

STANLEY[®]
Engineered Fastening



Aftermarket Products



HeliCoil[®] **POP**[®] **POP NUT**[®]

Aftermarket Products



Did you know...

Indy and NASCAR racing teams use Heli-Coil inserts.

A Boeing 747 has 250,000 Heli-Coil inserts as original equipment.

There are 250,000 Heli-Coil inserts in every space shuttle.

Why?

All of the above use lightweight, exotic materials and need strong threads.

What does this mean to you?

Today's cars are also made of light materials, such as aluminum, and tapped hole damage is a common occurrence. Stripping during removal of seized bolts, cross-threading and wear from constant assembly and disassembly, and corrosion can also cause thread damage. For these reasons, companies like General Motors, Ford, Chrysler, Boeing, Pratt & Whitney, McDonnell-Douglas, NASA, Harley Davidson, Caterpillar, Cummins, General Electric, Rolls-Royce, BMW, Porsche and many more, including the military, all use Heli-Coil inserts as original equipment in critical threaded areas with parts made of lightweight materials. They have found that the use of Heli-Coil inserts gives them a stronger and more reusable thread that resists the effects of corrosion.

The inserts offered in all of our Heli-Coil Thread Repair Kits are made of the same high quality stainless steel as the inserts used by these companies. The same technology that took us to the moon is available to fix the damaged threads on your car, truck, motorcycle, boat; anywhere they happen. This repair is virtually better than the original thread. It is quick, easy and permanent and in almost all cases, less expensive than replacing the part.



POP Blind Rivets are available in a variety of sizes, types and materials combined with dome, countersunk or large-flange head styles. This makes POP blind rivets ideal for a wide range of riveting applications. They are the most popular rivets for automotive use. Also available from POP are POP NUT® Sheet Metal Inserts, a general purpose threaded insert with exceptionally strong torque-out and pull-out characteristics and POP Plastic Rivets, a one-piece, all-plastic expansion rivet, and a variety of rugged manual and power tools.

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HeliCoil® Thread Repair System

Heli-Coil has the most effective and universally accepted method of thread repair. Heli-Coil inserts quickly and permanently restore **stripped, worn or damaged threads** to their original size and condition.

The inserts work in just about any part or material; **aluminum, magnesium, cast iron, bronze**, etc. The use of light weight (and soft) materials in fuel efficient cars means more thread damage... there is a Heli-Coil insert to repair virtually every application.

Damaged threads can be restored to better than new condition in spark plug ports, carburetor fuel inlets, transmission housings, oil drain plugs, exhaust and intake manifolds, head bolt holes, brake calipers and more!

The Heli-Coil system makes all other thread repair methods basically obsolete: welding, plugging, oversized fasteners and oversized drilling of mating parts. It's faster – you save time, increase your shop's repair capabilities and restore parts that otherwise would have to be scrapped.



Heli-Coil repairs are available in the following standard thread series and size ranges: **Inch Coarse** (#8 thru 1-1/2), **Inch Fine** (#10 thru 1-1/2), **Metric Coarse** (M3 thru M20), **Metric Fine** (M8 thru M18), **Spark Plug** (10mm, 12mm, 14mm, 18mm & 7/8"), and **Pipe Thread** (1/8" thru 1").

In addition to the above, custom sizes are available for various repairs.

Heli-Coil Stainless Steel Inserts

Heli-Coil inserts are precision formed coils of extremely hard stainless steel (18-8) diamond-shaped wire. When installed into a Heli-Coil tapped hole, the insert provides permanent conventional screw threads. The insert has a driving "tang" for installation which is notched for easy removal.



The Retention Principle

Heli-Coil inserts are larger in diameter before installation than the tapped hole. During installation, the inserting tool reduces the diameter of the leading coil so it can enter the tapped hole. After the installation, each high tensile stainless steel coil expands outward against the tapped hole to permanently anchor the insert.



Installation

Drill

Drill out the damaged threads using the drill size specified on the kit or set. Drill to sufficient depth to accommodate the insert length and bolt or screw being used.



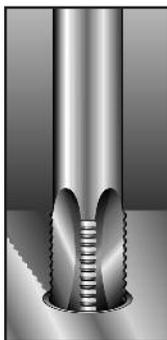
Install

Use the installation tool supplied in the kit or set. Just wind the insert into the hole until the top coil is 1/4 - 1/2 turn into the tapped thread. Now you're back to the original size and the original size fastener can be used.



Tap

Use the Heli-Coil tap supplied in the kit or set. Check the size on the shank to make sure you have the right one. Tap the hole to sufficient depth to accommodate the insert length and bolt or screw being used.



Tang Removal

The tang must be removed to allow full passage of the bolt or screw through the insert. Place square (unchamfered) end of a punch on the tang and strike sharply. For inserts over 1/2", M14 and up, and all spark plug sizes, use long nose pliers. Holding the tang with the pliers, bend it alternately in and out until it comes free.

Note: For **Spark Plug** repairs, **NO** drilling is necessary. The Heli-Coil spark plug kit contains a piloted reamer tap. With this tap, the damaged threads are removed and new threads are cut in one continuous operation.

Stripped & Fixed

When threads become stripped, worn or damaged for any reason, the strength and reliability are greatly reduced. Potentially dangerous situations are eliminated when the damaged thread is repaired with Heli-Coil inserts. The Heli-Coil threaded insert provides stronger, more reliable threads than the original tapped hole and at the same time eliminates the possibility of thread wear, corrosion, galling, seizing and rust.



Inch Thread Repairs Kits **HeliCoil**

Heli-Coil has complete coverage of inch thread repair sizes. Available from stock are Inch Coarse kits in sizes #8 through 1-1/2" and Inch Fine kits in sizes #10

through 1-1/2". Kits up to 3/4" are packaged in durable placon or vinyl pouches, and kits 7/8" and larger are packaged in sturdy metal cases and contain the proper

size high speed steel drill. All kits contain a Heli-Coil tap, installation tool, a quantity of inserts and detailed instructions.

INCH COARSE				Kit Contents and Replacement Parts					DRILL SIZE
THREAD SIZE + LENGTH	KIT PART NO.	KIT PKG. TYPE	INSERTS PER KIT	TAP PART NO.	INSTALLATION TOOL PART NO.	TOOL TYPE	PACKAGED INSERT PART NO.	PACKAGED INSERT QTY.	
8-32 x .246	5521-2	A	12	819-2	2288-2	2	R1185-2	12	11/64
10-24 x .285	5521-3	A	12	819-3	2288-3	2	R1185-3	12	13/64
12-24 x .324	5521-1	A	12	819-1	2288-1	2	R1185-1	12	15/64
1/4-20 x .375*	5521-4	A	12	819-4	2288-4	2	R1185-4	12	17/64
5/16-18 x .469*	5521-5	A	12	819-5	2288-5	2	R1185-5	12	21/64
3/8-16 x .562*	5521-6	A	12	819-6	2288-6	2	R1185-6	12	25/64
7/16-14 x .656*	5521-7	A	6	819-7	2288-7	2	R1185-7	6	29/64
1/2-13 x .750*	5521-8	A	6	819-8	2288-8	2	R1185-8	6	17/32
9/16-12 x .844	5521-9	B	6	819-9	2288-9	2	R1185-9	6	19/32
5/8-11 x .938	5521-10	B	6	819-10	2288-10	2	R1185-10	6	21/32
3/4-10 x 1.125	5521-12	B	4	819-12	2288-12	2	R1185-12	4	25/32

THE FOLLOWING KITS COME COMPLETE WITH HIGH SPEED STEEL DRILL BIT FOR 1/2" CHUCK.

7/8-9 x 1.312	5521-14	C	6	8187-14	3724-14	2	K1185-14	1	29/32
1-8 x 1.500	5521-16	C	6	8187-16	3724-16	2	K1185-16	1	1-1/32
1-1/8-7 x 1.688	5521-18	C	5	8187-18	3724-18	2	K1185-18	1	1-5/32
1-1/4-7 x 1.875	5521-20	C	4	8187-20	3724-20	2	K1185-20	1	1-9/32
1-3/8-6 x 2.062	5521-22	C	4	8187-22	3724-22	2	K1185-22	1	1-13/32
1-1/2-6 x 2.250	5521-24	C	4	8187-24	3724-24	2	K1185-24	1	1-17/32

*Sizes included in Master Thread Repair Set - Part No. 5621

A - Carded B - Pouch C - Metal Case



INCH FINE				Kit Contents and Replacement Parts					DRILL SIZE
THREAD SIZE + LENGTH	KIT PART NO.	KIT PKG. TYPE	INSERTS PER KIT	TAP PART NO.	INSTALLATION TOOL PART NO.	TOOL TYPE	PACKAGED INSERT PART NO.	PACKAGED INSERT QTY.	
10-32 x .285**	5528-3	A	12	821-3	2299-3	3	R1191-3	12	13/64
1/4-28 x .375**	5528-4	A	12	821-4	2299-4	3	R1191-4	12	17/64
5/16-24 x .469**	5528-5	A	12	821-5	2299-5	3	R1191-5	12	21/64
3/8-24 x .562**	5528-6	A	12	821-6	2299-6	3	R1191-6	12	25/64
7/16-20 x .656**	5528-7	A	6	821-7	2299-7	3	R1191-7	6	29/64
1/2-20 x .750**	5528-8	A	6	821-8	2299-8	3	R1191-8	6	33/64
9/16-18 x .844	5528-9	B	6	821-9	2299-9	3	R1191-9	6	37/64
5/8-18 x .938	5528-10	B	6	821-10	2299-10	3	R1191-10	6	41/64
3/4-16 x 1.125	5528-12	B	4	821-12	2299-12	3	R1191-12	4	49/64

THE FOLLOWING KITS COME COMPLETE WITH HIGH SPEED STEEL DRILL BIT FOR 1/2" CHUCK.

7/8-14 x 1.312	5528-14	C	6	8193-14	535-14	4	K1191-14	1	57/64
1-14 x 1.500	5528-16	C	6	8193-16	535-16	4	K1191-16	1	1-1/64
1-12 x 1.500	5528-161	C	6	8193-161	535-161	4	K1191-161	1	1-1/64
1-1/8-12 x 1.688	5528-18	C	5	8193-18	535-18	4	K1191-18	1	1-5/32
1-1/4-12 x 1.875	5528-20	C	4	8193-20	535-20	4	K1191-20	1	1-9/32
1-3/8-12 x 2.062	5528-22	C	4	8193-22	535-22	4	K1191-22	1	1-13/32
1-1/2-12 x 2.250	5528-24	C	4	8193-24	535-24	4	K1191-24	1	1-17/32

**Sizes included in Master Thread Repair Set - Part No. 5625

HeliCoil® Metric Thread Repair Kits

Heli-Coil has all you need in metric thread repair items. Available from stock are Metric Coarse kits in sizes M3 through M20 and Metric Fine kits

in sizes M8 through M20. All Metric kits contain a Heli-Coil tap, installation tool, a quantity of inserts and complete instructions.

METRIC COARSE				Kit Contents and Replacement Parts					
THREAD SIZE + LENGTH	KIT PART NO.	KIT PKG. TYPE	INSERTS PER KIT	TAP PART NO.	INSTALLATION TOOL PART NO.	TOOL TYPE	PACKAGED INSERT PART NO.	PACKAGED INSERT QTY.	DRILL SIZE
M3x0.5 x 4.5mm	5546-3	B	12	2087-3	7751-3	5	R1084-3	12	1/8
M4x0.7 x 6.0mm	5546-4	A	12	2087-4	3747-4	3	R1084-4	12	11/64
M5x0.8 x 7.5mm*†	5546-5	A	12	570-5	3747-5	3	R1084-5	12	13/64
M6x1 x 9.0mm*†	5546-6	A	12	570-6	3747-6	3	R1084-6	12	1/4
M7x1 x 10.5mm	5546-7	A	12	570-7	3747-7	2	R1084-7	12	9/32
M8x1.25 x 12.0mm*†	5546-8	A	12	570-8	3747-8	2	R1084-8	12	21/64
M9x1.25 x 13.5mm	5546-9	A	12	570-9	3747-9	2	R1084-9	12	23/64
M10x1.5 x 15.0mm*	5546-10	A	12	570-10	3747-10	2	R1084-10	12	13/32
M11x1.5 x 16.5mm	5546-11	A	6	580-11	3747-11	3	R1084-11	6	29/64
M12x1.75 x 18.0mm	5546-12	A	6	2087-12	3747-12	2	R1084-12	6	31/64
M14x2 x 21.0mm	5546-14	B	6	2087-14	3747-14	2	R1084-14	6	37/64
M16x2 x 24.0mm	5546-16	B	6	2087-16	3747-16	2	R1084-16	6	21/32
M18x2.5 x 27.0mm	5546-18	B	6	2087-18	3747-18	2	R1084-18	6	47/64
M20x2.5 x 30.0mm	5546-20	B	4	2087-20	3747-20	2	R1084-20	4	13/16

*Sizes included in Master Thread Repair Set - Part No. 5626-150

A - Carded B - Pouch

†Sizes included in Master Thread Repair Set - Part No. 5626-125



METRIC FINE				Kit Contents and Replacement Parts					
THREAD SIZE + LENGTH	KIT PART NO.	KIT PKG. TYPE	INSERTS PER KIT	TAP PART NO.	INSTALLATION TOOL PART NO.	TOOL TYPE	PACKAGED INSERT PART NO.	PACKAGED INSERT QTY.	DRILL SIZE
M8x1 x 12.0mm	5542-8	A	12	573-8	4835-8	3	R4255-8	12	21/64
M10x1 x 15.0mm	5542-10	A	12	573-10	4835-10	3	R4255-10	12	13/32
M11x1 x 16.5mm	5542-11	A	6	573-11	4835-11	3	R4255-11	6	7/16
M10x1.25 x 15.0mm†	5543-10	A	12	575-10	4640-10	3	R4649-10	12	13/32
M11x1.25 x 16.5mm	5543-11	A	6	4944-11	4640-11	3	R4649-11	6	29/64
M12x1.25 x 18.0mm	5543-12	A	6	4944-12	4640-12	3	R4649-12	6	31/64
M12x1.5 x 18.0mm	5544-12	A	6	4976-12	4973-12	3	R3745-12	6	31/64
M14x1.5 x 21.0mm	5544-14	B	6	4976-14	4973-14	3	R3745-14	6	9/16
M16x1.5 x 24.0mm	5544-16	B	6	4976-16	4973-16	3	R3745-16	6	21/32

†Sizes included in Master Thread Repair Set - Part No. 5626-125



Heli-Coil inserts are packaged according to thread size for easy handling and display. The inserts are contained in a sturdy, clear, plastic display box and marked with part number and thread size. The length of the inserts in inch and metric packages is 1–1/2 times the diameter of the bolt. This provides sufficient strength in most applications. Spark plug hole inserts are packaged in lengths corresponding to the various spark plug reaches. For shorter or longer lengths and volume applications, see page 8.

Thread Size + Length	Packaged Insert Part No.	Insert Qty.
INCH COARSE		
8-32x.246	R1185-2	12
10-24x.285	R1185-3	12
12-24x.324	R1185-1	12
1/4-20x.375	R1185-4	12
5/16-18x.469	R1185-5	12
3/8-16x.562	R1185-6	12
7/16-14x.656	R1185-7	6
1/2-13x.750	R1185-8	6
9/16-12x.844	R1185-9	6
5/8-11x.938	R1185-10	6
3/4-10x1.125	R1185-12	4
7/8-9x1.312	K1185-14	1
1-8x1.500	K1185-16	1
1-1/8-7x1.688	K1185-18	1
1-1/4-7x1.875	K1185-20	1
1-3/8-6x2.062	K1185-22	1
1-1/2-6x2.250	K1185-24	1
INCH FINE		
10-32x.285	R1191-3	12
1/4-28x.375	R1191-4	12
5/16-24x.469	R1191-5	12
3/8-24x.562	R1191-6	12
7/16-20x.656	R1191-7	6
1/2-20x.750	R1191-8	6
9/16-18x.844	R1191-9	6
5/8-18x.938	R1191-10	6
3/4-16x1.125	R1191-12	4
7/8-14x1.312	K1191-14	1
1-14x1.500	K1191-16	1
1-12x1.500	K1191-161	1
1-1/8-12x1.688	K1191-18	1
1-1/4-12x1.875	K1191-20	1
1-3/8-12x2.062	K1191-22	1
1-1/2-12x2.250	K1191-24	1

Thread Size	Length	Packaged Insert Part No.	Insert Qty.
METRIC COARSE			
M3x0.5	4.5	R1084-3	12
M4x0.7	6.0	R1084-4	12
M5x0.8	7.5	R1084-5	12
M6x1	9.0	R1084-6	12
M7x1	10.5	R1084-7	12
M8x1.25	12.0	R1084-8	12
M9x1.25	13.5	R1084-9	12
M10x1.5	15.0	R1084-10	12
M12x1.75	18.0	R1084-12	6
M14x2	21.0	R1084-14	6
M16x2	24.0	R1084-16	6
M18x2.5	27.0	R1084-18	6
M20x2.5	30.0	R1084-20	4
METRIC FINE			
M8x1	8.0	R4255-8-10	12
M10x1	15.0	R4255-10	12
M10x1.25	15.0	R4649-10	12
M11x1	11.0	R4255-11-10	6
M11x1.25	16.5	R4649-11	6
M12x1.25	18.0	R4649-12	6
M12x1.5	18.0	R3745-12	6
M14x1.5	21.0	R3745-14	6
M16x1.5	24.0	R3745-16	6

Sav-A-Thread® Spark Plug Inserts

Thread Size	Reach	Packaged Insert Part No.	Insert Qty.
M14x1.25	Short	R5326-14S	1
M14x1.25	Normal	R5326-14N	1
M14x1.25	Long	R5326-14L	1

SAV-A-THREAD PRO SET

M14x1.25	Short	R5326-14S-6	6
M14x1.25	Normal	R5326-14N-6	6
M14x1.25	Long	R5326-14L-6	6

Spark Plug – Wire Inserts

Thread Size	Reach	Packaged Insert Part No.	Insert Qty.
10-1.0mm	1/2"	R474-4	6
12-1.25mm	1/2"	R482-1	6
	3/4"	R482-2	6
	7/16"	R513	6
14-1.25mm	1/2"	R513-13	6
	3/4"	R513-10	6
	.472	R513-20	6
18-1.5mm	1/2"	R514-6	6
7/8"	1/2"-5/8"	R518-12	5

HeliCoil® Point of Purchase Displays

Heli-Coil offers effective point-of-purchase displays. They can be counter or pegboard positioned, can stand alone or be combined to build a thread repair center.

They contain only the fastest moving Heli-Coil sizes so you get faster turns and each display requires one cubic foot of space or less. This means more profit

per cubic foot. If your customers need something they don't see, it is available through our extensive network of warehouse distributors. With all this flexibility, you can tailor your thread repair inventory to the customer's needs in your trading area.

Heli-Coil displays are designed with eye catching graphics and high impact packaging — an attractive addition to your store. All packaging is color coded by thread series for easy identification and customer selection.

INCH COARSE DISPLAY Part No. 5820

KITS			PACKAGED INSERTS	
Qty.	Size	Part No.	Qty.	Part No.
1	1/4-20	5521-4	1	R1185-4
1	5/16-18	5521-5	1	R1185-5
1	3/8-16	5521-6	1	R1185-6
1	7/16-14	5521-7	1	R1185-7
1	1/2-13	5521-8	1	R1185-8
1	M14x1.25	5334-14	1	R5326-14S
			1	R5326-14N
			1	R5326-14L



METRIC DISPLAY Part No. 5829

KITS			PACKAGED INSERTS	
Qty.	Size	Part No.	Qty.	Part No.
1	M6x1	5546-6	1	R1084-6
1	M8x1.25	5546-8	1	R1084-8
1	M9x1.25	5546-9	1	R1084-9
1	M10x1.5	5546-10	1	R1084-10
1	M10x1.25	5543-10	1	R4649-10
1	M11x1.25	5543-11	1	R4649-11



INCH FINE DISPLAY Part No. 5825

KITS			PACKAGED INSERTS	
Qty.	Size	Part No.	Qty.	Part No.
1	10-32	5528-3	1	R1191-3
1	1/4-28	5528-4	1	R1191-4
1	5/16-24	5528-5	1	R1191-5
1	3/8-24	5528-6	1	R1191-6
1	7/16-20	5528-7	1	R1191-7
1	1/2-20	5528-8	1	R1191-8



SAV-A-THREAD® DISPLAY Part No. 5834

Description	Part No.	Qty.
Sav-A-Thread	5334-14	4
R-Pack, Short Insert	R5326-14S	1
R-Pack, Normal Insert	R5326-14N	2
R-Pack, Long Insert	R5326-14L	3

These “Shop Sets” are the professional’s choice and are available in inch and metric — coarse and fine. The inch and metric Master Sets contain the most common thread repair sizes. All of these master sets come complete with a drill, tap, installation tool and a quantity of inserts for each size and complete instructions.



Inch Master Thread Repair Sets

There are two master sets for inch sizes. The coarse set contains five sizes: 1/4, 5/16, 3/8, 7/16 and 1/2. The fine set has six sizes: #10, 1/4, 5/16, 3/8, 7/16 and 1/2.

THREAD SIZE + LENGTH	PACKAGED INSERT PART NO.	INSERT QUANTITY	TAP PART NO.	INSTALLATION TOOL PART NO.	DRILL SIZE
PART NO. 5621 – INCH COARSE CONTENTS					
1/4-20 x .375	R1185-4	12	819-4	2288-4	17/64
5/16-18 x .469	R1185-5	12	819-5	2288-5	21/64
3/8-16 x .562	R1185-6	12	819-6	2288-6	25/64
7/16-14 x .656	R1185-7	6	819-7	2288-7	29/64
1/2-13 x .750	R1185-8	6	819-8	2288-8	17/32
PART NO. 5625 – INCH FINE CONTENTS					
10-32 x .285	R1191-3	12	821-3	2299-3	13/64
1/4-28 x .375	R1191-4	12	821-4	2299-4	17/64
5/16-24 x .469	R1191-5	12	821-5	2299-5	21/64
3/8-24 x .562	R1191-6	12	821-6	2299-6	25/64
7/16-20 x .656	R1191-7	6	821-7	2299-7	29/64
1/2-20 x .750	R1191-8	6	821-8	2299-8	33/64

Metric Master Thread Repair Sets

Two sets are available in metric sizes. The metric coarse set contains sizes M5, M6, M8 and M10x1.5 and the metric fine set contains sizes M5, M6, M8 and M10x1.25.

THREAD SIZE + LENGTH	PACKAGED INSERT PART NO.	INSERT QUANTITY	TAP PART NO.	INSTALLATION TOOL PART NO.	DRILL SIZE
PART NO. 5626-150 – METRIC COARSE CONTENTS					
M5x0.8 x 7.5mm	R1084-5	12	570-5	3747-5	13/64
M6x1 x 9.0mm	R1084-6	12	570-6	3747-6	1/4
M8x1.25 x 12.0mm	R1084-8	12	570-8	3747-8	21/64
M10x1.5 x 15.0mm	R1084-10	12	570-10	3747-10	13/32
PART NO. 5626-125 – METRIC FINE CONTENTS					
M5x0.8 x 7.5mm	R1084-5	12	570-5	3747-5	13/64
M6x1 x 9.0mm	R1084-6	12	570-6	3747-6	1/4
M8x1.25 x 12.0mm	R1084-8	12	570-8	3747-8	21/64
M10x1.25 x 15.0mm	R4649-10	12	575-10	4640-10	13/32



HeliCoil® Spark Plug & Sav-A-Thread® Master Sets



Spark Plug Repair Kit

The 1st choice of Professional Mechanics and Rebuilders. Heli-Coil is the original in Spark Plug port repair.

Available in M10, M12, M14, M18 and 7/8".

Kits contain:

- Piloted reamer tap (no drilling necessary)
- Installation tool
- Quantity of packaged inserts (can be re-ordered)

The M12 and M14 kits contain several insert lengths to accommodate all spark plug reaches.

Heli-Coil inserts are preferred by virtually all US and foreign vehicle manufacturers.

Note: Do **not** use Heli-Coil inserts wire to repair taper seat spark plug ports.

THREAD SIZE	REACH	KIT PART NO.	INSERTS PER KIT	Kit Contents and Replacement Parts			
				TAP PART NO.	INSTALLATION TOOL PART NO.	INSERT PKG. PART NO.	INSERT QUANTITY
10-1.0mm	1/2"	5523-10	24	1030-10	4971-10	R474-4	6
12-1.25mm	1/2"	5523-12	12	1030-12	4971-12	R482-1	6
	3/4"		12			R482-2	6
14-1.25mm	3/8"	5523-14	6	1030-14	4971-14	R512	6
	7/16"		6			R513	6
	1/2"		6			R513-13	6
	3/4"		6			R513-10	6
	.472		6			R513-20	6
18-1.50mm	1/2"	5523-18	24	1030-18	4971-18	R514-6	6
7/8-18	1/2"-5/8"	550	10	549	548	K518-12	5

Sav-A-Thread® Spark Plug Repair Kit

Sav-A-Thread® solid bushing inserts are specifically designed to accept taper seat spark plug ports and will also repair gasketed spark plug configurations. Sav-A-Thread provides the easiest way to permanently repair spark plug hole threads. Virtually all engines built today have aluminum cylinder heads. The need for quick and easy repairs makes Sav-A-Thread® a must for every store and shop.

Note: Heli-Coil recommends removing the head before installation to insure chips do not enter cylinder.

- Positive mechanical locking feature means the insert will never come out!
- The piloted reamer tap means no drilling is necessary and perfect alignment of the tapped hole.
- Available in kit or set for the do-it-yourselfer and professional engine rebuilder.



Complete Kits

Complete Kits				Kit Contents and Replacement Parts				
SIZE	KIT PART NO.	REACH	INSERTS PER KIT	TAP PART NO.	TOOL PART NO.	REACH	INSERT PKG. PART NO.	INS. QTY.
M14x1.25	5334-14	Short	1	5329-14	5332-14	Short	R5326-14S	1
		Normal	1			Normal	R5326-14N	1
		Long	1			Long	R5326-14L	1
M14x1.25	5408-14	Short	6	5329-14	5332-14	Short	R5326-14S-6	6
		Normal	6			Normal	R5326-14N-6	6
		Long	6			Long	R5326-14L-6	6
M14x1.25	5409-14	Extended	—	5329-14-1	5332-14-1	Extended Reach		

Sav-A-Thread® Spark Plug Repair Kits

Part No. 5396-14

This M14 Kit is typically used in 4.6 and 5.4 liter Ford® engines. Product offers the highest quality and most durable repair available. Remove the head before installation to ensure chips do not enter the cylinder.

Kit includes:

- piloted reamer
- steel installation tool
- expanding tool
- 12 inserts.

(Refill package R5326-14E is available; includes 6 inserts)



Part No. 5396-16

This M16 kit is specifically designed for Ford® 4.6 and 5.4 liter – 3 Valve engines. For repair on ports containing Autolite® HT and Morocraft® Platinum PZT spark plugs.

Kit includes:

- piloted reamer
- steel installation tool
- expanding tool
- 12 inserts.

(Refill package R5326-16E is available; includes 6 inserts)



Head Bolt Thread Repair Kit – Part No. 1130

The Metric Head Bolt Kit is typically used in 4.0 and 4.2 liter GM® engines including Cadillac® as well as many other imports such as Honda® and Toyota®. The 1130 product will permanently restore stripped head bolts, has an extended reach for easy installation and a stop collar to control the installation depth.

The Kit contains:

- High speed steel drill bit
- High speed steel tap
- 12 Heli-Coil stainless steel inserts

Oxygen Sensor Thread Repair Kit – Part No. 4833

Quickly and permanently restore damaged M18 x 1.5 oxygen sensor threads in exhaust manifolds with this kit. No drilling is necessary with the piloted reamer tap, resulting in perfect alignment of the new tapped hole. Corrosion resistant stainless steel inserts improve future serviceability. This application is easy to use, works in minutes, and eliminates exhaust manifold replacement. Perfect for the professional engine rebuilder and the do-it-yourselfer.



Custom Kits

Custom application kits round out the complete line of Heli-Coil Thread Repair Kits. They are recommended by both domestic and foreign automakers and include kits for carburetors, various heavy duty applications, and several specially-designed repairs for a number of Volkswagen models.

All kits contain a Heli-Coil tap, installation tool, a quantity of inserts, and detailed instructions. The American Bosch kit and Detroit Diesel kit also include high speed steel drill bits.

Motorcycle Kits

Heli-Coil offers a complete range of kits and sets for the repair of damaged threads on motorcycles. The Heli-Coil Motorcycle Thread Repair Set contains M6, M8 and M10 sizes. Two lengths of M10 inserts are available: 15mm for most repairs and 25mm for head bolt repairs.

Also available are special sizes for specific Harley Davidson applications. All kits come with tap, installation tool, a quantity of inserts and complete instructions.

HEAVY DUTY APPLICATIONS

SIZE	HELI-COIL KIT PART NO.
Oil & Transmission Pan Screws	
1/4-20	5521-4
5/16-18	5521-5

SIZE	HELI-COIL KIT PART NO.
Cylinder Head Bolts	
7/16-14	5521-7
1/2-13	5521-8
9/16-12	5521-9
M10x1.5	5546-10
M11x1.5	5546-11
M11x1.25	5543-11
M12x1.75	5546-12

SIZE	HELI-COIL KIT PART NO.
Exhaust Manifold Studs	
1/4-20	5521-4
1/4-28	5528-4
5/16-18	5521-5
5/16-24	5528-5
3/8-16	5521-6
3/8-24	5528-6
7/16-14	5521-7
7/16-20	5528-7
1/2-20	5528-8
9/16-18	5528-9
5/8-18	5528-10
3/4-10	5521-12
M5x0.8	5546-5
M6x1	5546-6
M8x1.25	5546-8
M10x1.5	5546-10
M10x1.25	5543-10

SIZE	HELI-COIL KIT PART NO.
Starter Bolts	
3/8-16	5521-6
M10x1.5	5546-10

SIZE	HELI-COIL KIT PART NO.
Alternator Bolts	
5/16-18	5521-5
3/8-16	5521-6
M10x1.5	5546-10

SIZE	HELI-COIL KIT PART NO.
Drain Plugs	
1/2-20	5528-8
5/8-18	5528-10
3/4-16	5528-12
7/8-14	5528-14
M12x1.75	5546-12
M14x1.5	5544-14
M16x1.5	5544-16

SIZE	HELI-COIL KIT PART NO.
Brake Caliper Bolts	
M9x1.25	5546-9
M11x1.25	5543-11

HEAVY DUTY APPLICATIONS

SIZE	HELI-COIL KIT PART NO.
Aux. Transmission Cases (Fuller)	
3/8-16	5521-6
5/16-18	5521-5

SIZE	HELI-COIL KIT PART NO.
Caterpillar Flywheel Bolts	
3/4-16	5528-12

SIZE	HELI-COIL KIT PART NO.
Cummins Head Bolt	
11/16-16	5559-11

SIZE	HELI-COIL KIT PART NO.
Caterpillar Pre-Combustion Chamber	
3/4-12	4922-12
7/8-12	4922-141
1-12	4922-161
1 1/8-12	4922-18
1 1/4-12	4922-20

SIZE	HELI-COIL KIT PART NO.
Wheel Studs	
3/4-10	5521-12
3/4-16	5528-12

SIZE	HELI-COIL KIT PART NO.
Motor Mounts/Bell Housing	
1/2-13	5521-8
5/8-11	5521-10

SIZE	HELI-COIL KIT PART NO.
Oil Pan	
7/16-14	5521-7

SIZE	HELI-COIL KIT PART NO.
Intake Manifolds	
3/8-16	5521-6

SIZE	HELI-COIL KIT PART NO.
After Coolers	
5/16-18	5521-5

SIZE	HELI-COIL KIT PART NO.
Valve Cover	
3/8-16	5521-6

SIZE	HELI-COIL KIT PART NO.
Detroit Diesel Series "92" Block Head Bolt/Main Bearing	
11/16-11	5575-11

SIZE	HELI-COIL KIT PART NO.
Mack-Scania Head Bolt	
M14x1.5	5544-14

SIZE	HELI-COIL KIT PART NO.
American Bosch APE Diesel Fuel Pumps	
1/4-20	5401-4-1-SL

SPARK PLUG HOLE THREADS

SIZE	HELI-COIL KIT PART NO.
Wire Insert*	
10-1.0mm	5523-10
12-1.25mm	5523-12
14-1.25mm	5523-14
18-1.5mm	5523-18
7/8-18	550

SIZE	HELI-COIL KIT PART NO.
Sav-A-Thread**	
M14x1.25	5334-14 or 5408-14 5409-14

*For gasket type spark plug assemblies only.

**For Taper seat or gasket type spark plug assemblies.

SIZE	HELI-COIL KIT PART NO.
Motorcycle Thread Repair Set	
M6x1, M8x1.25 and M10x1.25 (2 lengths)	4650

SIZE	HELI-COIL KIT PART NO.
Cam Screw Cover, Tappet Guide, Oil Pump Stud and Timer Mounting	
1/4-24	5540-4

SIZE	HELI-COIL KIT PART NO.
Front/Rear Brake Drum	
3/8-20	5540-6

SIZE	HELI-COIL KIT PART NO.
Head Bolt	
7/16-16	5540-7

SIZE	HELI-COIL KIT PART NO.
Drain Plug - Engine and Transmission	
1/2-13	5521-8-2

SIZE	HELI-COIL KIT PART NO.
Drain Plug - Chain Case	
1/2-20	5528-8-2

SIZE	HELI-COIL KIT PART NO.
Timing Plug	
5/8-18	5528-10-2

SIZE	HELI-COIL KIT PART NO.
Generator Case Bolt	
5/16-18	5521-5-2

SIZE	HELI-COIL KIT PART NO.
Transmission Cover	
5/16-18	5521-5-3

SIZE	HELI-COIL KIT PART NO.
Japanese Motorcycle Head Bolt	
M10x1.25	4647-10-1

TYPICAL VOLKSWAGEN APPLICATIONS

SIZE	HELI-COIL KIT PART NO.
VW Electro Magnetic	
M8x1	5542-8

SIZE	HELI-COIL KIT PART NO.
Fuel Cut Off Jet	
M11x1	5542-11

SIZE	HELI-COIL KIT PART NO.
VW Rabbit Head Bolt Threads	
M11x1.25	5546-11

SIZE	HELI-COIL KIT PART NO.
VW Fuel Injection Head Sensor	
M10x1	5542-10-1

PIPE THREAD KITS

SIZE	HELI-COIL KIT PART NO.
1/8-27	5407-2
1/4-18	5407-4
3/8-18	5407-6
1/2-14	5407-8
3/4-14	5407-12
1-11 1/2	5407-16

POP is the world acknowledged leader in blind rivet fastening technology, and POP rivet tools are the state-of-the-art in design, performance and durability. In addition to being the industry's original manufacturer and pioneer, POP is constantly updating and improving its complete product line to keep pace with rapidly advancing automotive markets and the increasing needs of today's automotive service professionals.

POP rivets are more effective and practical than other fastening methods such as welding, sheet metal screws, nuts and bolts, solid rivets and adhesives. They are ideal for repairs where access is limited to one side only. No surface preparation is required. The job can be done with no special skills. Almost any material can be fastened with POP rivets, especially plastics and sheet metal. The results are uniform and vibration proof.

Installation

POP rivets consist of two parts: **(A) rivet body** and **(B) setting mandrel**. In operation, the mandrel is pulled back to expand the rivet body and form a tight vibration-free fastener. The mandrel breaks off automatically after the rivet is set.



1. After selecting the proper rivet, drill a hole corresponding to the diameter of the rivet through the materials to be fastened. When using counter-sunk head rivets a 120° countersunk bit is required. Use POP Part No. 60928 for countersink drilling.
2. Open the handle of the rivet tool and insert the rivet mandrel in the nose-piece of the tool.
3. Place the rivet body in the pre-drilled hole. Then squeeze the rivet tool handles until the rivet mandrel breaks off.

Automotive repair, shop use

POP rivets provide an effective, high strength fastening technique. They're ideal for structural repairs, body and collision work, modifications, parts and accessory mounting and countless in-shop and miscellaneous applications. The use of rivets in automotive assembly has increased significantly because of their strength and ease of use.

Choose power or manual

POP's rivet fastening system is one of the most versatile you can buy. It requires minimal capital investment and inventory. The rivets can be installed manually or by power tools. They're designed for simple operation and ease of use.

Wide application range

POP offers a complete range of rivets to meet almost every automotive, marine, small engine, hardware and shop application. POP rivets are available in various materials, types, sizes and styles for all types of fastening from plastics to dissimilar metals to pressure tight sealing.

Rivet Materials

In order to meet a variety of requirements for strength, corrosion and rust considerations and application materials, POP rivets are offered in specific materials and material combinations.

TYPE	APPLICATION
All Steel	High strength: Use with steel
Aluminum	Lightweight: Use with aluminum, areas susceptible to rust & corrosion
Alum./Steel	Combines features of both materials
All Stainless	Very high strength: Use with stainless & steel. Prevents corrosion or rust.
Stainless/Steel	Very high strength. Applications where corrosion resistance is not a major factor.
Copper	Electrical conductivity

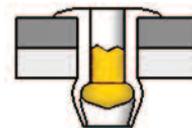
TYPES & STYLES

Rivet Types

There are three basic rivet types available for automotive use.

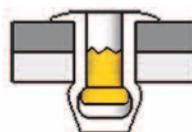
Open End

Designed for a wide range of applications, they resemble conventional tubular rivets when set, but retain the mandrel within the rivet body for added strength. Open end rivets are available in a variety of materials in dome, countersunk or large flange head styles.



Closed End

Specially configured with a cup shaped end that forms a tight seal, POP closed end rivets are much stronger than open end rivets. They are available in dome and countersunk head styles.



T-Rivets

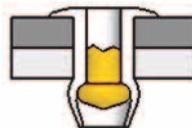
Made for structural and high stress applications. They feature a hardened steel mandrel which splits the rivet body into a trifurcated shape. This provides high clamping strength even in thin or fragile material.



Head Styles

Dome Head

Low profile design and neat appearance, this style is very versatile and most commonly used. The head size is twice the diameter of the rivet body. It provides enough bearing surface for all applications except soft or brittle material.



Large Flange

Features twice the under-head bearing surface as the dome style. It's ideal for fastening soft or brittle materials to a rigid backing surface.



Countersunk

Designed with a 120° head profile for flush surface mounting applications.



POP[®] Rivet Ordering Information

All rivet sizes are available in these **500-piece Pro Pack** boxes to meet the increasing needs of today's automotive service professionals. POP also offers all rivet sizes and back-up plates packaged in **100-piece Shop Pack** boxes — convenient for body shop or service garage.



Rivet Dia.	Head Dia.	Grip Range	Plated Steel Rivet Steel Mandrel			Stainless Steel Rivet Steel Mandrel			Stainless Steel Rivet Stainless Steel Mandrel		
			Code No.	100 pc. Shop Pack No.	500 pc. Pro Pack No.	Code No.	100 pc. Shop Pack No.	500 pc. Pro Pack No.	Code No.	100 pc. Shop Pack No.	500 pc. Pro Pack No.
OPEN END RIVETS											
3/32	3/16 3/16	Up to 1/8 1/8 to 1/4	SD32 SD34	59435 59436	60435 60436						
1/8	1/4	1/32 to 1/16	SD41	59437	60437	SSD42	59560	60560	SSD42-S	59540	60540
	1/4	1/16 to 1/8	SD42	59438	60438						
	.220	1/16 to 1/8	SK42	59439	60439	SSD43	59561	60561	SSD43-S	59541	60541
	3/8	1/16 to 1/8	SDL42	59440	60440						
	1/4	1/8 to 3/16	SD43	59441	60441	SSD44	59562	60562	SSD44-S	59542	60542
	.220	1/8 to 3/16	SD44	59442	60442						
	1/4	3/16 to 1/4	SK44	59443	60443	SSD46	59563	60563	SSD46-S	59543	60543
	.220	3/16 to 1/4	SDL44	59444	60444						
	3/8	3/16 to 1/4	SD45	59445	60445	SSD48	59573	60573	SSD48-S	59544	60544
	1/4	1/4 to 5/16	SD46	59446	60446						
1/4	5/16 to 3/8	SD48	59447	60447							
5/32	5/16	1/16 to 1/8	SD52	59448	60448	SSD52	59564	60564	SSD52-S	59545	60545
	5/16	1/8 to 3/16	SD53	59449	60449						
	5/16	3/16 to 1/4	SD54	59450	60450	SSD54	59565	60565	SSD54-S	59546	60546
	5/16	1/4 to 3/8	SD56	59451	60451						
	5/16	3/8 to 1/2	SSD56	59566	60566						
3/16	3/8	1/16 to 1/8	SD62	59453	60453	SSD62	59567	60567	SSD62-S	59548	60548
	3/8	1/8 to 1/4	SD64	59454	60454						
	5/8	1/8 to 1/4	SDL64	59455	60455	SSD64	59568	60568	SSD64-S	59549	60549
	3/8	1/4 to 3/8	SD66	59456	60456						
	5/8	1/4 to 3/8	SDL66	59457	60457	SSD66	59569	60569	SSD66-S	59550	60550
	3/8	3/8 to 1/2	SD68	59458	60458						
	5/8	3/8 to 1/2	SDL68	59459	60459	SSD68	59570	60570	SSD68-S	59551	60551
	3/8	1/2 to 5/8	SD610	59460	60460						
	5/8	1/2 to 5/8	SDL610	59461	60461						
	3/8	5/8 to 3/4	SD612	59462	60462						
	5/8	5/8 to 3/4	SDL612	59463	60463						
	1/4	1/2	1/16 to 1/4	SD84	59464	60464	SSD84	59571	60571	SSD84-S	59552
1/2		1/4 to 3/8	SD86	59465	60465						
1/2		3/8 to 1/2	SD88	59466	60466						
1/2		5/8 to 3/4	SD812	59467	60467						
CLOSED END RIVETS											
1/8	.236	1/16 to 1/8									
	.236	1/8 to 3/16									
	.236	3/16 to 1/4									
	.236	3/16 to 1/4									
	.236	1/4 to 5/16									
	.236	3/8 to 1/2									
5/32	5/16	1/16 to 1/8									
	5/16	1/8 to 3/16									
	5/16	1/8 to 3/16									
	5/16	1/16 to 1/4									
	5/16	3/16 to 5/16									
3/16	3/8	1/8 to 1/4	SD64H	59640	60640						
	3/8	1/4 to 3/8									
	3/8	3/8 to 1/2									
1/4	1/2	1/8 to 1/4	SD84H	59642	60642						
	1/2	1/4 to 3/8									
T-RIVETS											
1/4	.510	1/32 to 9/64									
	.510	9/64 to 3/16									
	.510	33/64 to 5/8									

Rivet Code Explanation – Example: Rivet Code No. AD42AH

A	D	4	2	A	H
Body Material	Head Style	Rivet Diameter	Max. Grip Length	Mandrel Material	Core Design*
A – Aluminum S – Carbon Steel SS – Stainless Steel	D – Dome Head DL – Dome Head, Large Flange K – Countersunk	in 32nds of an inch 4/32 = 1/8"	in 16ths of an inch 2/16 = 1/8"	A – Aluminum S – Stainless Steel Blank – Steel	H – Hollow Blank – Solid Core

* Pertains to closed end rivets only.

Rivet Dia.	Head Dia.	Grip Range	Aluminum Rivet Aluminum Mandrel			Aluminum Rivet Steel Mandrel			Copper Rivet Steel Mandrel		
			Code No.	100 pc. Shop Pack No.	500 pc. Pro Pack No.	Code No.	100 pc. Shop Pack No.	500 pc. Pro Pack No.	Code No.	100 pc. Shop Pack No.	500 pc. Pro Pack No.
OPEN END RIVETS											
33/32	3/16	Up to 1/8	AD32-A	59470	60470	AD32	59503	60503			
	3/16	1/8 to 1/4	AD34-A	59471	60471	AD34	59504	60504			
1/8	1/4	1/32 to 1/16	AD41-A	59472	60472	AD41	59505	60505	CD42	59571	60571
	1/4	1/16 to 1/8	AD42-A	59473	60473	AD42	59506	60506			
	.220	1/16 to 1/8	AK42-A	59474	60474	AK42	59507	60507			
	3/8	1/16 to 1/8	ADL42-A	59475	60475	ADL42	59508	60508			
	1/4	1/8 to 3/16	AD43-A	59476	60476	AD43	59509	60509			
	.220	1/8 to 3/16				AK43	59510	60510			
	1/4	3/16 to 1/4	AD44-A	59477	60477	AD44	59511	60511	CD44	59572	60572
	.220	3/16 to 1/4				AK44	59512	60512			
	3/8	3/16 to 1/4	ADL44-A	59478	60478	ADL44	59513	60513			
	1/4	1/4 to 5/16	AD45-A	59479	60479	AD45	59514	60514			
	1/4	5/16 to 3/8	AD46-A	59480	60480	AD46	59515	60515			
	1/4	3/8 to 1/2	AD48-A	59481	60481	AD48	59516	60516			
5/32	5/16	1/16 to 1/8	AD52-A	59482	60482	AD52	59517	60517			
	5/16	1/8 to 3/16	AD53-A	59483	60483	AD53	59518	60518			
	5/16	3/16 to 1/4	AD54-A	59484	60484	AD54	59519	60519			
	5/16	1/4 to 3/8	AD56-A	59485	60485	AD56	59520	60520			
	5/16	3/8 to 1/2	AD58-A	59486	60486	AD58	59521	60521			
3/16	3/8	1/16 to 1/8	AD62-A	59487	60487	AD62	59522	60522			
	3/8	1/8 to 1/4	AD64-A	59488	60488	AD64	59523	60523			
	5/8	1/8 to 1/4	ADL64-A	59489	60489	ADL64	59524	60524			
	3/8	1/4 to 3/8	AD66-A	59490	60490	AD66	59525	60525			
	5/8	1/4 to 3/8	ADL66-A	59491	60491	ADL66	59526	60526			
	3/8	3/8 to 1/2	AD68-A	59492	60492	AD68	59527	60527			
	5/8	3/8 to 1/2	ADL68-A	59493	60493	ADL68	59528	60528			
	3/8	1/2 to 5/8	AD610-A	59494	60494	AD610	59529	60529			
	5/8	1/2 to 5/8	ADL610-A	59495	60495	ADL610	59530	60530			
	3/8	5/8 to 3/4	AD612-A	59496	60496	AD612	59531	60531			
	5/8	5/8 to 3/4	ADL612-A	59497	60497	ADL612	59532	60532			
1/4	1/2	1/16 to 1/4	AD84-A	59498	60498	AD84	59533	60533			
	1/2	1/4 to 3/8	AD86-A	59499	60499	AD86	59534	60534			
	1/2	3/8 to 1/2				AD88	59535	60535			
	1/2	5/8 to 3/4	AD812-A	59500	60500	AD812	59536	60536			
CLOSED END RIVETS											
1/8	.236	1/16 to 1/8	AD42AH	59620	60620	AD42H	59590	60590	CD45H	59644	60644
	.236	1/8 to 3/16				AD43H	59604	60604			
	.236	3/16 to 1/4	AD44AH	59621	60621	AD44H	59592	60592			
	.236	3/16 to 1/4				AK44H	59593	60593			
	.236	1/4 to 5/16				AD45H	59608	60608			
	.236	3/8 to 1/2				AD48H	59595	60595			
5/32	5/16	1/16 to 1/8				AD52H	59596	60596			
	5/16	1/8 to 3/16				AD53H	59609	60609			
	5/16	1/8 to 3/16				AK53H	59607	60607			
	5/16	1/16 to 1/4	AD54AH	59622	60622						
3/16	3/8	1/8 to 1/4	AD64AH	59624	60624	AD64H	59599	60599			
	3/8	1/4 to 3/8				AD66H	59605	60605			
	3/8	3/8 to 1/2				AD68H	59601	60601			
1/4	1/2	1/8 to 1/4				AD84H	59606	60606			
	1/2	1/4 to 3/8				AD86H	59603	60603			
T-RIVETS											
1/4	.510	1/32 to 9/64				AD8140-T	59580	60580			
	.510	9/64 to 3/16				AD8187-T	59581	60581			
	.510	33/64 to 5/8				AD8620-T	59582	60582			

BACK-UP PLATES

Hole Size	Material	Code No.	100 pc. Shop Pack	Thrifty Packs	
			Part No.	Part No.	Qty./Pkg.
1/8	Steel	SBUP-4	59660	57660	40
1/8	Aluminum	ABUP-4	59661	57661	30
3/16	Aluminum	ABUP-6	59662	57662	30

In order to select the proper rivet for your application, follow the procedure below:

1. Select rivet type according to application material and holding strength required. (Refer to Rivet Types, Page 13.)
2. Choose rivet head style best suited for your application. (See Head Styles, Page 13.)
3. Measure joint thickness to determine correct rivet length (Grip Range).
4. Select proper rivet diameter according to recommendations for hole size and strength required. (Larger rivets provide more strength.)

POP® Point Of Purchase Displays

POP point-of-purchase displays offer a complete and effective way to organize and simplify your sheet material fastener inventory. They contain only the most popular and fastest moving items so you get faster turns. With five different displays and four product lines to choose from, you can tailor your inventory to your customer's requirements.

All packaging contains application information so the customer can select the right fastener.



POP® Thrift Pack Display P/N 5835

Part No.	Code No.	Grip Ranget	Rivet Dia.	Qty./ Display	Qty./ Pkg.
Steel Rivet/Steel Mandrel					
57438	SD42	1/16-1/8	1/8	5	25
57442	SD44	3/16-1/4	1/8	5	20
57446	SD46	5/16-3/8	1/8	5	15
Aluminum Rivet/Aluminum Mandrel					
57473	AD42-A	1/16-1/8	1/8	5	25
57477	AD44-A	3/16-1/4	1/8	5	20
57480	AD46-A	5/16-3/8	1/8	5	15
57487	AD62-A	Up to 1/8	3/16	5	15
57488	AD64-A	1/8-1/4	3/16	5	15
57490	AD66-A	1/4-3/8	3/16	5	15
Back-Up Plates					
57660	SBUP-4	1/8 Hole	Steel	3	40
57661	ABUP-4	1/8 Hole	Alum	3	30
57662	ABUP-6	3/16 Hole	Alum	3	30
Tools					
PS15-CS				4	



POP® Plastic Rivet Display P/N 5870

Part No.	Grip Ranget	Rivet Dia.	Qty./ Display	Qty./ Pkg.
57712	.059-.177	5.0mm	2	25
57714	.118-.177	5.0mm	2	25
57715	.118-.236	5.0mm	2	25
57720	.236-.394	5.0mm	2	25
57721	.157-.335	6.0mm	2	25
57732	.157-.236	6.3mm	2	25
57735	.157-.236	6.3mm	2	25
57736	.157-.394	6.3mm	2	25
57737	.157-.394	6.3mm	2	25
57741	.315-.472	6.3mm	2	25
57747	.098-.197	6.6mm	2	25
57748	.098-.197	6.6mm	2	25
57752	.098-.236	7.0mm	2	25
Tools				
60930	Pouched Rivet tool		4	



POP® SHOP RACK DISPLAY P/N 5856

Part No.	Code No.	Grip Ranget	Rivet Dia.	Qty./ Display
Steel Rivet/Steel Mandrel				
59438	SD42	1/16-1/8	1/8	3
59439	SK42	1/16-1/8	1/8	2
59442	SD44	3/16-1/4	1/8	6
59443	SK44	3/16-1/4	1/8	3
59446	SD46	5/16-3/8	1/8	4
59447	SD48	3/8-1/2	1/8	3
Aluminum Rivet/Aluminum Mandrel				
59473	AD42-A	1/16-1/8	1/8	2
59477	AD44-A	3/16-1/4	1/8	4
59480	AD46-A	5/16-3/8	1/8	2
59488	AD64-A	1/8-1/4	3/16	3
59490	AD66-A	1/4-3/8	3/16	2
Tools				
PS15-CS				2

Note: Shop pack boxes contain 100 rivets



Thrift Packs

The nine most popular rivet sizes are packaged in these reusable, easy-to-store boxes. Perfect for the do-it-yourselfer!

Rivet Dia.	Head Dia.	Grip Range	Plated Steel Rivet Steel Mandrel		Aluminum Rivet Aluminum Mandrel		Qty. Per Pkg.
			Part No.	Code No.	Part No.	Code No.	
Rivet Thrift Packs – Open End Rivets							
1/8	1/4	1/16 to 1/8	57438	SD42	57473	AD42-A	25
	1/4	3/16 to 1/4	57442	SD44	57477	AD44-A	20
	1/4	5/16 to 3/8	57446	SD46	57480	AD46-A	15
3/16	3/8	Up to 1/8			57487	AD62-A	15
	3/8	1/8 to 1/4			57488	AD64-A	15
	3/8	1/4 to 3/8			57490	AD66-A	15



POP[®] Body Shop Rivet Assortment Kit – Part No. 60980

POP[®] offers you a convenient way to organize your inventory of the most popular custom application rivets. The Assortment contains 12 varieties of rivets to satisfy common repair applications. Complete descriptions for each rivet, OEM application information and reorder numbers are included.

Custom Application Rivets

POP has the most complete line of special application rivets. These include **T-Rivets** for window regulator and door handle applications, **Trim Rivets, Bumper Rivets, Rear Window Gasket Rivets, Swivel Emblem Trunk Rivets** and more.

Rivet Dia.	Head Dia.	Application	Plated Steel Rivet Steel Mandrel		Aluminum Rivet Aluminum Mandrel		Aluminum Rivet Steel Mandrel		St. Steel Rivet Steel Mandrel		Use on/Equivalent to	
			P/N	Code No.	P/N	Code No.	P/N	Code No.	P/N	Code No.		
Pro Packs – Custom Application Rivets – 500 Per Pack												
1/8	1/4	Aluminum Trim Channel Rivet			60477	AD44-A					For attaching molding channels with snap-in color trim GM #9436175, Ford #385189, Chrysler #6031115 Ford, Lincoln & Mercury cars & trucks #388047-S100 Ford #385323, Chrysler #6031091 GM #9432137, Chrysler #6032138 GM #94372820-S36, yellow zinc dichromate coated GM #9439719, Black oxide coated Used on trim clips Used on filler covered panels Used for high strength applications Fisher body #20325696 GM #9432552	
1/4	.510	Window Regulator Rivet					60580	AD8140-T				
1/4	.510	Outside Door Handle Rivet					60581	AD8187-T				
1/4	.510	Glass Stop Rivet					60582	AD8620-T				
5/32	5/16	Swivel Emblem Trunk Lock Rivet					60607	AK53H				
1/4	1/2	Bumper Rivet	60800	SD84038								
3/16	3/8	Bumper Fascia Rivet	60801	SD66025								
1/8	13/64	Std. Alum. Trim Clip Rivet			60802	AD43-A-28						
1/8	13/64	Long Alum. Trim Clip Rivet			60803	AD44-A-28						
1/8	13/64	Std. Stainless Trim Clip Rivet							60804	SSD43-28		
1/8	.318	Rear Window Gasket Rivet					60805	ADL43-318				
1/8	1/4	Multi purpose Rivet					60806	ADL43				
Shop Packs – Customer Application Rivets – 100 Per Box												
1/8	1/4	Aluminum Trim Channel Rivet			59477	AD44-A						For attaching molding channels with snap-in color trim GM #9436175, Chrysler #6031115, Ford #385189 Ford, Lincoln & Mercury cars & trucks #388047-S100 Ford #385323, Chrysler #6031091 GM #9432137, Chrysler #6032138 GM #94372820-S36, yellow zinc dichromate coated GM #9439719, Black oxide coated Used on trim clips Used on filler covered panels Used for high strength applications Fisher body #20325696 GM #9432552
1/4	.510	Window Regulator Rivet					59580	AD8140-T				
1/4	.510	Outside Door Handle Rivet					59581	AD8187-T				
1/4	.510	Glass Stop Rivet					59582	AD8620-T				
5/32	5/16	Swivel Emblem Trunk Lock Rivet					59607	AK53H				
1/4	1/2	Bumper Rivet	59800	SD84038								
3/16	3/8	Bumper Fascia Rivet	59801	SD66025								
1/8	13/64	Std. Alum. Trim Clip Rivet			59802	AD43-A-28						
1/8	13/64	Long Alum. Trim Clip Rivet			59803	AD44-A-28						
1/8	13/64	Std. Stainless Trim Clip Rivet							59804	SSD43-28		
1/8	.318	Rear Window Gasket Rivet					59805	ADL43-318				
1/8	1/4	Multi Purpose Rivet					59806	ADL43				



This unique device is a one piece, all plastic expansion rivet designed to securely fasten a wide variety of materials in a broad range of applications.

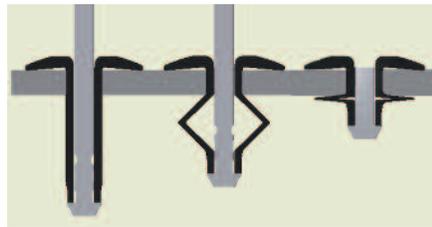
The POP Plastic Rivet quickly inserts from one side of the assembly, using standard rivet setting tools. As the tool pulls the pin through the body, it draws the panels together.

When set, the pin breaks off flush with the head, leaving an attractive, solid color finished appearance.

The POP Plastic Rivet will hold panels of a wide variety of materials, metal or plastic. It is particularly effective for soft materials such as rubber or padded fabrics.

Auto manufacturers use these rivets for many applications on today's automobiles. When necessary, these rivets must be replaced with plastic rivets that meet or

exceed OEM specifications. POP Plastic Rivets are designed to meet these specifications.



1. Insert plastic rivet in assembly with Plastic Rivet Tool P/N 60930 engaging the pin.
2. As tool pulls pin through body, it folds legs in middle and draws panels together at same time.
3. Pin is pulled to full extension after legs are clamped tight against the panel for a secure hold. The pin breaks off and is removed.

Features:

- Easy assembly from one side
- Draws mating panels together and clamps them securely without secondary washers
- Prevents marring of soft, painted or other materials that are easily damaged
- Wide-flange design eliminates rivet pull-through in soft materials
- Provides secure clamping action
- Rivet pin is broken off during assembly for an attractive, solid color finished appearance
- Strong, lightweight, non-corrosive, non-conductive
- Available in a wide variety of sizes

Applications:

- Fascia strips and grill attachments
- License plate brackets
- Exterior molding
- Hi mount stop light
- Door panel attachments

Ordering Information



POP offers plastic rivets for the most popular aftermarket applications. All sizes are packaged in reusable, plastic boxes. Each package contains 25 rivets.

PART NO.	RIVET DIA.	SUGGESTED DRILL SIZE	GRIP RANGE	HEAD DIA.	REPLACES OEM PLASTIC RIVET PART NUMBER
57712	5.0mm	7/32	.059-.177	.472	GM 20423647, Ford N803170S, Ford N804189S
57714	5.0mm	7/32	.118-.177	.472	AMC 8934202855, Ford N804863S, Chry 34202855, Chry 6500859
57715	5.0mm	7/32	.118-.236	.472	AMC 8934202652, Chry 6500899, GM 20432975, Ford N804343S, VW 175-853-577
57720	5.0mm	7/32	.236-.394	.472	Chry 6500898, Chry 6500982
57721	6.0mm	1/4	.157-.335	.512	GM-BOC 25524005
57732	6.3mm	1/4	.157-.236	.669	Chry 4370132, GM 14070914
57735	6.3mm	1/4	.157-.236	.669	Chry 6500911, GM 14063981, GM-CPC 15506827, GM- T&B 15506921, Ford/Mazda KA01500Z1, Ford N803043S
57736	6.3mm	1/4	.157-.394	.512	GM 20452072, Ford N803862S
57737	6.3mm	1/4	.157-.394	.669	AMC 8934201631, AMC 8934201835
57741	6.3mm	1/4	.315-.472	.661	Chry 4370138, Ford N804675S
57747	6.6mm	9/32	.098-.197	.512	GM 20421672
57748	6.6mm	9/32	.098-.197	.709	GM 20433026, VW 175-853-577A
57752	7.0mm	5/16	.098-.236	.709	GM 1019689, GM-CPC 10087278



PRG510A-Plus

Designed for high production and trouble-free operation. This pneumatic rivet tool is ideal for a variety of applications. Comes with everything needed to set 1/8" thru 3/16" rivet sizes.



PRG544

Heavy duty air hydraulic rivet tool designed to help increase productivity and avoid downtime. It is the leading choice for high volume, trouble-free operations. Sets a variety of rivet styles and materials up to 1/4" and has hardened steel jaws. Tool comes ready to set 1/4" rivets and includes a 3/16" conversion kit.

POWER TOOL/RIVET GUIDE

TOOL	RIVET MATERIAL		RIVET DIAMETER										
			OPEN-END RIVETS					CLOSED-END SEALING RIVETS*			T-RIVETS*		
			3/32	1/8	5/32	3/16	1/4	1/8	5/32	3/16	1/4	3/16	1/4
PRG510A-PLUS & PRG544	Rivet	Mandrel											
	Alum.	Alum.	• •	• •	• •	• •	•	• •	• •	•			
	Alum.	Steel	• •	• •	• •	• •	•	• •	•	•	•	•	•
	Steel	Steel	• •	• •	• •	•	•	•	•	•	•		
	St'less	St'less		• •	•	•		•	•	•			
	St'less	Steel		• •	•	•							

● PRG510A-Plus equipped to set 1/8" rivets. All other sizes require conversion nosepieces (included).

● PRG544 equipped to set 1/4" rivets. All other sizes require conversion parts (included).

(*) Nosepieces to be ordered separately

POP RIVET TOOL INTERCHANGEABLE NOSEPIECES

TOOL	RIVET DIAMETER					
	3/32	1/8	5/32	3/16	1/4	1/4 T-Rivet
PRG510A-Plus	PRN314	PRN414	PRN514	PRN614	—	—
PRG544	PRN314	PRN414	PRN514	PRN614	PRN811	PRN825

REPLACEMENT JAWS

REPLACEMENT JAWS PART NO.	FOR USE WITH TOOL MODEL NO.	RIVET DIAMETER
PRG540-46	PRG544	Up to 3/16"
PRG540-44	PRG544	1/4"
PRG402-8A	PRG510A-Plus	Up to 3/16"

60930-KIT

POPSet[®] Plastic Rivet Tool

- One stroke setting tool (60930)
- Designed to set POP plastic rivets up to 5/16"
- Never need to change nosepiece
- Supplied as a kit with 100 of the most popular plastic rivets



PS15-KIT

POPSet[®] Rivet Tool Kit

- Professional plier style hand tool (PS15-CS)
- Designed to set Aluminum rivets up to 3/16" and Steel up to 5/32"
- Supplied with nosepieces and nosepiece wrench
- Supplied as a 265 piece kit with wide assortment of 8 rivet types



PS10-BL

POPSet[®] DIY Hand Plier Rivet Tool

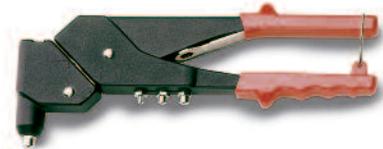
- Sets Aluminum rivets up to 3/16" (4.8mm)
- Contoured handle grips
- Robust construction
- Supplied with 4 nosepieces and wrench



PS15-CS

POPSet[®] Professional Hand Plier

- Sets Aluminum rivets up to 3/16" (4.8mm)
- Professional grade
- Contoured handle grips
- Rivet retaining handle
- Robust construction
- Supplied with 4 nosepieces and wrench



61946

Swivelhead Rivet Tool

- Rotates full 360° for easy access to any application
- Includes 3/32, 1/8, 5/32 and 3/16 nosepieces and wrench
- All steel construction for durability



PS25

POPSet[®] Heavy Duty Lazy Tong Rivet Tool

- Heavy duty grade
- Sets all rivets up to 1/4" (6.4mm) including high strength
- Supplied with 5 nosepieces and wrench
- Linkage system for improved mechanical advantage

PS45

POPSet[®] Heavy Duty Lever Rivet Tool

- Telescopic levered high capacity tool
- Compact non-extended position
- Heavy duty grade
- Sets all rivets up to 1/4" (6.4mm) including high strength
- Integral removable mandrel collector
- Supplied with 5 nosepieces and wrench



MANUAL TOOL & RIVET GUIDE

TOOL	RIVET MATERIAL		RIVET DIAMETER				TOOL	RIVET MATERIAL		RIVET DIAMETER			
	Rivet	Mandrel	3/32	1/8	5/32	3/16		Rivet	Mandrel	1/8	5/32	3/16	1/4
PS10-BL & PS15-CS	Alum.	Alum.	●	● ●	● ●	● ●	PS25 & PS45	Alum.	Alum.	● ●	● ●	● ●	● ●
	Alum.	Steel	●	● ●	● ●	●		Alum.	Steel	● ●	● ●	● ●	● ●
	Steel	Steel	●	● ●	● ●			Steel	Steel	● ●	● ●	● ●	● ●
	St'less	St'less		● ●	● ●			St'less	St'less	● ●	● ●	● ●	● ●
	St'less	Steel		●				St'less	Steel	●	●	●	
	T-Rivets							T-Rivets				●	●

POP RIVET TOOL INTERCHANGEABLE NOSEPIECES

POP Rivet Tools are furnished with nosepieces to set the most frequently used range of rivet sizes (see tool descriptions on page 22). To order additional nosepieces for other requirements — rivet sizes and types — use the chart below.



Nosepieces

TOOL	RIVET DIAMETER					
	3/32	1/8	5/32	3/16	1/4	1/4 T-Rivet
PS15-CS	DPM400-A08	DPM400-B08	DPM400-C08	DPM400-D08	—	—
PS25 & PS45	—	DPM400-B10	DPM400-C10	DPM400-D10	DPM400-F10	DPM400-FT0

REPLACEMENT JAWS

REPLACEMENT JAWS PART NO.	FOR USE WITH TOOL MODEL NO.	RIVET DIAMETER
DPM400-084	PS15-CS	Up to 3/16"
FAN400-020	PS25 & PS45	All



Countersunk Drill
(P/N 60928)

Jaws

POP NUT® Blind Rivet Nuts and Tools



POP NUT Inserts are designed for use in any sheet metal application. They allow the do-it-yourselfer, as well as the automotive

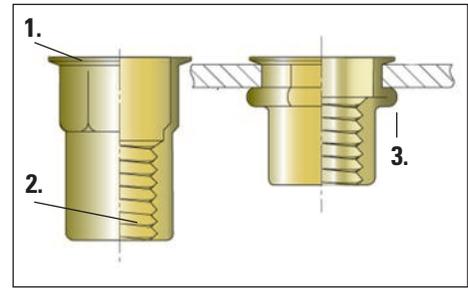
professional, to use bolts and machine screws in place of weaker sheet metal screws even when you can get to only one side of the work.

POP NUT Inserts are knurled to keep them from spinning in the hole. When forced into the hole and set in place, the knurl engages the parent material providing high resistance to spinning due to over-torque or cross threading. The "bubble" of material over the backside means that the insert will not pull through; even

when used in thin material. POP NUT Inserts are made of zinc-plated steel to provide strong, corrosion-resistant threads. Two different grip ranges are available to accommodate most applications. When installed, the low profile head is nearly flush so no countersinking is necessary.

POP NUT Inserts can be used to attach luggage racks, mud flaps, side moldings, rear window louvers, roof racks, ladders, grab bars, truck bed hand rails, wind deflection screens, custom ground effects, almost any accessory to sheet material.

POP NUT Inserts are stronger and more reliable than sheet metal screws and allow more flexibility in assembly and dis-assembly.



1. Low profile head means the insert is nearly flush. No countersinking necessary.
2. Axial knurl keeps the insert from spinning in the hole.
3. "Bubble" of material provides high resistance to insert pull out.

Ordering Information

PART NO.	THREAD SIZE	DRILL SIZE	GRIP RANGE	PIECES PER BOX
57821	6-32	17/64	.020-.080	50
57822	8-32	17/64	.020-.080	50
57823	10-24	19/64	.020-.130	50
57824	10-32	19/64	.020-.130	50
57825	1/4-20	25/64	.027-.165	40
57827	5/16-18	17/32	.027-.150	25
57829	3/8-16	17/32	.027-.150	20
57836	6-32	17/64	.080-.130	50
57837	8-32	17/64	.080-.130	50
57838	10-24	19/64	.130-.225	50
57839	10-32	19/64	.130-.225	50
57840	1/4-20	25/64	.165-.260	40
57842	5/16-18	17/32	.150-.312	25
57844	3/8-16	17/32	.150-.312	20
57832	M5x0.8	19/64	0.5-3.3mm	50
57833	M6x1	25/64	0.7-4.2mm	40
57834	M8x1.25	17/32	0.7-3.8mm	25
57835	M10x1.5	17/32	0.7-3.8mm	20

POP NUT® Rivet Nut Tool and Kit

The robust POP NUT tool is offered in both Inch (PNT-110-I) and Metric (PNT-110-M). The tool has a setting capacity up to ¼" (M6) steel and 10-32 (M5) stainless steel. Also supplied in a kit, the PNT-110-I-KIT (Inch Kit) and the PNT-110-M-KIT (Metric Kit) contains 190 assorted rivet nuts and includes mandrels and nosepieces for each size.



POP NUT® PNT110

Professional Hand Plier Tool

- Robust aluminum casting and steel construction
- Contoured handle grips for comfort
- Quick-change mandrel and nosepiece design
- Supplied as a kit with Mandrels and Nosepieces
- Length: 9.6" (245 mm)
- Weight: 1.5 lbs. (0.68 kg)



Part Number	Thread Sizes	Nosepiece Type
PNT110-I	6-32, 8-32, 10-24, 10-32 & 1/4-20	Flat
PNT110-M	M3, M4, M5 & M6	Flat

POP NUT® PNT310

Lever Tool

- Lever tool for optimum pulling force
- Professional standard, heavy duty steel construction
- Supplied as a kit with Mandrels and Nosepieces
- Quick-change mandrel and nosepiece design
- Quick-reverse spin arm for fast withdrawal from set inserts
- Stroke adjustment with scale display
- Length: 22" (560 mm)
- Weight: 5.4 lbs. (3.45 kg)



Part Number	Thread Sizes	Nosepiece Type
PNT310-I	10-24, 10-32, 1/4-20, 5/16-18 & 3/8-16	Flat
PNT310-M	M5, M6, M8 & M10	Flat

Powerful Brands. Breakthrough Solutions.

At STANLEY, Engineered Fastening we believe in seeking ways to serve our customers better. We create the future by anticipating our customers needs. Through diversifying our product lines, creating unique assembly technologies and offering a breadth of service to meet the demands of industry worldwide, STANLEY Engineered Fastening provides technological solutions to over 100 different industries.



Avdel®

Avdel® has been producing assembly systems since 1936 and offers a comprehensive range of fasteners and tooling. [More Info>](#)



POP®

From 2mm micro rivets to 1/4" structural rivets, POP blind rivets meet the needs of multiple markets. [More Info>](#)



Dodge®

With a focus on high-quality threaded inserts for plastics products, Dodge has been a leader in the fastening market since the 1950s. [More Info>](#)



STANLEY Assembly Technologies

STANLEY Assembly Technologies supplies production solutions to the global assembly market. [More Info>](#)



Gripco®

Gripco® has been providing quality nut and threaded assembled products since 1904. [More Info>](#)



Spiralock®

Spiralock is a technologically superior fastening system ideally suited for threaded joint applications subjected to heavy shock and vibration. [More Info>](#)



Heli-Coil®

Based on a long history that began in the aerospace industry, Heli-Coil offers a vast range of high-quality. [More Info>](#)



Tucker®

A one-sided drawn-arc welding process is the foundation of the Tucker No-Hole assembly solution. [More Info>](#)



iForm®

iForm® continues a proud heritage since 1969 and represents over 40 years of creative threaded fastener application engineering. [More Info>](#)

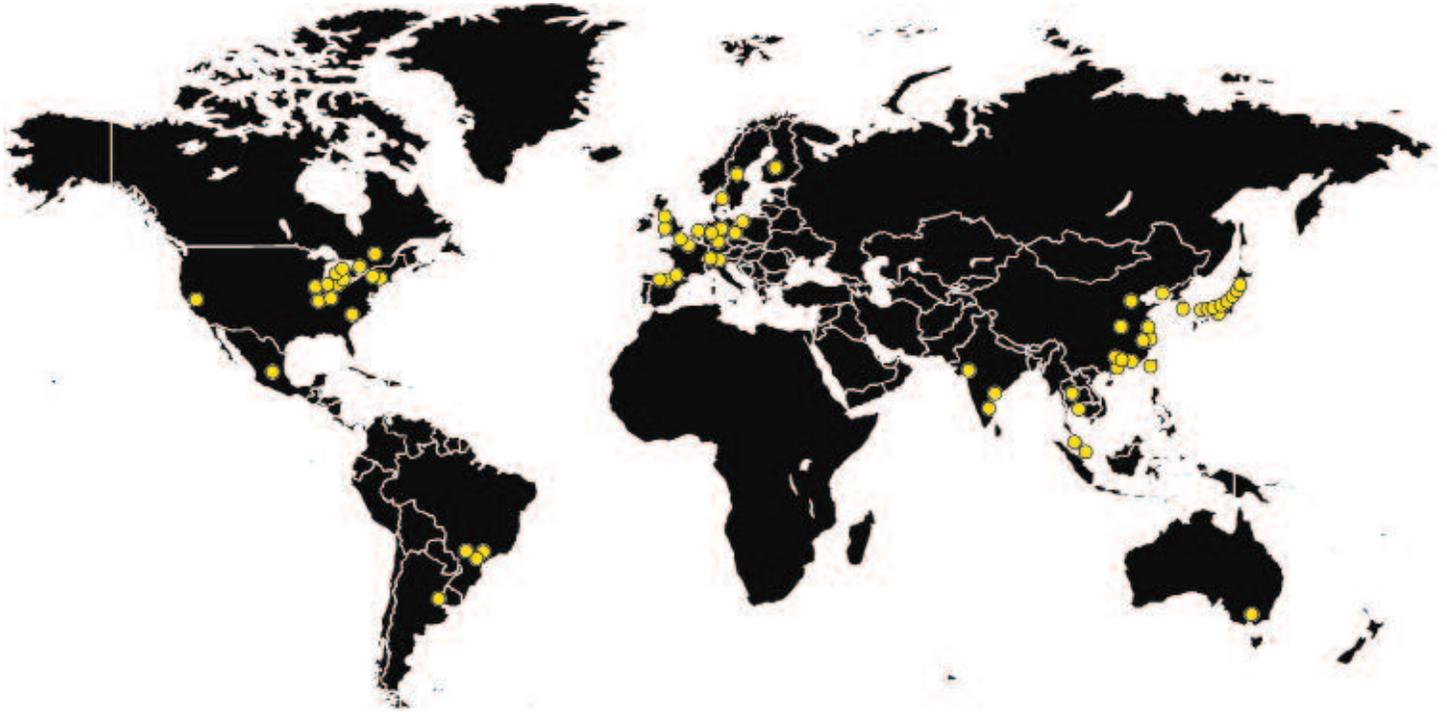


Warren®

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