

UNI-BODY, SUBFRAME AND MOUNTING SYSTEM

STEEL SUBFRAME THREAD REPAIR INSERT (G2206642)

GENERAL PROCEDURES

SPECIAL TOOL(S)



JLR-502-041

Steel Subframe Insert Kit

ACTIVATION

⚠ CAUTION:

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.

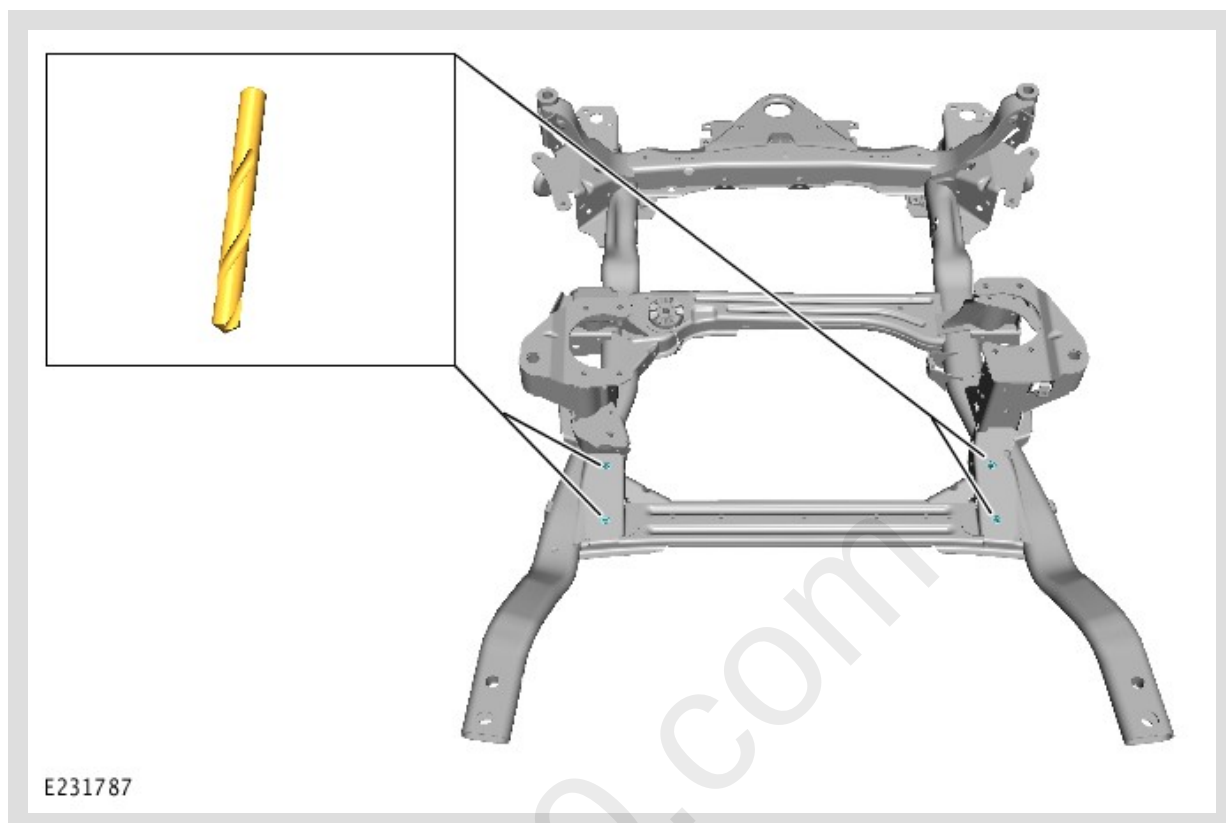
△ NOTES:

- This procedure contains some variation in the illustrations depending on the vehicle specification, but the essential information is always correct.
- This procedure contains illustrations showing certain components removed to provide extra clarity.

1.

ⓘ CAUTION:

Apply a suitable cutting lubricate to the drill bit prior to drilling.



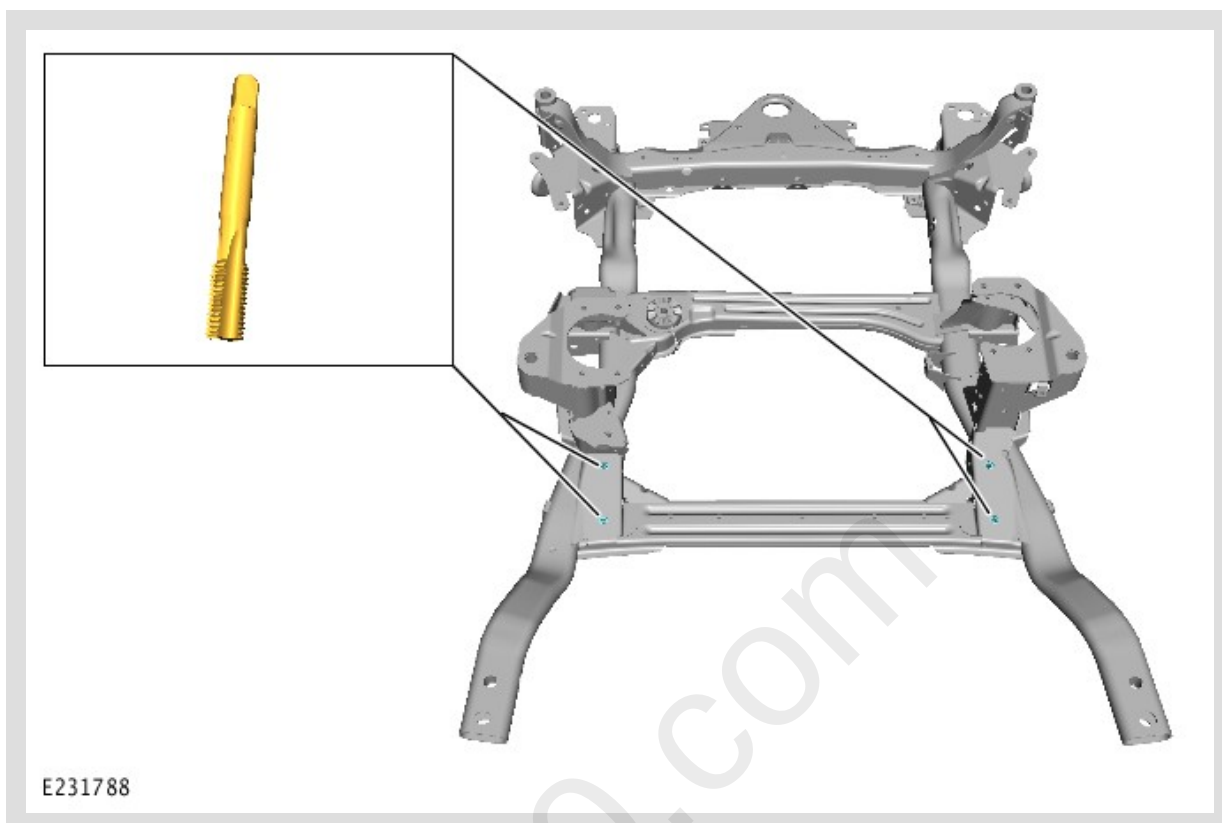
Using the M12 drill bit supplied, drill out the remaining thread.

Special Tool(s): [JLR-502-041](#)

2.

NOTE:

Apply a suitable cutting lubricate to the tap bit prior to re-threading.



Using the M12 cutting tool provided, install a new thread.

Special Tool(s): [JLR-502-041](#)

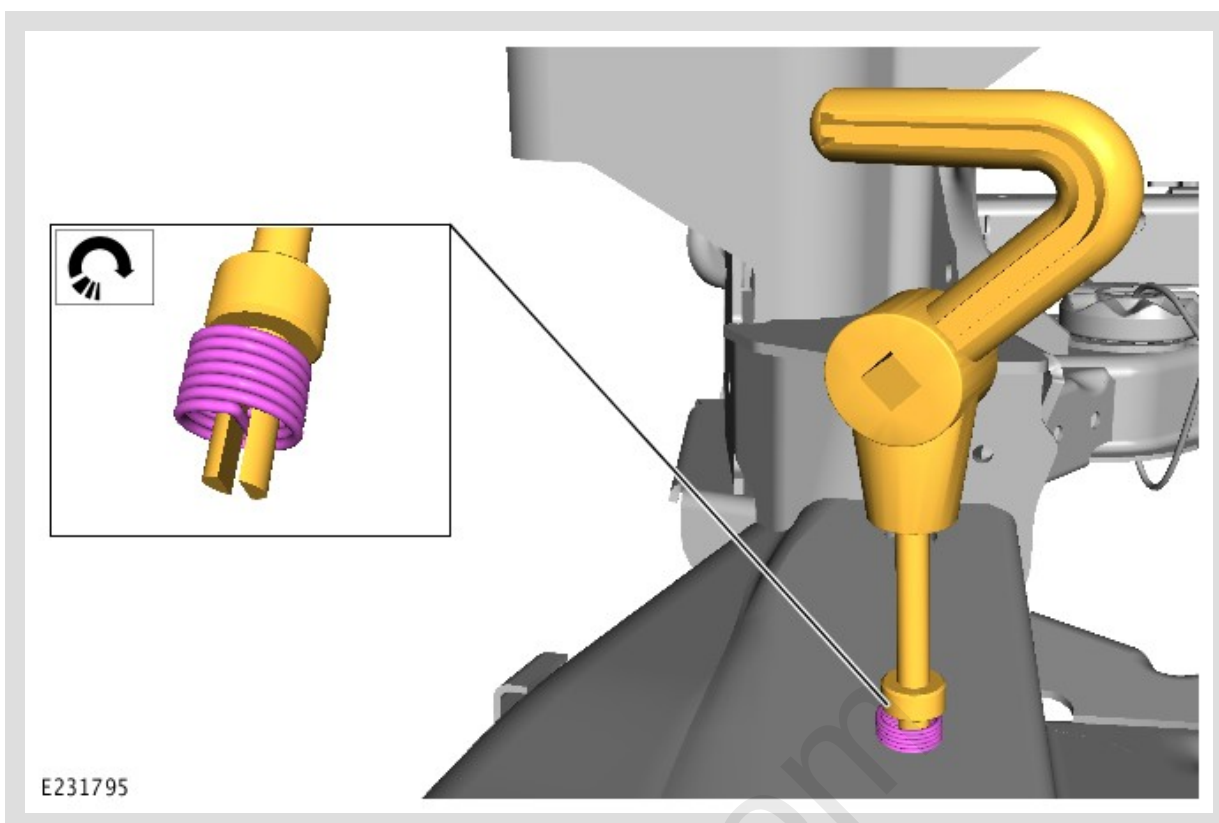
3.

WARNING:

Eye protection must be worn.

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

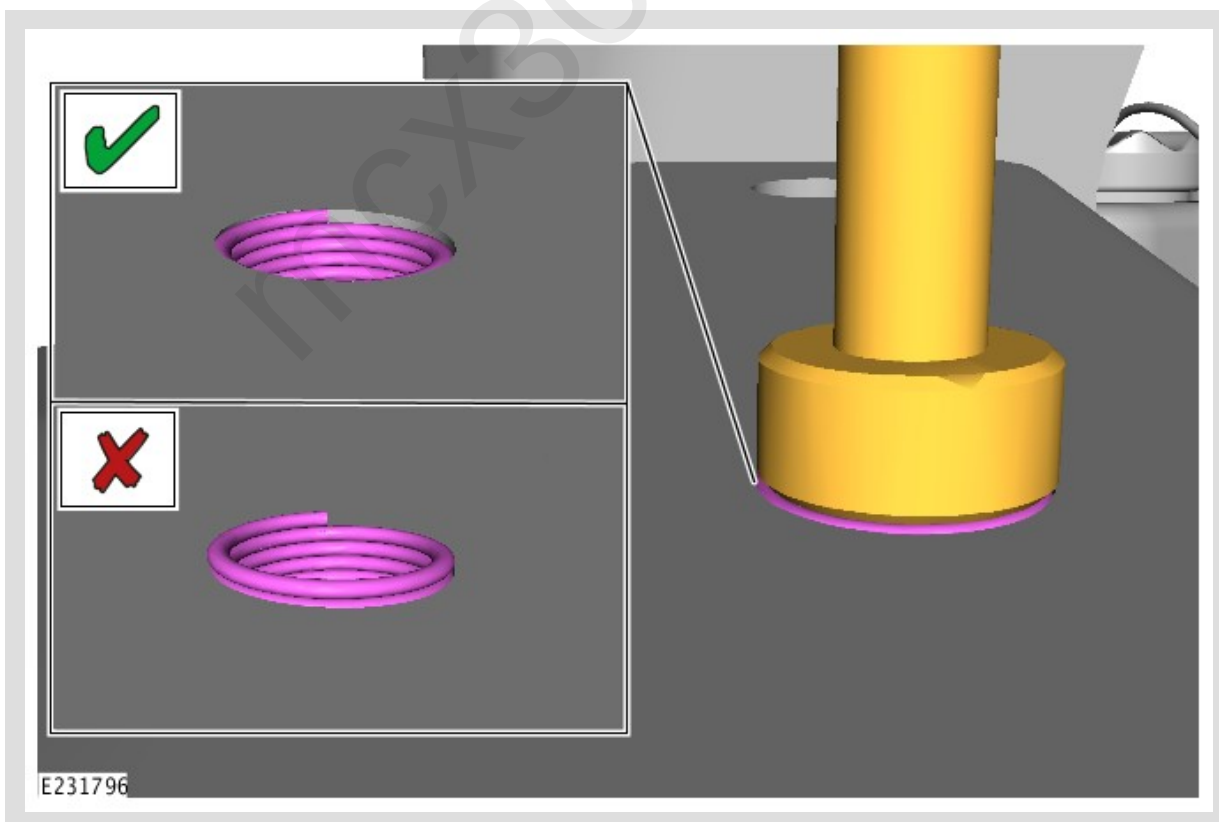
4.



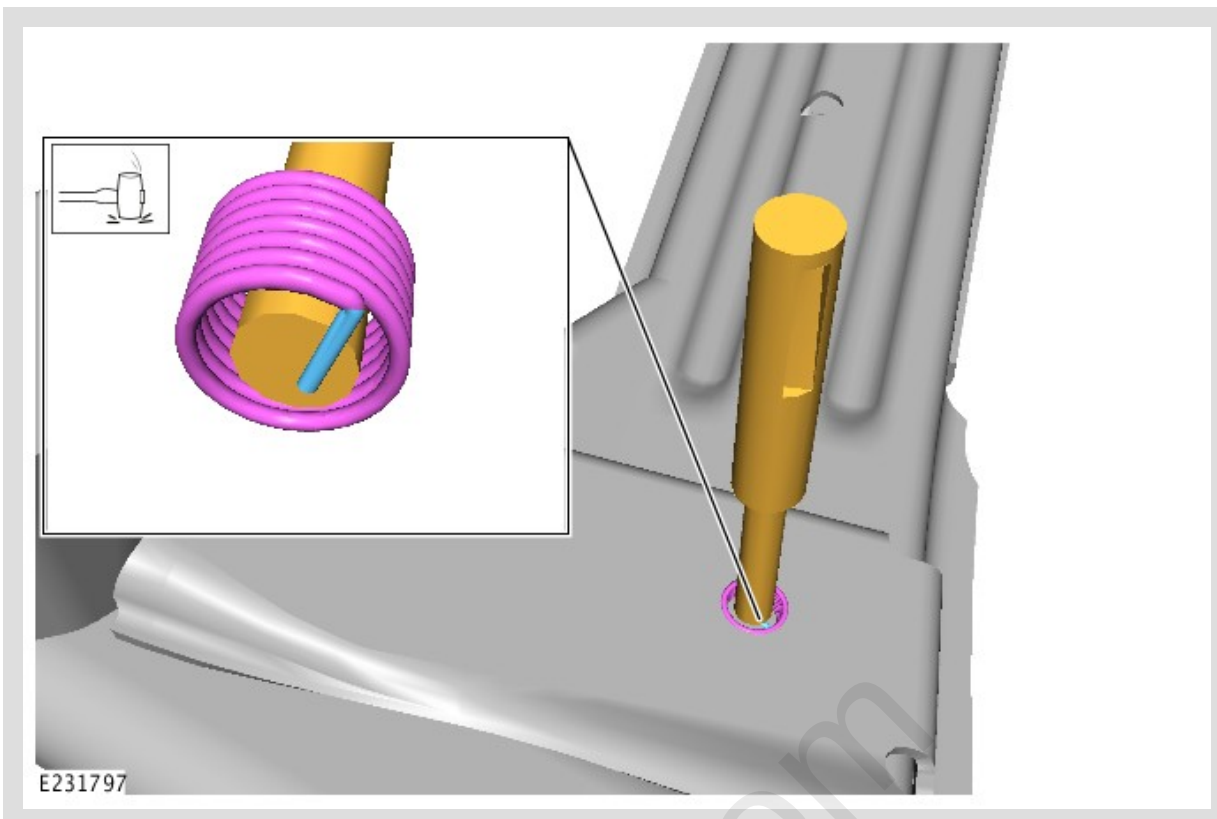
Using the special tool, install the insert.

Special Tool(s): [JLR-502-041](#)

5.



Make sure that the insert is correctly installed.

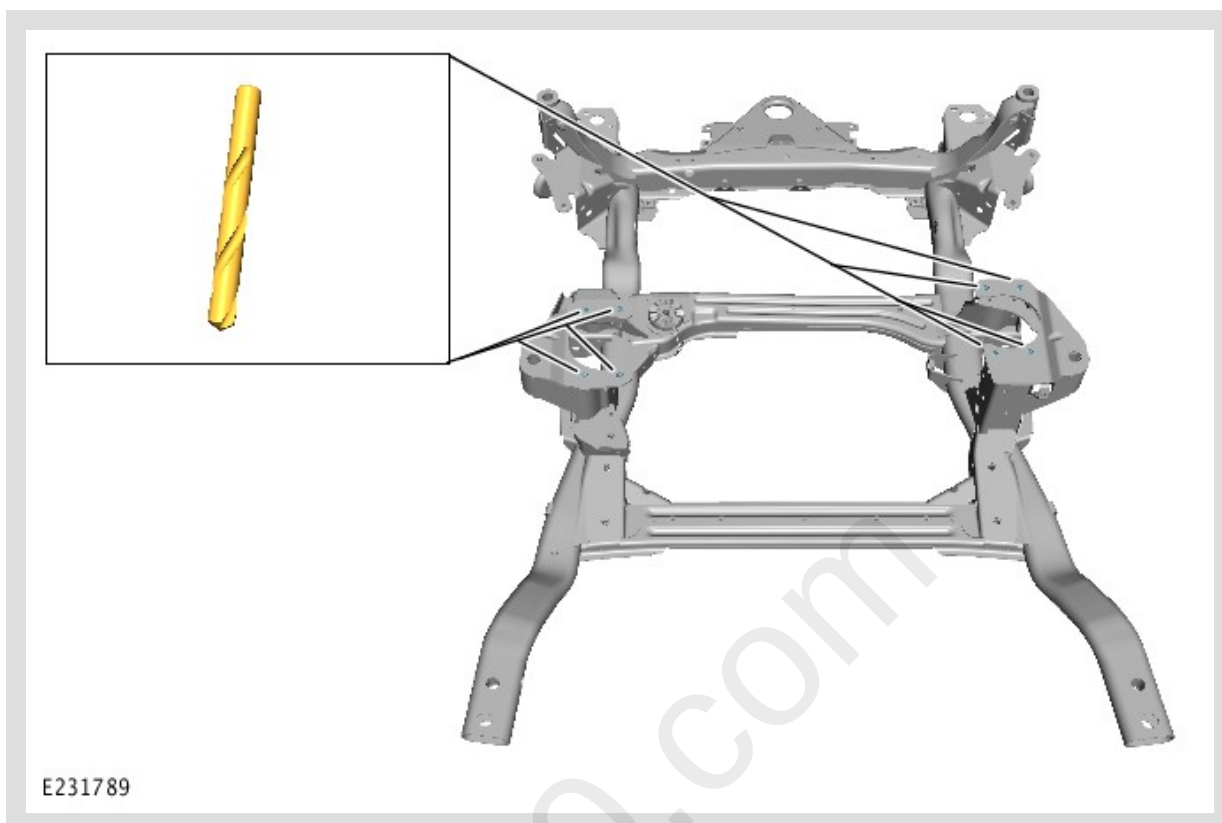


Using the special punch tool, remove the remaining insertion tang shown above.

Special Tool(s): [JLR-502-041](#)

ⓘ CAUTION:

Apply a suitable cutting lubricate to the drill bit prior to drilling.



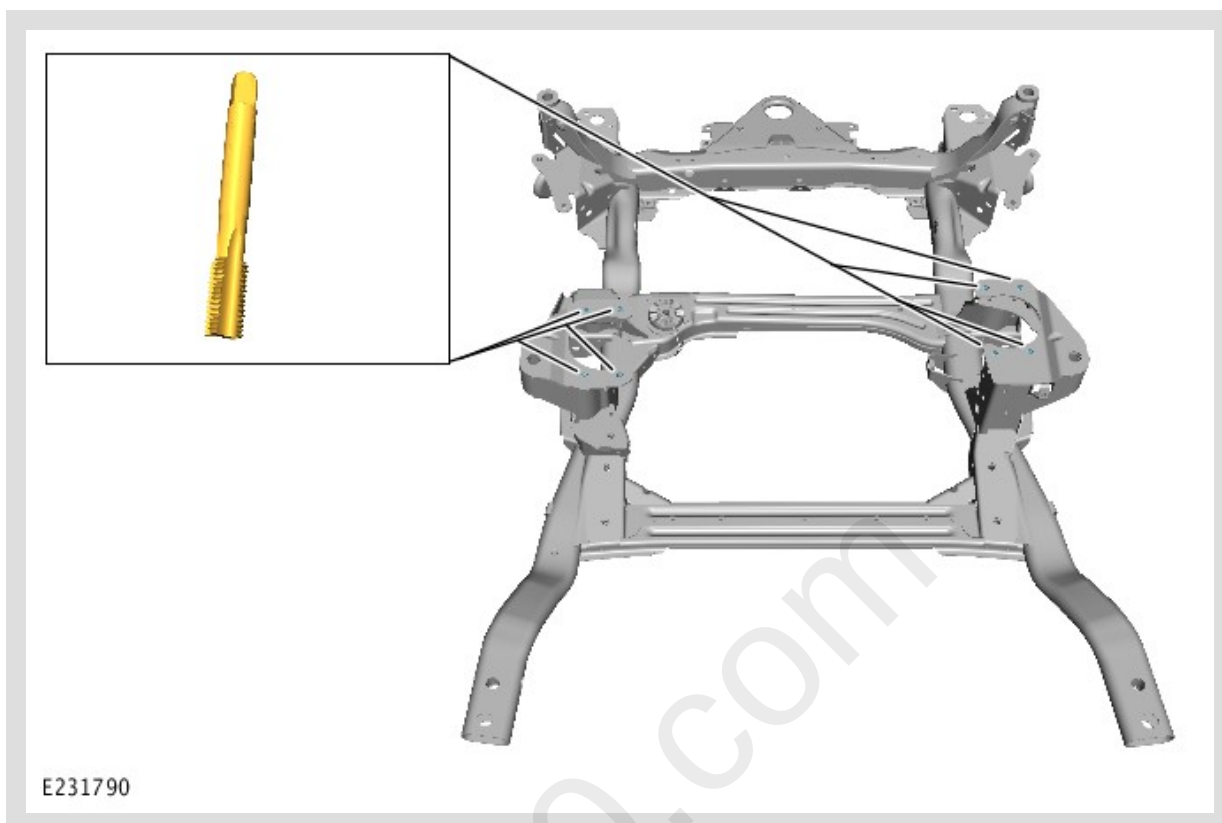
Using the M8 drill bit supplied, drill out the remaining thread.

Special Tool(s): [JLR-502-041](#)

8.

NOTE:

Apply a suitable cutting lubricate to the tap bit prior to re-threading.



Using the M8 cutting tool provided, install a new thread.

Special Tool(s): [JLR-502-041](#)

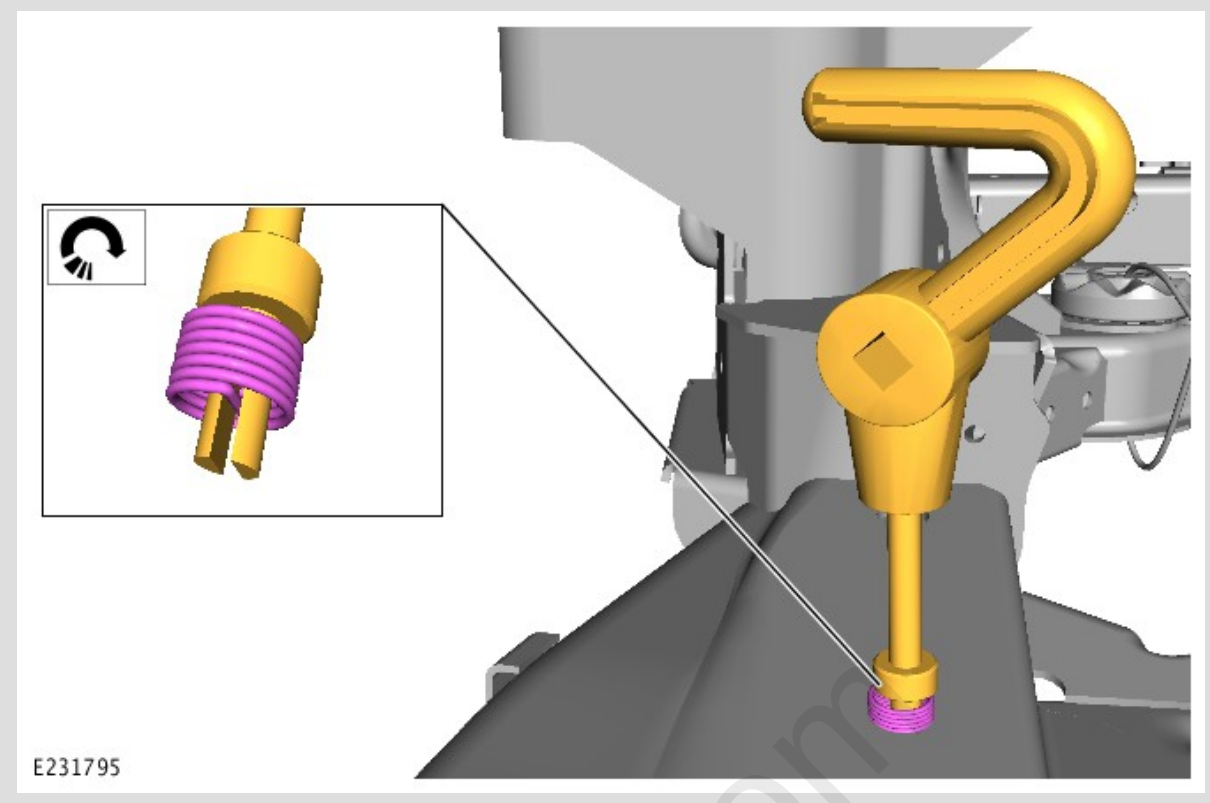
9.

WARNING:

Eye protection must be worn.

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

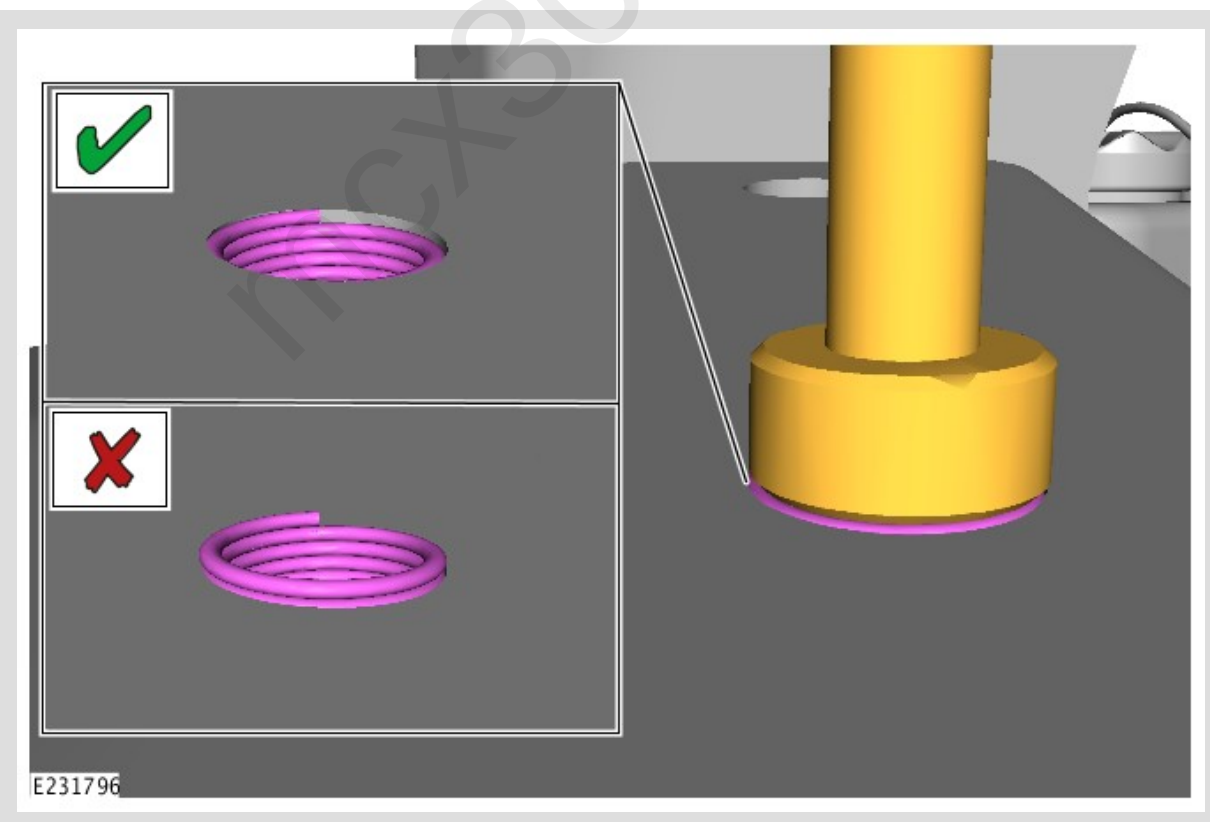
10.



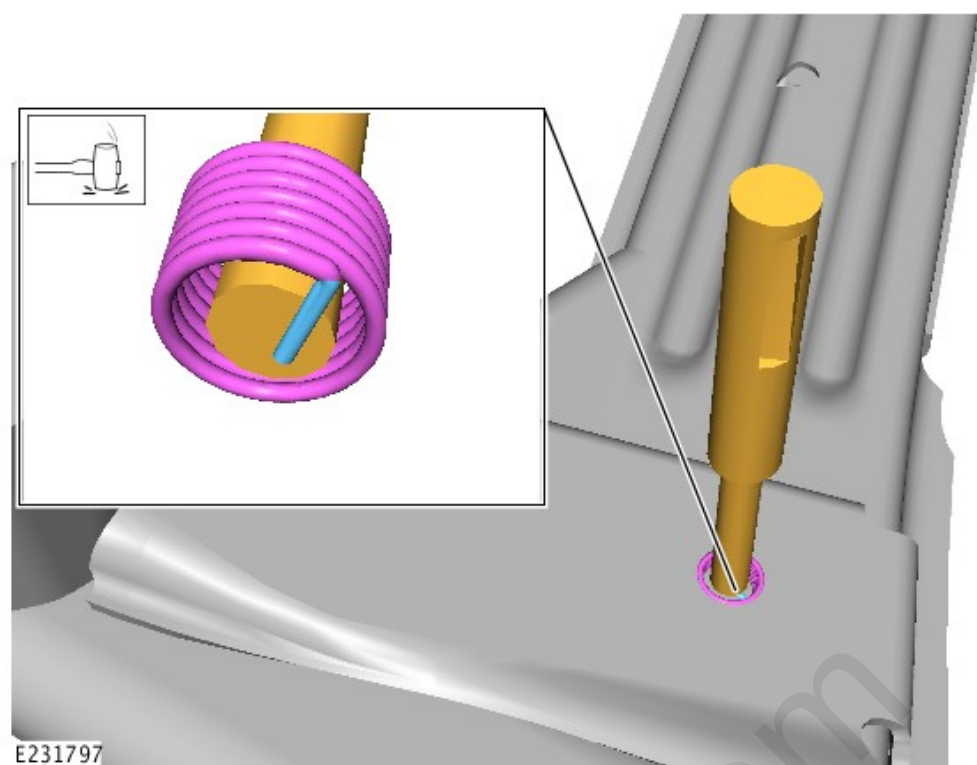
Using the special tool, install the insert.

Special Tool(s): [JLR-502-041](#)

11.



Make sure that the insert is correctly installed.

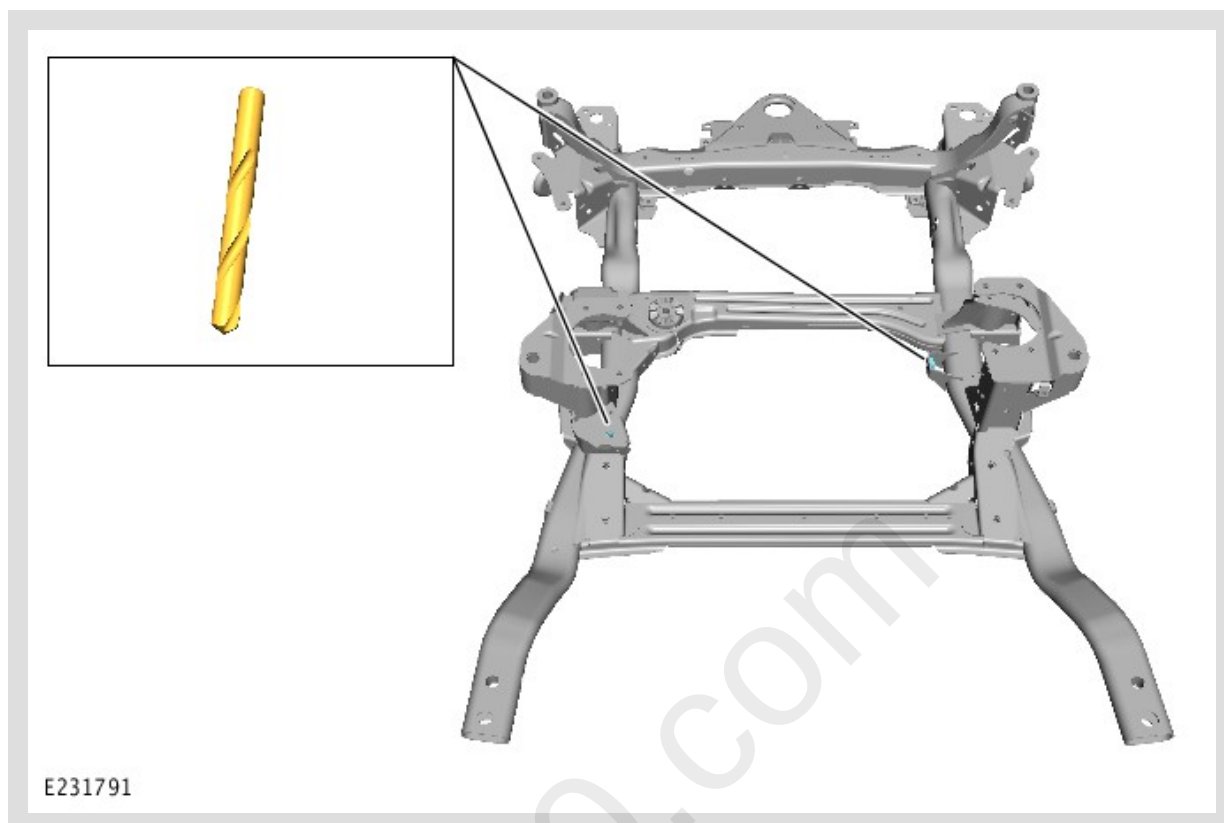


Using the special punch tool, remove the remaining insertion tang shown above.

Special Tool(s): [JLR-502-041](#)

ⓘ CAUTION:

Apply a suitable cutting lubricate to the drill bit prior to drilling.



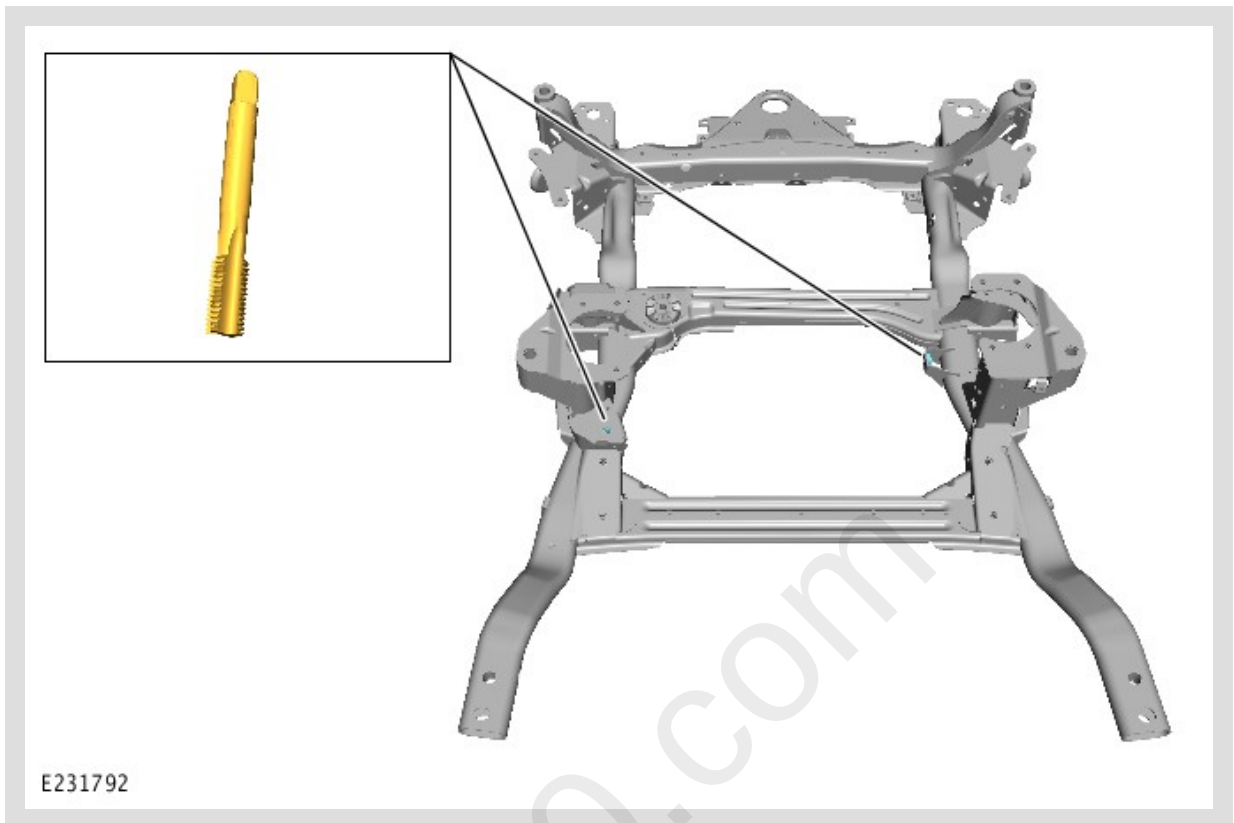
Using the M10 drill bit supplied, drill out the remaining thread.

Special Tool(s): [JLR-502-041](#)

14.

NOTE:

Apply a suitable cutting lubricate to the tap bit prior to re-threading.



Using the M10 cutting tool provided, install a new thread.

Special Tool(s): [JLR-502-041](#)

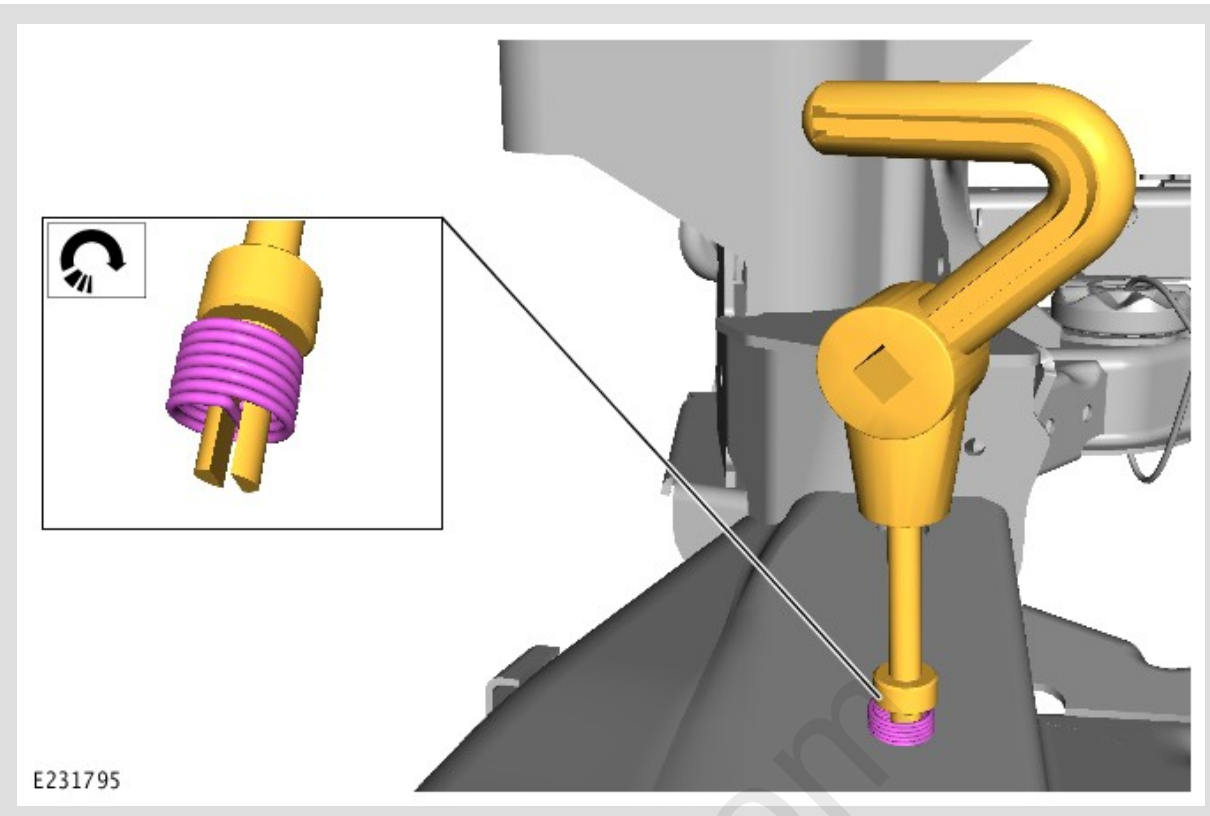
15.

WARNING:

Eye protection must be worn.

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

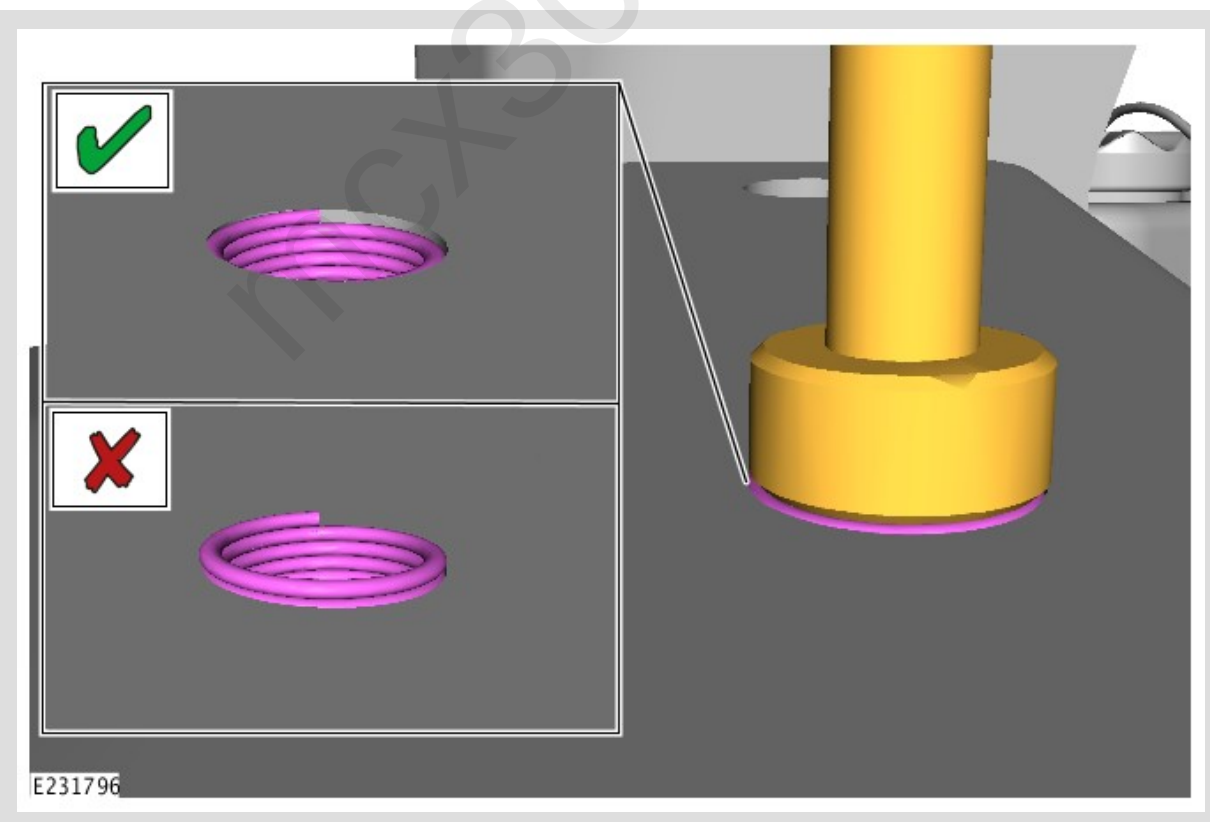
16.



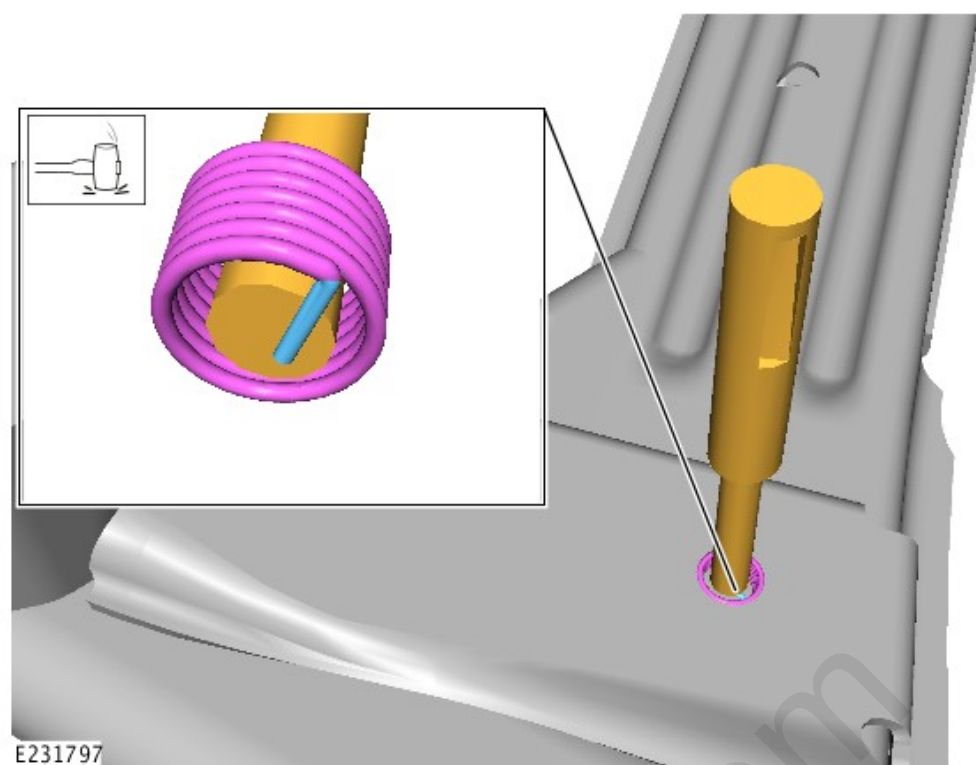
Using the special tool, install the insert.

Special Tool(s): [JLR-502-041](#)

17.



Make sure that the insert is correctly installed.

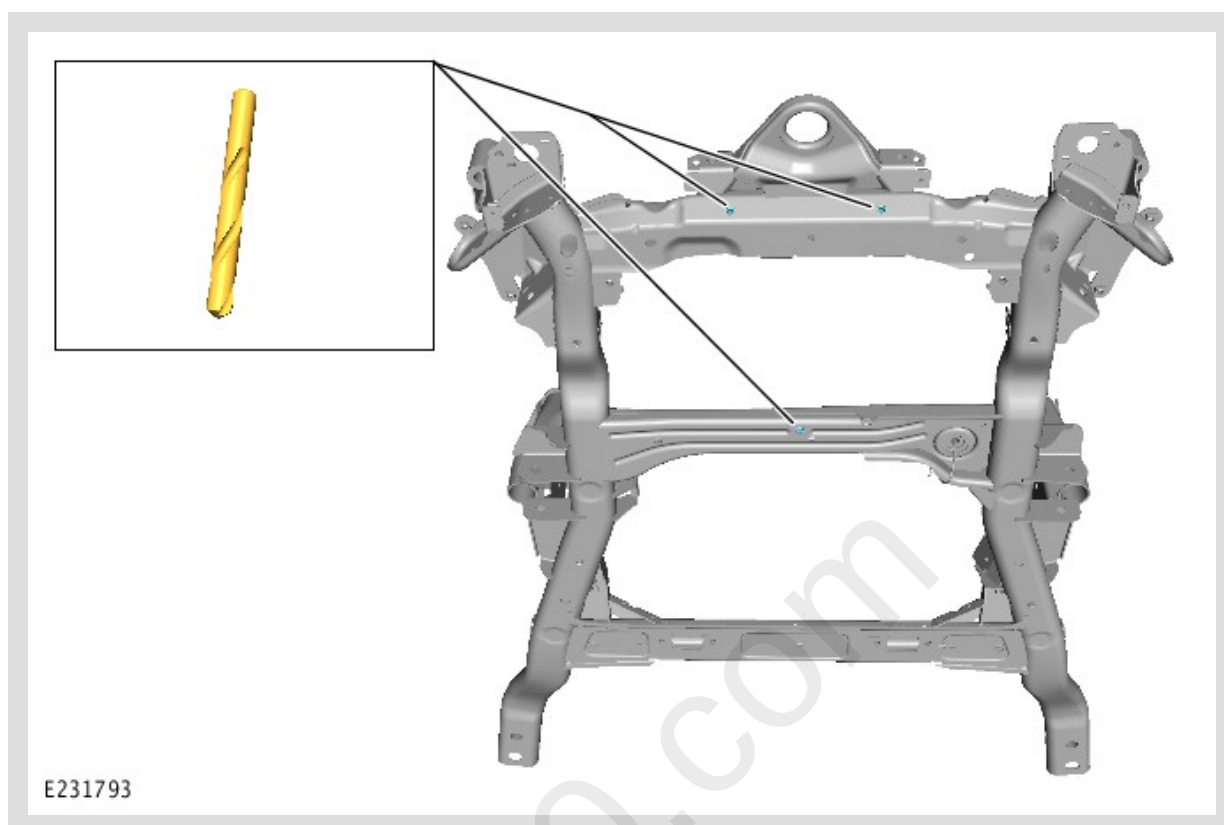


Using the special punch tool, remove the remaining insertion tang shown above.

Special Tool(s): [JLR-502-041](#)

ⓘ CAUTION:

Apply a suitable cutting lubricate to the drill bit prior to drilling.



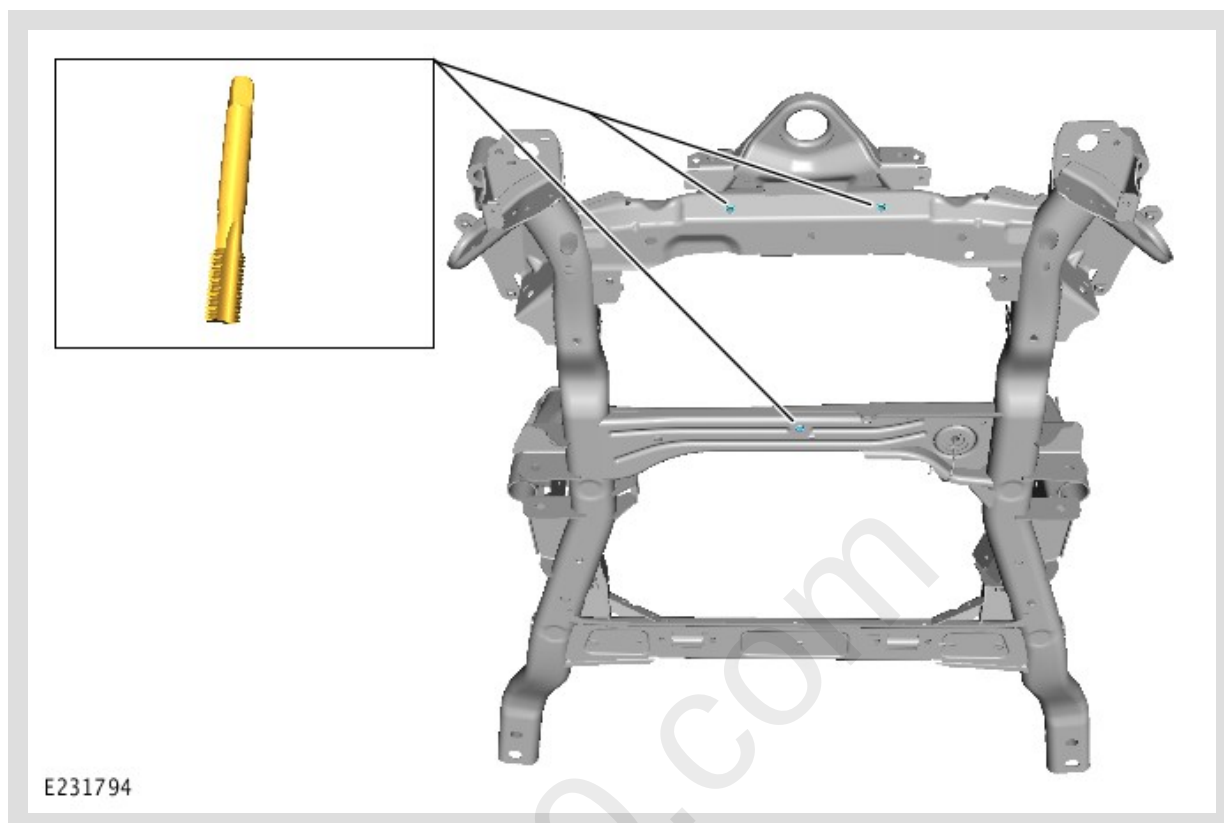
Using the M8 drill bit supplied, drill out the remaining thread.

Special Tool(s): [JLR-502-041](#)

20.

NOTE:

Apply a suitable cutting lubricate to the tap bit prior to re-threading.



Using the M8 cutting tool provided, install a new thread.

Special Tool(s): [JLR-502-041](#)

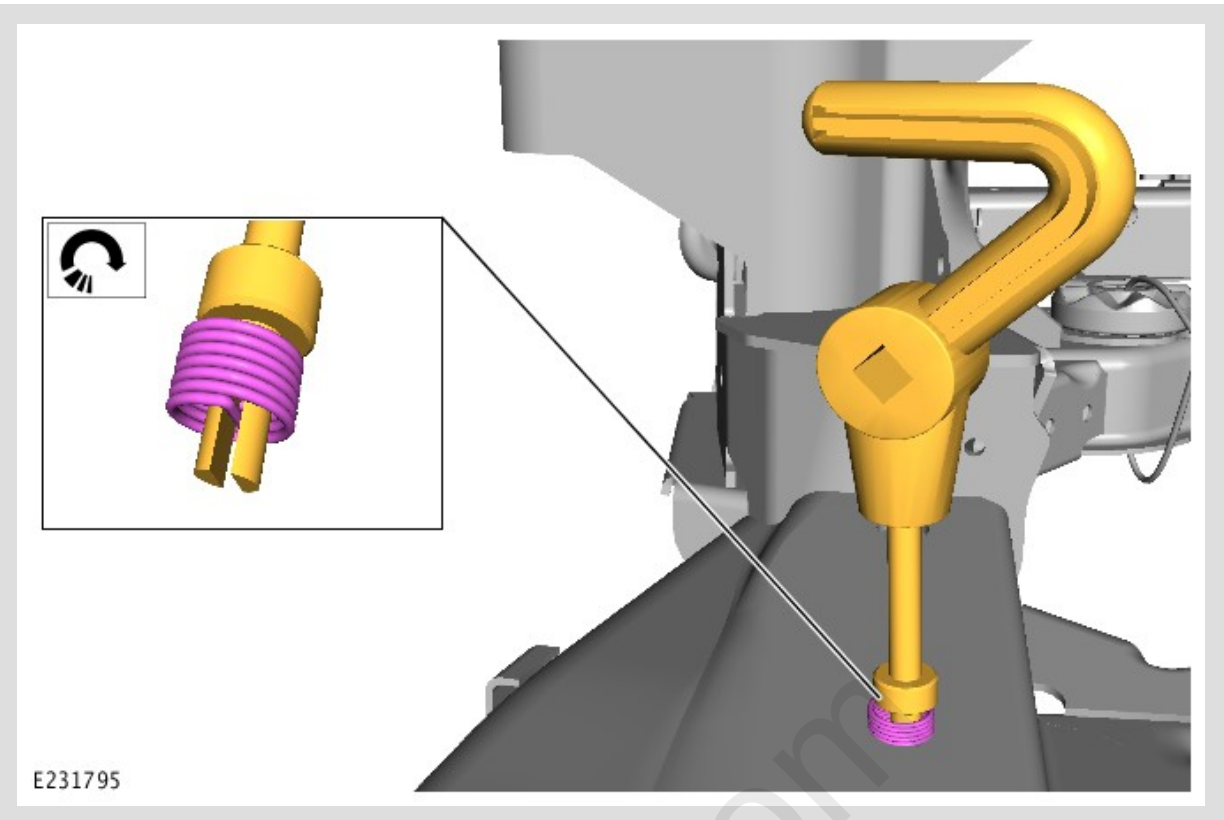
21.

WARNING:

Eye protection must be worn.

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

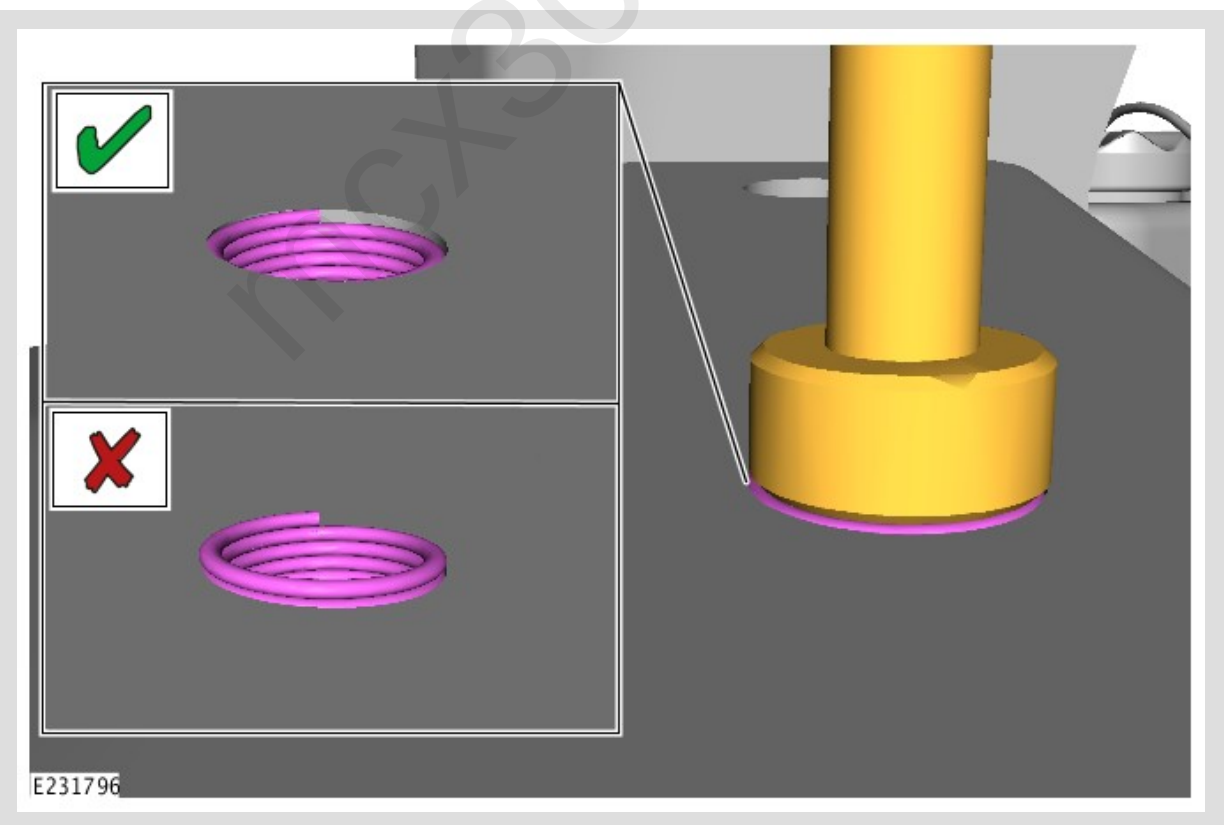
22.



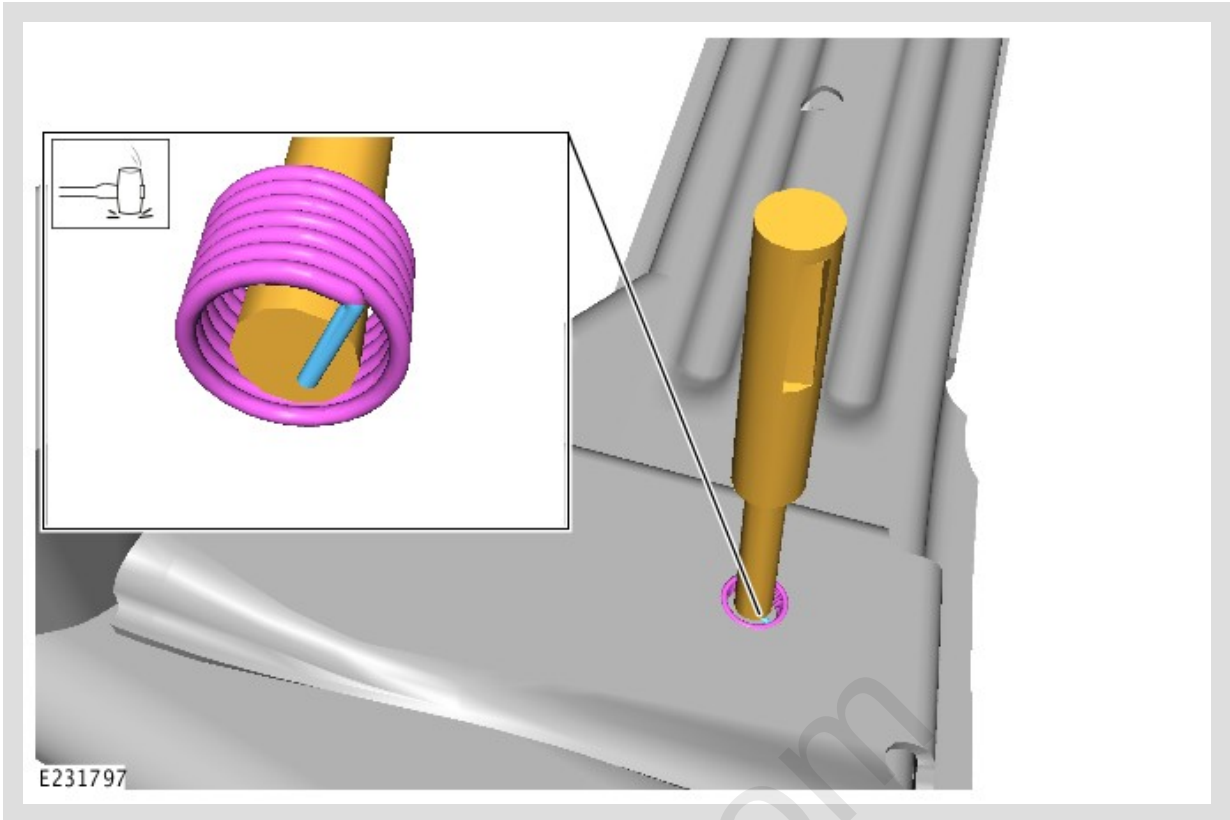
Using the special tool, install the insert.

Special Tool(s): [JLR-502-041](#)

23.



Make sure that the insert is correctly installed.



Using the special punch tool, remove the remaining insertion tang shown above.

Special Tool(s): [JLR-502-041](#)