



GLOW PLUG DRILL OUT SET M12X1,25

MANUAL
6041760

SAFETY NOTICE

To understand the functioning of the tools, is it necessary to read the manual first!

- > Read these instructions before assembling, during installation and throughout use and in the proper sequence
- > Always refer to the OEM manufacturer's instructions and service manuals for the latest data and to maintain the correct sequence
- > These work instructions and the recommended tools are meant to serve as aides only and are by no means a guarantee for certain results.
- > This tool kit is a special collection and it has been tested and used successfully on several occasions. It is of the utmost importance to maintain the correct procedure as per the instructions
- > The use of the tools should only be carried out by qualified personnel!



ATTENTION
Special caution



CORRECT



LIGHT BULB
Hint or recommendation

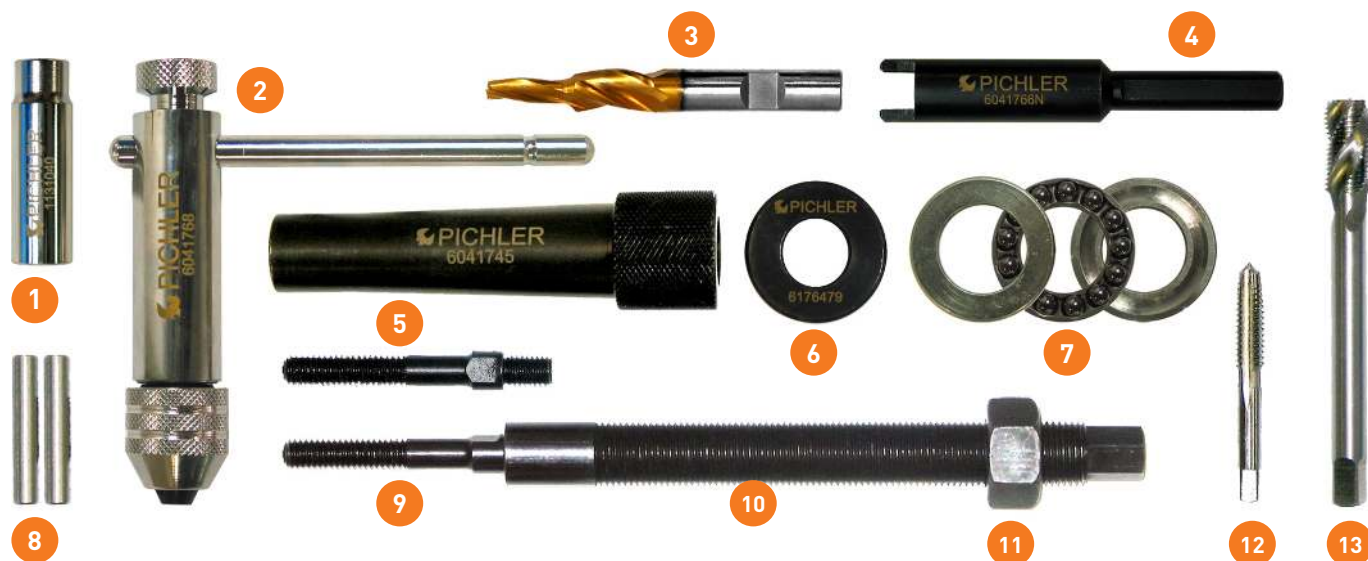


WRONG



SAFETY GOGGLES
Wearing safety goggles
necessary





Nr.	PART.-NR.	Description	6041760
1	1131040	Stud puller custom-made 4.0 mm	1
2	6041768	Tool Holder with Ratchet „KEEPER“ short for M3 - M8	1
3	6041765	Shouldered Drill Ø 10,75 / 6,0 / 5,0 mm	1
4	6041766N	Tool Holder for the Shouldered Drill	1
5	6041745	Drill and Extraction Sleeve	1
6	6176479	Bearing Adapter i.d.16,0 mm	1
7	6176478	Axial Ball Bearing	1
8	60417710	Drill Sleeve	2
9	6041762	Extraction Insert UNC 5/16"	2
10	6041748	Extraction Spindle M16x1.5	1
11	60417476	Nut M16x1.5 DIN 934	1
12	6041763	Tap HSSG UNC 5/16" DIN 351	1
13	6041764	Tap HSSG-E M12x1,25 RSPI 35 bottom tap	1

These tools should only be used by skilled technicians

1. Place the Stud Puller 4.0 mm **1131040** on the central electrode. With a 1/4" ratchet break off the central electrode by turning it several times clockwise.



2. Remove the central electrode together with the Stud Puller, if needed use a magnet and remove the torn off hexagon.



With engines, where the glow plug is in a bore, is absolutely necessary, that the Drill and Extraction Sleeve **6041745** is used!



3. Place the Drill and Extraction Sleeve **6041745** in the bore and spot drill the glow plug with the Tool Holder **6041766N** and the Stepped Drill **6041765**. (Clamp the drill on the flat spot in the tool holder and as deep as possible!). Before removing the drill clean with compressed air or a vacuum cleaner the dirt and the splinters from the opening and check to assure that has been drilled correctly to the stop of the tool holder.

Tip: Good results can be obtained, by putting a funnel on the nozzle of the vacuum cleaner.



4. Remove the Drill Sleeve and remove dirt and filings by compressed air, a vacuum cleaner and/or a magnet, drill without using the Drill Sleeve till the stop of the Tool Holder!



5. Clamp the HSS Tap UNC 5/16" **6041763** into the Tool Holder with Ratchet „KEEPER" **6041768** and cut a thread. (It can happen that the glow plug already comes out after this procedure, then continue with point 7).



Remove the Drill Sleeve and remove dirt and filings by compressed air, a vacuum cleaner and/or a magnet.

6. Replace the Drill and Extraction Sleeve **6041745** in the bore, screw the Extraction Insert UNC 5/16" **6041762** with Extraction Spindle **6041748** in the cut thread, position the Bearing Adapter **6176479** with Axial Ball Bearing **6176478** and screw on Nut **60417476**.



ATTENTION

During extraction it is most important to prevent the spindle from turning, be sure to use a wrench on the hex to prevent rotation and extract the glow plug.

7. Wet the threads of Tap HSSG-E M12x1,25 **6041764** and with the Tool Holder with Ratchet "KEEPER" **6041738** clean the thread in the cylinder head and install new glow plug with the proper torque.



Should the original thread M 12x1,25 in the cylinder head be damaged or the proper torque can not be reached, the thread can be renewed with the kit **6041905**.

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