

GARDSERT® Installations



GARDSERTS are to be considered a permanent repair of damaged threads without pull-out or wear-out.

GARDSERTS are self-tapping and require no special tools.

GARDSERTS are made of 54-58 hardened stainless steel.

(If installing in greater than 35 Rockwell C-scale, please call for technical support.)

MANUAL INSTALLATION

You will need the appropriate wrenches, drill bit, heavy duty hex nut and **Grade 8** cap screw matching the internal thread of the GARDSEERT.

(When installing in 6000 Series Aluminum – Call for technical support.)

1) Drill out damaged threads (reference drill chart included with each shipment).

For blind holes, make sure to drill 1/8 to 3/8 deeper for chip clearance.

<p>2A GEN 5</p> <p>Using minimum rated Grade 8 cap screw matching the internal thread of the GARDSERT, assemble unit as shown. Screw GARDSERT onto the cap screw with flats away from the nut. Screw to bottom but DO NOT screw past bottom of GARDSERT. Thread hex nut down to the GARDSERT. Tighten snugly to the top of the GARDSERT.</p>		<p>2B HOLE TYPE AND THIN WALL</p> <p>Using minimum rated Grade 8 cap screw matching the internal thread of the GARDSERT, assemble unit as shown. Screw GARDSERT onto the cap screw to chip hole. DO NOT protrude tip of the cap screw into chip hole. Thread hex nut down to the GARDSERT. Tighten snugly to the top of the GARDSERT.</p>
---	--	--

3) Apply GARD Deluxe Tapping Fluid to external GARDSERT threads and predrilled hole. Carefully align the GARDSERT straight into the hole by hand. Using a wrench, turn the hex nut clockwise until the nut is flush on the work piece. Hold the head of cap screw with a wrench not allowing it to turn counter-clockwise. Loosen the nut turning counter-clockwise and remove cap screw. You now have a completely threaded hole and a solid repair.



GARDSERT® Installations

AIR TOOL INSTALLATION

You will need an air tool and wrench, appropriate drill bit, minimum **Grade 8** cap screw matching internal thread of the GARDSERT, oversize size close tolerance heavy duty hex nut, oversize size close tolerance heavy duty flat washers.

(When installing in 6000 Series Aluminum – Call for tech technical support.)

- 1) Drill out damaged threads (reference drill chart included with each shipment).
For blind holes, make sure to drill 1/8 to 3/8 deeper for chip clearance.

<p>2A) GEN 5 Using minimum Grade 8 cap screw matching the internal thread of the GARDSERT, assemble unit as shown. Screw GARDSERT onto the cap screw with flats away from the nut. Screw to bottom but DO NOT screw past bottom of GARDSERT.</p>		<p>2B) HOLE TYPE AND THIN WALL Using minimum Grade 8 cap screw matching the internal thread of the GARDSERT, assemble unit as shown. Screw GARDSERT onto the cap screw to chip holes but DO NOT protrude tip of cap screw into chip holes.</p>
--	--	---

Appropriate size cap screw
Oversize size close tolerance heavy duty hex nut (1)
oversize and heavy duty flat washers (2-3)

- 3) Apply GARD Deluxe Tapping Fluid to external GARDSERT threads. Carefully align the GARDSERT straight into the hole by hand. Drive in clockwise by putting the air tool socket on the cap screw head. Apply air tool to turn GARDSERT into substrate until washer is flush with work piece. Place wrench on oversized nut and secure it. Reverse air tool to break assembly loose and remove cap screw. You now have a completely threaded hole and a solid repair.

