

## TAB 5 - INSTALLATION

Installation tools for Tap-Lok thread-cutting and Speedserts thread-forming inserts feature hardened studs for twisting the threaded insert into the base material and a release mechanism for easy removal of the tool once the insert is locked into the base material.

For installation, the insert is twisted into the tool stud and into contact with the tool nose piece. The tool is then used to twist the threaded insert into the base material.

To remove the tool from the insert, the insert must be released. Production tools automatically release the insert when torque on the tool is reversed. Hand tools must be released manually.

DRILL PRESS INSTALLATION - PRODUCTION TOOL	HAND TOOL INSTALLATION
<p><b>3 Easy Steps:</b></p> <ol style="list-style-type: none"> <li>1. Bring the end of the nose piece tightly against the surface of the material. Hold in position.</li> <li>2. Lock the spindle in position.</li> <li>3. Set the drill press stop. (Readjust the stop after testing for exact insert depth.) Release the spindle lock.</li> </ol> <p>After set-up is complete, hold the insert so that the rotating tool drive stud will thread into it. Hold the insert by the outer thread until it is snug against the nose piece.</p> <p>Maintain the speed of the installation stud to between 100 and 500 RPM.</p>	<p><b>To Install:</b></p> <ol style="list-style-type: none"> <li>1. Install hand tool in a holding device such as a drill press chuck or hand-tapping fixture to assure perpendicular alignment with work.               <ol style="list-style-type: none"> <li>a. <b>Caution:</b> Do not use power. Chucking the hand tool on a drill press is for alignment purposes only.</li> </ol> </li> <li>2. Screw the insert onto the stud until it contacts the nut.</li> <li>3. Install to the correct depth in the drilled hole.</li> <li>4. Hold the stud against rotation and loosen the nut with a wrench.</li> <li>5. Unscrew the stud from the insert.</li> </ol> <p>It is important that that installation tool be squarely aligned with the work surface.</p> <p>Field repairs can be made by using the hand tool in conjunction with either a carpenter’s brace or a speed wrench.</p>

## INSTALLATION TOOLS FOR THREAD-CUTTING AND THREAD FORMING INSERTS

Inch Sizes			Metric Sizes		
Internal Threads	Production Tool Number	Hand Tool Number	Internal Threads	Production Tool Number	Hand Tool Number
2-56	PT0256	HT0256	M2 x 0.4	PTM0204	HTM0204
4-40	PT0440	HT0440	M3 x 0.5	PTM0305	HTM0305
6-32	PT0632	HT0632	M3.5 x 0.6	PTM0306	HTM0306
8-32	PT0832	HT0832	M4 x 0.7	PTM0407	HTM0407
10-24	PT1024	HT1024	M5 x 0.8	PTM0508	HTM0508
10-32	PT1032	HT1032	-	-	-

1/4-20	PT2520	HT2520	M6 x 1.0	PTM0610	HTM0610
1/4-28	PT2528	HT2528	-	-	-
5/16-18	PT3118	HT3118	M8 x 1.25	PTM0812	HTM0812
5/16-24	PT3124	HT3124	-	-	-
3/8-16	PT3716	HT3716	M10 x 1.5	PTM1015	HTM1015
3/8-24	PT3724	HT3724	-	-	-
7/16-14	PT4314	HT4314	-	-	-
7/16-20	PT4320	HT4320	-	-	-
1/2-13	PT5013	HT5013	M12 x 1.75	PTM1217	HTM1217
1/2-20	PT5020	HT5020	-	-	-
9/16-12	PT5612	HT5612	M14 x 2.0	PTM1420	HTM1420
9/16-18	PT5618	HT5618	-	-	-
5/8-11	PT6211	HT6211	M16 x 2.0	PTM1620	HTM1620
5/8-18	PT6218	HT6218	-	-	-
3/4-10	PT7510	HT7510	M18 x 2.0	PTM1820	HTM1820
3/4-16	PT7516	HT7516	-	-	-

**To Order Production or Hand Tools:** Specify the tool number for the internal thread size of the thread-cutting or thread-forming insert desired.

**To Order Replacement Parts:** Replacement studs and nose pieces can be ordered for production tools. Specify the production tool number with a suffix:

Stud = ST  
Nose Piece = NP

**Example:** Replacement nose piece for production tool for 8-32 insert would be specified by PT0832-NP.

#### **IMPORTANT NOTES FOR ORDERING TOOLS**

1. High-volume users are advised to order replacement studs when placing insert order.
2. Special tools are available for installing threaded inserts into deep recesses and close to obstructions.

For further information, contact Groov-Pin Customer Service.