

SPARK PLUG RETHREADING TOOL FOR FORD INSTRUCTIONS: **CAREFULLY READ & FOLLOW ALL INSTRUCTIONS.**



1. To begin, remove any obstructions. Turn crank so piston below damaged spark plug hole is down on the power stroke.
IMPORTANT: Intake valve must be closed.



2. Use the drill assembly with a 1/2" ratchet & extension to drill clear through remaining threads and to enlarge the hole to accept the sleeve. Then remove drill.



3. Place stop tube against the wall of the head so it lines up with the plug hole.



4. Insert tap assembly into stop tube and turn with 1/2" ratchet & extension until it bottoms out against the top of the stop tube. Then remove.



5. Use vacuum extension with a vacuum to remove aluminum shavings that have dropped into cylinder. Be sure to remove all shavings.



6. Use an inspection scope to make sure all shavings are removed from cylinder. Vacuum again if necessary. Start motor to blow out what you don't suck out.



7. Thread the sleeve onto the inserting assembly. Serrations go on first and will hold the sleeve in place at the top of the tapped plug hole.



8. Spray the insert with the thread sealant primer.



9. Apply a bead of thread sealant toward the bottom of the insert.

SPARK PLUG RETHREADING TOOL FOR FORD INSTRUCTIONS, CONTINUED: CAREFULLY READ & FOLLOW ALL INSTRUCTIONS.



10. Put stop tube in place again.



11. Screw the insert into hole by hand until head comes to within .060" of top of stop or until against stop.



12. Apply grease or oil to the angle on the swedger assembly.



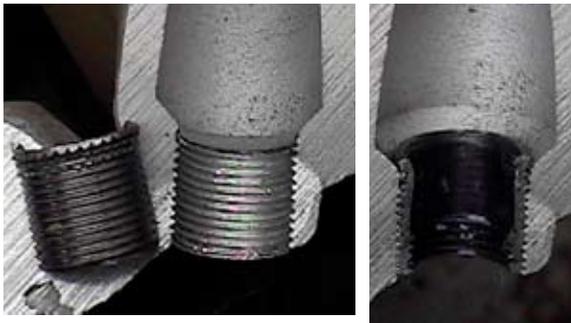
13. Place swedger in hole and strike with hammer until the white line meets the top of the stop tube. Do not over swedge.



14. To remove swedger tap gently on the side of the swedger or use a flat blade screwdriver in top groove to pry the swedger from hole. You may also use pliers to twist the swedger out in hard-to-reach areas. Remove stop tube.



15. Now the plug can be inserted. It will line up exactly with the other plugs. In this photo the middle plug has been fixed with a sleeve.



Cutaway view of head that has been fixed. The steel sleeve will be much stronger than the aluminum threads.

Important:
An inspection scope must be used to insure all shavings are removed from the combustion chamber. An inspection scope is not included in the 65900 set. Order the 66090 Inspection Scope and 66100 45° Mirror Attachment if needed.



Patent 6,474,285
Made in USA
Printed in USA
165900.94

PARTS LIST:
66000 TAP HOLDER ASSEMBLY WITH TAP
65980 TAP
66010 SWEDGER ASSEMBLY
66020 THD. INSERT INSTALL ASS'Y
66030 DRILL HOLDER ASSEMBLY WITH DRILL
65970 DRILL BIT
66040 STOP TUBE
66050 VACUUM TUBE ASSEMBLY
66060 THREAD SEALANT
66070 THREAD SEALANT PRIMER
66090 INSPECTION SCOPE (Optional)
66100 45 DEG MIRROR ATTACHMENT (Optional)
66110 BLOW MOLDED CASE
66120 FOAM INSERT FOR CASE
66130 BAG OF 10 STEEL SLEEVES