

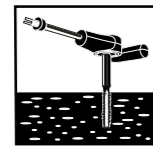
## Recoil® Inserts

With a choice of free-running or screw-locking designs, Recoil® offers a broad range of thread insert systems to ensure the best match of product to the application. The standard Recoil free-running insert provides for easy installation of a female thread, delivering the necessary “holding power” for most applications. For particularly demanding or extreme high-vibration applications, Recoil offers a screw-locking design, which provides a superior locking function in the female thread.

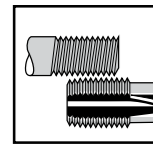
### How to Install Recoil Inserts



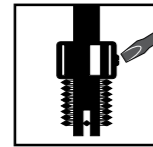
**1. DRILL:** Drill to clear out the damaged thread with drill size as specified on kit (if necessary).



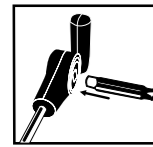
**3a. TAP HOLE:** Tap hole to the required depth using correct procedures (if unsure contact your dealer).



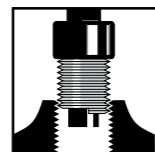
**2. CHECK:** Ensure tap thread matches bolt.



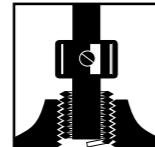
**4. SET TOOL:** Place insert on installation tool, positioning the adjustable top so that the insert tang is centered in the tang slot.



**3. TAP:** Place tap into tap wrench or use the square drive in the installation tool if provided. (Square drive tool only suitable for tapping non-ferrous alloys.)



**5. INSTALL:** Wind insert in with light downward pressure until 1/4 to 1/2 turn below the surface.



**6. TANG REMOVAL:** Do not attempt to twist tang off with tool. Lift tool from tang, turn tool 90° and tap down sharply. Use Tang Break Tool where supplied. For sparkplug and large fine thread inserts, use long nose pliers to pull tang out.



## Thread Repair Kits

Recoil offers a choice of repair kits to meet a wide range of repair options. Recoil Trade Series provides everything required to make a successful repair – drill bit, STI tap, installation tool, and three lengths of inserts – all packaged in a convenient kit. Trade Series kits are available to accommodate a wide range of Inch Coarse, Inch Fine, Metric Coarse, and Metric Fine uses.



## Installation Tooling

Recoil offers a broad selection of installation tooling, providing easy, secure installation, for both manufacturing and repair applications. For the manufacturer, Recoil offers the choice of electrically powered tools, in addition to high-production volume pneumatic tools. Another Recoil innovation, the Work Arm System, combines strip-feed inserts with a pneumatic tool, to contribute to the efficiency and productivity of manufacturing operations.

## Recoil® Bringing Versatility to a Range of Applications

Offering a wide variety of sizes, materials, finishes and coatings. Recoil® brand products are versatile enough to fit a broad range of applications. Recoil threaded inserts, installation tooling, taps, gauges, and thread-repair kits accommodate manufacturing and aftermarket applications in the automotive, aerospace, electronics, ship building, defense, power-generation and transportation industries. Manufactured in all popular thread

forms, Recoil inserts are engineered in accordance with stringent quality standards, including AS9100, ISO9001, TS16949, Boeing Certification, Mil Spec and others.

Competitively priced, Recoil products have been proven to deliver superior performance, durability, and value.

## Howmet Fastening Systems

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## Recoil® Series Metric Part Number Range



