

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 Steel or Stainless Steel (depending on your selection).

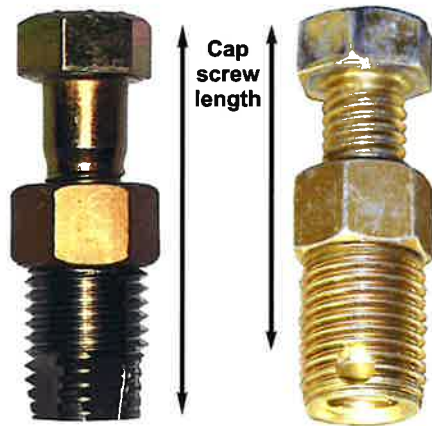
GARDSERTS have the pull-out strength that is more than double that of a Grade 8 bolt.

MANUAL INSTALLATION

You will need: the appropriate drill bit (**note: When installing in 6000 Series Aluminum - use Steel size drill bit**), hex nut, wrenches and hardened bolt for the GARDSERT®.

- 1) Drill out damaged threads (reference drill chart included with each shipment).
- 2) Turn hex nut onto cap screw, follow by threading the GARDSERT® onto the cap screw, and be sure to keep the cutting holes open.
- 3) Carefully align the GARDSERT® to the hole and turn into the hole clockwise using a wrench on the hex nut. Bottom out assembly on the work piece. Hold the cap screw and loosen the hex nut, turning counter-clockwise. You now have a completely threaded hole and a solid repair.

All Gen 5 type GARDSERTS, Install the cap screw flush to the bottom of the GARDSERT.



Hex nut, same thread as internal thread of the GARDSERT®



GARDSERTS

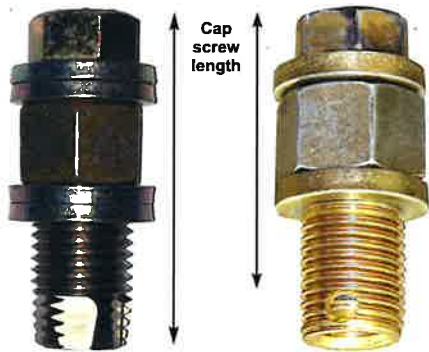
GARDSERT® Installations

AIR TOOL INSTALLATION

You will need: Your air tool and wrench. The appropriate drill bit (**note: When installing in 6000 Series Aluminum - use Steel size drill bit**), oversized hex nut, oversized flat washers and hardened bolt for the **GARDSERT®**

- 1) Drill out damaged threads (reference drill chart included with each shipment).
- 2) Obtain a cap screw matching the internal thread of the **GARDSERT®**. Assemble unit virtually as shown. (1) flat washer, (1) oversized nut, (1-2) flat washers, finishing with the **GARDSERT®**.
- 3) Carefully align the **GARDSERT®** to the hole, drive in by putting the socket of the air tool on the cap screw head. Bottom out assembly on the work piece. Place spanner wrench on oversized nut and secure it. Reverse air tool to break assembly loose. You now have a completely threaded hole and a solid repair.

All Gen 5 type GARDSERTS, Install the cap screw flush to the bottom of the GARDSERT.



- (1) appropriate size F-911 cap screw
- (1) oversized hex nut
- (2) flat washers
- GARDSERT®**

GARDSERTS