

Document Information

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Vehicles affected: P14: 720S, 720S Spider

Location: Body BIW - Active Aero

Concern: Unable to achieve specified torque

Condition: Permanent

Diagnostic Trouble Codes

N/A

Measure

Care Point: There is always a risk of damaging the airbrake panel during the drilling procedure so extra attention is required to ensure the drill does not go through the panel.

If during installation of the airbrake panel you are unable to achieve the specified torque in one of the six fixings, please follow the steps below to correctly install a HeliCoil insert:

1. Clean the old threads in preparation for the insert
2. Drill out the old threads using a 6.2mm drill bit
3. Tap the hole using the HeliCoil Roughing tap
4. Run the HeliCoil Finishing tap
5. Clean threads of any excess material from the tapping process

Preparing and installing the HeliCoil insert

1. Slide the insert into the pre-coil insert tool

2. Rotate the tool handle to thread it through the insert until the notch in the tool contacts the tang of the insert
3. Continue rotating the handle to wind the insert into the threaded end of the pre-coil body
4. Using one hand, hold the insert tool squarely against the surface of the workpiece over the tapped hole. Rotate the handle of the insert tool to drive the insert through the pre-coil body and into the tapped hole in the housing
5. As the insert is installed, be sure to allow the pre-coil body to float as needed to allow the windings of the HeliCoil to align with the threads in the housing
6. After the insert is seated to the proper depth, unthread the installation tool

Parts Information

Please be informed that all the items below will be supplied by Technical Support once a Technical Request is created.

Insert Specification:

- BOLLHOFF Helicoil F106CN x 18 (Insert type F106, Material CN - Stainless steel, Insert Length 18mm)

Tool Specification:

- M6 HeliCoil Taps - Rough 060100R, Fine 060100P
- M6 HeliCoil Gauge 0601006
- HeliCoil Insert Tool - 01500106000

Warranty Information

Resolution Code to use for the Warranty Claim is found below, the total time that can be claimed to repair one thread is 0.45 hour. For any additional threads a 0.1 hour can be claim as an additional cost in the Work Package. Ensure the breakdown of the time and explanation is also recorded in the Work Package.

Location: DB - Body Panel and Closures

Function Group: AG - Active Aero

Sub Group: 03 - Rear Active Aero Panels

Part: 01 - Airbrake Panel Assy

Fault Group: A1 - Mechanical

Fault Code: 1H - Distorted

Cause: 2D - Material Defect

Rectification: 02 - Repair

MTI Updates Information

N/A

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