

ROTO-MOLD INSERT KIT

PROCEDURE INSTRUCTIONS:

TOOLS REQUIRED: Torch, Lock-Grip Pliers, Knife, Emery Cloth, Screw to match specific insert.

FOR SAFETY: When performing procedure, wear protective gloves and safety glasses.

⚠ WARNING: Make sure area is well ventilated. Batteries emit hydrogen gas. Explosion or fire can result. Keep sparks and open flame away from batteries.

REMOVING A ROTO-MOLD INSERT:

1. Locate a screw that matches the thread size of the insert. Hold the screw with lock-grip pliers and carefully heat the end of the screw until red hot (Figure 1).

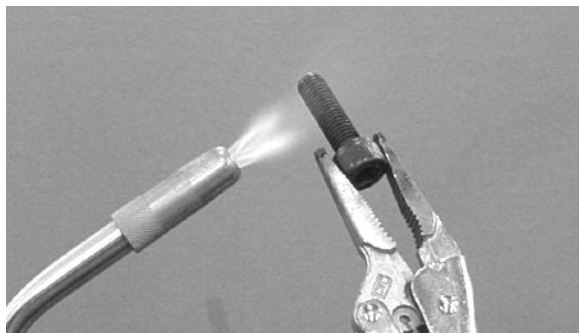


FIG. 1

2. Carefully thread the hot screw into the insert until it bottoms out. Wait 5-10 seconds then slowly pull the insert straight out (Figure 2). Avoid a rocking motion when pulling. Repeat step 1 if necessary.

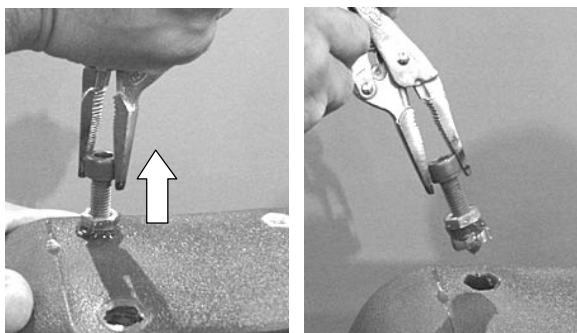


Fig. 2

REPLACING A ROTO-MOLD INSERT:

1. Fill the cavity with about 1/2 inch of clear plastic bead (supplied with the kit). Use torch to soften the plastic (Figure 3). Larger cavities may require extra plastic.

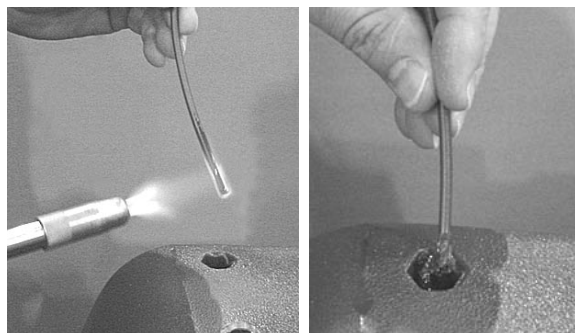


Fig. 3

2. Locate a screw that matches the thread size of the insert. Hold the screw with lock-grip pliers and carefully heat the end of the screw until red hot (Figure 1). *NOTE: Do not apply flame directly on insert, damage may result.*
3. Carefully thread the new insert onto the hot screw. Wait 5-10 seconds then slowly press the insert straight into the cavity (Figure 4). The insert should be flush with the plastic surface. Hold the insert in position until the plastic cools. Repeat step 2 if necessary.

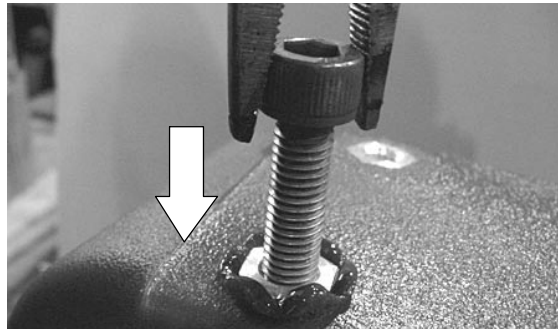


Fig. 4

4. Remove the excess plastic around the insert and touch up the area with an emery cloth (Figure 5).



Fig. 5

ROTO-MOLD INSERT KIT

CONTENTS AND REFERENCE GUIDE

INSERT DIAMETER X THREAD SIZE	PART NO.	QTY.
M10X1.5X.66	611700	3
M8X1.25X.72	610992	3
M6X1X.625	140586	3
M6X1X13	606852	3
M5X.8X.625	140588	3
M5X.8X.59	140475	3
M4X.7X10	606850	3
M4X.7X.56	140482	3
M4X.7X.44	140476	3
M4X.7X.34	140479	3
3/8–16X.75	603370	3
5/16–18X.75	140560	3
1/4–20X.63	140529	3
1/4–20X.625	140543	3
1/4–20X.62	140499	3
10–24X.625	140542	3
10–24X.62	600143	3
8–32X.394	140599	3
POLYETHYLENE, 4MMX914MM (36")	–	1

NOTE: INSERTS ARE NOT SOLD SEPARATELY.