

**Conventional tools**

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Heli-Coil tap M 10  
Item No. 0140 0100104

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Heli-Coil threaded insert M 10  
Standard item No. 0130 0100020

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e.g. Böllhoff & Co., D–4800 Bielefeld 14

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Heli-Coil hand installer M 10  
Item No. 0150 0410000–1

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**Note**

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Stripped threads for intermediate flange or transmission attachment must be replaced with Heli-Coil threaded inserts standard, item No. 0130 0100020, with a length equivalent to twice the diameter of the bolts (11 threads).

If stripped threads are not accessible with removed transmission or intermediate flange because of limited space, the engine must be removed.

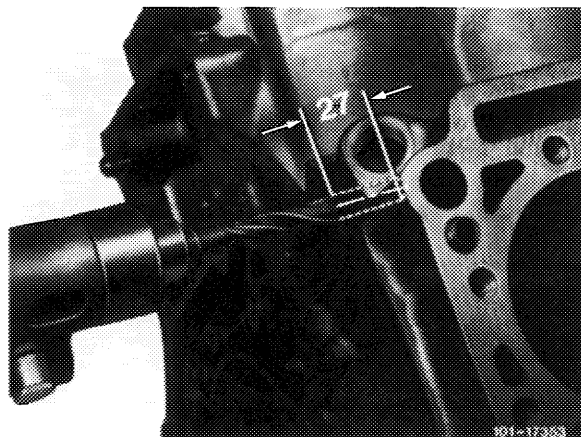
**Reconditioning**

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1 Drill core hole approx. 27 mm deep using an HSS spiral drill of 10 mm dia.

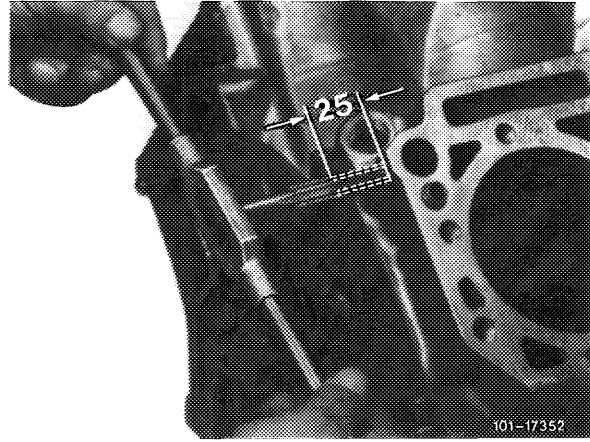
The core hole diameter should be a minimum of 10 mm and a maximum of 10.3 mm.

2 Blow out chips.



3 Cut Heli-Coil installation thread approx. 25 mm deep using Heli-Coil tap M 10 (outside diameter 12.0 mm), item No. 0140 0100104. To do so, lubricate tap with honing oil.

4 Blow out chips.

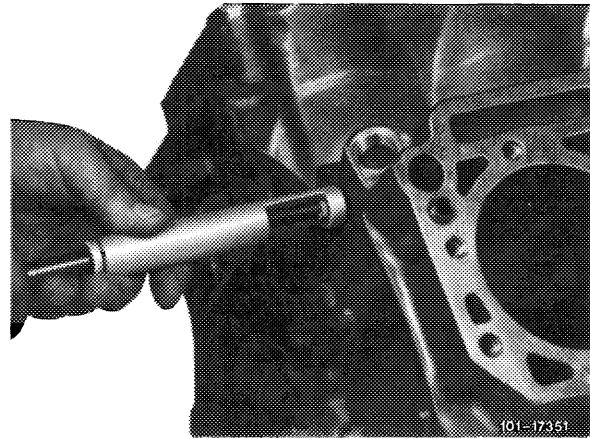


5 Use hand installer M 10, item No. 0150 0410000-1, to screw in oil-coated Heli-Coil threaded insert M 10, standard item No. 0130 01000020.

**Caution!**

The uppermost thread must be positioned approx. 2 mm below the mating surface.

6 Using an arbor, break off drive end of the threaded bush.



7 Screw in a bolt to check inserted thread for misalignment and ease of operation.

The screw-in depth should be approx. 23 mm.