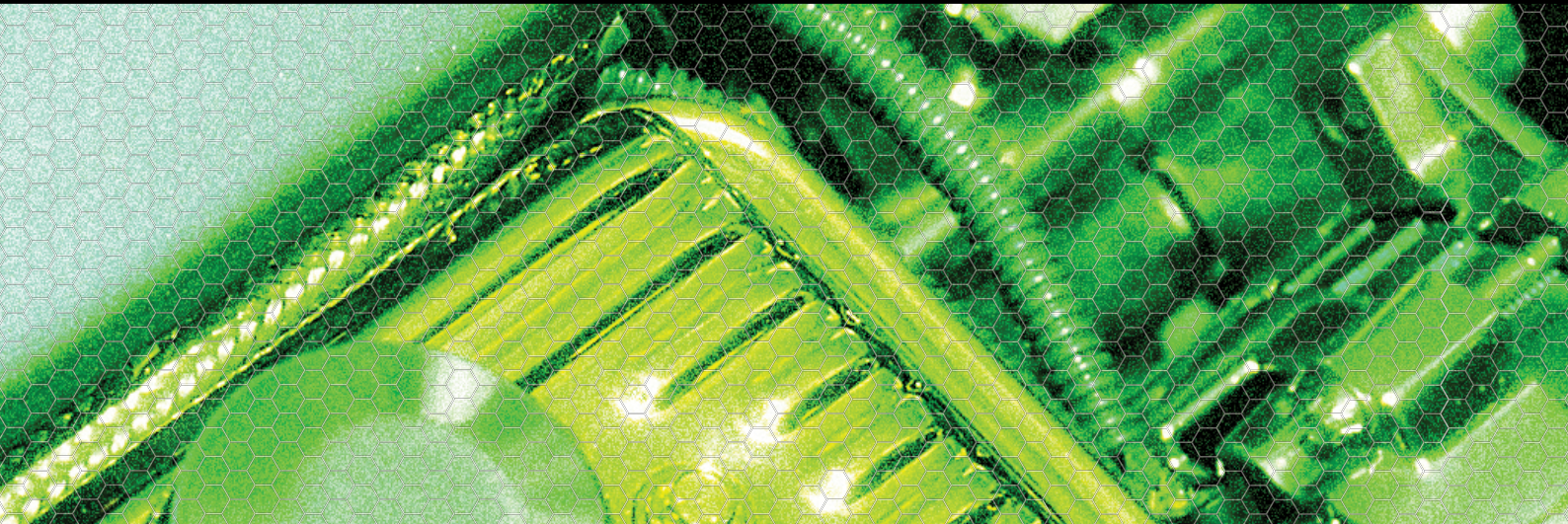
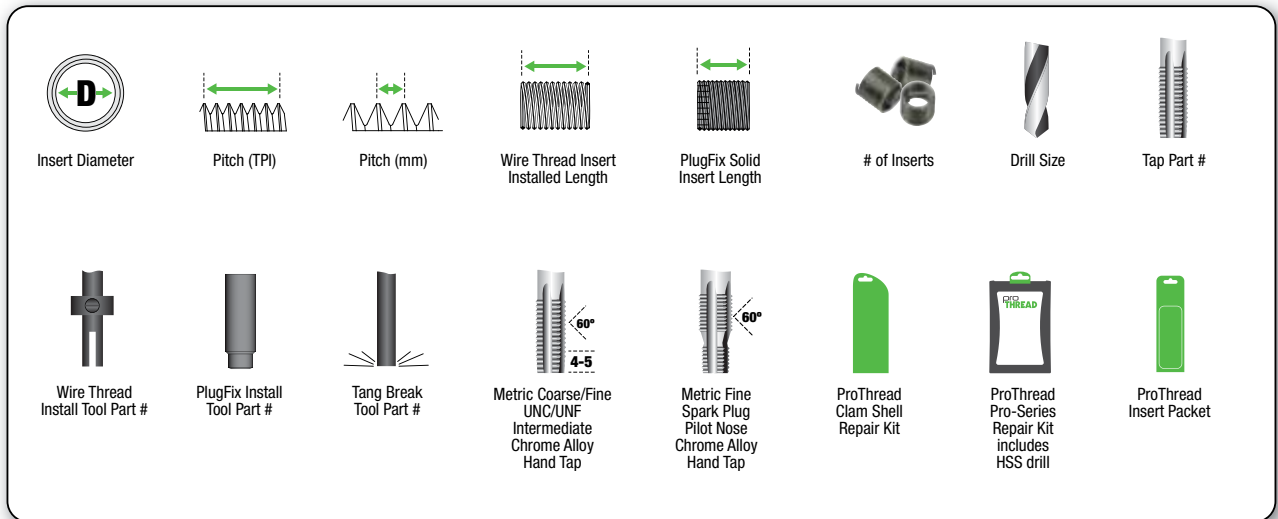


pro  
**THREAD**



**THREAD REPAIR SOLUTIONS**  
FOR THE AUTOMOTIVE AFTERMARKET

**BUYER'S GUIDE 03/2015**



**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 whilst 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 200,000psi and a hardness of Rc43-50. 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 helps 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 utilising 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.

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  2. **FREIGHT TERMS:** Bordo has no minimum invoice value. All orders over \$250 nett exclusive of GST are freight-free — prices are ex-warehouse. Bordo reserves the right to despatch freight-free orders by a carrier and method of its choosing. Freight-free orders are calculated on a \$250 nett exclusive of GST basis per order for each warehouse dispatch. Drop-shipments incur freight charges.
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    - 7.1 Goods delivered by Bordo International Pty Ltd ("the supplier") to the customer ("the goods") remain the sole and absolute property of the supplier as legal and equitable owner until all money due to the supplier from the customer on any account has been paid by the customer to the supplier but are at the customer's risk from the time of delivery of the goods to it.
    - 7.2 The customer acknowledges that it is in possession of the goods as bailee for the supplier until they are sold by the customer to another party and property as between the customer and the other party is deemed to have passed.
    - 7.3 Until delivery to a purchaser from the customer, the customer undertakes to store the goods on its premises separately from its own goods or those of any other person in a manner which makes them readily identifiable as goods of the supplier.
    - 7.4 The customer's right to possession of the goods ceases if it does anything or fails to do anything which would entitle a receiver to take possession of any assets of the customer or which would entitle any person to present a petition for the winding up of the customer.
    - 7.5 The applicant's purchaser's right to possession of the goods ceases if under the Corporations Act 2001 an administrator is appointed over the customer.
    - 7.6 The supplier may for the purpose of examination or recovery of the goods enter upon the premises where they are stored or where they are reasonably thought to be stored.
    - 7.7 The entire proceeds of the sale of any of the goods by the customer must be held in trust for the supplier and must not be mingled with any other money paid into any overdrawn bank account and must at all times be identifiable as the money of the supplier.
    - 7.8 Until the goods have been paid for in full the purchaser is at liberty to sell the goods in the ordinary course of its business as agent of the supplier and must account to the supplier for the proceeds of any such sales.
    - 7.9 The customer warrants that it is not at the time of entering into this agreement insolvent and knows of no circumstances which would entitle any creditor to appoint a receiver or to petition for winding up or to exercise any other rights over or against its assets.
    - 7.10 If any of these retention of title provisions are construed to be invalid or not enforceable in accordance with their terms all other provisions which are self-sustaining and capable of separate enforcement without regard to the invalid provisions shall be and continue to be valid and enforceable in accordance with their terms.
  8. **CREDITS/RETURNS:** Authorisation must be obtained before returning goods for credit. No goods will be accepted for credit that are correctly supplied and invoiced if not returned freight paid within 14 days and delivery freight will be charged. Also a 10% restocking fee will be charged for any goods supplied correctly. For details on credit/return procedure please visit our web site [www.bordo.com.au](http://www.bordo.com.au)
  9. **FAULTY GOODS:** Will be replaced no charge freight paid. Please hold faulty goods pending our instruction to either hand to representative on next visit or return at our expense.
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**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.

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

**THREAD REPAIR KITS – CLAM SHELL**

MM	MM	INSTALLED LENGTH	\$	PART #	#	MM	PART #	PART #	
<b>METRIC COARSE / METRIC FINE</b>									
<b>5.00</b>	0.80	1.5D	7.50MM	<b>21.84</b>	3598-508K	3	5.2*	3597-508I	3500-HIT8-GB
<b>6.00</b>	1.00	1.5D	9.00MM	<b>21.84</b>	3598-61K	3	6.3*	3597-61I	3500-HIT9-GB
<b>8.00</b>	1.25	1.5D	12.00MM	<b>26.00</b>	3598-8125K	3	8.3*	3597-8125I	3500-HIT11-GB
<b>10.00</b>	1.25	1.5D	15.00MM	<b>32.24</b>	3598-10125K	3	10.3*	3597-10125I	3500-HIT13-GB
<b>10.00</b>	1.50	1.5D	15.00MM	<b>32.24</b>	3598-1015K	3	10.4*	3597-1015I	3500-HIT13-GB
<b>12.00</b>	1.50	1.5D	18.00MM	<b>39.52</b>	3598-1215K	3	12.4*	3597-1215I	3500-HIT15-GB
<b>12.00</b>	1.75	1.5D	18.00MM	<b>39.52</b>	3598-12175K	3	12.5*	3597-12175I	3500-HIT15-GB

MM	MM	INSTALLED LENGTH	\$	PART #	#	MM	PART #	PART #	
<b>SPARK PLUG</b>									
<b>12.00</b>	1.25	–	1/2"	<b>52.00</b>	3598-12125K	2	–	3597-12125PN	3500-HIT15-GB
		–	3/4"	–	–	2	–	–	–
<b>14.00</b>	1.25	–	3/8"	<b>53.04</b>	3598-14125K	2	–	3597-14125PN	3500-HIT17-GB
		–	1/2"	–	–	2	–	–	–
		–	3/4"	–	–	2	–	–	–

INCH	TPI	INSTALLED LENGTH	\$	PART #	#	MM	PART #	PART #	
<b>UNC</b>									
<b>No.6</b>	32	1.5D	0.21"	<b>29.12</b>	3598-632K	3	3.7*	3597-632I	3500-HIT5-GB
<b>No.8</b>	32	1.5D	0.25"	<b>29.12</b>	3598-832K	3	4.4*	3597-832I	3500-HIT6-GB
<b>No.10</b>	24	1.5D	0.28"	<b>23.92</b>	3598-1024K	3	5.1*	3597-1024I	3500-HIT7-GB
<b>1/4</b>	20	1.5D	0.38"	<b>23.92</b>	3598-1420K	3	6.7*	3597-1420I	3500-HIT9-GB
<b>5/16</b>	18	1.5D	0.47"	<b>23.92</b>	3598-51618K	3	8.3*	3597-51618I	3500-HIT10-GB
<b>3/8</b>	16	1.5D	0.56"	<b>30.16</b>	3598-3816K	3	9.9*	3597-3816I	3500-HIT13-GB
<b>7/16</b>	14	1.5D	0.66"	<b>35.36</b>	3598-71614K	3	11.6*	3597-71614I	3500-HIT14-GB
<b>1/2</b>	13	1.5D	0.75"	<b>38.48</b>	3598-1213K	3	13.0*	3597-1213I	3500-HIT15-GB

INCH	TPI	INSTALLED LENGTH	\$	PART #	#	MM	PART #	PART #	
<b>UNF</b>									
<b>No.10</b>	32	1.5D	0.28"	<b>23.92</b>	3598-1032K	3	5.1*	3597-1032I	3500-HIT8-GB
<b>1/4</b>	28	1.5D	0.38"	<b>23.92</b>	3598-1428K	3	6.7*	3597-1428I	3500-HIT9-GB
<b>5/16</b>	24	1.5D	0.47"	<b>23.92</b>	3598-51624K	3	8.3*	3597-51624I	3500-HIT11-GB
<b>3/8</b>	24	1.5D	0.56"	<b>30.16</b>	3598-3824K	3	9.8*	3597-3824I	3500-HIT13-GB
<b>7/16</b>	20	1.5D	0.66"	<b>35.36</b>	3598-71620K	3	11.5*	3597-71620I	3500-HIT14-GB
<b>1/2</b>	20	1.5D	0.75"	<b>38.48</b>	3598-1220K	3	13.0*	3597-1220I	3500-HIT15-GB

**PLUG FIX SOLID INSERT**

<b>GROUP</b>	<b>PROC</b>
INSERT TYPE	SOLID KNURLED
PACKAGING	<b>CLAM SHELL</b>

**SPARK PLUG – PLUG FIX**

MM	MM	INSERT LENGTH	\$	PART #	#	MM	PART #	PART #	
<b>14.00</b>	1.25	–	3/8"	<b>53.04</b>	3599-14125K	2	–	3599-14125PN	3599-14125SWG
		–	1/2"	–	–	2	–	–	–
		–	3/4"	–	–	2	–	–	–





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

#### THREAD REPAIR KITS – KIT BOX

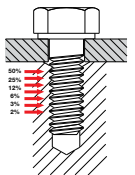
MM	MM	INSTALLED LENGTH	\$	PART #	#	MM	PART #	PART #	PART #	
<b>METRIC COARSE / METRIC FINE</b>										
3.00	0.50	1.5D	4.50MM	36.40	3597-305K	20	3.2	3597-305I	3500-HIT4-GB	3500-TB4-GB
4.00	0.70	1.5D	6.00MM	36.40	3597-407K	20	4.2	3597-407I	3500-HIT6-GB	3500-TB6-GB
5.00	0.80	1.5D	7.50MM	31.20	3597-508K	20	5.2	3597-508I	3500-HIT8-GB	3500-TB8-GB
6.00	1.00	1.5D	9.00MM	31.20	3597-61K	20	6.3	3597-61I	3500-HIT9-GB	3500-TB9-GB
8.00	1.25	1.5D	12.00MM	36.40	3597-8125K	20	8.3	3597-8125I	3500-HIT11-GB	3500-TB12-GB
10.00	1.25	1.5D	15.00MM	46.80	3597-10125K	15	10.3	3597-10125I	3500-HIT13-GB	3500-TB13-GB
10.00	1.50	1.5D	15.00MM	46.80	3597-1015K	15	10.4	3597-1015I	3500-HIT13-GB	3500-TB13-GB
12.00	1.50	1.5D	18.00MM	57.20	3597-1215K	10	12.4	3597-1215I	3500-HIT15-GB	3500-TB15-GB
12.00	1.75	1.5D	18.00MM	57.20	3597-12175K	10	12.4	3597-12175I	3500-HIT15-GB	3500-TB15-GB
14.00	1.50	1.5D	21.00MM	72.80	3597-1415K	10	14.4*	3597-1415I	3500-HIT16-GB	–
14.00	2.00	1.5D	21.00MM	72.80	3597-142K	10	14.3*	3597-142I	3500-HIT16-GB	–
16.00	2.00	1.5D	24.00MM	83.20	3597-162K	10	16.5*	3597-162I	3500-HIT18-GB	–

MM	MM	INSTALLED LENGTH	\$	PART #	#	MM	PART #	PART #	PART #	
<b>SPARK PLUG</b>										
10.00	1.00	–	0.339"	62.40	3597-101K	5	–	3597-101PN	3500-HIT13-GB	3500-TB13-GB
			1/2"	–	–	5	–	–	–	–
12.00	1.25	–	1/2"	72.80	3597-12125K	5	–	3597-12125PN	3500-HIT15-GB	3500-TB15-GB
			3/4"	–	–	5	–	–	–	–
14.00	1.25	–	3/8"	74.88	3597-14125K	5	–	3597-14125PN	3500-HIT17-GB	–
			1/2"	–	–	5	–	–	–	–
			3/4"	–	–	5	–	–	–	–

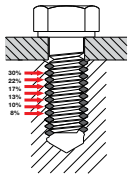
INCH	TPI	INSTALLED LENGTH	\$	PART #	#	MM	PART #	PART #	PART #	
<b>UNC</b>										
No.6	32	1.5D	0.21"	41.60	3597-632K	20	3.8	3597-632I	3500-HIT5-GB	3500-TB5-GB
No.8	32	1.5D	0.25"	41.60	3597-832K	20	4.4	3597-832I	3500-HIT6-GB	3500-TB6-GB
No.10	24	1.5D	0.28"	33.28	3597-1024K	20	5.2	3597-1024I	3500-HIT7-GB	3500-TB8-GB
1/4	20	1.5D	0.38"	33.28	3597-1420K	20	6.7	3597-1420I	3500-HIT9-GB	3500-TB9-GB
5/16	18	1.5D	0.47"	38.48	3597-51618K	20	8.3	3597-51618I	3500-HIT10-GB	3500-TB12-GB
3/8	16	1.5D	0.56"	48.88	3597-3816K	15	9.9	3597-3816I	3500-HIT13-GB	3500-TB12-GB
7/16	14	1.5D	0.66"	50.96	3597-71614K	15	11.6	3597-71614I	3500-HIT14-GB	3500-TB14-GB
1/2	13	1.5D	0.75"	59.28	3597-1213K	10	13.0	3597-1213I	3500-HIT15-GB	3500-TB15-GB
9/16	12	1.5D	0.84"	72.80	3597-91612K	10	15.0*	3597-91612I	3500-HIT16-GB	–
5/8	11	1.5D	0.94"	83.20	3597-5811K	10	16.5*	3597-5811I	3500-HIT18-GB	–
3/4	10	1.5D	1.13"	93.60	3597-3410K	5	19.8*	3597-3410I	3500-HIT20-GB	–

INCH	TPI	INSTALLED LENGTH	\$	PART #	#	MM	PART #	PART #	PART #	
<b>UNF</b>										
No.10	32	1.5D	0.28"	33.28	3597-1032K	20	5.1	3597-1032I	3500-HIT8-GB	3500-TB8-GB
1/4	28	1.5D	0.38"	33.28	3597-1428K	20	6.7	3597-1428I	3500-HIT9-GB	3500-TB9-GB
5/16	24	1.5D	0.47"	38.48	3597-51624K	20	8.3	3597-51624I	3500-HIT11-GB	3500-TB12-GB
3/8	24	1.5D	0.56"	48.88	3597-3824K	15	9.8	3597-3824I	3500-HIT13-GB	3500-TB13-GB
7/16	20	1.5D	0.66"	50.96	3597-71620K	15	11.5	3597-71620I	3500-HIT14-GB	3500-TB14-GB
1/2	20	1.5D	0.75"	59.28	3597-1220K	10	13.0	3597-1220I	3500-HIT15-GB	3500-TB15-GB
9/16	18	1.5D	0.84"	72.80	3597-91618K	10	14.7*	3597-91618I	3500-HIT16-GB	–
5/8	18	1.5D	0.94"	83.20	3597-5818K	10	16.3*	3597-5818I	3500-HIT18-GB	–
3/4	16	1.5D	1.13"	93.60	3597-3416K	5	19.5*	3597-3416I	3500-HIT21-GB	–

#### Standard Bolt



#### Bolt with ProThread Wire Insert



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 aluminium alloys.












\* Tapping drill not included in thread repair kit.
















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












**WORKSHOP THREAD REPAIR KITS – METRIC COARSE**

										
MM	MM	INSTALLED LENGTH	\$	PART #	#	MM	PART #	PART #	PART #	PART #
<b>M5 – M12</b>										
<b>5.00</b>	0.80	1.5D	7.50MM	<b>202.80</b>	3597-MET-WK1	25	5.2	3597-508I	3500-HIT8-GB	3500-TB8-GB
<b>6.00</b>	1.00	1.5D	9.00MM	–	–	25	6.3	3597-61I	3500-HIT9-GB	3500-TB9-GB
<b>8.00</b>	1.25	1.5D	12.00MM	–	–	25	8.3	3597-8125I	3500-HIT11-GB	3500-TB12-GB
<b>10.00</b>	1.50	1.5D	15.00MM	–	–	20	10.4	3597-1015I	3500-HIT13-GB	3500-TB13-GB
<b>12.00</b>	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 #	PART #
<b>M6 – M10 + M12 &amp; M14 SPARK PLUG</b>										
<b>6.00</b>	1.00	1.5D	9.00MM	<b>262.08</b>	3597-SP-WK1	25	6.3	3597-61I	3500-HIT9-GB	3500-TB9-GB
<b>8.00</b>	1.25	1.5D	12.00MM	–	–	25	8.3	3597-8125I	3500-HIT11-GB	3500-TB12-GB
<b>10.00</b>	1.50	1.5D	15.00MM	–	–	20	10.4	3597-1015I	3500-HIT13-GB	3500-TB13-GB
<b>12.00</b>	1.25	–	1/2"	–	–	5	–	3597-12125PN	3500-HIT15-GB	3500-TB15-GB
<b>12.00</b>	1.25	–	3/4"	–	–	5	–	–	–	–
<b>14.00</b>	1.25	–	8.40MM	–	–	5	–	3597-14125PN	3500-HIT17-GB	–
<b>14.00</b>	1.25	–	12.40MM	–	–	5	–	–	–	–
<b>14.00</b>	1.25	–	16.40MM	–	–	5	–	–	–	–

**WORKSHOP THREAD REPAIR KITS – METRIC COARSE AND METRIC FINE**

										
MM	MM	INSTALLED LENGTH	\$	PART #	#	MM	PART #	PART #	PART #	PART #
<b>M6 &amp; M8 METRIC COARSE AND M10 &amp; M12 METRIC FINE</b>										
<b>6.00</b>	1.00	1.5D	9.00MM	<b>229.25</b>	3597-MET-JAPAN	25	6.3	3597-61I	3500-HIT9-GB	3500-TB9-GB
<b>8.00</b>	1.25	1.5D	12.00MM	–	–	25	8.3	3597-8125I	3500-HIT11-GB	3500-TB12-GB
<b>10.00</b>	1.25	1.5D	15.00MM	–	–	15	10.3	3597-10125I	3500-HIT13-GB	3500-TB13-GB
<b>12.00</b>	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 #	PART #
<b>M5 – M8 METRIC COARSE + M14 SPARK PLUG AND 1/4" &amp; 5/16" UNC</b>										
<b>5.00</b>	0.80	1.5D	7.50MM	<b>245.44</b>	3597-OPE-WK1	25	5.2*	3597-508I	3500-HIT8-GB	3500-TB8-GB
<b>6.00</b>	1.00	1.5D	9.00MM	–	–	25	6.3*	3597-61I	3500-HIT9-GB	3500-TB9-GB
<b>8.00</b>	1.25	1.5D	12.00MM	–	–	25	8.3*	3597-8125I	3500-HIT11-GB	3500-TB12-GB
<b>14.00</b>	1.25	–	3/8"	–	–	3	–	3597-14125PN	3500-HIT17-GB	–
<b>14.00</b>	1.25	–	1/2"	–	–	3	–	–	–	–
<b>14.00</b>	1.25	–	3/4"	–	–	3	–	–	–	–
<b>1/4</b>	20	1.5D	0.38"	–	–	25	6.7*	3597-1420I	3500-HIT9-GB	3500-TB9-GB
<b>5/16</b>	18	1.5D	0.47"	–	–	25	8.3*	3597-51618I	3500-HIT10-GB	3500-TB12-GB

\* Tapping drill not included in thread repair kit.



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

WORKSHOP THREAD REPAIR KITS – UNC										
INCH	TPI	INSTALLED LENGTH	\$	PART #	#	MM	PART #	PART #	PART #	
<b>UNC 1/4" – UNC 1/2"</b>										
1/4	20	1.5D	0.38"	<b>230.88</b>	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 #	
<b>UNF 1/4" – UNF 1/2"</b>										
1/4	28	1.5D	0.38"	<b>230.88</b>	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



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

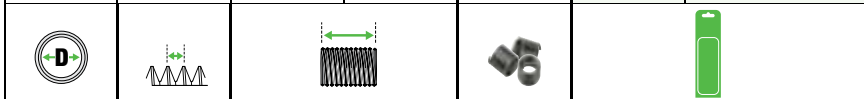
**HANG SELL REPLACEMENT INSERTS**



MM      MM      INSTALLED LENGTH      #      \$      PART #

**METRIC COARSE / METRIC FINE**

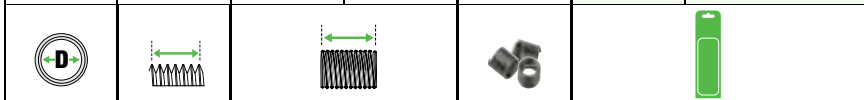
<b>3.00</b>	0.50	1.5D	4.00MM	10	<b>6.97</b>	3597-305X4.5P
<b>4.00</b>	0.70	1.5D	6.00MM	10	<b>6.97</b>	3597-407X6P
<b>5.00</b>	0.80	1.5D	7.50MM	10	<b>6.97</b>	3597-508X7.5P
<b>6.00</b>	1.00	1.5D	9.00MM	10	<b>7.86</b>	3597-61X9P
<b>8.00</b>	1.25	1.5D	12.00MM	10	<b>8.59</b>	3597-8125X12P
<b>10.00</b>	1.25	1.5D	15.00MM	10	<b>13.76</b>	3597-10125X15P
<b>10.00</b>	1.50	1.5D	15.00MM	10	<b>12.07</b>	3597-1015X15P
<b>12.00</b>	1.50	1.5D	18.00MM	10	<b>16.85</b>	3597-1215X18P
<b>12.00</b>	1.75	1.5D	18.00MM	10	<b>16.85</b>	3597-12175X18P
<b>14.00</b>	1.50	1.5D	21.00MM	5	<b>13.31</b>	3597-1415X21P
<b>14.00</b>	2.00	1.5D	21.00MM	5	<b>13.31</b>	3597-142X21P
<b>16.00</b>	2.00	1.5D	24.00MM	5	<b>16.40</b>	3597-162X24P



MM      MM      INSTALLED LENGTH      #      \$      PART #

**SPARK PLUG**

<b>10.00</b>	1.00	-	0.339"	10	<b>10.90</b>	3597-101X.339P
<b>10.00</b>	1.00	-	1/2"	10	<b>12.30</b>	3597-101X1/2P
<b>12.00</b>	1.25	-	1/2"	10	<b>15.89</b>	3597-12125X1/2P
<b>12.00</b>	1.25	-	3/4"	10	<b>16.85</b>	3597-12125X3/4P
<b>14.00</b>	1.25	-	3/8"	10	<b>9.27</b>	3597-14125X3/8P
<b>14.00</b>	1.25	-	1/2"	10	<b>14.15</b>	3597-14125X1/2P
<b>14.00</b>	1.25	-	3/4"	10	<b>18.58</b>	3597-14125X3/4P



INCH      TPI      INSTALLED LENGTH      #      \$      PART #

**UNC**

<b>No.6</b>	32	1.5D	0.21"	10	<b>6.85</b>	3597-632X207P
<b>No.8</b>	32	1.5D	0.25"	10	<b>6.85</b>	3597-832X246P
<b>No.10</b>	24	1.5D	0.28"	10	<b>6.85</b>	3597-1024X285P
<b>1/4</b>	20	1.5D	0.38"	10	<b>7.70</b>	3597-1420X375P
<b>5/16</b>	18	1.5D	0.47"	10	<b>8.54</b>	3597-51618X469P
<b>3/8</b>	16	1.5D	0.56"	10	<b>12.07</b>	3597-3816X562P
<b>7/16</b>	14	1.5D	0.66"	10	<b>14.32</b>	3597-71614X656P
<b>1/2</b>	13	1.5D	0.75"	10	<b>16.40</b>	3597-1213X750P
<b>9/16</b>	12	1.5D	0.84"	5	<b>11.23</b>	3597-91612X844P
<b>5/8</b>	11	1.5D	0.94"	5	<b>16.12</b>	3597-5811X937P
<b>3/4</b>	10	1.5D	1.13"	5	<b>22.35</b>	3597-3410X1.125P

**UNF**

<b>No.10</b>	32	1.5D	0.28"	10	<b>6.85</b>	3597-1032X285P
<b>1/4</b>	28	1.5D	0.38"	10	<b>7.70</b>	3597-1428X375P
<b>5/16</b>	24	1.5D	0.47"	10	<b>8.54</b>	3597-51624X469P
<b>3/8</b>	24	1.5D	0.56"	10	<b>12.07</b>	3597-3824X562P
<b>7/16</b>	20	1.5D	0.66"	10	<b>14.32</b>	3597-71620X656P
<b>1/2</b>	20	1.5D	0.75"	10	<b>16.40</b>	3597-1220X750P
<b>9/16</b>	18	1.5D	0.84"	5	<b>11.23</b>	3597-91618X844P
<b>5/8</b>	18	1.5D	0.94"	5	<b>16.12</b>	3597-5818X937P
<b>3/4</b>	16	1.5D	1.13"	5	<b>22.35</b>	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 #
<b>SPARK PLUG – PLUG FIX</b>					
14.00	1.25	2 EACH: 3/8", 1/2", 3/4"	6	21.05	3599-14125CP
14.00	1.25	3/8"	5	14.91	3599-14125X3/8P
14.00	1.25	1/2"	5	17.62	3599-14125X1/2P
14.00	1.25	3/4"	5	20.45	3599-14125X3/4P

### MERCHANDISERS



GROUP –	\$	PART #				
<b>8 KIT BENCH TOP MERCHANDISER</b>	<b>530.94</b>	3597-D1				
MM / INCH	MM	DESCRIPTION	QTY	PART #	QTY	PART #
<b>METRIC COARSE / METRIC FINE</b>						
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



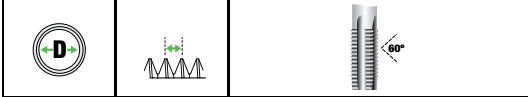
GROUP PROC	\$	PART #				
<b>10 KIT BENCH TOP MERCHANDISER</b>	<b>523.71</b>	3598-D1				
MM / INCH	MM / TPI	DESCRIPTION	QTY	PART #	QTY	PART #
<b>METRIC COARSE / METRIC FINE</b>						
6.00	1.00	WIRE INSERTS	1	3598-61K	1	3597-61X9P
8.00	1.25	WIRE INSERTS	1	3598-8125K	1	3597-8125X12P
10.00	1.50	WIRE INSERTS	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
<b>UNC</b>						
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

The ProThread bench merchandisers are double sided units that display thread repair kits on one side and replacement insert packets on the other.



GROUP	PROT
MATERIAL	<b>CARBON STEEL</b>
LEAD	INTERMEDIATE OR PILOT NOSE
TYPE	<b>STI</b> (SCREW THREAD INSERT)

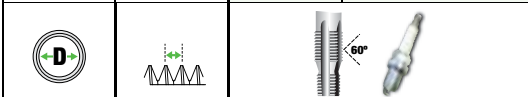
**STI TAPS**



MM	MM	\$	PART #
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**METRIC COARSE / METRIC FINE**

3.00	0.50	11.75	3597-305I
4.00	0.70	11.75	3597-407I
5.00	0.80	9.10	3597-508I
6.00	1.00	9.10	3597-61I
7.00	1.00	9.36	3597-71I
8.00	1.25	9.36	3597-8125I
10.00	1.25	11.96	3597-10125I
10.00	1.50	11.96	3597-1015I
12.00	1.50	15.55	3597-1215I
12.00	1.75	15.55	3597-12175I
14.00	1.50	22.31	3597-1415I
14.00	2.00	22.31	3597-142I
16.00	2.00	29.12	3597-162I



MM	MM	\$	PART #
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**SPARK PLUG**

10.00	1.00	13.00	3597-101PN
12.00	1.25	16.59	3597-12125PN
14.00	1.25	22.31	3597-14125PN



INCH	TPI	\$	PART #
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**UNC**

No.6	32	11.75	3597-632I
No.8	32	11.75	3597-832I
No.10	24	11.75	3597-1024I
1/4	20	9.10	3597-1420I
5/16	18	9.36	3597-51618I
3/8	16	11.96	3597-3816I
7/16	14	11.96	3597-71614I
1/2	13	15.55	3597-1213I
9/16	12	22.31	3597-91612I
5/8	11	29.12	3597-5811I
3/4	10	31.56	3597-3410I

**UNF**

No.10	32	11.75	3597-1032I
1/4	28	9.10	3597-1428I
5/16	24	9.36	3597-51624I
3/8	24	11.96	3597-3824I
7/16	20	11.96	3597-71620I
1/2	20	15.55	3597-1220I
9/16	18	22.31	3597-91618I
5/8	18	29.12	3597-5818I
3/4	16	31.56	3597-3416I

GROUP	PROT
MATERIAL	<b>CARBON STEEL</b>
LEAD	PILOT NOSE
TYPE	<b>STI</b> (SCREW THREAD INSERT)

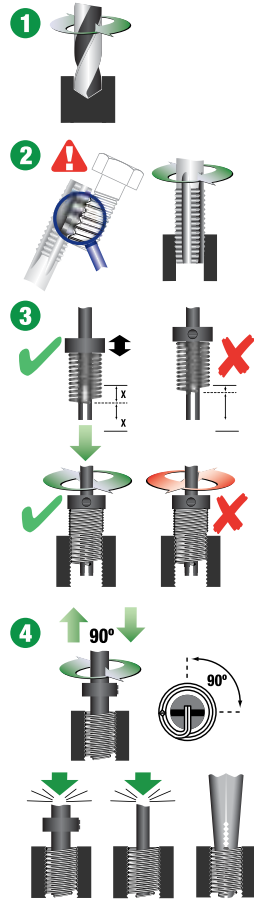
**PLUG FIX – HEX END PILOT NOSE TAP**



MM	MM	\$	PART #
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**SPARK PLUG – PLUG FIX**

14.00	1.25	22.31	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	<b>ALL WIRE THREAD INSERTS</b>
TOOL TYPE	HAND INSTALLATION



GROUP	PROI
USE WITH	<b>PLUG FIX SOLID INSERTS</b>
TOOL TYPE	HAND INSTALLATION

HAND INSTALLATION TOOLS			
MM	MM	\$	PART #
METRIC COARSE / METRIC FINE			
<b>3.00</b>	0.50	<b>17.97</b>	3500-HIT4-GB
<b>4.00</b>	0.70	<b>12.36</b>	3500-HIT6-GB
<b>5.00</b>	0.80	<b>12.36</b>	3500-HIT8-GB
<b>6.00</b>	1.00	<b>12.36</b>	3500-HIT9-GB
<b>7.00</b>	1.00	<b>12.36</b>	3500-HIT10-GB
<b>8.00</b>	1.25	<b>12.36</b>	3500-HIT11-GB
<b>10.00</b>	1.25	<b>12.36</b>	3500-HIT13-GB
<b>10.00</b>	1.50	<b>12.36</b>	3500-HIT13-GB
<b>12.00</b>	1.50	<b>14.60</b>	3500-HIT15-GB
<b>12.00</b>	1.75	<b>14.60</b>	3500-HIT15-GB
<b>14.00</b>	1.50	<b>15.72</b>	3500-HIT16-GB
<b>14.00</b>	2.00	<b>15.72</b>	3500-HIT16-GB
<b>16.00</b>	2.00	<b>15.72</b>	3500-HIT18-GB
MM	MM	\$	PART #
SPARK PLUG			
<b>10.00</b>	1.00	<b>12.36</b>	3500-HIT13-GB
<b>12.00</b>	1.25	<b>14.60</b>	3500-HIT15-GB
<b>14.00</b>	1.25	<b>15.72</b>	3500-HIT17-GB
INCH	TPI	\$	PART #
UNC			
<b>No.6</b>	32	<b>17.97</b>	3500-HIT5-GB
<b>No.8</b>	32	<b>12.36</b>	3500-HIT6-GB
<b>No.10</b>	24	<b>12.36</b>	3500-HIT7-GB
<b>1/4</b>	20	<b>12.36</b>	3500-HIT9-GB
<b>5/16</b>	18	<b>12.36</b>	3500-HIT10-GB
<b>3/8</b>	16	<b>12.36</b>	3500-HIT13-GB
<b>7/16</b>	14	<b>13.48</b>	3500-HIT14-GB
<b>1/2</b>	13	<b>14.60</b>	3500-HIT15-GB
<b>9/16</b>	12	<b>15.72</b>	3500-HIT16-GB
<b>5/8</b>	11	<b>15.72</b>	3500-HIT18-GB
<b>3/4</b>	10	<b>15.72</b>	3500-HIT20-GB
UNF			
<b>No.10</b>	32	<b>12.36</b>	3500-HIT8-GB
<b>1/4</b>	28	<b>12.36</b>	3500-HIT9-GB
<b>5/16</b>	24	<b>12.36</b>	3500-HIT11-GB
<b>3/8</b>	24	<b>12.36</b>	3500-HIT13-GB
<b>7/16</b>	20	<b>13.48</b>	3500-HIT14-GB
<b>1/2</b>	20	<b>14.60</b>	3500-HIT15-GB
<b>9/16</b>	18	<b>15.72</b>	3500-HIT16-GB
<b>5/8</b>	18	<b>15.72</b>	3500-HIT18-GB
<b>3/4</b>	16	<b>20.22</b>	3500-HIT21-GB

PLUG FIX – SWAGE TOOL			
MM	MM	\$	PART #
SPARK PLUG – PLUG FIX			
<b>14.00</b>	1.25	<b>15.72</b>	3599-14125SWG

### Features and benefits

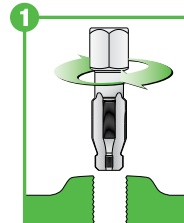
- No drill required
- Solid inserts in 3 lengths to suit most common spark plug reaches
- Suitable for aluminium and cast iron
- Simple, easy to use permanent repair

### Applications

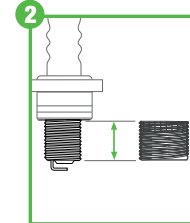
- Taper and gasket seat spark plug ports

### 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.



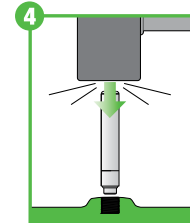
**Tap:** Pilot nose taps require no pre-drilling. Lubricate the tap with a suitable lubricant. Hand start tap and then turn with 19mm or 3/4" socket wrench. Tap entire length of port.



**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.



**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.



**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).

# pro THREAD



INDUSTRIAL TOOLS

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**Email** info@bordo.com.au **Web** www.bordo.com.au



100% AUSTRALIAN  
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Part No. 9910-CATPROTHREAD0315



9 3 2 6 5 1 8 1 3 9 2 0 1