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Thread Inserts / Repair

See also in the Sportsterpedia:

- [Cutting Oils, Soaking Oils and Lubes](#)
- [General Drilling and Tapping](#)

Helicoil



Helicoil Kit ¹⁾

Time-Sert

Time-Sert Kit ²⁾

Roll Form Thread Repair

Roll Form Taps- used to pressure form threads in softer material like aluminum.

Roll form taps are used to “restore” damaged threads.

They work well because they will actually push the metal back to shape as opposed to cutting it away.

Word of caution: they use a lot of force and are way easier to break so don't get to western with them.

Use plenty of oil and steady pressure.

Turn in 2 or 3 turns, back off 1 or 2 turns to allow the pressure to come off and if you are using a cut tap the cut material needs to come out.

Roll form tap and dies look like the standard versions but they dont have the sharp cutting edge.

They are great for cleaning debris out of threads, and also straighten out slightly mangled threads by pushing them straight again without removing any material.

Some kits come with thread files that come in handy to clean up the threads.

If roll form taps don't work, you can try the standard tap and dies.

As with any version, be careful when chasing existing threads.

The tool can be inserted wrong and started to crossthread them.

Craftsman (52105) Thread Repair Kit ³⁾



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1)

photo by Freewheeler of the XLFORUM

<https://www.xlforum.net/forum/sportster-motorcycle-forum/sportster-motorcycle-era-specific-and-model-specific/ironhead-sportster-motorcycle-talk-1957-1985/172781-helicoiling-the-primary-drain-plug?t=1852458&highlight=stripped+plug>

2)

photo by rubine of the XLFORUM

<https://www.xlforum.net/forum/sportster-motorcycle-forum/sportster-motorcycle-general-discussion-and-problems/187159-time-sert-cylinder-stud-repair/page5?t=1999530&page=5>

3)

photo by Shadowdog500 of the XLFORUM

<https://www.xlforum.net/forum/sportster-motorcycle-forum/sportster-motorcycle-era-specific-and-model-specific/ironhead-sportster-motorcycle-talk-1957-1985/51523-question-about-my-rocker-oil-lines?t=221093&highlight=split+rocker+box>

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Last update: **2024/01/24 18:15**

