

# Recoil Pro XL Thread Repair Kits

To watch our installation demo video visit [afsindustrial](#) on YouTube.

For more information on any of our Recoil products visit [www.afsrrecoil.net](http://www.afsrrecoil.net)



Everything You need for complete thread repair in one handy box



## Kits Contents:

- 10 Wire Thread Inserts, 1.5D Length
- 1 STI HSS Intermediate Tap
- 1 Installation Tool
- 1 Tang-break Tool
- 1 Drill-bit

Thread form and Size	RS Kit Part Number	Recoil Part Number	Replacement Pack RS Code	Replacement Pack Recoil Code	Inserts In Pack
UNC 1/2 - 13	703-7197	33088	RS244-8448	23083	10
M10-1.5	703-7175	35108	RS528-671	25103	10
M12-1.75	703-7188	35128	RS528-687	25123	10
M10-1.25	703-7172	37108	RS246-1126	27103	10
M12-1.5	703-7179	37128		27123	10



### Installation Tool

The installation tool has been designed to accommodate a tap holder in the handle, so the same tool can be used for two functions in the thread repair process.



### STI Tap

Screw Thread Insert (STI) taps are special taps specifically used to prepare holes for installation of wire thread inserts.



### Tang- break Tool

For easy tang removal in blind holes. Magnetised to ensure no broken tangs are left in the application after installation.

Recoil inserts are formed from high quality stainless steel wire with a diamond shaped cross section, wound to the shape of a spring thread. Once the wire is wound into a helical coil and installed into a tapped hole, it provides a permanent and wear resistant thread in the parent material that is generally stronger than the original thread. The inserts are designed to be greater in diameter than the tapped hole and compress as they are installed. This allows maximum surface contact area with the tapped thread, safely and permanently anchoring the inserts into place. The insert's compensatory action shares the load over the entire bolt and hole, increasing pull out and torque out strength. With a Recoil insert in place, load and stress are more evenly distributed over the assembly.

Information shown in mm	UNC	Metric			
	1/2-13	M10-1.5	M12-1.75	M10-1.25	M12-1.5
Free coil Dia. Min.	15.1	11.95	14.3	11.8	14
Free coil Dia. Max.	15.8	12.5	15	12.65	14.95
Number of coils (+/- 0.25)	7.875	8	8.25	9.85	9.5
Nominal Length	19.1	15	18	15	18

Insert Material Type: Stainless 304

Max Temperature: Peak 425 C (800 F) Continuous 315 C (600F)