

Drill the fluo tapped nut, observing the nominal diameter of the insert, see table.

Ø nominal	Ø drilling hole (mm)
M6 x 100	10.2
M8 x 125	13.5
M10 x 150	15.5

2. ANTI-CORROSION PROTECTION

If it is a hollow section, inject wax to stabilise the swarf and protect the parts which have been bared during the drilling operation.

[\(see 04F, Bodywork products and mountings, Anti-corrosion protection products after assembly: Use\)](#)

3. FITTING THE CAPTIVE NUT

Fitting the captive nut[\(see 40H, Bolted connections, Screw connection with crimped mounting: Description\)](#) .



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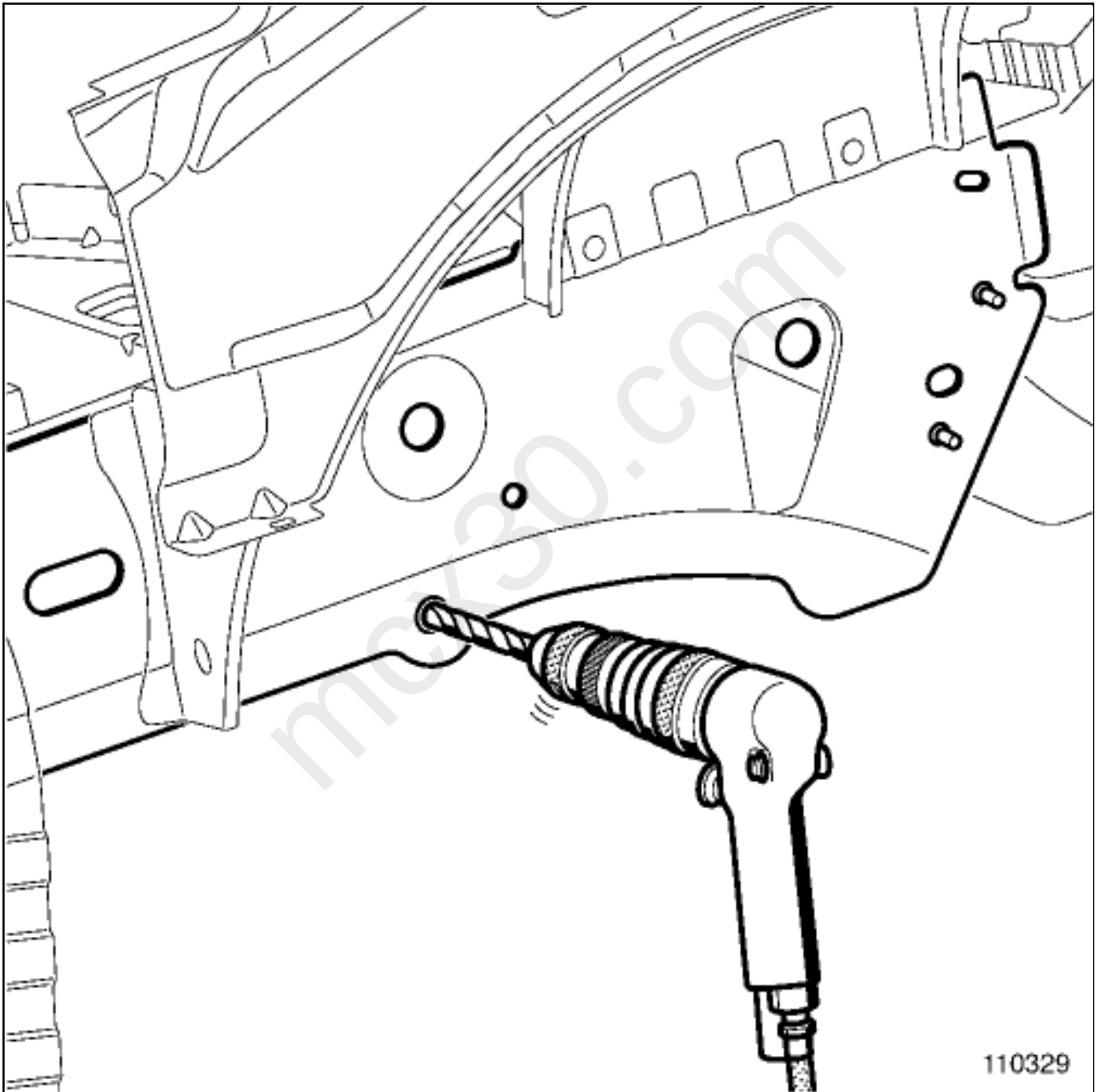


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BOLTED CONNECTION WITH WELDED NUT

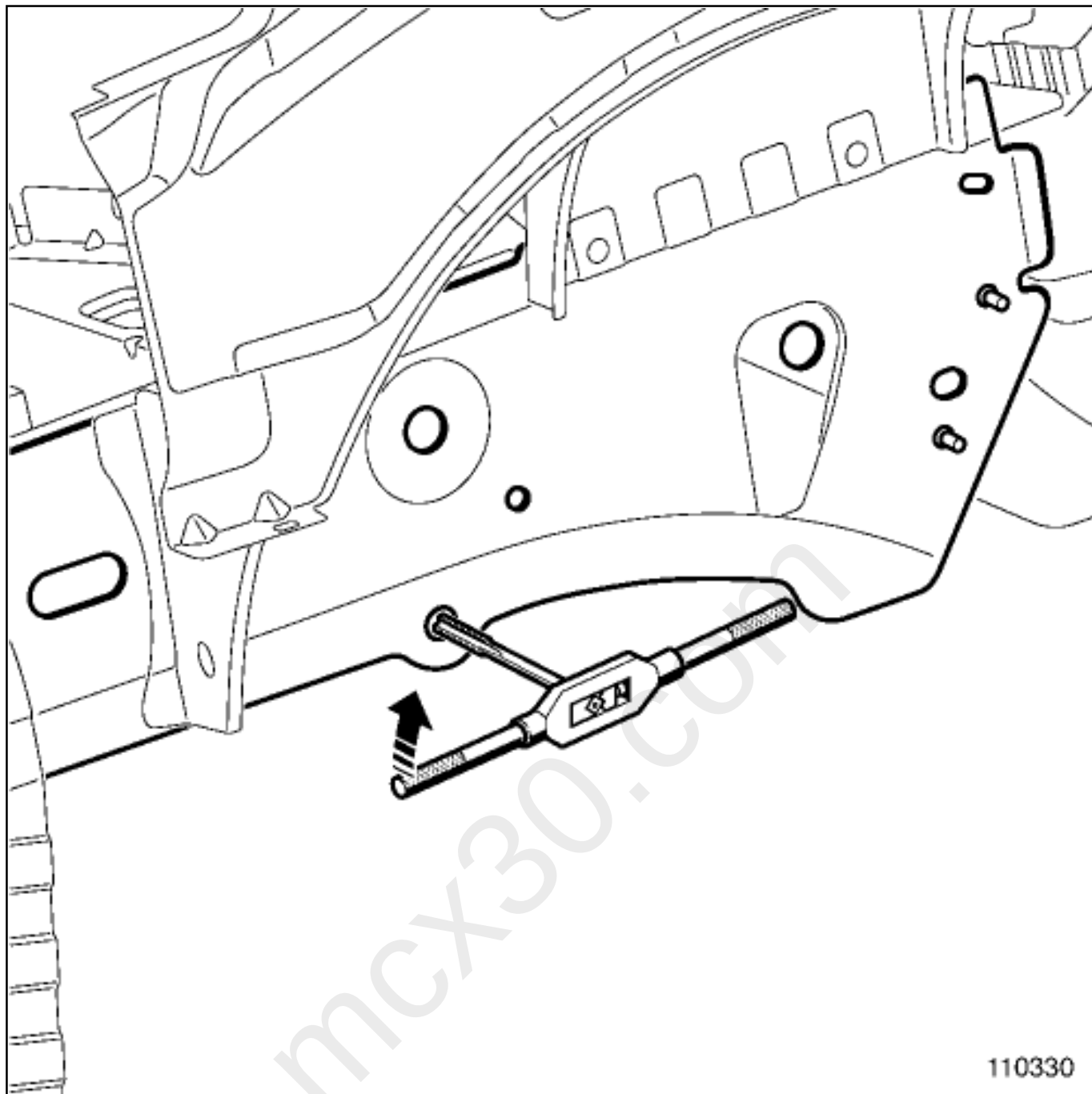
Repairing a welded nut is done using a helical thread insert from "helicoil" type, to be ordered at a supplier's as well as the appropriate material.

1. PREPARATION



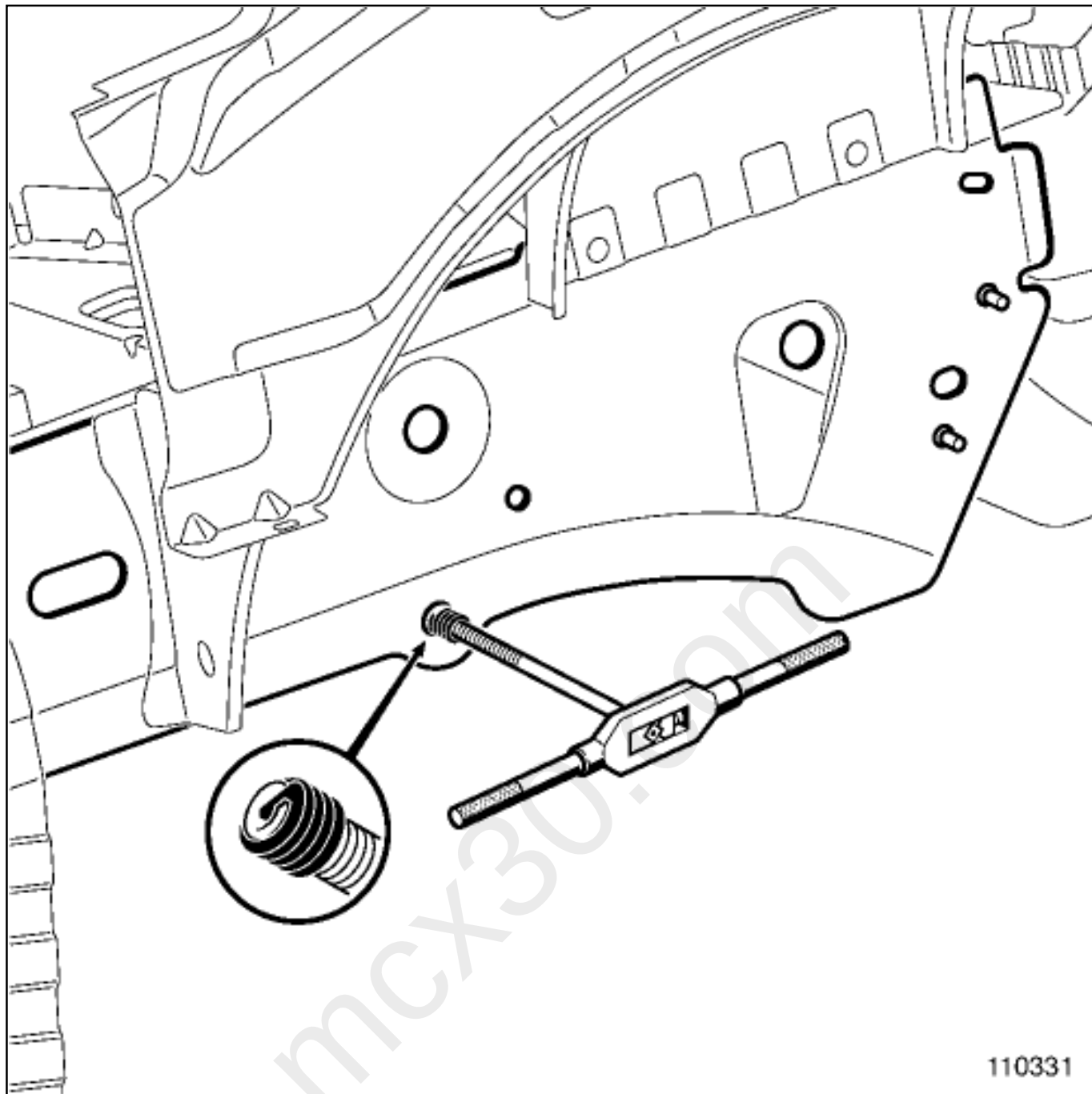
Drill a front hole according to the nominal diameter of the thread, see table below.

Ø nominal	Ø drill bit (mm)
M4	4.2
M5	5.2
M6	6.3
M8	8.4
M10	10.5
M12	12.5
M14	12.5



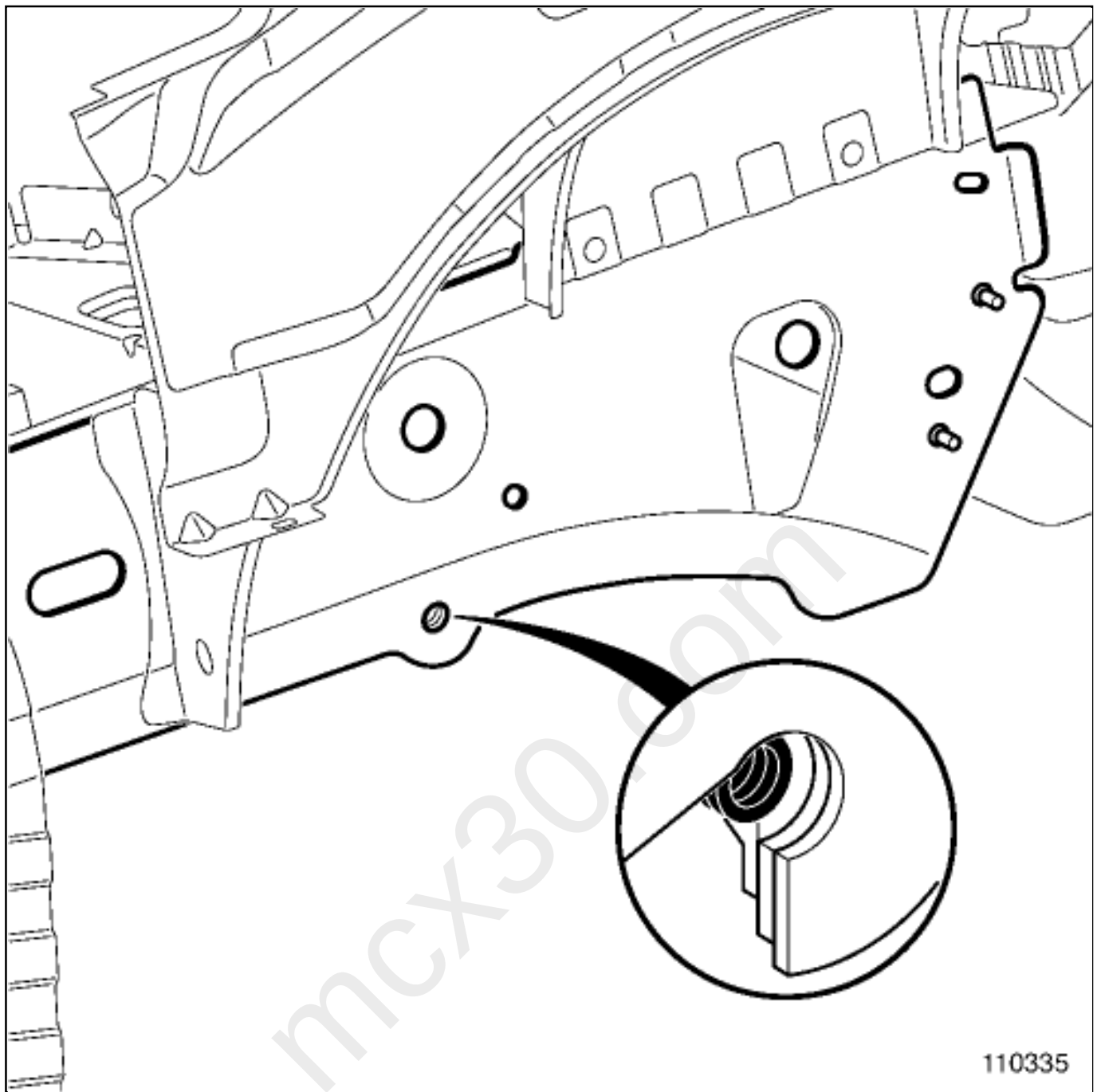
Tap the drilling hole using the tap provided with the helical thread inserts, do not forget to lubricate during the operation to evacuate the shavings.

2. FITTING THE HELICAL THREAD INSERT



Insert the helical thread insert on to the adapted pin by placing the driving plate pin in the neck provided.

Turn the pin in the drilling hole.



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Note:

For perfect insertion of the helical thread insert at 0.25pitch below the surface of the part.

Break the driving plate pin using a jet.