



EN

REPAIR KIT FOR PEDAL THREAD 5/8"X24 TPI (LEFT & RIGHT)

PE-04700

VAR thanks you for purchasing **PE-04700** specially designed for damaged pedal thread (5/8" x 24 tpi) repair.

Please read this manual carefully before each use.



The set contains :

- 1 set of 2 reaming taps (5/8" x 24 tpi and 5/8" x 24 tpi L)
- 5 threaded inserts for right crank arm (gold)
- 5 threaded inserts for left crank arm (grey or black)
- Comes in a compartmented box

General recommendations

Reaming taps and threaded inserts are precision tools that must be used and stored with care, avoiding shocks, falls and mistreatments.

Never use conventional lubricants which are not suitable for metal machining and which reduce the quality of work and your tools' lifespan

Instructions

Required elements :

- **VAR DV-04320** tap handle
- **VAR NL-77000** cutting fluid
- **VAR NL-75300** degreaser
- **VAR NL-77400** threadlocker
- **VAR PE-65000** pedal wrench

Execution :

1. Mark the cutting direction of the reaming taps. The "L" marking indicates that the reaming tap is used to the left, on the left hand crank arm. The unidentified reaming tap is used to the right, on the right crank arm.

2. Install the selected reaming tap on a **VAR DV-04320** tap handle.

3. Apply **VAR NL-77000** cutting fluid on the reaming tap and on the threads to be eliminated to obtain a qualitative work (reducing the heating of the elements and their related deformation) and to preserve the reaming tap's lifespan.

3. With the tap handle, manipulate the reaming tap in its cutting direction. To the left for a left crank arm, to the right for a right crank arm.

4. When the reaming is complete, clean the metal shavings with a clean cloth.

5. Reapply **VAR NL-77000** cutting fluid to the reaming tap and start creating the threads to the final dimensions. Advance the tool by 1 turn then break the created shaving by moving the reaming tap backwards by 1/2 turn. Follow this procedure on the entire thread to create.

6. Remove the tool, then using **VAR NL-75300** degreaser and a clean cloth, remove all residue of cutting fluid and metal shavings.

7. Apply **VAR NL-77400** threadlocker to the outer side of the threaded insert and screw it onto the pedal thread. Screw then tighten the assembly on the crank arm respecting the tightening direction.

8. Allow the threadlocker to dry then cut off the excess threaded insert. The repair allows the application of the usual tightening torques.