

Fitting Threaded Inserts

I use threaded inserts in quite a few of my shop jigs and accessories. A good way to make sure the insert goes in straight is to use the chuck on a drill press.

Start by drilling an undersized pilot hole for the insert. Find a spare bolt that fits the insert, cut off the head, and mount it in the chuck. Next thread a nut and the insert on to the bolt, see drawing. Tighten the nut to make sure the insert is secured to the bolt.

Lower the drill, applying light pressure with the control arm while you rotate the chuck (clockwise) by hand.

When the insert is completely embedded, lock the spindle in place and back off the nut from the top of the insert. Then unlock the spindle and unthread the bolt from the insert while slowly releasing pressure on the control arm.

