB8-GB
1/4	28	1.5D	0.38"	20	6.7	3597-1428I	3500-HIT9-GB	3500-TB9-GB
5/16	24	1.5D	0.47"	20	8.3	3597-51624I	3500-HIT11-GB	3500-TB12-GB
3/8	24	1.5D	0.56"	15	9.8	3597-3824I	3500-HIT13-GB	3500-TB13-GB
7/16	20	1.5D	0.66"	15	11.5	3597-71620I	3500-HIT14-GB	3500-TB14-GB
1/2	20	1.5D	0.75"	10	13.0	3597-1220I	3500-HIT15-GB	3500-TB15-GB
9/16	18	1.5D	0.84"	10	14.7*	3597-91618I	3500-HIT16-GB	-
5/8	18	1.5D	0.94"	10	16.3*	3597-5818I	3500-HIT18-GB	-
3/4	16	1.5D	1.13"	5	19.5*	3597-3416I	3500-HIT21-GB	-



In a conventional threaded joint 75% of the load is placed on the first three threads. The helical coil design of the ProThread Wire Thread Insert allows the shear loading to be transformed into a more desirable radial loading (hoop stress) over the entire length of the insert.

Use of a ProThread Wire Thread Insert results in a far stronger thread than can be obtained by using conventional drilling or tapping. Improved strength allows designers to select fasteners based on minimum bolt strength and allows the use of smaller diameters and thread lengths - even in magnesium and aluminum alloys.

*Tapping drill not included in thread repair kit.

GROUP	PROC
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	FREE RUNNING
PACKAGING	KIT BOX

WORKSHOP THREAD REPAIR KITS – METRIC COARSE

MM	MM	INSTALLED LENGTH	PART #	#	MM	PART #	PART #	PART #	
M5 – M12									
5.00	0.80	1.5D	7.50MM	3597-MET-WK1	25	5.2	3597-508I	3500-HIT8-GB	3500-TB8-GB
6.00	1.00	1.5D	9.00MM	-	25	6.3	3597-61I	3500-HIT9-GB	3500-TB9-GB
8.00	1.25	1.5D	12.00MM	-	25	8.3	3597-8125I	3500-HIT11-GB	3500-TB12-GB
10.00	1.50	1.5D	15.00MM	-	20	10.4	3597-1015I	3500-HIT13-GB	3500-TB13-GB
12.00	1.75	1.5D	18.00MM	-	15	12.4	3597-12175I	3500-HIT15-GB	3500-TB15-GB

WORKSHOP THREAD REPAIR KITS – METRIC COARSE AND SPARK PLUG

MM	MM	INSTALLED LENGTH	PART #	#	MM	PART #	PART #	PART #	
M6 – M10 + M12 & M14 SPARK PLUG									
6.00	1.00	1.5D	9.00MM	3597-SP-WK1	25	6.3	3597-61I	3500-HIT9-GB	3500-TB9-GB
8.00	1.25	1.5D	12.00MM	-	25	8.3	3597-8125I	3500-HIT11-GB	3500-TB12-GB
10.00	1.50	1.5D	15.00MM	-	20	10.4	3597-1015I	3500-HIT13-GB	3500-TB13-GB
12.00	1.25	-	1/2"	-	5	-	3597-12125PN	3500-HIT15-GB	3500-TB15-GB
12.00	1.25	-	3/4"	-	5	-	-	-	-
14.00	1.25	-	8.40MM	-	5	-	3597-14125PN	3500-HIT17-GB	-
14.00	1.25	-	12.40MM	-	5	-	-	-	-
14.00	1.25	-	16.40MM	-	5	-	-	-	-

WORKSHOP THREAD REPAIR KITS – METRIC COARSE AND METRIC FINE

MM	MM	INSTALLED LENGTH	PART #	#	MM	PART #	PART #	PART #	
M6 & M8 METRIC COARSE AND M10 & M12 METRIC FINE									
6.00	1.00	1.5D	9.00MM	3597-MET-JAPAN	25	6.3	3597-61I	3500-HIT9-GB	3500-TB9-GB
8.00	1.25	1.5D	12.00MM	-	25	8.3	3597-8125I	3500-HIT11-GB	3500-TB12-GB
10.00	1.25	1.5D	15.00MM	-	15	10.3	3597-10125I	3500-HIT13-GB	3500-TB13-GB
12.00	1.25	1.5D	18.00MM	-	10	12.3	3523-12.00I	3500-HIT15-GB	3500-TB15-GB

WORKSHOP THREAD REPAIR KITS – METRIC COARSE, SPARK PLUG AND UNC

MM / INCH	MM / TPI	INSTALLED LENGTH	PART #	#	MM	PART #	PART #	PART #	
M5 – M8 METRIC COARSE + M14 SPARK PLUG AND 1/4" & 5/16" UNC									
5.00	0.80	1.5D	7.50MM	3597-OPE-WK1	25	5.2*	3597-508I	3500-HIT8-GB	3500-TB8-GB
6.00	1.00	1.5D	9.00MM	-	25	6.3*	3597-61I	3500-HIT9-GB	3500-TB9-GB
8.00	1.25	1.5D	12.00MM	-	25	8.3*	3597-8125I	3500-HIT11-GB	3500-TB12-GB
14.00	1.25	-	3/8"	-	3	-	3597-14125PN	3500-HIT17-GB	-
14.00	1.25	-	1/2"	-	3	-	-	-	-
14.00	1.25	-	3/4"	-	3	-	-	-	-
1/4	20	1.5D	0.38"	-	25	6.7*	3597-1420I	3500-HIT9-GB	3500-TB9-GB
5/16	18	1.5D	0.47"	-	25	8.3*	3597-51618I	3500-HIT10-GB	3500-TB12-GB

*Tapping drill not included in thread repair kit.

GROUP	PROC
INSERT TYPE	WIRE THREAD
INSERT MATERIAL	304 STAINLESS STEEL
STYLE	FREE RUNNING
PACKAGING	KIT BOX

WORKSHOP THREAD REPAIR KITS – UNC

INCH	TPI	INSTALLED LENGTH	PART #	#	MM	PART #	PART #	PART #	
UNC 1/4" – UNC 1/2"									
1/4	20	1.5D	0.38"	3597-UNC-WK1	25	6.7	3597-1420I	3500-HIT9-GB	3500-TB9-GB
5/16	18	1.5D	0.47"	-	25	8.3	3597-51618I	3500-HIT10-GB	3500-TB12-GB
3/8	16	1.5D	0.56"	-	20	9.9	3597-3816I	3500-HIT13-GB	3500-TB12-GB
7/16	14	1.5D	0.66"	-	20	11.6	3597-71614I	3500-HIT14-GB	3500-TB14-GB
1/2	13	1.5D	0.75"	-	15	13.0	3597-1213I	3500-HIT15-GB	3500-TB15-GB

WORKSHOP THREAD REPAIR KITS – UNF

INCH	TPI	INSTALLED LENGTH	PART #	#	MM	PART #	PART #	PART #	
UNF 1/4" – UNF 1/2"									
1/4	28	1.5D	0.38"	3597-UNF-WK1	20	6.7	3597-1428I	3500-HIT9-GB	3500-TB9-GB
5/16	24	1.5D	0.47"	-	20	8.3	3597-51624I	3500-HIT11-GB	3500-TB12-GB
3/8	24	1.5D	0.56"	-	15	9.8	3597-3824I	3500-HIT13-GB	3500-TB13-GB
7/16	20	1.5D	0.66"	-	10	11.5	3597-71620I	3500-HIT14-GB	3500-TB14-GB
1/2	20	1.5D	0.75"	-	10	13.0	3597-1220I	3500-HIT15-GB	3500-TB15-GB



WIREFINSERTS
PACKETS

GROUP	PRWI
INSERT TYPE	WIRE THREAD
MATERIAL	304 STAINLESS STEEL
STYLE	FREE RUNNING
PACKAGING	CLAM SHELL

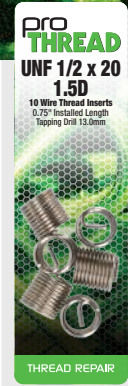
HANG SELL REPLACEMENT INSERTS

MM	MM	INSTALLED LENGTH	#	PART #	
METRIC COARSE / METRIC FINE					
3.00	0.50	1.5D	4.00MM	10	3597-305X4.5P
4.00	0.70	1.5D	6.00MM	10	3597-407X6P
5.00	0.80	1.5D	7.50MM	10	3597-508X7.5P
6.00	1.00	1.5D	9.00MM	10	3597-61X9P
8.00	1.25	1.5D	12.00MM	10	3597-8125X12P
10.00	1.25	1.5D	15.00MM	10	3597-10125X15P
10.00	1.50	1.5D	15.00MM	10	3597-1015X15P
12.00	1.50	1.5D	18.00MM	10	3597-1215X18P
12.00	1.75	1.5D	18.00MM	10	3597-12175X18P
14.00	1.50	1.5D	21.00MM	5	3597-1415X21P
14.00	2.00	1.5D	21.00MM	5	3597-142X21P
16.00	2.00	1.5D	24.00MM	5	3597-162X24P

MM	MM	INSTALLED LENGTH	#	PART #	
SPARK PLUG					
10.00	1.00	-	0.339"	10	3597-101X.339P
10.00	1.00	-	1/2"	10	3597-101X1/2P
12.00	1.25	-	1/2"	10	3597-12125X1/2P
12.00	1.25	-	3/4"	10	3597-12125X3/4P
14.00	1.25	-	3/8"	10	3597-14125X3/8P
14.00	1.25	-	1/2"	10	3597-14125X1/2P
14.00	1.25	-	3/4"	10	3597-14125X3/4P

INCH	TPI	INSTALLED LENGTH	#	PART #	
UNC					
No.6	32	1.5D	0.21"	10	3597-632X207P
No.8	32	1.5D	0.25"	10	3597-832X246P
No.10	24	1.5D	0.28"	10	3597-1024X285P
1/4	20	1.5D	0.38"	10	3597-1420X375P
5/16	18	1.5D	0.47"	10	3597-51618X469P
3/8	16	1.5D	0.56"	10	3597-3816X562P
7/16	14	1.5D	0.66"	10	3597-71614X656P
1/2	13	1.5D	0.75"	10	3597-1213X750P
9/16	12	1.5D	0.84"	5	3597-91612X844P
5/8	11	1.5D	0.94"	5	3597-5811X937P
3/4	10	1.5D	1.13"	5	3597-3410X1.125P

INCH	TPI	INSTALLED LENGTH	#	PART #	
UNF					
No.10	32	1.5D	0.28"	10	3597-1032X285P
1/4	28	1.5D	0.38"	10	3597-1428X375P
5/16	24	1.5D	0.47"	10	3597-51624X469P
3/8	24	1.5D	0.56"	10	3597-3824X562P
7/16	20	1.5D	0.66"	10	3597-71620X656P
1/2	20	1.5D	0.75"	10	3597-1220X750P
9/16	18	1.5D	0.84"	5	3597-91618X844P
5/8	18	1.5D	0.94"	5	3597-5818X937P
3/4	16	1.5D	1.13"	5	3597-3416X1.125P



PLUG FIX SOLID INSERT

GROUP	PRWI
INSERT TYPE	SOLID KNURLED
PACKAGING	CLAM SHELL

HANG SELL REPLACEMENT INSERTS

MM	MM	INSERT LENGTH	#	PART #
SPARK PLUG - PLUG FIX				
14.00	1.25	2 EACH: 3/8", 1/2", 3/4"	6	3599-14125CP
14.00	1.25	3/8"	5	3599-14125X3/8P
14.00	1.25	1/2"	5	3599-14125X1/2P
14.00	1.25	3/4"	5	3599-14125X3/4P

MERCHANDISERS

GROUP -	PART #
8 KIT BENCH TOP MERCHANDISER	3597-D1

MM / INCH	MM / TPI	DESCRIPTION	QTY	PART #	QTY	PART #
METRIC COARSE / METRIC FINE						
5.00	0.80	WIRE INSERTS	1	3597-508K	1	3597-508X7.5P
6.00	1.00	WIRE INSERTS	1	3597-61K	1	3597-61X9P
8.00	1.25	WIRE INSERTS	1	3597-8125K	1	3597-8125X12P
10.00	1.50	WIRE INSERTS	1	3597-1015K	1	3597-1015X15P
12.00	1.75	WIRE INSERTS	1	3597-12175K	1	3597-12175X18P
12.00	1.25	WIRE INSERTS	1	3598-12125K	-	-
14.00	1.25	WIRE INSERTS	1	3598-14125K	1	3597-14125X3/8P
14.00	1.25	WIRE INSERTS	-	-	1	3597-14125X1/2P
14.00	1.25	WIRE INSERTS	-	-	1	3597-14125X3/4P
14.00	1.25	PLUG FIX SOLID	1	3599-14125K	1	3599-14125X3/8P
14.00	1.25	PLUG FIX SOLID	-	-	1	3599-14125X1/2P
14.00	1.25	PLUG FIX SOLID	-	-	1	3599-14125X3/4P
14.00	1.25	PLUG FIX SOLID	-	-	1	3599-14125CP

GROUP PROC	PART #
10 KIT BENCH TOP MERCHANDISER	3598-D1

MM / INCH	MM / TPI	DESCRIPTION	QTY	PART #	QTY	PART #
METRIC COARSE / METRIC FINE						
6.00	1.00	WIRE INSERTS	1	3598-61K	1	3597-61X9P
8.00	1.25	WIRE INSERTS	1	3598-8125K	1	3597-8125X12P
10.00	1.50	WIRE INSERTS	1	3598-1015K	1	3597-1015X15P
12.00	1.75	WIRE INSERTS	1	3598-12175K	1	3597-12175X18P
14.00	1.25	WIRE INSERTS	1	3598-14125K	1	3597-14125X3/8P
14.00	1.25	WIRE INSERTS	-	-	1	3597-14125X1/2P
14.00	1.25	WIRE INSERTS	-	-	1	3597-14125X3/4P
14.00	1.25	PLUG FIX SOLID	1	3599-14125K	1	3599-14125X3/8P
14.00	1.25	PLUG FIX SOLID	-	-	1	3599-14125X1/2P
14.00	1.25	PLUG FIX SOLID	-	-	1	3599-14125X3/4P
UNC						
1/4	20	WIRE INSERTS	1	3598-1420K	1	3597-1420X375P
5/16	18	WIRE INSERTS	1	3598-51618K	1	3597-51618X469P
3/8	16	WIRE INSERTS	1	3598-3816K	1	3597-3816X562P
7/16	14	WIRE INSERTS	1	3598-71614	1	3597-71614X656P



TheProThreadbenchmerchandisersaredouble sidedunits thatdisplaythreadrepairkits onone sideandreplacementinsertpackets ontheother.

STI TAPS
CARBONSTEEL

GROUP	PROT
MATERIAL	CARBON STEEL
LEAD	INTERMEDIATE
TYPE	STI (SCREW THREAD INSERT)

STI TAPS



MM	MM	PART #
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METRIC COARSE / METRIC FINE

3.00	0.50	3597-305I
4.00	0.70	3597-407I
5.00	0.80	3597-508I
6.00	1.00	3597-61I
7.00	1.00	3597-71I
8.00	1.25	3597-8125I
10.00	1.25	3597-10125I
10.00	1.50	3597-1015I
12.00	1.50	3597-1215I
12.00	1.75	3597-12175I
14.00	1.50	3597-1415I
14.00	2.00	3597-142I
16.00	2.00	3597-162I



MM	MM	PART #
----	----	--------

SPARK PLUG

10.00	1.00	3597-101PN
12.00	1.25	3597-12125PN
14.00	1.25	3597-14125PN



INCH	TPI	PART #
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UNC

No.6	32	3597-632I
No.8	32	3597-832I
No.10	24	3597-1024I
1/4	20	3597-1420I
5/16	18	3597-51618I
3/8	16	3597-3816I
7/16	14	3597-71614I
1/2	13	3597-1213I
9/16	12	3597-91612I
5/8	11	3597-5811I
3/4	10	3597-3410I

UNF

No.10	32	3597-1032I
1/4	28	3597-1428I
5/16	24	3597-51624I
3/8	24	3597-3824I
7/16	20	3597-71620I
1/2	20	3597-1220I
9/16	18	3597-91618I
5/8	18	3597-5818I
3/4	16	3597-3416I

GROUP	PROT
MATERIAL	CARBON STEEL
LEAD	INTERMEDIATE
TYPE	STI (SCREW THREAD INSERT)

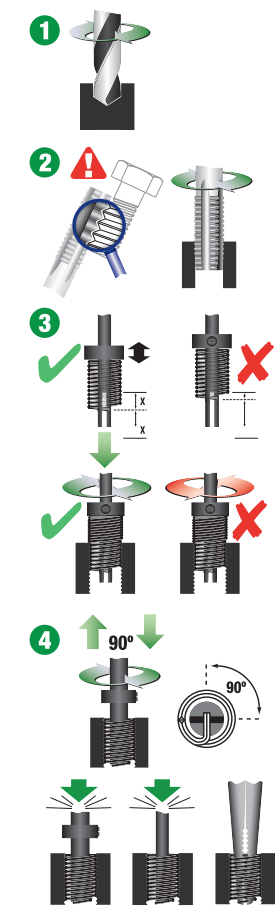
PLUG FIX – HEX END PILOT NOSE TAP



MM	MM	PART #
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SPARK PLUG – PLUG FIX

14.00	1.25	3599-14125PN
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1 Drill to clear the damaged thread with a standard twist drill. The required tapping drill size is shown on the front of each pack. **NOTE** Spark Plug inserts utilise a pilot nose tap which does not require pre-drilling.

2 Use the specified tap to cut the holding thread into the cleared hole. When tapping a hole, it is recommended to use a suitable cutting lubricant. **NOTE** Wire Thread inserts require the use of STI taps which are slightly oversize to provide the correct hole diameter. Always check that the thread and pitch of the tap are the same as the bolt or spark plug you wish to insert into the finished hole.

3 Loosen the grub screw and slide the collar along the insert tool shaft so that the tang on the insert is positioned half way up the insert tool slot. **NOTE** Do not position tang at the very top or bottom of the insert tool slot. Use the installation tool to wind the insert into the threaded hole using light downward pressure until half a turn below the surface. **NOTE** Do not work against the thread direction as the tang may break off.

4 Lift installation tool, rotate 90° and tap down sharply to break off wire thread insert tang. Use the tang break off tool to perform this function where supplied. **NOTE** For spark plug and large inserts use long nose pliers to remove the tang.

You have successfully repaired your damaged thread. The new thread is normally stronger than the original.

GROUP	PROI
USE WITH	PLUG FIX SOLID INSERTS
TOOL TYPE	HAND INSTALLATION

PLUG FIX – SWAGE TOOL



MM	MM	PART #
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SPARK PLUG – PLUG FIX

14.00	1.25	3599-14125SWG
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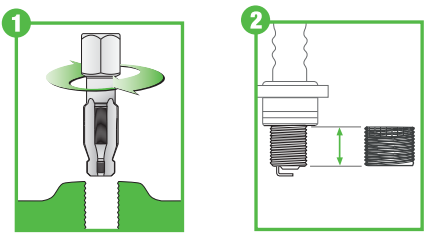
Features and benefits

- No drill required
- Solid inserts in 3 lengths to suit most common spark plug reaches
- Suitable for aluminium and cast iron
- Simple, easy to use permanent repair

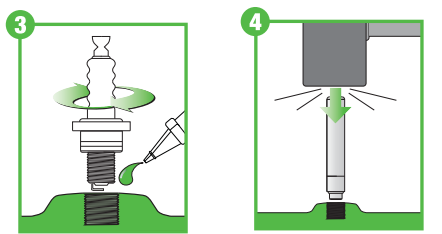
Applications

- Taper and gasket seat spark plug ports

IMPORTANT NOTE
It is important that no foreign material enters the combustion chamber. We recommend the head be removed from the engine prior to repair.



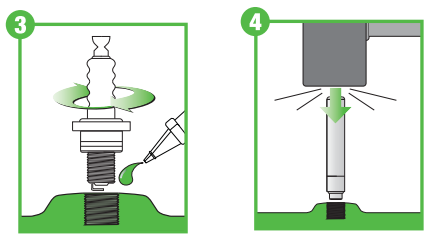
1 Pilot nose taps require no pre-drilling. Lubricate the tap with a suitable lubricant. Hand start tap and then turn with 19mm or 3/4" socket wrench. Tap entire length of port.



2 Select Insert: Ensure selected insert is the same length as the thread on the spark plug. The knurled end of the insert should be at the top of the spark plug port.



3 Install Insert: Wind the correct insert on to the spark plug. Coat outside threads with hi-temp silicone. Wind assembly into spark plug port until fully seated. Wind spark plug out.



4 Complete installation: Place swage tool into insert and hit several times to expand knurl. Install spark plug to recommended torque. Do not run engine until sealant has cured (refer to manufacturer's instructions).

INSTALLATION
TOOLS

HAND INSTALLATION TOOLS



METRIC COARSE / METRIC FINE

3.00	0.50	3500-HIT4-GB
4.00	0.70	3500-HIT6-GB
5.00	0.80	3500-HIT8-GB
6.00	1.00	3500-HIT9-GB
7.00	1.00	3500-HIT10-GB
8.00	1.25	3500-HIT11-GB
10.00	1.25	3500-HIT13-GB
10.00	1.50	3500-HIT13-GB
12.00	1.50	3500-HIT15-GB
12.00	1.75	3500-HIT15-GB
14.00	1.50	3500-HIT16-GB
14.00	2.00	3500-HIT16-GB
16.00	2.00	3500-HIT18-GB



SPARK PLUG

10.00	1.00	3500-HIT13-GB
12.00	1.25	3500-HIT15-GB
14.00	1.25	3500-HIT17-GB



UNC

No.6	32	3500-HIT5-GB
No.8	32	3500-HIT6-GB
No.10	24	3500-HIT7-GB
1/4	20	3500-HIT9-GB
5/16	18	3500-HIT10-GB
3/8	16	3500-HIT13-GB
7/16	14	3500-HIT14-GB
1/2	13	3500-HIT15-GB
9/16	12	3500-HIT16-GB
5/8	11	3500-HIT18-GB
3/4	10	3500-HIT20-GB

UNF

No.10	32	3500-HIT8-GB
1/4	28	3500-HIT9-GB
5/16	24	3500-HIT11-GB
3/8	24	3500-HIT13-GB
7/16	20	3500-HIT14-GB
1/2	20	3500-HIT15-GB
9/16	18	3500-HIT16-GB
5/8	18	3500-HIT18-GB
3/4	16	3500-HIT21-GB

pro THREAD



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