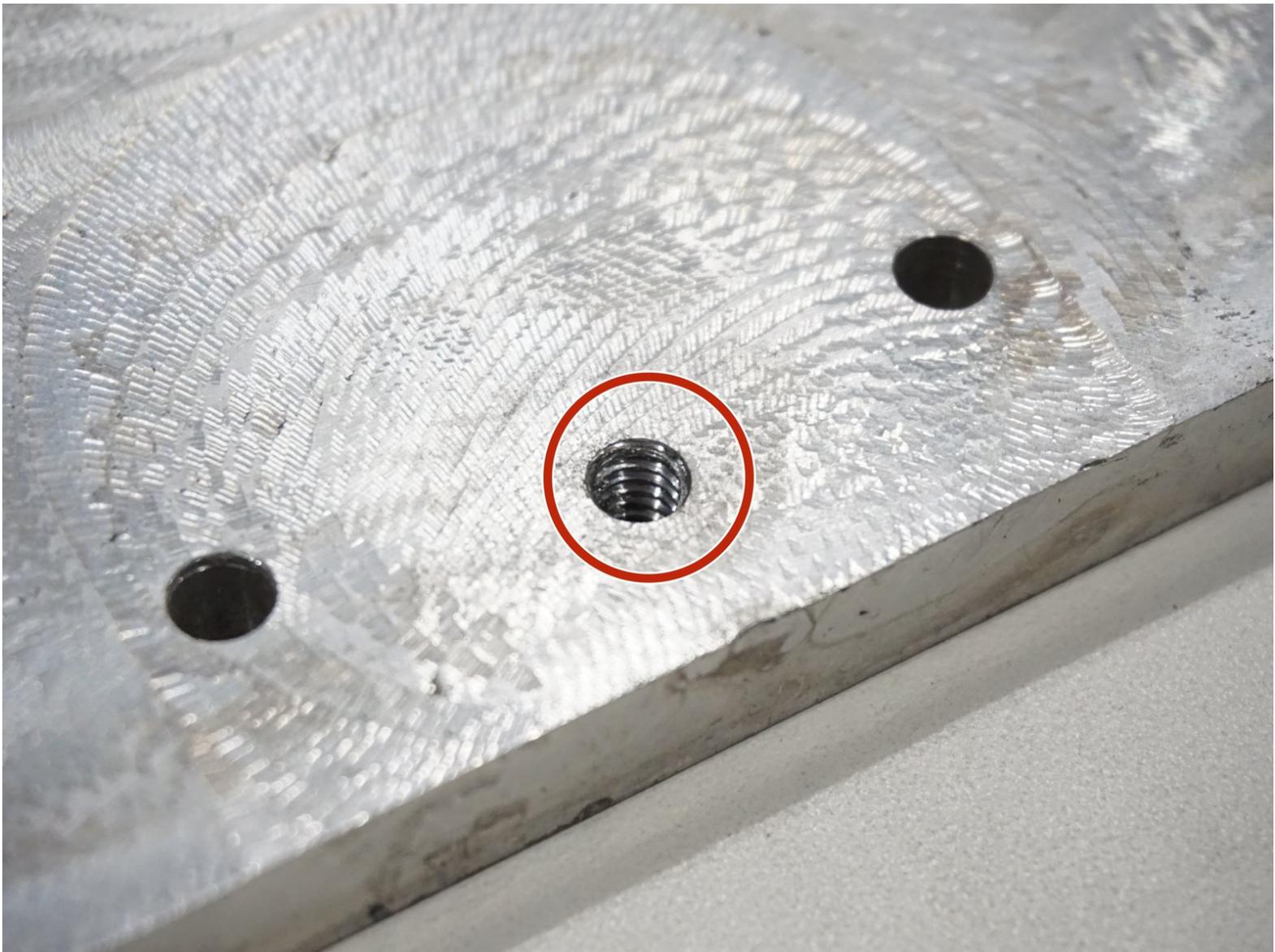




# How to Fix a Cross Threaded or Stripped Hole in Aluminum

A free repair guide for users who have stripped the threads in a hole of an aluminum part and need to re-tap it.

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## INTRODUCTION

How to re-thread a stripped or mis-threaded aluminum hole.

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### TOOLS:

- [Cut Tap](#) (1)
  - [Tap Handle](#) (1)
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## Step 1 — How to Fix a Cross Threaded or Stripped Hole in Aluminum



- Determine which hole has the cross threaded or stripped screws.
- Determine the size of the current thread. Threads are called out by the outer diameter, a dash, and then the thread count. For example, the tap shown is 1/4"-20".
  - ⓘ The hole's outer diameter can be determined by measuring the width of the screw or bolt that goes into the hole.
  - ⓘ The thread count can be determined by counting the number of threads in one inch of screw length.
- Select the appropriate tap size.
  - ⚠ Taps are sharp. Do not handle the teeth.
- Install the tap into the tap handle (See photo).

## Step 2



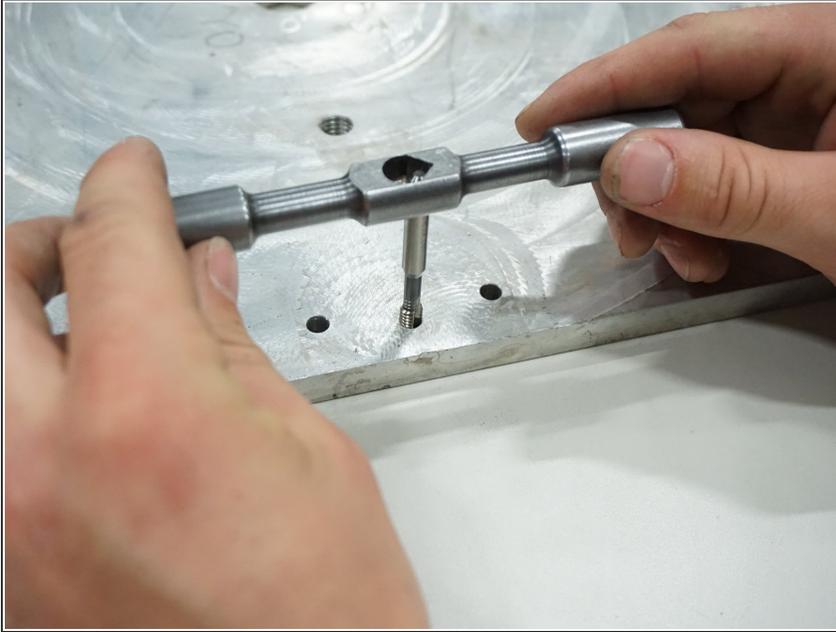
- Align the tap attached to the tap handle over the cross threaded or stripped hole.
- For right hand screws, insert tap into tap hole as you slowly rotate the tap handle clockwise.
- ⓘ 99 percent of of holes, screws, and bolts are right hand screws. If you know your hole is a left hand thread, rotate counterclockwise instead of clockwise.

## Step 3



- Rotate the tap handle clockwise two full rotations, then counterclockwise 1/4 of a turn.

## Step 4



- Repeat step three until you cannot easily rotate the the tap handle clockwise anymore.
- Rotate the tap handle counterclockwise until the tap is out of the part.

After re-tapping your miss threaded check to make sure the threads work by screwing in the bolt or screw the hole is intended for