

AW7012– Drill Fixture

Repair Instructions for:

Chasing Threads in Top Flange

Made by JAQUITH INDUSTRIES- Syracuse New York 13210

Ph– 315-478-5700 / Email– sales@jaquith.com / Website- www.jaquith.com

STEP 1



Determine if base is L867B or L868B
cut energy to fixture if applicable

Unbolt and remove light fixture
or cover from light base to be repaired.

Be sure that you have adequate amount
of tapping fluid prior to starting
process.



Position drill bushing over broken bolt
and attach to light base using
provided flat head bolts

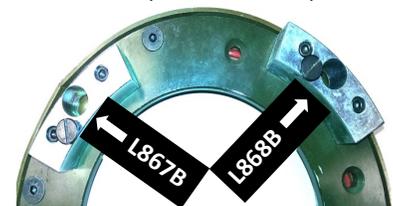
Note: (If applicable)

Longer Bolts have been provided to
accommodate spacer ring thicknesses.

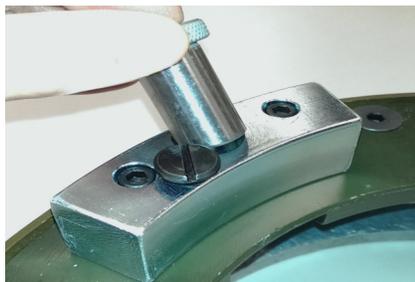
Bushing Locations:

Most outer positioned bushing block is
for L868B (11.25" bolt circle)

inner positioned bushing block is for
L867B(10.25" bolt circle)



STEP 2



Insert 5/32" bushing into bushing block



Use liberal amount of tapping fluid

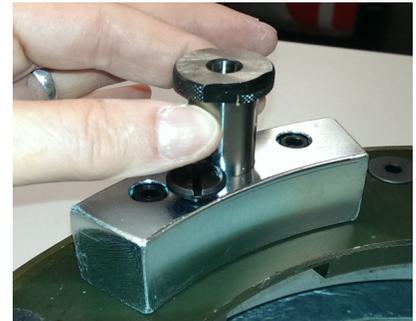


Use 5/32" drill to core our center of bolt
(slow to medium drill speed preferred)



Remove 5/32" bushing, using reverse
drill speed, attempt to remove bolt with
Extractor. If unable to remove bolt,
go to step #3

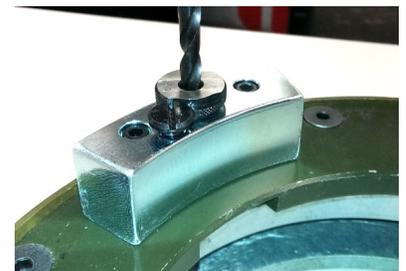
STEP 3



Insert 5/16" bushing into bushing block



Use liberal amount of tapping fluid



Use 5/16" drill and drill out remainder
of broken bolt, being sure to drill
all the way through top flange to be sure
bolt is completely removed.
(slow to medium drill speed preferred)



Reapply liberal amount of tapping fluid
using slow drill speed or manual ratchet,
use 3/8"-16 tap and slowly chase
threads in base top flange.

Remove drill fixture and wipe off
top flange to remove all
material and remaining tapping fluid.

Note: If you are unable to repair threads
Use Stainless Steel Inserts as
Shown starting on step #4

Threaded Insert Capabilities Required

Due to many variables, No guaranteed result is implied as a result of using the AW7012 Drill Fixture Thread Repair Kit.

AW7012G– Drill Fixture

Repair Instructions for

Installing S.S Threaded Insert

Note: Must have AW7012G kit or upgraded AW7012 with Part# AW7012SS

Contact Jaquith if you did not purchase the AW7012G to purchase the required upgrade kit

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AW7012SS– Upgrade Kit



Steps #4 Through #7 provide instruction on insertion of a Stainless Steel Threaded Insert

This process is will replace your damaged Threads in the top flange of your base or Extension /Top Section Please review instructions carefully prior to starting the steps



Position drill bushing over broken bolt and attach to light base using provided flat head bolts

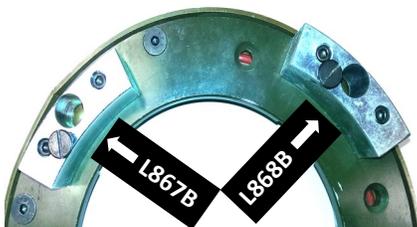
Note: (If applicable)

Longer Bolts have been provided to accommodate spacer ring thicknesses.

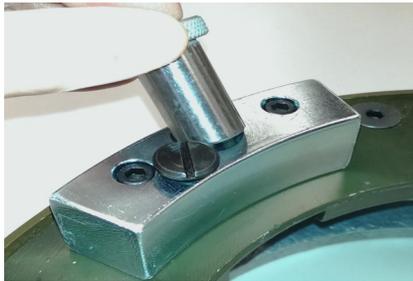
Bushing Locations:

Most outer positioned bushing block is for L868B (11.25" bolt circle)

inner positioned bushing block is for L867B(10.25" bolt circle)



STEP 4



Insert 15/32" bushing into bushing block
Apply liberal amount of tapping fluid



Use 15/32" drill bit, drill hole in top flange
Drill through spacer rings if applicable
If you do not have any Spacer Rings and/or Flange Rings, go to step #6

STEP 5



If you have Spacer Rings and/or Flange Ring, insert 1/2" bushing and use Reamer to enlarge through holes in Spacer Rings and/or Flange Ring-ONLY.

Use depth gauge to avoid reaming top flange hole– DO NOT REAM OUT
Top Flange of base and/or Top Flange of Extension or Top Section

STEP 6



Assemble Long Installation Tool using 3/8" -16 x 5 1/2" Bolt
Assembly sequence should consist of
5 1/2" bolt

1- 3/8" SAE Flat Washer

1- 1/2"-13 Hex Nut

2- 3/8" SAE Flat Washers

Installation Sleeve

3/8" S.S threaded Insert

Assure that cutting holes on insert are at the end the of assembly

The Installation Sleeve has a slightly larger diameter than the insert. This will assure that the insert is installed flush to the top of the flange.



Insert 1/2" bushing into bushing block
Liberally apply tapping fluid to insert and drilled hole . Attached wrench on the cap screw and turn in the threaded insert until the installation sleeve bottoms out on top of flange. Insert should now be installed flush to top of flange.

To release installation tool:
Place another wrench on 1/2" nut and loosen cap screw.

Threaded Insert is now installed

Take tube brush and remove any metal chip that may remain inside insert
Repair is now complete!



400 Series Stainless Steel Insert
Will not back out / Will not wear out