THE NUTTY COMPANY INC
FASTENER SPECIALISTS SINCE 1977

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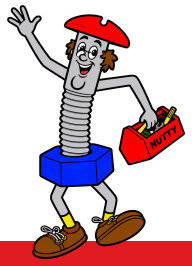


PRODUCT DATA SHEET

Stainless Steel Thread Repair Inserts

1.0 Sizes, Drill & Tap (inches)



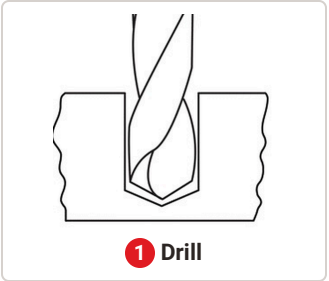
- **Solid wall stainless steel** inserts that repair stripped threads – or add stronger threads – in metal.
- **Drill, tap and thread in** like an ordinary fastener, using standard drills and taps.
- **Self-locking:** a pre-applied thread-locking adhesive on the outside thread holds the insert in place and resists vibration.
- The repaired hole takes the **original bolt size**.
- Stainless steel for corrosion resistance – good for food, beverage, marine and outdoor equipment.

Internal thread = the bolt size the repaired hole takes. **External thread** = the oversize thread you tap in the part. **L** = insert length. Drill and tap sizes are for the external thread.

Stock No.	Internal Thread	External Thread	L Length	Drill Size	Tap Size
XEZ632	**6-32**	1/4-20	.280	**#7**	**1/4-20**
XEZ832	**8-32**	5/16-18	.290	**F**	**5/16-18**
XEZ1024	**10-24**	3/8-16	.406	**5/16"**	**3/8-16**
XEZ1032	**10-32**	3/8-16	.406	**5/16"**	**3/8-16**
XEZ1420	**1/4-20**	7/16-14	.437	**23/64"**	**7/16-14**
XEZ51618	**5/16-18**	1/2-13	.484	**27/64"**	**1/2-13**
XEZ3816	**3/8-16**	9/16-12	.515	**31/64"**	**9/16-12**
XEZ1213	**1/2-13**	3/4-10	.656	**21/32"**	**3/4-10**

Dimensions in inches. Inch threads. Contact us for other sizes.

2.0 Installation



1. **Drill.** Drill out the stripped hole with the drill size in the table, straight and at least as deep as the insert length L.
2. **Tap.** Tap the hole with a standard tap of the external thread size listed. Clean out chips and oil.
3. **Install.** Turn the insert in, slot end up, with a screwdriver, a bolt and jam nut, or a drive tool, until it is flush to slightly below the surface. The repaired hole is ready for the original bolt size.

3.0 Material & Specifications

Property	Specification
Type	Solid wall, self-locking threaded insert for metal, slotted
Material	Stainless steel
Internal thread	USS coarse, 6-32 to 1/2-13
External thread	USS coarse, standard tap sizes (see table)
Locking	Pre-applied thread-locking adhesive
Cure	Fastener-ready in 5–10 minutes; full cure 72 hours
Install	Standard drill and tap; screwdriver, bolt & jam nut or drive tool

4.0 Common Uses

- Repairing stripped threads in aluminum, steel and cast iron
- Engine, pump and machine parts
- Food and beverage equipment
- Marine and outdoor equipment
- Adding wear-resistant threads to soft metal parts
- Field and shop maintenance repairs

5.0 Tips for a Good Install

- Drill straight. A crooked hole gives a crooked insert and bolt.
- Clean chips and cutting oil out of the tapped hole before installing so the adhesive can bond.
- Install the insert flush or slightly below the surface – never proud.
- Drive the insert by its slot, with a bolt and jam nut, or with a drive tool.
- Allow the adhesive to set before loading the fastener.

Disclaimer: The above is a compilation of data from various industry standards. The Nutty Company, Inc. has made every effort to present the data accurately. However, The Nutty Company, Inc. cannot be held liable for any claim traceable to any errors, typographical or otherwise, contained herein.



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