

## INSTRUCTIONS FOR USING KATO TANGLESS® COILTHREAD® INSERT TOOLS

THE FOLLOWING INSTRUCTIONS ARE APPLICABLE TO THE  
KATO TANGLESS PREWINDER HAND INSTALLATION TOOL (2KPH Series)

Figure 2

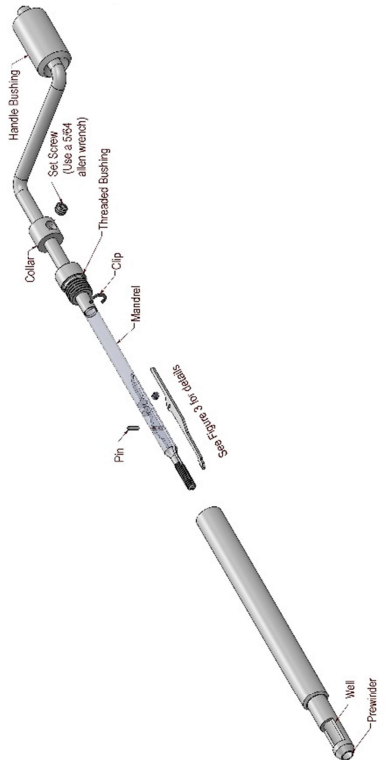
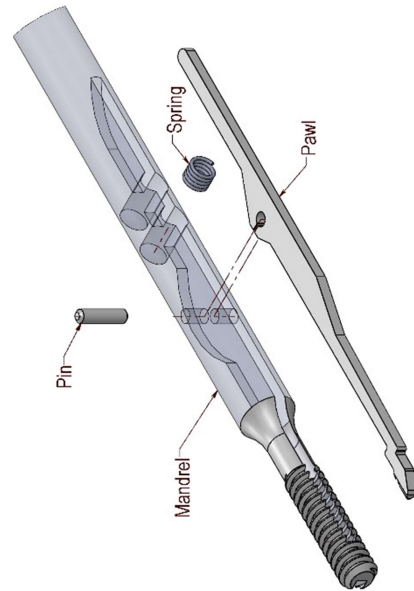
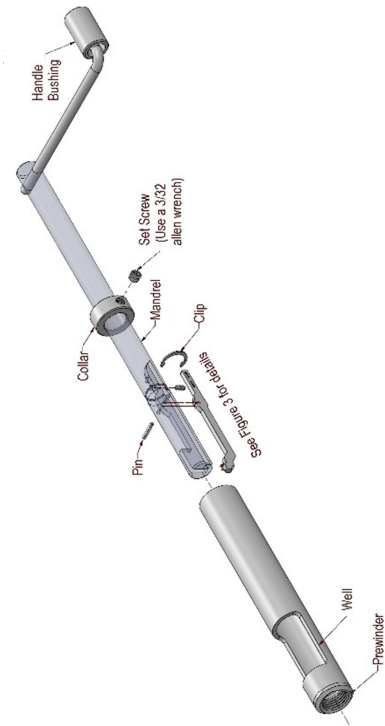
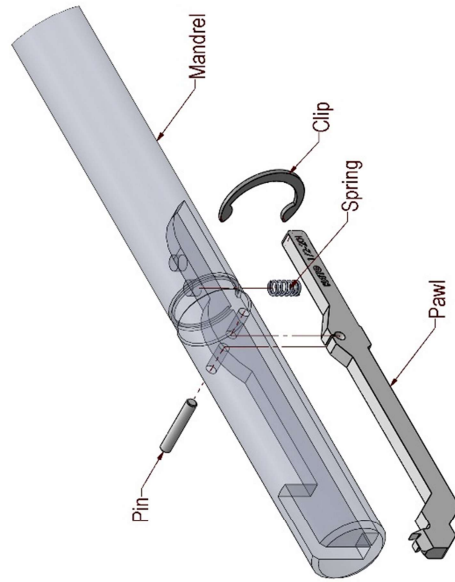
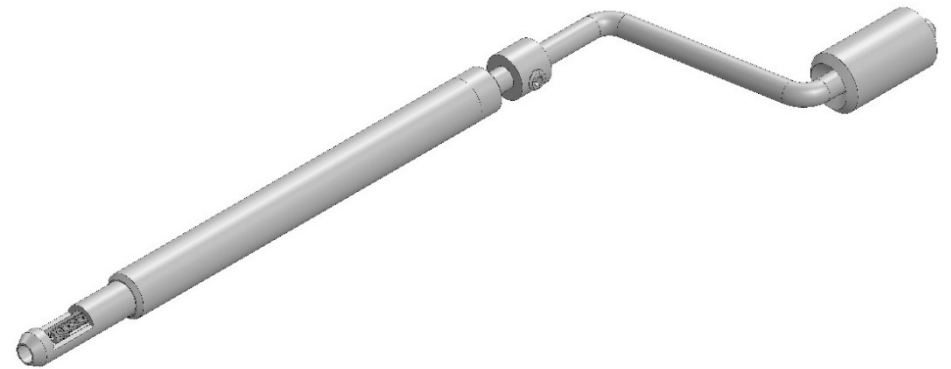
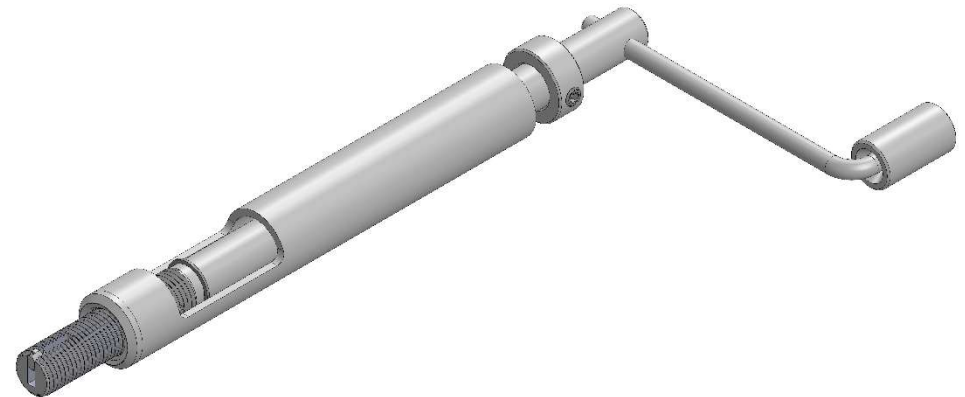


Figure 1



(Style 1)



(Style 2)

## BEFORE YOU BEGIN PLEASE REVIEW:

- Proper hole preparation procedure.
- A step by step instructional video can be found in the KATOpedia section of the KATO website [www.katofastening.com](http://www.katofastening.com).

### DEPTH ADJUSTMENT

1. Loosen the Collar (by loosening the set screw with a Allen wrench) and slide it towards the back of the Mandrel.
2. Pull the Mandrel towards the back of the Prewinder Body and place an insert into the well. *No need to orient the insert because Tangless CoilThread inserts are bi-directional.*
3. Slide the Mandrel forward until it reaches the insert, then rotate the mandrel Clockwise until the pawl engages the insert's drive notch (do not push down on the Mandrel). Continue to rotate the Mandrel until the tip of the insert begins to exit the Prewinder (no more than a coil).
4. Place the tool perpendicular to the tapped hole. Rotate the Mandrel clockwise, slowly, until the insert exits the Prewinder. Continue rotating until the insert is installed into the tapped hole to the correct depth (3/4 - 1 1/2 threads below the surface for a hole with a countersink; 1/4 - 1/2 threads below the surface for a hole without a countersink).
5. Slide the Collar forward until it is flush with the back of the Prewinder Body.
6. Hold the Collar against the Prewinder Body and tighten the set screw in the Collar. Do not overtighten set screw.
7. Rotate the Mandrel counterclockwise until it exits completely out of the installed insert.
8. Check installation for proper depth and readjust the stop Collar if necessary.

### INSERT INSTALLATION

9. Pull the Mandrel towards the back of the Prewinder Body and place an insert into the well.
10. Slide the mandrel forward until it reaches the insert, then rotate the Mandrel Clockwise until the pawl engages the insert's drive notch. Continue to rotate Mandrel until the tip of the insert begins to exit the Prewinder (no more than a coil).
11. Place the tool perpendicular to the tapped hole. Rotate the Mandrel clockwise until the Collar reaches the back of the Prewinder Body. The insert is now installed.  
**CAUTION: Avoid excessive wobble of the tool as this may damage the Mandrel.**
12. Rotate the Mandrel counterclockwise until it exits completely out of the installed insert.

**DO NOT APPLY ANY DOWNWARD PRESSURE OR TRY TO FORCE THE INSERT INTO THE HOLE, LET THE WEIGHT OF THE TOOL DO THE WORK. FORCING THE INSERT INTO THE TAPPED HOLE MAY RESULT IN INSTALLATION FAILURE AND CAUSE DAMAGE TO THE TOOL AND/OR WORKPIECE.**

### TOOL MAINTENANCE

- Regularly inspect the tool for wear.
- Keep the pawl hook and slot clean and free of debris.

### SAFETY

Always wear eye protection when working with KATO tools.



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### PARTS REPLACEMENT

Replacement pawl, and pawl kits (which includes one pawl, two pins, and two springs) are available from KATO (see parts list below).

Follow the procedure below to replace a damaged, or worn, pawl.

1. Loosen the collar and slide away from the prewinder body (for sizes 5/16 and 3/8 remove clip and skip step 3).
2. Thread the bushing out of the prewinder body (2-56 through 1/4" and M2.5 through M6 only).
3. Slide the prewinder body off the threaded mandrel.
4. Push out the cross pin. Be careful not to lose the pin.
5. Remove the pawl from the mandrel slot.
6. Remove the compression spring from the mandrel. Be careful not to lose it.

To reassemble:

7. Insert the spring into the mandrel. The spring goes into the hole closest to the pin.
8. Insert the pawl into the mandrel slot.
9. Line up the pin holes (pawl and mandrel) and press in the pin.
10. Check for spring action and free movement of the pawl in the mandrel slot.
11. Thread the mandrel back into the prewinder.
12. Slide the prewinder body back over the mandrel.
13. Thread the bushing into the prewinder body and hand-tighten (for sizes 5/16 and 3/8 press clip on mandrel).

### FOR ASSISTANCE CONTACT THE KATO TECH GROUP AT

Phone: (757) 873-8980

Email: [support@katofastening.com](mailto:support@katofastening.com)

or, visit us online at [www.katofastening.com](http://www.katofastening.com)

## PARTS LIST

REPLACEMENT PARTS	KATO PART NUMBER
Pawl	2KIPX-XX
Pawl Kit (includes 1 pin and 2 Springs)	2KIPX-XXK

**X-XX** Signifies Size Designation & Thread Type. For example, 2KIPC-02

### TIPS & TRICKS

Having difficulty getting the insert installed? Try one or more of these helpful tips:

- Dipping the insert in Alcohol or other non-residual solution will provide lubrication and may help facilitate installation. **USING ALCOHOL ON LOCKING INSERTS WILL CAUSE THE RED DYE TO BLEED**