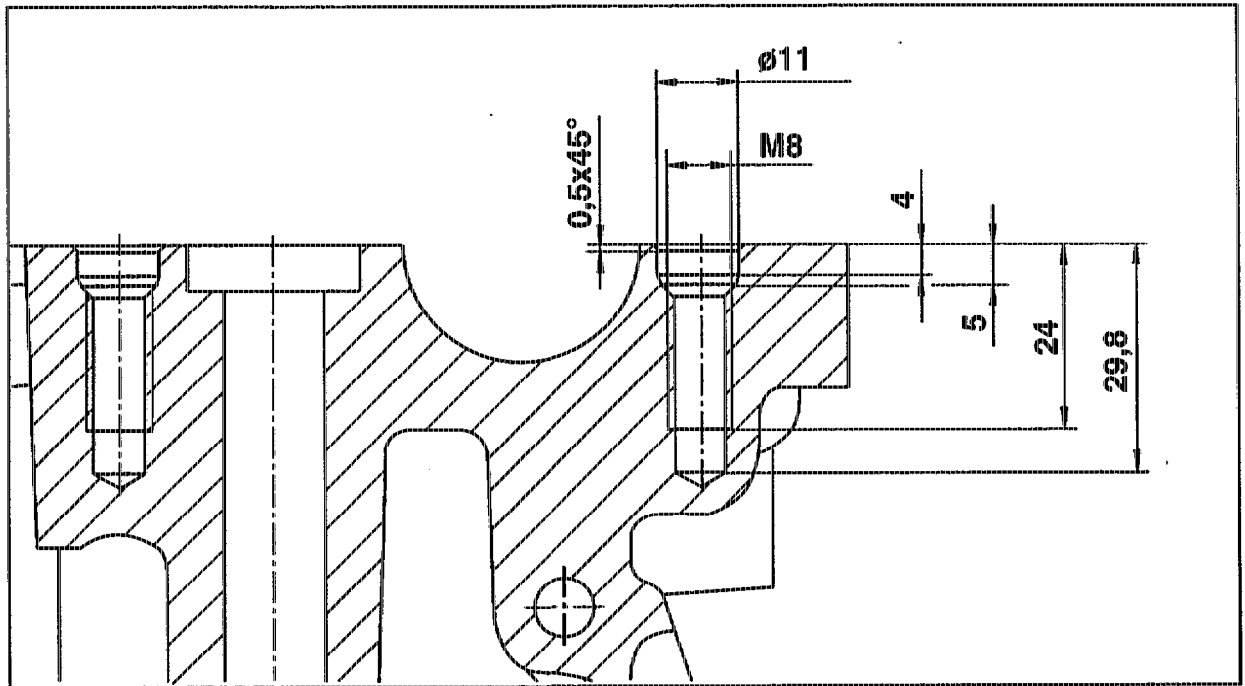


01-4192 Servicing threads for camshaft bearing cap bolts

Preceding work:
Camshaft removed (05-2200).

Operation no. of operation texts and work units or standard texts
and flat rates



P01.30-0274-55

Dowel sleeves	remove, install.
Bore	widen, pay attention to core plug depth.
HELI-COIL thread	tap.
HELI-COIL threaded insert	screw in.

Data in mm

Twist drill Ø	8.4
Core plug depth from contact surface	28
Threaded insert below contact surface	6
Length of thread screwed in	20

Commercially available tools

HELI-COIL hand thread tap M8 pre-tap	e.g.	Böllhoff GmbH Postfach 14 02 29 D-33622 Bielefeld Order no. 0140.108 0104
HELI-COIL hand thread tap M8 final tap	e.g.	Böllhoff GmbH Postfach 14 02 29 D-33622 Bielefeld Order no. 0140.208 0102
HELI-COIL hand installation tool	e.g.	Böllhoff GmbH Postfach 14 02 29 D-33622 Bielefeld Order no. 0150.040 800
HELI-COIL threaded insert M8 x 20	e.g.	Böllhoff GmbH Postfach 14 02 29 D-33622 Bielefeld Order no. 0130.008 0020