



INSTRUCTIONS FOR USING KATO TANGLESS COILTHREAD® INSERT TOOLS

THE FOLLOWING INSTRUCTIONS ARE APPLICABLE TO THE KATO TANGLESS ROUND ELECTRIC INSTALLATION TOOL (2KRE Series) Sizes: 0-80, 1-64, & M2.

Mandrel Length

0-80: 1.82 in.

1-64: 2.73 in.

M2X.4: 2.73 in.

Gage Handle

2KREH-UI: 2 in.



BEFORE YOU BEGIN REVIEW...

- Proper hole preparation procedures.
- The step by step instructional video found in the KATOpedia section of katofastening.com
- The entire content of this document prior to operation.

IN THE BOX

- 1 Mandrel Assembly (1 Threaded Mandrel, 1 Pawl, 1 Spring, 1 Pin)
- 1 Adjusting Sleeve Housing
- 1 Lock Nut
- 1 2KREH-UI Gage Handle



0-80 REPLACEMENT PARTS LIST

REPLACEMENT PARTS		PART NUMBERS	
Pawl		2KIPF-00	
Pawl Kit		2KIPF-00K	
Adjusting Sleeve Housing		2KREF-00H	
Replacement Mandrel		2KREF-00M	
STI Taps	Style	3B	2B
	Plug	CTF-00SRP-H1	CTF-00SRP-H2
	Bottoming	CTF-00SRB-H1	CTF-00SRB-H2
STI Gages	Working	CGF-00X-3B	CGF-00X-2B
	Reference	CGF-00W-3B	CGF-00W-2B

1-64 REPLACEMENT PARTS LIST

REPLACEMENT PARTS		PART NUMBERS	
Pawl		2KIPC-01	
Pawl Kit		2KIPC-01K	
Adjusting Sleeve Housing		2KREC-01H	
Replacement Mandrel		2KREC-01M	
STI Taps	Style	3B	2B
	Plug	CTC-01SRP-H1	CTC-01SRP-H2
	Bottoming	CTC-01SRB-H1	CTC-01SRB-H2
STI Gages	Working	CGC-01X-3B	CGC-01X-2B
	Reference	CGC-01W-3B	CGC-01W-2B

M2 REPLACEMENT PARTS LIST

REPLACEMENT PARTS		PART NUMBERS	
Pawl		2KIPM-2	
Pawl Kit		2KIPM-2K	
Adjusting Sleeve Housing		2KREM-2H	
Replacement Mandrel		Free-Running	Locking
		2KREM-F2M	2KREM-L2M
STI Taps	Style	4H	5H
	Plug	CTM-2X.4SRP-4H	CTM-2X.4SRP-5H
	Bottoming	CTM-2X.4SRB-4H	CTM-2X.4SRB-5H
STI Gages	Working	CGM-2X.4-4H	CGM-2X.4-5H
	Reference	N/A	N/A

SAFETY

Always wear eye protection when working with KATO Tools.

FOR ASSISTANCE CONTACT KATO SUPPORT AT:

Phone: (757) 873-8980

Email: support@katofastening.com or, visit us online katofastening.com

DEPTH ADJUSTMENT

1. Manually loosen the Lock Nut and Adjusting Sleeve.
2. Thread the Lock Nut and Adjusting Sleeve towards the back of the Mandrel to fully expose the front threads.
3. Thread the insert to be installed onto the Mandrel until the Pawl engages the drive notch. Tangless inserts are Bi-Directional, so insert orientation is not required.
4. Turn the Adjusting Sleeve until it is approximately 1 thread behind the end of the insert. This will ensure proper installation depth (3/4 - 1 1/2 threads below the surface for a hole with a countersink; 1/4 - 1/2 threads below the surface for a hole without a countersink).
Note: Inserts may vary ± 0.25 coil. KATO recommends that the installation depth of each lot be tested using a sample tapped hole prior to installing inserts into production parts.
5. Manually tighten the Lock Nut against the Adjusting Sleeve. (Be careful not to move the Adjusting Sleeve when tightening)

INSERT INSTALLATION

BULK INSERTS ONLY:

1. Hold the tool perpendicular to the tapped hole and align the insert with the countersink. Tool alignment is key to ensure smooth installation and longer tool life.
2. Rotate the Mandrel Clockwise until the Adjusting Sleeve contacts the parent material. The insert is now installed.
CAUTION: Avoid excessive wobble of the tool as this may damage the Mandrel.
3. Rotate the Mandrel counterclockwise until it completely exits out of the installed insert.
4. Check and adjust installation depth as needed.

DO NOT APPLY ANY DOWNWARD PRESSURE OR TRY TO FORCE THE INSERT INTO THE STI THREAD, LET THE WEIGHT OF THE TOOL DO THE WORK. FORCING THE INSERT INTO THE TAPPED HOLE MAY RESULT IN INSTALLATION FAILURE, AND MAY CAUSE DAMAGE TO THE TOOL AND/OR WORKPIECE.

INSERT REMOVAL

If necessary, KATO Tangless inserts can be easily removed without damaging the workpiece or the insert by using the KATO 2KRT Series Tangless Removal Tool. The KATO removal tool can also be used to reposition inserts that are installed too deep.

TIPS & TRICKS

Having difficulty? Try one or more of these helpful tips:

- Do not apply any downward pressure on the tool during installation. Let the weight of the tool rest over the tapped hole.
- Inspect and clean the tool periodically to ensure the components are properly functioning.
- Dipping the insert in Alcohol or another non-residual solution will provide lubrication and help facilitate installation. **USING ALCOHOL ON LOCKING INSERTS WILL CAUSE THE RED DYE TO BLEED.**

REPLACEMENT PARTS

Replacement Pawls, Pawl Kits (includes 1 Pawl, 2 Pins, and 2 Springs), and replacement Mandrels are available from KATO (see Table on last page).

TO REPLACE A DAMAGED PAWL OR MANDREL

1. Loosen the Lock Nut.
2. Remove the Adjusting Sleeve and Lock Nut from the Mandrel.
3. Push out the Pawl Pin (see Figure 1). Be careful not to lose the Pin.
4. Remove the Pawl from the Mandrel slot.
5. Remove the Spring from the Mandrel. Be careful not to lose the Spring.

TO REASSEMBLE

6. Insert the Spring into the Mandrel (the Spring goes into the hole closest to the Pawl Pin).
7. Insert the Pawl into the Mandrel Slot.
8. Line up the Pin holes (Pawl & Mandrel) and press in the Pin.
9. Check for spring action and free movement of the Pawl in the Mandrel slot.
10. Thread the Lock Nut and Adjusting Sleeve back into the Mandrel.

TOOL MAINTENANCE

Installation tools should be periodically inspected for damage or wear. Tools should be kept clean of any foreign objects and debris (chips, oils, and dirt). This will prevent the tool from unsuccessful installations. Operator misuse can contribute to premature wear and/or damage to the Pawl or Mandrel.

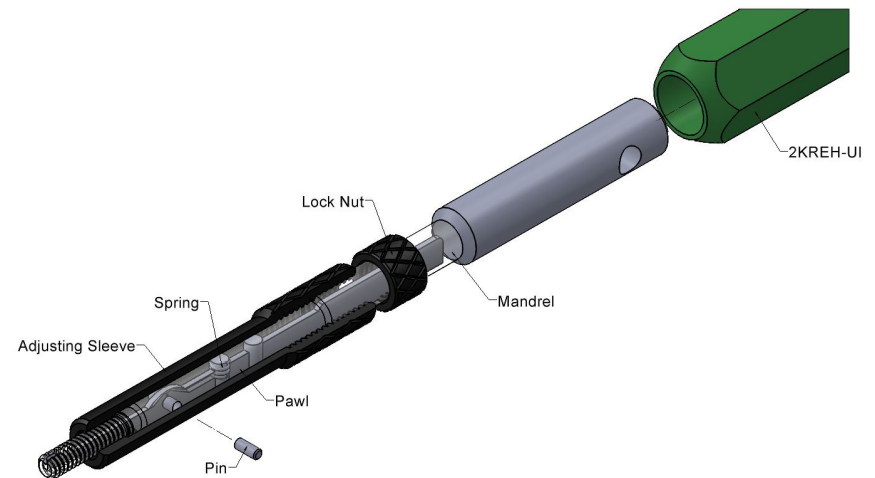


Figure 1