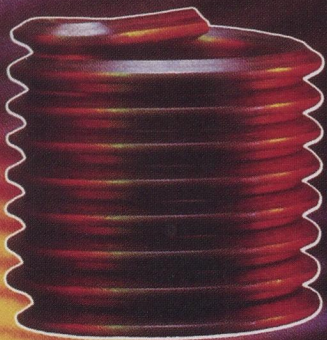




THREAD KITS CO.



PERMA-COIL[®]

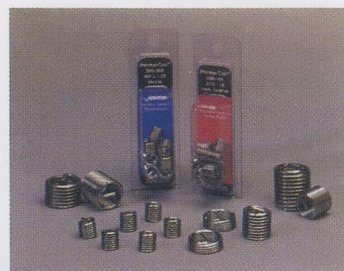
**HELICALLY COILED INSERTS
AND THREAD REPAIR KITS**

PERMA-COIL® Thread Repair Kits, Insert Packs

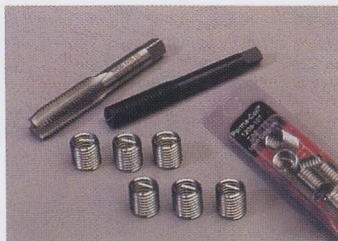
Perma-Coil® helically coiled inserts are made of stainless steel wire that has been rolled to a carefully controlled thread form. When installed, Perma-Coil® inserts adjust to a tapped hole, becoming a functional thread with a strength exceeding the original.

Perma-Coil® inserts and repair kits are designed to repair stripped threads in a variety of metals. Aluminum, aluminum alloys, steel, and cast iron. If the original threads can be stripped, Perma-Coil® inserts can repair them. By following the detailed instructions enclosed in every Perma-Coil® kit, even an inexperienced do-it-yourselfer can repair stripped threads, permanently.

INSERT PACKS
Thread Repair
Inserts Only



COARSE & METRIC
THREAD REPAIR KITS
Thread Repair Inserts
Tap
Installation Tool



FINE THREAD
REPAIR KITS
Thread Repair Inserts
Tap
Insert Prewinder
Installation Tool



MECHANIC'S MASTER THREAD REPAIR KITS

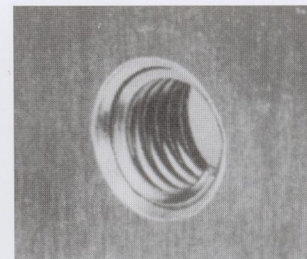
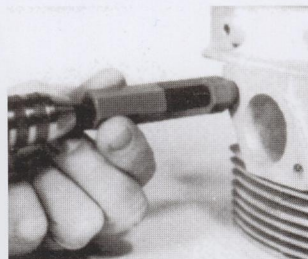
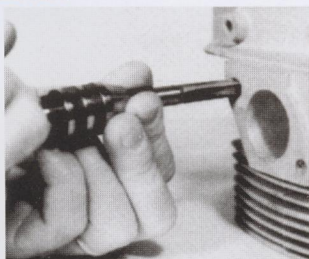
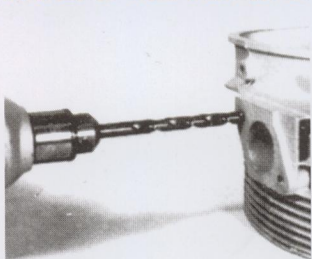
These kits, designed for the professional mechanic, Perma-Coil® contain the most popular sizes used in automotive and light truck applications. Each kit contains 30 Perma-Coil® helically coiled inserts, 5 taps, and 5 installation tools. (Fine thread kits contain 5 pre-winding tools. Metric thread kits contain 3 prewinding tools.)

FINE COARSE METRIC



1208 FMK Mechanic's Master Fine Thread Repair Kit	1208 CMK Mechanic's Master Coarse Thread Repair Kit	1221 MMK Mechanic's Master Metric Thread Repair Kit (Fits most popular European and Japanese metric thread sizes)
Thread Size 1/4 - 28 5/16 - 24 3/8 - 24 7/16 - 20 1/2 - 20	Thread Size 1/4 - 20 5/16 - 18 3/8 - 16 7/16 - 14 1/2 - 13	Thread Size 5 x 0.8mm 6 x 1.0mm 8 x 1.25mm 10 x 1.25mm 10 x 1.5mm

THREAD REPAIR MADE EASY



1. Drill out damaged threads. 2. Tap new threads.

3. Install new Perma-Coil® insert. (Prewinding tool shown is used for fine thread applications only.)

4. Remove tang from insert. You now have a permanently repaired thread.

PERMA-PLUG® SPARK PLUG REPAIR KIT

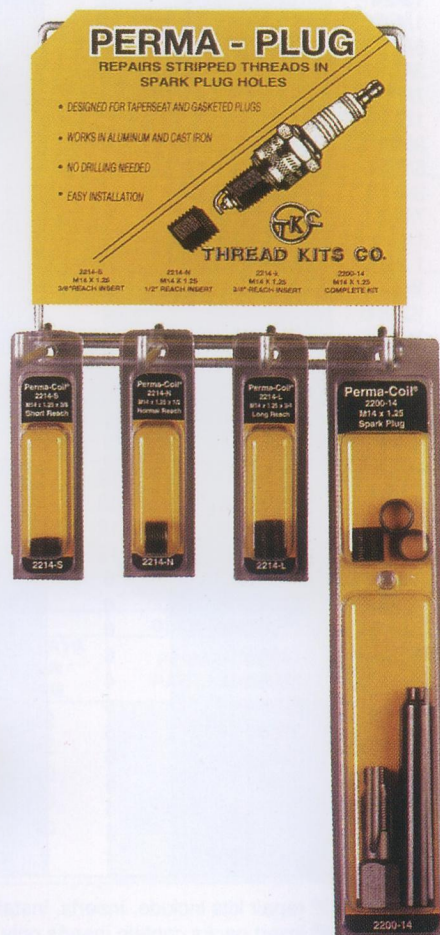
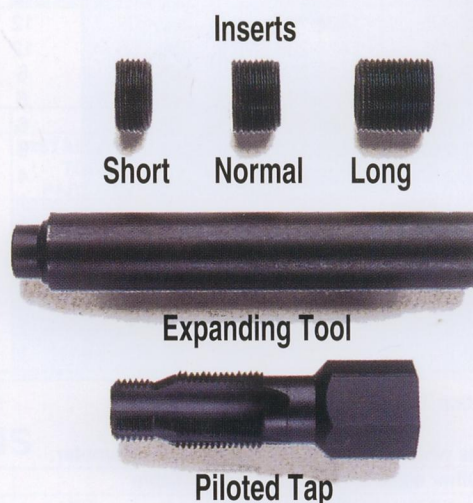
***Can Be Used With Taper
Seat Or Gasket Type
Spark Plugs.***

▲ ***Works in Aluminum and Cast Iron***

▲ ***No Drilling Needed***

▲ ***Easy Installation***

▲ ***Permanent Repair***



COMPLETE DISPLAY CENTER: Part No. 1400-1

Display Contents:

Description	Part No.	Qty
M14 - 1.25 Perma Plug Kit	2200 - 14	3
M14 - 1.25 x 3/8" Short Reach Insert	2214 - S	4
M14 - 1.25 x 1/2" Normal Reach Insert	2214 - N	4
M14 - 1.25 x 3/4" Long Reach Insert	2214 - L	4

COMPLETE KIT				KIT CONTENTS AND REPLACEMENT PARTS				
Size	Kit P/N	Reach	Insert Per Kit	Tap P/N	Tool P/N	Reach	Insert Pkg P/N	Insert Qty.
M14 - 1.25	2200 - 14	Short	1	2258 - 14	2294 - 14	Short	2214 - S	1
		Normal	1			Normal	2214 - N	1
		Long	1			Long	2214 - L	1

INDIVIDUAL THREAD REPAIR KITS

INCH SERIES - COARSE

THREAD SIZE	REPAIR KITS*		REPLACEMENT PARTS				BULK INSERTS	
	REPAIR KIT* PART NO.	INSERTS PER PACK	KIT TOOL	KIT TAP	PACKAGED** INSERTS	QTY. INSERTS	PERMA-COIL® PART NUMBER	DRILL SIZE
4-40	1208-014	12	1172-014	1428-014	208-014	12	208 C04-0168	1/8
5-40	1208-015	12	1172-015	1428-015	208-015	12	208 C05-0188	9/64
6-32	1208-016	12	1182-016	1428-016	208-016	12	208 C06-0207	5/32
8-32	1208-018	12	1182-018	1428-018	208-018	12	208 C08-0246	11/64
10-24	1208-101	12	1182-101	1428-101	208-101	12	208 C1-0285	13/64
12-24	1208-102	12	1182-102	1428-102	208-102	12	208 C2-0324	15/64
1/4-20	1208-104	12	1182-104	1428-104	208-104	12	208 C4-0375	17/64
5/16-18	1208-105	12	1182-105	1428-105	208-105	12	208 C5-0469	21/64
3/8-16	1208-106	12	1182-106	1428-106	208-106	12	208 C6-0562	25/64
7/16-14	1208-107	6	1182-107	1428-107	208-107	6	208 C7-0656	29/64
1/2-13	1208-108	6	1182-108	1428-108	208-108	6	208 C8-0750	17/32
9/16-12	1208-109	6	1182-109	1428-109	208-109	6	208 C9-0844	19/32
5/8-11	1208-110	6	1182-110	1428-110	208-110	6	208 C10-0938	21/32
3/4-10	1208-112	4	1182-112	1428-112	208-112	4	208 C12-1125	25/32
7/8-9	3208-C14	6	1182-114	1043-14CP3	108-114	1	208-C14-1312	29/32
1-8	3208-C16	6	1182-116	1043-16CP3	108-116	1	208-C16-1500	1 1/32
1 1/8-7	3208-C18	5	1182-118	1043-18CP3	108-118	1	208 C18-1688	1 11/64
1 1/4-7	3208-C20	4	1182-120	1043-20CP3	108-120	1	208-C20-1875	1 19/64
1 3/8-6	3208-C22	4	1182-122	1043-22CP3	108-122	1	208 C22-2062	1 27/64
1 1/2-6	3208-C24	4	1182-124	1043-24CP3	108-124	1	208 C24-2250	1 35/64

INCH SERIES - FINE

10-32	1208-201	12	1172-201	1428-201	208-201	12	208 F1-0285	13/64
1/4-28	1208-204	12	1172-204	1428-204	208-204	12	208 F4-0375	17/64
5/16-24	1208-205	12	1172-205	1428-205	208-205	12	208 F5-0469	21/64
3/8-24	1208-206	12	1172-206	1428-206	208-206	12	208 F6-0562	25/64
7/16-20	1208-207	6	1172-207	1428-207	208-207	6	208 F7-0656	29/64
1/2-20	1208-208	6	1172-208	1428-208	208-208	6	208 F8-0750	33/64
9/16-18	1208-209	6	1172-209	1428-209	208-209	6	208 F9-0844	37/64
5/8-18	1208-210	6	1172-210	1428-210	208-210	6	208 F10-0938	41/64
3/4-16	1208-212	4	1172-212	1428-212	208-212	4	208 F12-1125	49/64
7/8-14	3208-F14	6	1039-14F	1043-14FP3	108-214	1	208 F14-1312	57/64
1-14	3208-F164	6	1039-164F	1043-164FP3	108-2164	1	208 F164-1500	1 1/64
1-12	3208-F16	6	1039-16F	1043-16FP3	108-216	1	208 F16-1500	1 1/64
1 1/8-12	3208-F18	5	1039-18F	1043-18FP3	108-218	1	208 F18-1688	1 5/32
1 1/4-12	3208-F20	4	1039-20F	1043-20FP3	108-220	1	208 F20-1875	1 9/32
1 3/8-12	3208-F22	4	1039-22F	1043-22FP3	108-222	1	208 F22-2062	1 13/32
1 1/2-12	3208-F24	4	1039-24F	1043-24FP3	108-224	1	208 F24-2250	1 17/32

* Perma-Coil® repair kits include: Inserts, Installation Tool, and Tap

** Perma Coil® insert packs contain inserts only

The above packs and insert bags contain inserts whose length is 1-1/2 times their diameter.
(For example, the 1/4-20 inserts is 3/8" long.) Other sizes and lengths are available

SPARK PLUG SERIES - WIRE TYPE INSERTS

The Perma-Coil® spark plug series includes a full range of individually packaged kits and inserts. They have application in all types of engines and are available in 10, 12, 14, and 18mm sizes. Each kit includes the appropriate reamer/tap and installation tool for all sizes except the 18mm. For the 18mm, you choose the reach and quantity of Perma-Coil® stainless steel inserts required.

Do not use Perma-Coil® wire spark plug inserts to repair taper seat spark plug ports.

THREAD SIZE	REACH	KIT PART NO.	INSERT PER KIT	INSERT PACK PART NO.	INSERTS PER PACK	TAP PART NO.	TOOL PART NO.	BULK INSERT PART NO.
10-1.0mm	1/2"	1210-410*	—	410-500	6	1458-100	1094-100	SP1010-01-0500
12-1.25mm	1/2"	1212-412*	—	412-500	6	1458-123	1094-123	SP1213-01-0500
	3/4"	—	—	412-750	6	—	—	SP1213-01-0750
14-1.25mm	3/8"	1214-414*	—	414-375	6	1458-143	1094-143	SP1413-01-0375
	7/16"	—	—	414-438	6	—	—	SP1413-01-0438
	1/2"	—	—	414-500	6	—	—	SP1413-01-0500
	3/4"	—	—	414-750	6	—	—	SP1413-01-0750
18-1.50mm	1/2"	1218-500	6	418-500	6	1458-185	1094-185	SP1815-01-0500

* NOTE: 10mm, 12mm, and 14mm spark plug kits contain tap and installation tool ONLY - NO inserts in kit.
Purchase packages of inserts separately. Same tools are applicable regardless of insert reach.

METRIC SERIES - COARSE

THREAD SIZE	REPAIR KITS*		REPLACEMENT PARTS				BULK INSERTS	DRILL SIZE
	REPAIR KIT* PART NO.	INSERTS PER PACK	KIT TOOL	KIT TAP	PACKAGED** INSERTS	QTY. INSERTS	PERMA-COIL® PART NUMBER	
M3 X 0.5	1221-303	12	1287-303	1448-303	206-303	12	206 M3C-0045	1/8
M4 X 0.7	1221-304	12	1287-304	1448-304	206-304	12	206 M4C-0060	11/64
M5 X 0.8	1221-305	12	1287-305	1448-305	206-305	12	206 M5C-0075	13/64
M6 X 1	1221-306	12	1287-306	1448-306	206-306	12	206 M6C-0090	1/4
M7 X 1	1221-307	12	1289-307	1448-307	206-307	12	206 M7C-0105	9/32
M8 X 1.25	1221-308	12	1289-308	1448-308	206-308	12	206 M8C-0120	21/64
M9 X 1.25	1221-309	12	1289-309	1448-309	206-309	12	206 M9C-0135	3/8
M10 X 1.5	1221-310	12	1289-310	1448-310	206-310	12	206-M10C-0150	13/32
M11 X 1.5	1221-311	6	1289-311	1448-311	106-311	6	206 M11C-0165	29/64
M12 X 1.75	3221-M12C	6	1289-312	5043-120CP4	106-312	6	206 M12C-0180	31/64
M14 X 2	3221-M14C	6	1289-314	5043-140CP4	106-314	6	206 M14C-0210	37/64
M16 X 2	3221-M16C	6	1289-316	5043-160CP4	106-316	6	206 M16C-0240	21/32
M18 X 2.5	3221-M18C	6	1289-318	5043-180CP4	106-318	6	206 M18C-0270	47/64
M20 X 2.5	3221-M20C	6	1289-320	5043-200CP4	106-320	6	206 M20C-0300	13/16

METRIC SERIES - FINE

M8 X 1.0	1221-M8F	6	1287-608	1448-608	106-608	6	206 M8F-0120	21/64
M10 X 1.0	1221-M1010	6	1287-61010	1448-61010	106-61010	6	206 M1010-0150	13/32
M10 X 1.25	3221-M10F	12	1287-610	1448-610	106-610	12	206 M10F-0150	13/32
M11 X 1.0	1221-M11F	6	1287-611	1448-611	106-611	6	206 M11F-0165	7/16
M11 X 1.25	1221-M1125	6	1287-61125	1448-61125	106-61125	6	206 M1125-0165	29/64
M12 X 1.25	3221-M12F	6	1287-612	5043-120FP4	106-612	6	206 M12F-0180	31/64
M12 X 1.5	3221-M1215	6	1287-61215	5043-1215FP4	106-61215	6	206 M1215-0180	31/64
M14 X 1.5	3221-M14F	6	1287-614	5043-140FP4	106-614	6	206 M14F-0210	9/16
M16 X 1.5	3221-M16F	6	1287-616	5043-160FP4	106-616	6	206 M16F-0240	21/32

PIPE THREAD SERIES

THREAD SIZE	REPAIR PACKS		REPLACEMENT PARTS				BULK INSERTS	DRILL SIZE
	PIPE THREAD INSERT KIT NO.	INSERTS PER PACK	INSTALLATION TOOL PART NO.	TAP PART NO.	INSERT BAG NO.	INSERTS PER BAG	PERMA-COIL® PART NUMBER	
1/8-27	3218-2	12	1189-2	1188-2P	318-2	12	218-2	3/8
1/4-18	3218-4	12	1189-4	1188-4P	318-4	12	218-4	33/64
3/8-18	3218-6	10	1189-6	1188-6P	318-6	10	218-6	21/32
1/2-14	3218-8	10	1189-8	1188-8P	318-8	10	218-8	13/16
3/4-14	3218-12	10	1189-12	1188-12P	318-12	10	218-12	1 1/64
1-11 1/2	3218-16	6	1189-16	1188-16P	318-16	6	218-16	1 9/32

SPECIAL APPLICATIONS

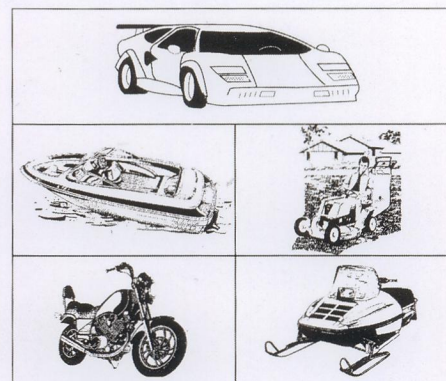
THREAD SIZE	REPAIR KITS*		REPLACEMENT PARTS				BULK INSERTS	DRILL SIZE
	REPAIR KIT* PART NO.	INSERTS PER PACK	KIT TOOL	KIT TAP	PACKAGED** INSERTS	QTY. INSERTS	PERMA-COIL® PART NUMBER	
7/8-20	3208-1420	10	1037-1420	1043-1420P2	208-1420	1	208 1420-0330	57/64
1-20	3208-1620	10	1037-1620	1043-1620P2	208-1620	1	208 1620-0325	1 1/64
1 1/16-16	3424-1250	9	1424-1	1043-1116	324-1116-1250	3	208 1116-1250	45/64
1 1/4-24	1208-404	12	1182-404	1428-404	208-404	12	208 424-0500	17/64
3/8-20	1208-406	6	1172-406	1428-406	208-406	6	208 620-0375	25/64

SPECIFICATIONS

Perma-Coil® inserts and tools meet all applicable industrial and military specifications. They may be used on all military and government trucks, aircraft and other vehicles covered by MS 21208 and MS 21209; also NAS 1222 specifications for helically coiled wire inserts.

WHERE?

Use Perma-Coil® Replacement Kits to repair threads on your car, boat, lawn equipment, motorcycle, snowmobile and other recreational vehicles, appliances, plumbing and heating equipment and anywhere metal threads become stripped, crossed or otherwise damaged.





1208-5

COMPLETE DISPLAY CENTER NO. 1208-5 INCH COARSE AND SPARK PLUGS

INCLUDES ONE EACH:

1208-104	1/4-20	REPAIR KIT
1208-105	5/16-18	REPAIR KIT
1208-106	3/8-16	REPAIR KIT
1208-107	7/16-14	REPAIR KIT
1208-108	1/2-13	REPAIR KIT
2200-14*	M14x 1.25	REPAIR KIT

INSERT PACKS

208-104	1/4-20	INSERT PACK
208-105	5/16-18	INSERT PACK
208-106	3/8-16	INSERT PACK
208-107	7/16-14	INSERT PACK
208-108	1/2-13	INSERT PACK
2214-S*	14mm x 3/8	INSERT PACK
2214-N*	14mm x 1/2	INSERT PACK
2214-L*	14mm x 3/4	INSERT PACK

*SOLID TYPE PERMA-PLUG INSERTS



1221-3

DISPLAY CENTER NO. 1221-3 METRIC THREADS

INCLUDES ONE EACH:

1221-305	M5 x .8	REPAIR KIT
1221-306	M6 x 1.0	REPAIR KIT
1221-308	M8 x 1.25	REPAIR KIT
1221-310	M10 x 1.5	REPAIR KIT
3221-M10F	M10 x 1.25	REPAIR KIT
3221-M12C	M12 x 1.75	REPAIR KIT
3221-M12F	M12 x 1.25	REPAIR KIT

INSERT PACKS

206-305	M5 x .8	INSERT PACK
206-306	M6 x 1.0	INSERT PACK
206-308	M8 x 1.25	INSERT PACK
206-310	M10 x 1.5	INSERT PACK
106-610	M10 x 1.25	INSERT PACK
106-312	M12 x 1.75	INSERT PACK
106-612	M12 x 1.25	INSERT PACK



1208-1

**COMPLETE DISPLAY CENTER: 1208-1
1/2 INCH COARSE THREADS**

INCLUDES ONE EACH:

1208-014	4-40	REPAIR KIT
1208-015	5-40	REPAIR KIT
1208-016	6-32	REPAIR KIT
1208-018	8-32	REPAIR KIT
1208-101	10-24	REPAIR KIT
1208-102	12-24	REPAIR KIT
1208-104	1/4-20	REPAIR KIT
1208-105	5/16-18	REPAIR KIT
1208-106	3/8-16	REPAIR KIT
1208-107	7/16-14	REPAIR KIT
1208-108	1/2-13	REPAIR KIT
1208-109	9/16-12	REPAIR KIT
1208-110	5/8-11	REPAIR KIT
1208-112	3/4-10	REPAIR KIT

INSERT PACKS

208-014	4-40	INSERT PACK
208-015	5-40	INSERT PACK
208-016	6-32	INSERT PACK
208-018	8-32	INSERT PACK
208-101	10-24	INSERT PACK
208-102	12-24	INSERT PACK
208-104	1/4-20	INSERT PACK
208-105	5/16-18	INSERT PACK
208-106	3/8-16	INSERT PACK
208-107	7/16-14	INSERT PACK
208-108	1/2-13	INSERT PACK
208-109	9/16-12	INSERT PACK
208-110	5/8-11	INSERT PACK
208-112	3/4-10	INSERT PACK



1208-2

**DISPLAY CENTER NO. 1208-2
1/4 INCH FINE THREADS**

INCLUDES ONE EACH:

1208-201	10-32	REPAIR KIT
1208-204	1/4-28	REPAIR KIT
1208-205	5/16-24	REPAIR KIT
1208-206	3/8-24	REPAIR KIT
1208-207	7/16-20	REPAIR KIT
1208-208	1/2-20	REPAIR KIT
1208-210	5/8-18	REPAIR KIT

INSERT PACKS

208-201	10-32	INSERT PACK
208-204	1/4-28	INSERT PACK
208-205	5/16-24	INSERT PACK
208-206	3/8-24	INSERT PACK
208-207	7/16-20	INSERT PACK
208-208	1/2-20	INSERT PACK
208-210	5/8-18	INSERT PACK

KITS

Size	Helicoil® #	Perma-Coil® #
INCH SERIES - COARSE		
12-24	5521-1	1208-102
8-32	5521-2	1208-018
10-24	5521-3	1208-101
1/4-20	5521-4	1208-104
5/16-18	5521-5	1208-105
3/8-16	5521-6	1208-106
7/16-14	5521-7	1208-107
1/2-13	5521-8	1208-108
9/16-12	5521-9	1208-109
5/8-11	5521-10	1208-110
3/4-10	5521-12	1208-112
INCH SERIES - FINE		
10-32	5528-3	1208-201
1/4-28	5528-4	1208-204
5/16-24	5528-5	1208-205
3/8-24	5528-6	1208-206
7/16-20	5528-7	1208-207
1/2-20	5528-8	1208-208
5/8-18	5528-10	1208-210
METRIC SERIES - COARSE		
M5 x 0.8	5546-5	1221-305
M6 x 1.0	5546-6	1221-306
M8 x 1.25	5546-8	1221-308
M10 x 1.5	5546-10	1221-310
M12 x 1.75	5546-12	3221-M12C
METRIC SERIES - FINE		
M10 x 1.25	5543-10	3221-M10F
M12 x 1.25	5543-12	3221-M12F
SPARK PLUG SERIES (Wire Type)		
M14 x 1.25	5523-14	1214-414
M18 x 1.25	5523-18	1218-500
SPARK PLUG SERIES (Solid Type)		
M14 x 1.25	5334-14	2200-14

INSERT PACKAGES

Helicoil® #	Perma-Coil® #
INCH SERIES - COARSE	
R1185-1	208-102
R1185-2	208-018
R1185-3	208-101
R1185-4	208-104
R1185-5	208-105
R1185-6	208-106
R1185-7	208-107
R1185-8	208-108
R1185-9	208-109
R1185-10	208-110
R1185-12	208-112
INCH SERIES - FINE	
R1191-3	208-201
R1191-4	208-204
R1191-5	208-205
R1191-6	208-206
R1191-7	208-207
R1191-8	208-208
R1191-10	208-210
METRIC SERIES - COARSE	
R1084-5	206-305
R1084-6	206-306
R1084-8	206-308
R1084-10	206-310
R1084-12	106-312
METRIC SERIES - FINE	
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