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2020.0 DEFENDER (LE), 502-00

UNI-BODY, SUBFRAME AND MOUNTING SYSTEM

THREAD REPAIR INSERT (G1573756)

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CHECK

 CAUTIONS:

- If one hole/thread is damaged, all remaining holes/threads must have a steel insert installed.
- Make sure that the drill speed is not at maximum when repairing the damaged hole/thread. Use a suitable electric drill with a slow speed setting.

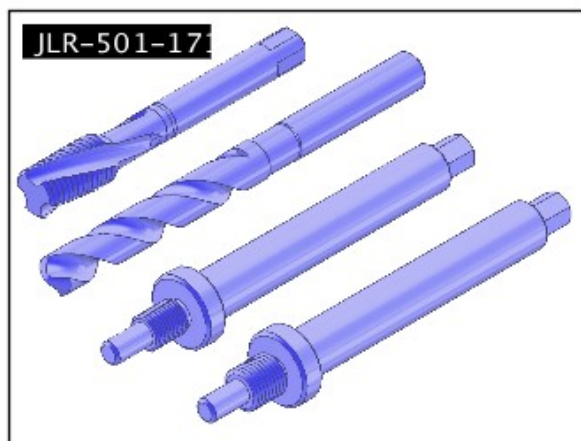
 NOTE:

Some variation in the illustrations may occur, but the essential information is always correct.

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**WARNING:**

Prior to carrying out this procedure, make sure that the sub-frame is not already installed with inserts. Using a suitable magnet, check the damaged hole for a steel insert. Do not drill if there is a steel insert located already. Failure to follow this instruction may result in permanent damage to the vehicle.



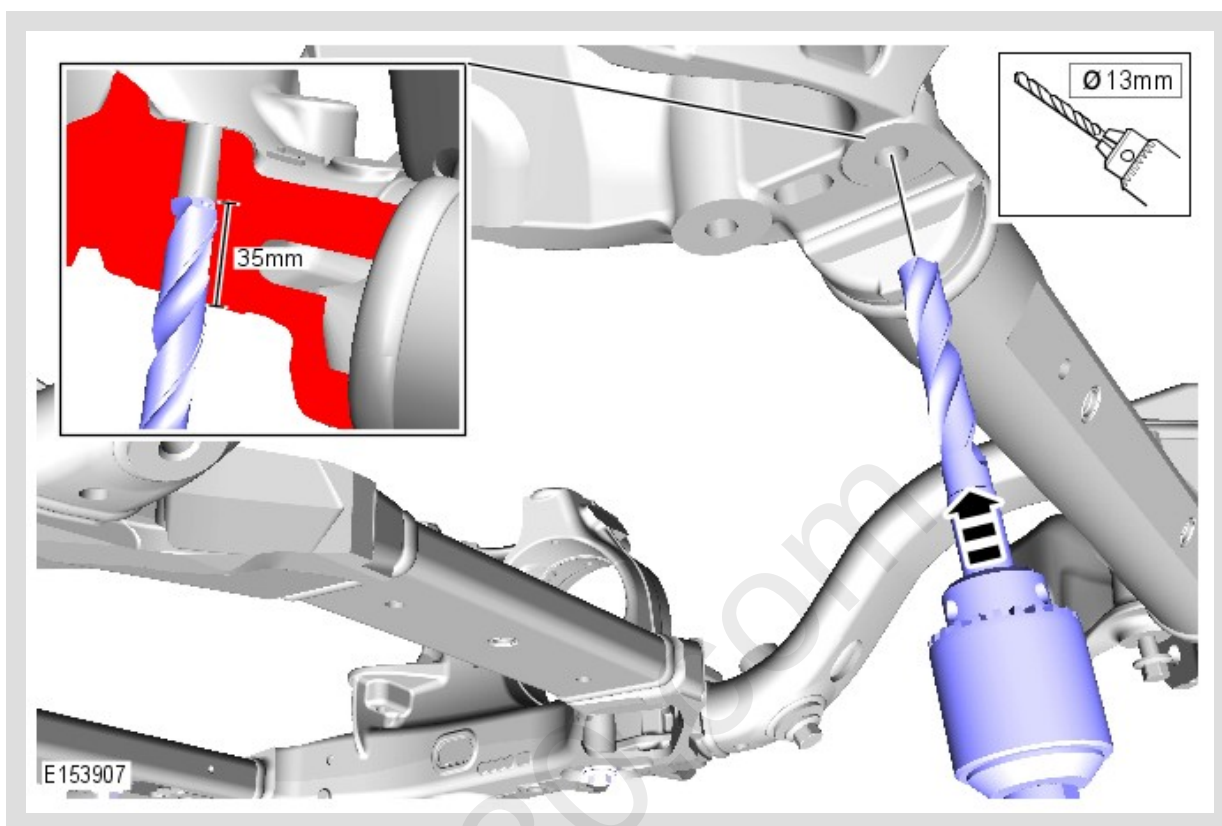
E156333

The procedure requires tools from JLR-501-169 and JLR-501-171.

2.

⚠ CAUTIONS:

- Make sure that the depth of the drill does not exceed 35 mm.
- Apply a suitable cutting lubricate to the drill bit prior to drilling.



Drill the hole to a depth of 35 mm using a 13mm drill.

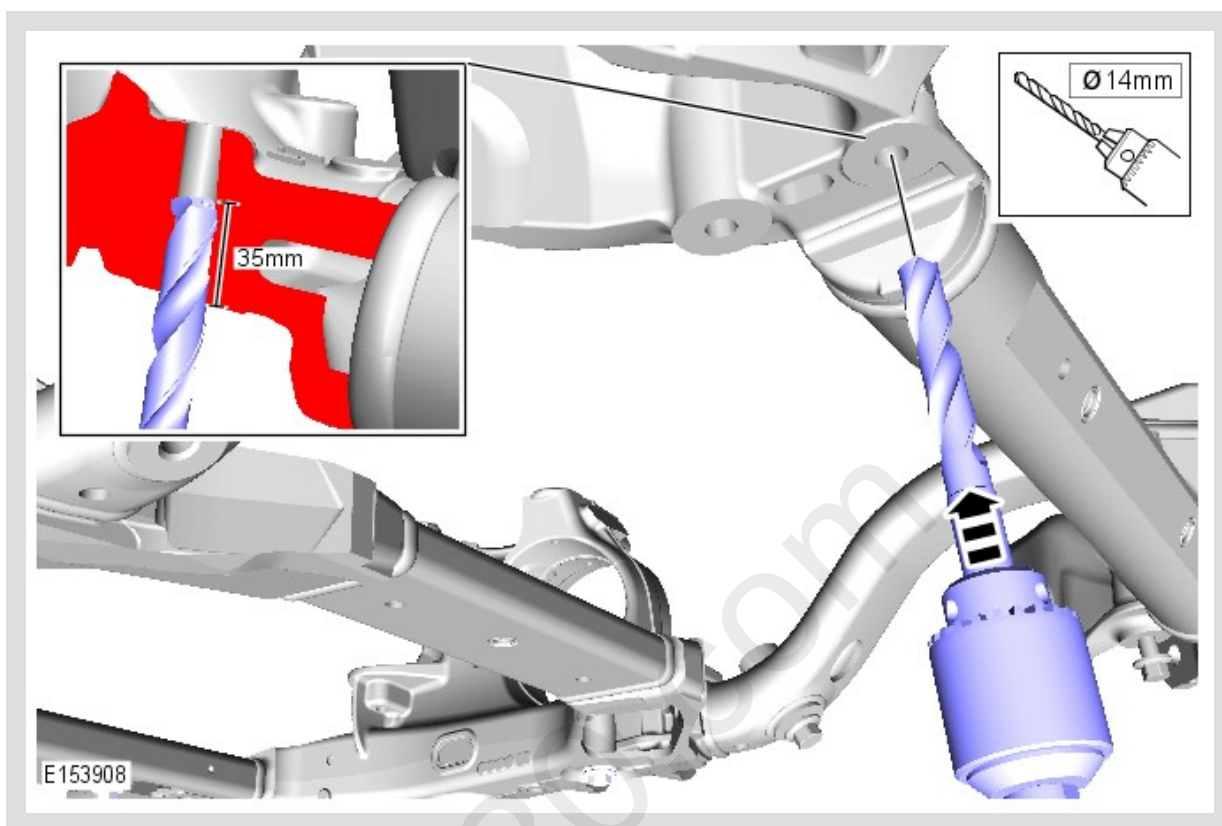
3.

Using compressed air make sure the hole is clean and free of debris.

4.

ⓘ CAUTIONS:

- Make sure that the depth of the drill does not exceed 35 mm.
- Apply a suitable cutting lubricate to the drill bit prior to drilling.



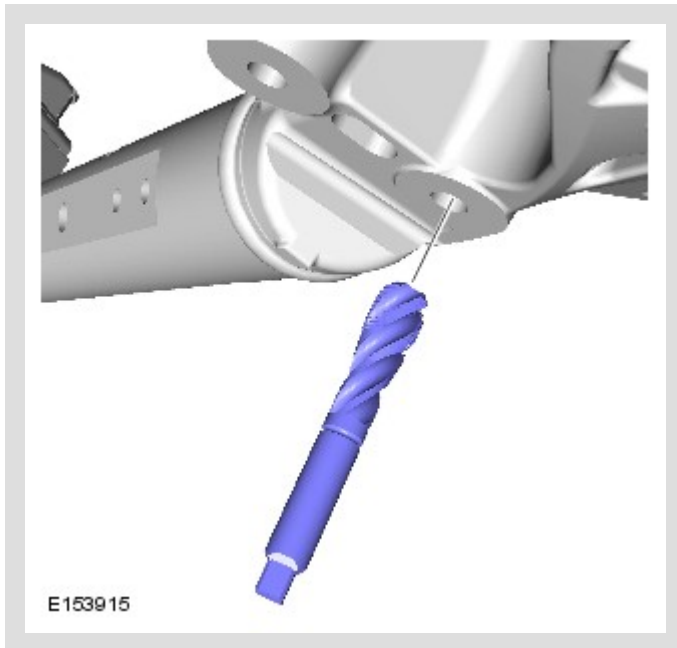
Drill the hole to a depth of 35 mm using a 14mm drill.

5.

Using compressed air make sure the hole is clean and free of debris.

 NOTE:

Apply a suitable cutting lubricate to the tap prior to cutting the thread.

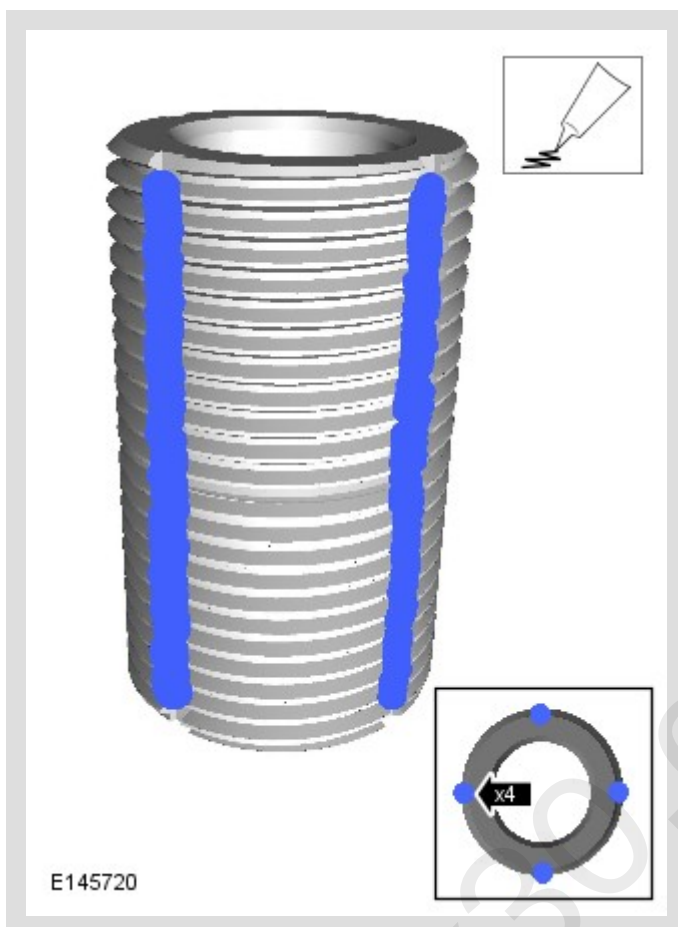


Tap the hole using a M16 x 2.0 flute tap.

7.

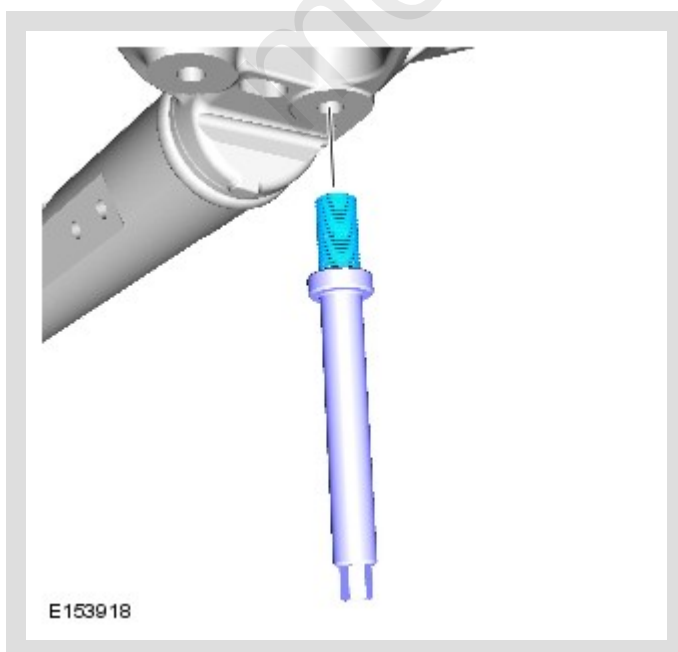
⚠ CAUTION:

Make sure that the threaded steel insert is clean and free of oil residue before applying Loctite.



Apply four beads of Loctite 243 to the outside of the threaded steel insert as shown.

8.

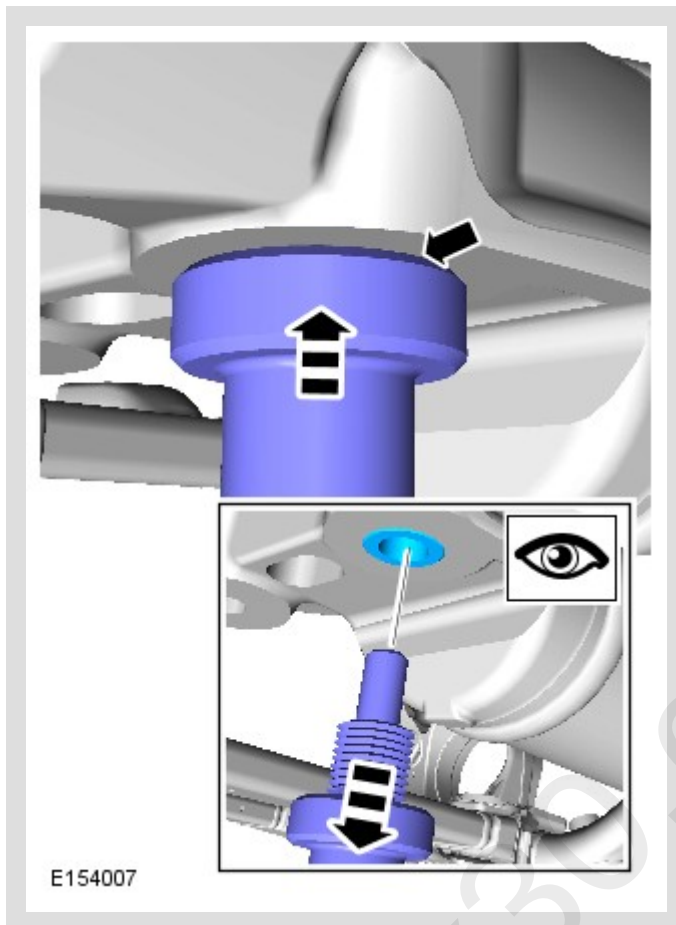


Using the special tool JLR-501-171, install the threaded insert into the body. Note that the special tool will stop against the sub-frame.

9.

⚠ CAUTION:

Allow the Loctite to cure before installing any of the sub-frame fixings.



Make sure the steel insert is located flush with the sub-frame as shown in the illustration.

10.

⚠ CAUTIONS:

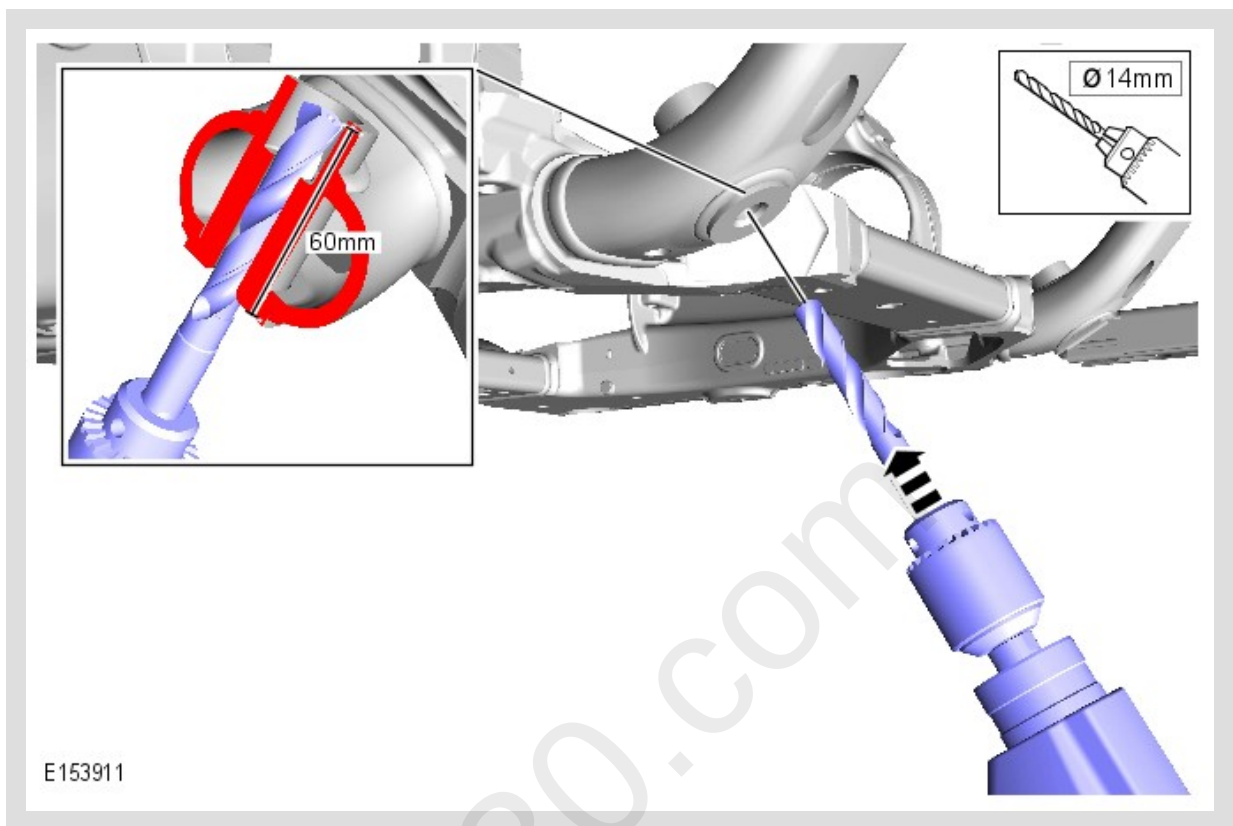
- Make sure that the depth of the drill does not exceed 35 mm.
- Apply a suitable cutting lubricate to the drill bit prior to drilling.

Repeat steps 2-9 for any remaining M12 fixings.

11.

⚠ CAUTIONS:

- Make sure that the depth of the drill does not exceed 60 mm.
- Apply a suitable cutting lubricate to the drill bit prior to drilling.



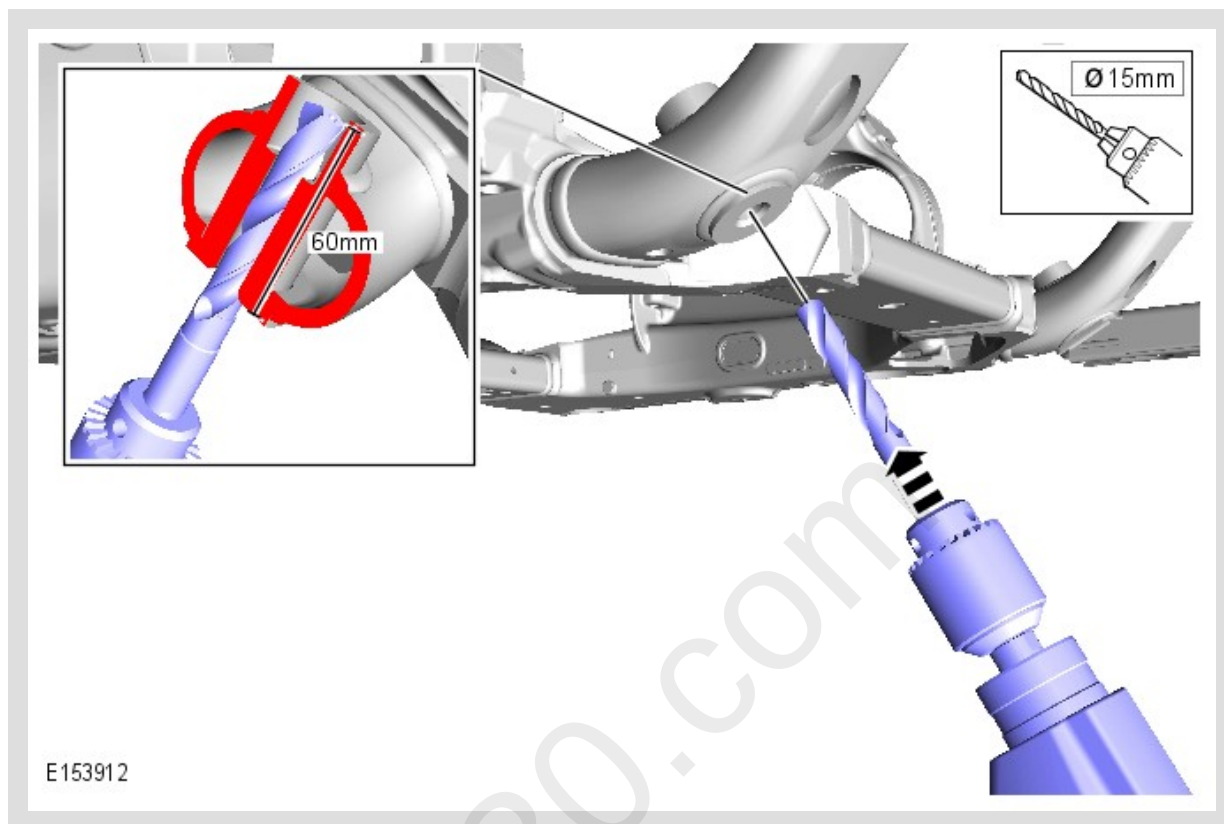
Drill the hole to a depth of 60 mm using a 14mm drill.

12.

Using compressed air make sure the hole is clean and free of debris.

ⓘ CAUTIONS:

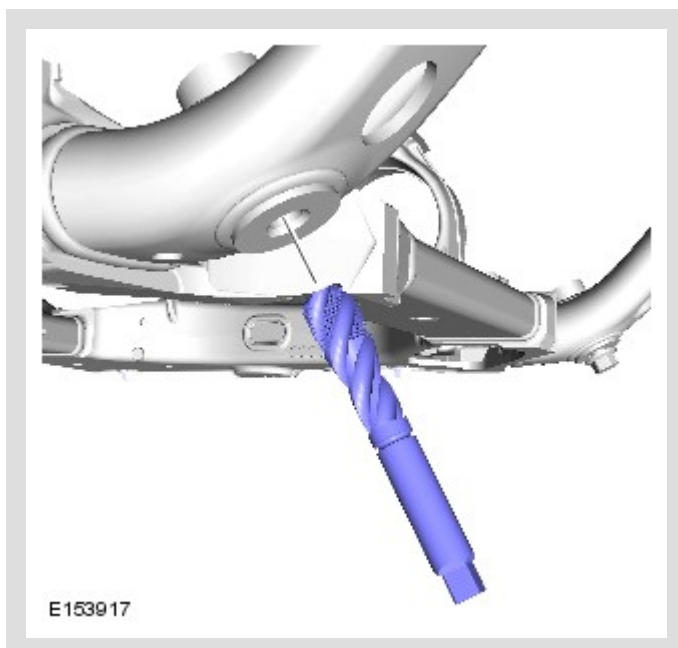
- Make sure that the depth of the drill does not exceed 60 mm.
- Apply a suitable cutting lubricate to the drill bit prior to drilling.



Repeat steps 11 and 12 using a 15, 16, and 16.5mm drill bit.

 NOTE:

Apply a suitable cutting lubricate to the tap prior to cutting the thread.

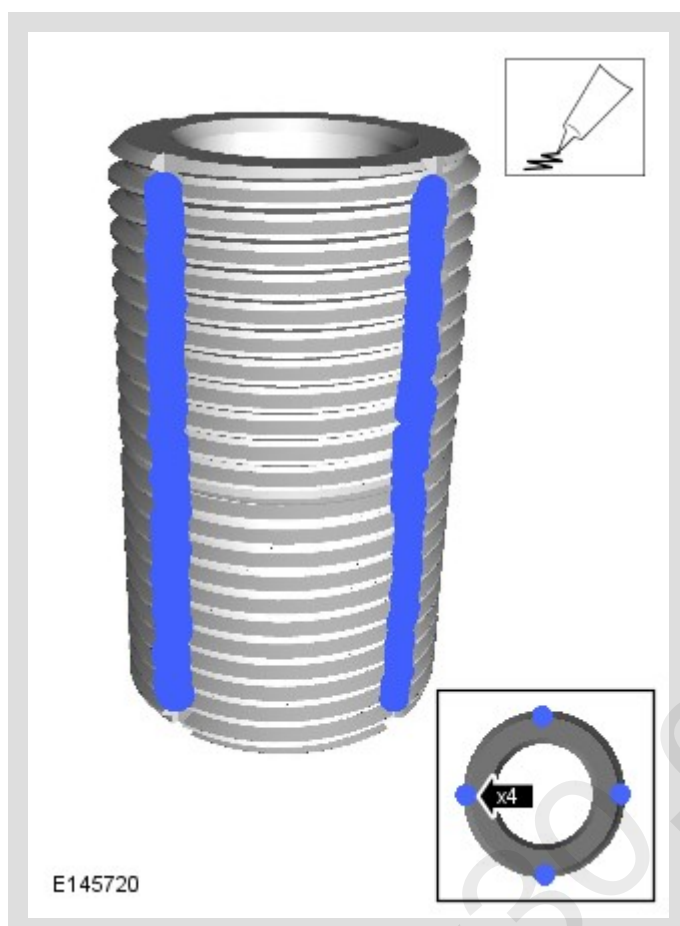


Tap the hole using a M18 x 1.5 flute tap.

15.

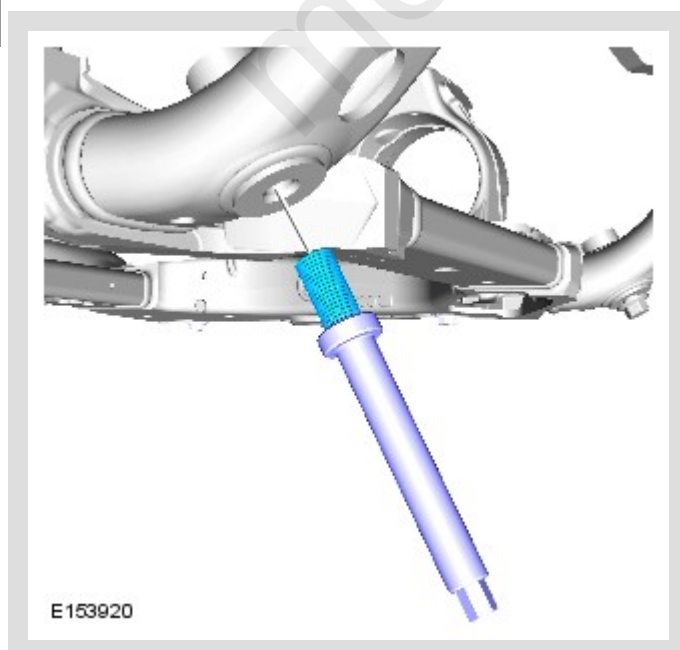
CAUTION:

Make sure that the threaded steel insert is clean and free of oil residue before applying Loctite.



Apply four beads of Loctite 243 to the outside of the threaded steel insert as shown.

16.

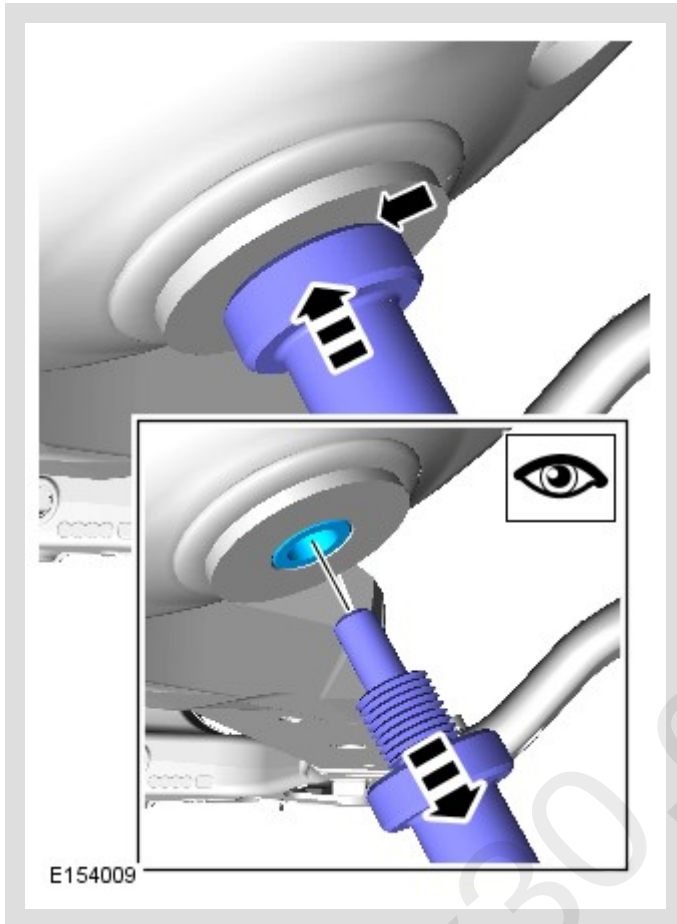


Using the special tool JLR-501-171, install the threaded insert into the body. Note that the special tool will stop against the sub-frame.

17.

⚠ CAUTION:

Allow the Loctite to cure before installing any of the sub-frame fixings.



Make sure the steel insert is located flush with the sub-frame as shown in the illustration.

18.

⚠ CAUTIONS:

- Make sure that the depth of the drill does not exceed 35 mm.
- Apply a suitable cutting lubricate to the drill bit prior to drilling.

Repeat steps 11-17 for any remaining M14 fixings.

ADJUSTMENT

1. Repeat the process for the remaining sub-frame fixings.