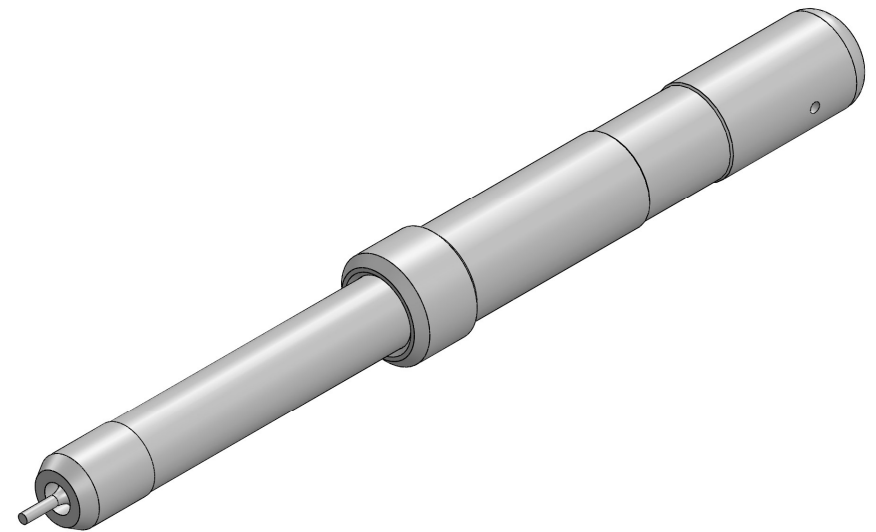


INSTRUCTIONS FOR USING KATO TANGED COILTHREAD® INSERT TOOLS

THE FOLLOWING INSTRUCTIONS ARE APPLICABLE TO THE
KATO TANG BREAK-OFF TOOL (KTBT Series)



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PARTS LIST

REPLACEMENT PARTS	KATO PART NUMBER
Replacement Punch	KTBT-XXRP
Replacement Punch for 2-1/2 & 3 Dia inserts	KTBT-XXRP-30
X-XX Signifies Thread Type & Size Designation. For example, KTBT-06RP	

BEFORE YOU BEGIN PLEASE REVIEW:

- Proper hole preparation procedures.
- Installation depths in accordance with NASM33537.

DIRECTIONS

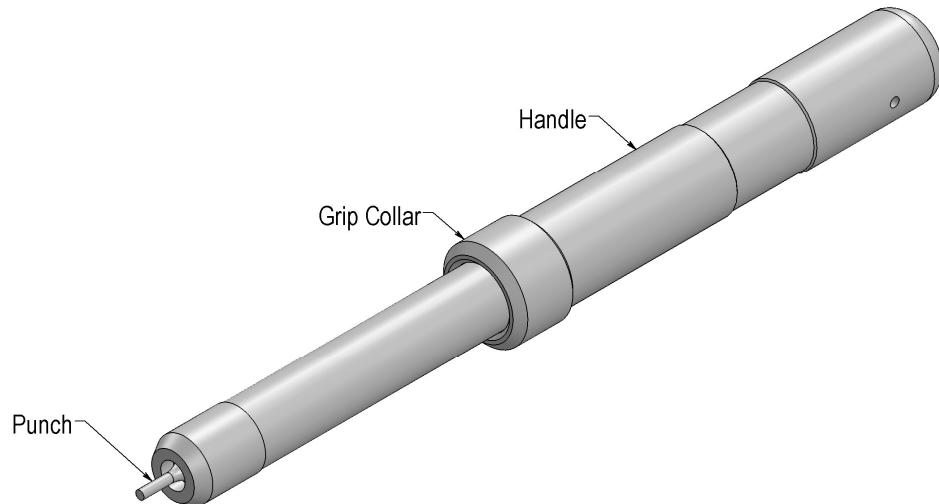
After insert installation, KATO recommends the tang be removed prior to screw assembly to prevent interference. In addition, this allows the male fastener to enter from either end of the insert.

1. Insert the Punch end of the tool into the installed insert so that the Punch is in contact with the Tang.
2. Grasp the handle of the tool and press down on the barrel firmly. The spring-loaded Punch delivers a sharp, uniform blow that cleanly breaks off the Tang.
3. Remove tang from the bottom of the hole (blind holes).

NOTES

- The KTBT series is designed to remove Tangs from the same direction as insert installation.
- For insert sizes above 1/2" or M12 use Needle Nose Pliers to remove the Tang.
- KATO Tang Break-off Tools are designed to work with 1, 1-1/2, and 2 diameter length inserts installed to the proper installation 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)
- For 2-1/2 and 3 diameter length inserts, a longer punch will be necessary (add a "-30" suffix to the tang break-off tool part number).

**TO ELIMINATE THE TANG BREAK-OFF PROCESS COMPLETELY
SWITCH TO KATO TANGLESS INSERTS!**



TOOL MAINTENANCE

Tools should be periodically inspected for damage or wear. Tools should be kept clean so that foreign objects and debris (chips, oils, and/or dirt) will not clog the components, preventing the Punch from fully extending out from the housing.

PARTS REPLACEMENT

Follow the procedures below to replace a worn/broken Punch:

1. Loosen and remove the Grip Collar with caution as internal components are under compression.
2. Slide out the spring from the front section of the tool.
3. Separate the used Punch from the spring.
4. Insert the new Punch into the spring.

To Reassemble:

5. Insert the spring assembly into the front section (Punch first).
6. Slide the front section into the tool handle.
7. Tighten the Grip Collar.

SAFETY

Always wear eye protection when working with KATO Tools.

FOR ASSISTANCE CONTACT THE KATO TECH GROUP AT

Phone (757) 873-8980

Email: support@katofastening.com

or, visit us online www.katofastening.com



TIPS & TRICKS

Having difficulty breaking the tang off? Try one or more of these helpful tips:

- Check the installation depth of the insert to ensure the depth is in accordance with NAMS33537 (1/4 - 1/2 threads below surface with no countersink or 3/4 - 1 1/2 threads below the surface with a counter sink).
- Center the punch on the tang to ensure solid surface contact between the punch and the tang.
- Hold the punch perpendicular to the tang to ensure full impact is direct.