Features of Self-Tapping Inserts
Slot tapped inserts with both external and internal threads. This fastener reinforces relatively low mechanical thread strength and allows shaping of the key tapping.

How to Use a Bolt & Nut
Use a hex nut and a Self-Tapping Insert in a double-nut arrangement as shown below. Do not obstruct the first thread or the 3-flutes with the bolt. After the insertion is complete, loosen the hex nut while rotating the bolt head.

Machining Procedure & Precautions for Use
1. Drill a pilot hole in the workpiece, using the appropriate length of tap pilot hole diameters shown in the table above. When the tapped material has high hardness, drill a pilot hole of slightly larger diameter within the range.
2. With the slot facing down, fit the self-tapping insert all the way onto the tip of the hand tool (Fig. 1). Put the insert vertically into the pilot hole by turning the tool handle (Fig. 2).
3. The pilot hole diameter is too small, it may cause a lag in pitch or looseness, and damage tools.
4. *At the start of tapping (1 to 2 pitches), check to see if the tools are aligned straight with the pilot hole. If the insert is going in straight, start turning the tool and tool handle counterclockwise to separate the tool from the work. (Fig. 3) Further turning a tool after already contact with the work could damage the self-tapping part of the insert and result in a loose fit.
5. Before the first use, please select a proper pilot hole dia. through trials.
6. When the tapped material has high hardness, drill a pilot hole of slightly larger diameter within the range.

Insertion and Removal Tools

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Type</th>
<th>Material</th>
<th>Thread</th>
<th>Length</th>
<th>Diameter</th>
<th>Head</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>TLTP</td>
<td>Insert Tool</td>
<td>303 Stainless Steel — Free-Cutting Steel Chromate</td>
<td>M6</td>
<td>20.0 mm</td>
<td>6.9</td>
<td>1/4&quot;</td>
<td>20</td>
</tr>
<tr>
<td>TLTN</td>
<td>Removal Tool</td>
<td>303 Stainless Steel — Free-Cutting Steel Chromate</td>
<td>M6</td>
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