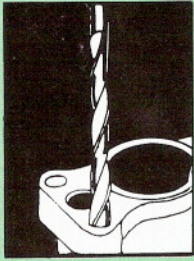
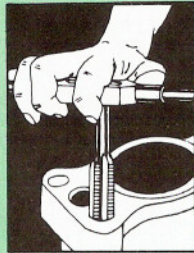


INSTALLATION PROCEDURE



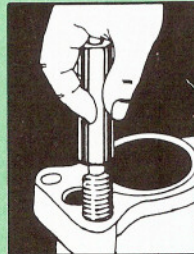
DRILLING

Use regular procedures, working to diameters specified in the Table on reverse. The first column is for Aluminium. For Steel, Magnesium and Plastics, the alternative larger size drills recommended in the second column should be used.



TAPPING

FASTMAN tapping is usually done in a single operation with one of the types of *FASTMAN* finishing taps. *FASTMAN* roughing taps are available, however, for occasions when tough materials make both rough and finish cuts necessary.



Gauging

Clean tapped hole. Use required *FASTMAN* thread gauge to check size and full thread depth in conventional manner.



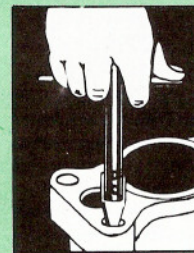
INSTALLING INSERTS

Prewinder Type *FASTMAN* Inserting Tools are available for hand installation of Inserts. The Prewinder Type is a precision tool which aligns and precompresses the insert for easy installation. A slotted mandrel in the tool drives the insert by its tang. This tool is recommended for hand installation of all sizes of Coarse & Fine Series of Inserts.



REMOVING INSERT TANGS

The tang on a *FASTMAN* Insert should be removed after installation only when necessary for screw clearance or product appearance, and in such cases notched inserts should be used. This is easily accomplished by placing the punch of the Tang Break Off Tool into the installed insert and resting tool squarely on the insert tang. Strike the top of the tool with a hammer, using a sharp blow. (Fig.4)



EXTRACTING INSERTS

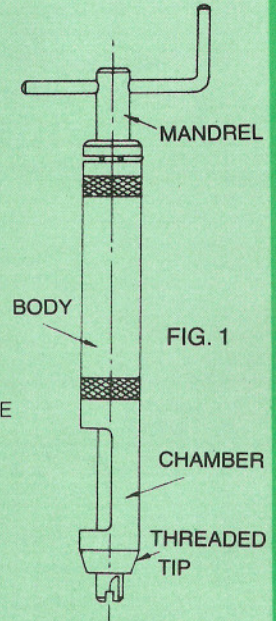
In rare instances, inserts are installed too deep, cross-threaded or otherwise improperly inserted. Such inserts are readily removed with *FASTMAN* Extracting Tools which are available in four sizes to fit all sizes of inserts. Place the blade of the extracting tool into the insert as shown in Fig. 5. Hit the top of the tool with a hammer, causing the blade to bite into the insert. Push down on the tool and rotate counterclockwise to back the insert out of the hole.

(*FASTMAN* inserts produce permanent threads; hence extraction is not normally necessary.)

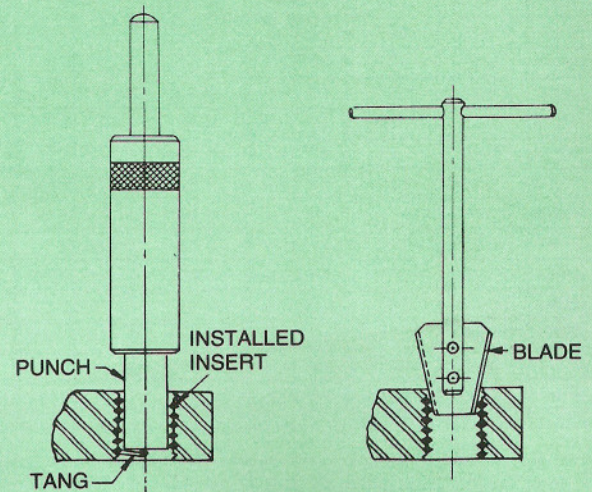
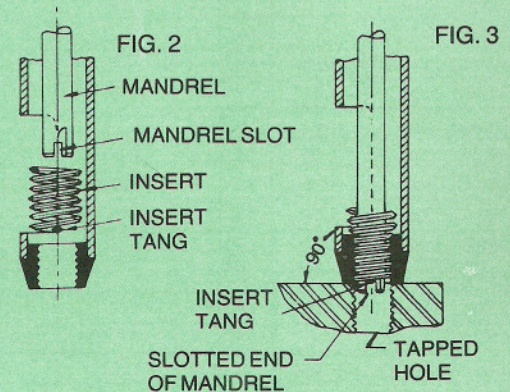
METHOD OF USING THE PREWINDER TYPE INSERTING TOOL

To use *FASTMAN* Prewinder Type Inserting Tool. (Fig. 1) retract mandrel and place insert in chamber with tang end towards threaded tip of tool. Advance the mandrel until slot fully engages the insert tang. Rotate and advance the mandrel until the mandrel protrudes 1 mm from tip. Hold tool firmly and squarely against work (Fig. 3) and install insert into tapped hole by rotating mandrel at a slow, uniform rate, until the top coil of the insert is $\frac{1}{4}$ to $\frac{1}{2}$ turn below top surface of hole. DO NOT PUSH ON MANDREL. DO NOT REVERSE MANDREL TO REMOVE TANG.

When inserts are installed in small parts which can be held in hand, the Inserting Tool should preferably be mounted in a vice and the work brought to the tool.



PREWINDER TYPE INSERTING TOOL



TANG BREAK-OFF TOOL

FIG. 4

EXTRACTING TOOL

FIG. 5