# Compressor cross-head guide bolt hole repairs with Full-Torque thread repair inserts

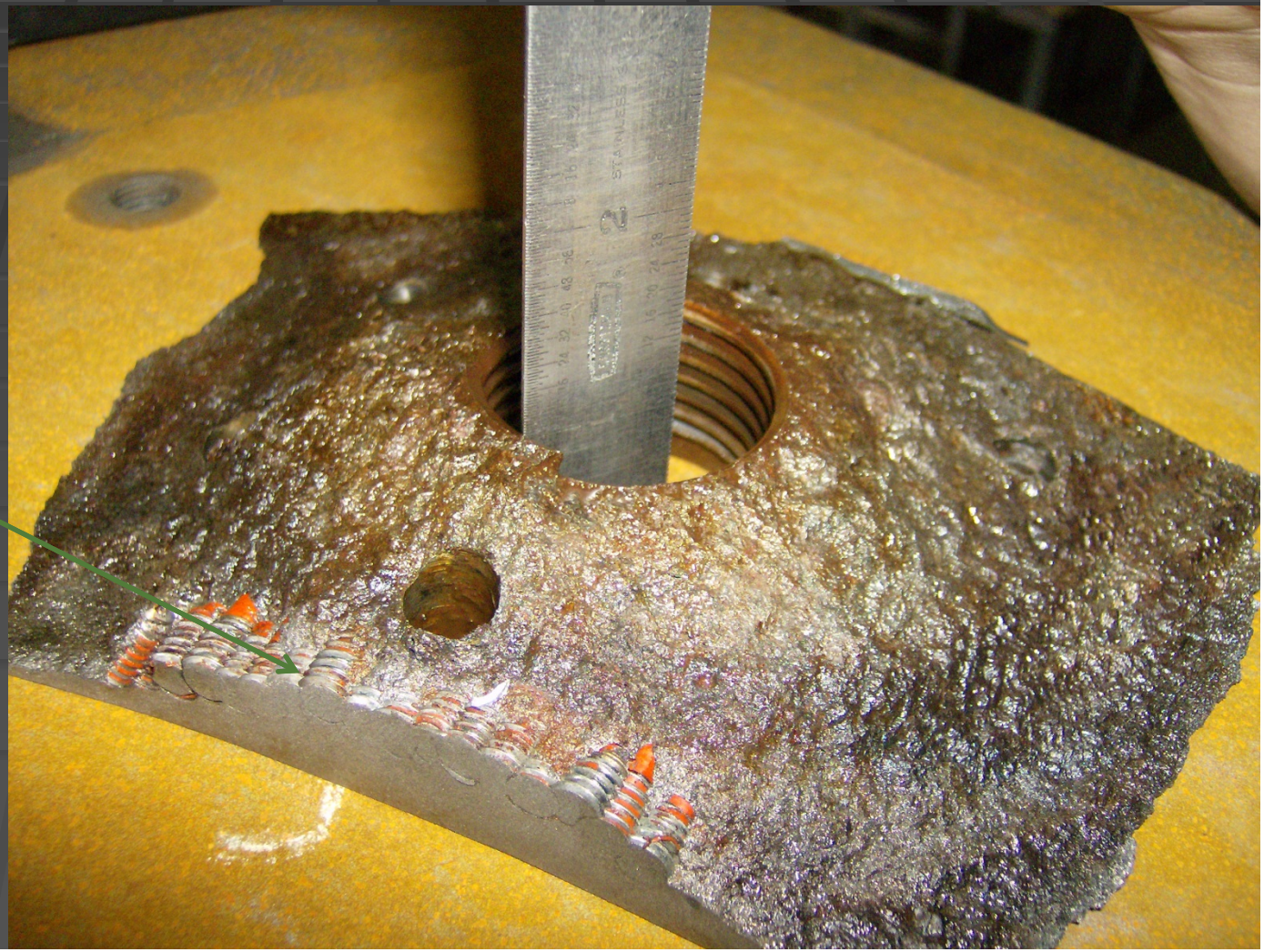
# Failed prior repair attempt

- Bolt hole pull-out due to poor stud design

# Multiple damaged bolt holes

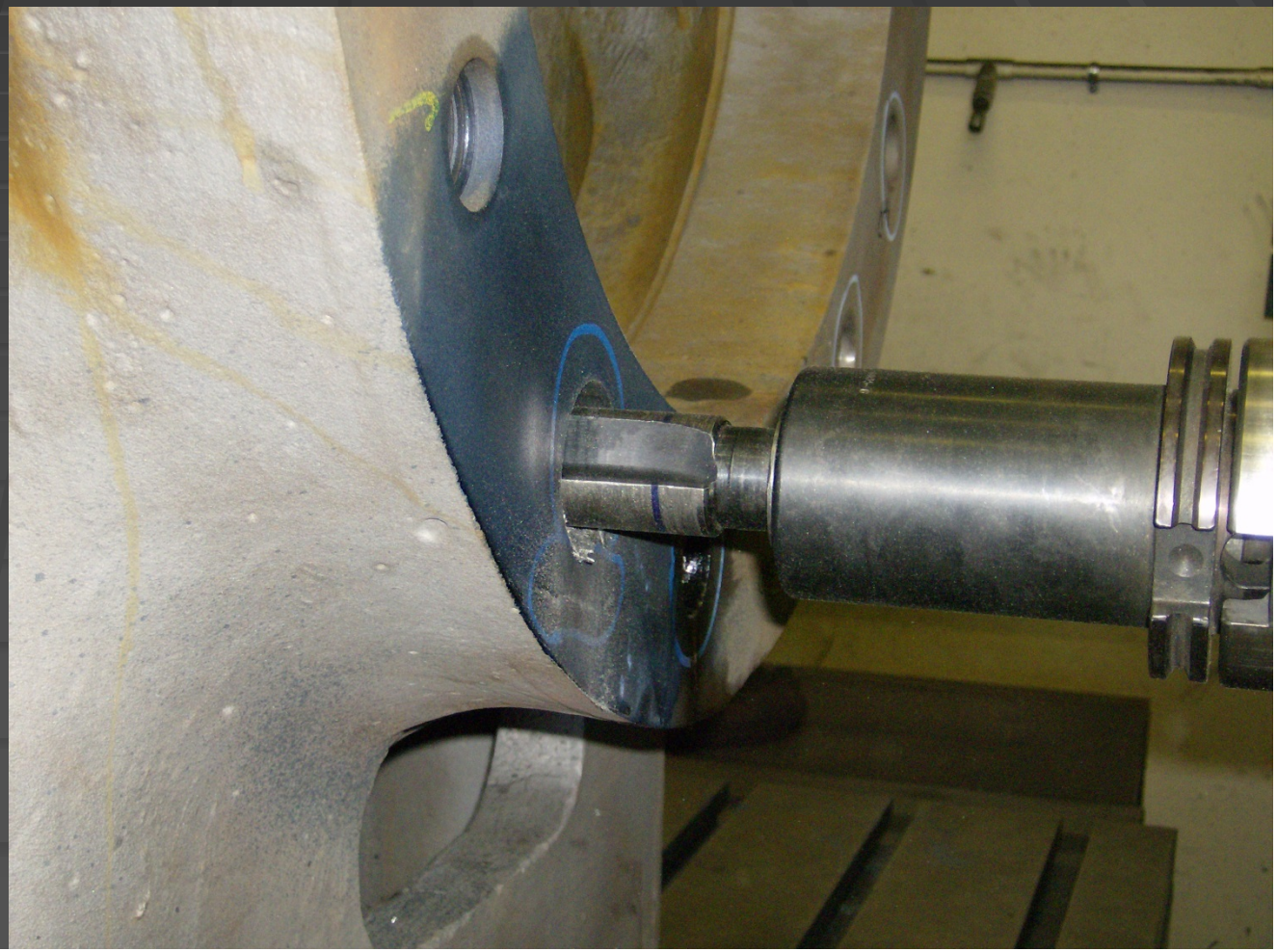
# Bottom view of pulled out piece of cast iron

- Old metal stitching attempt to his the crack with standard threaded pins



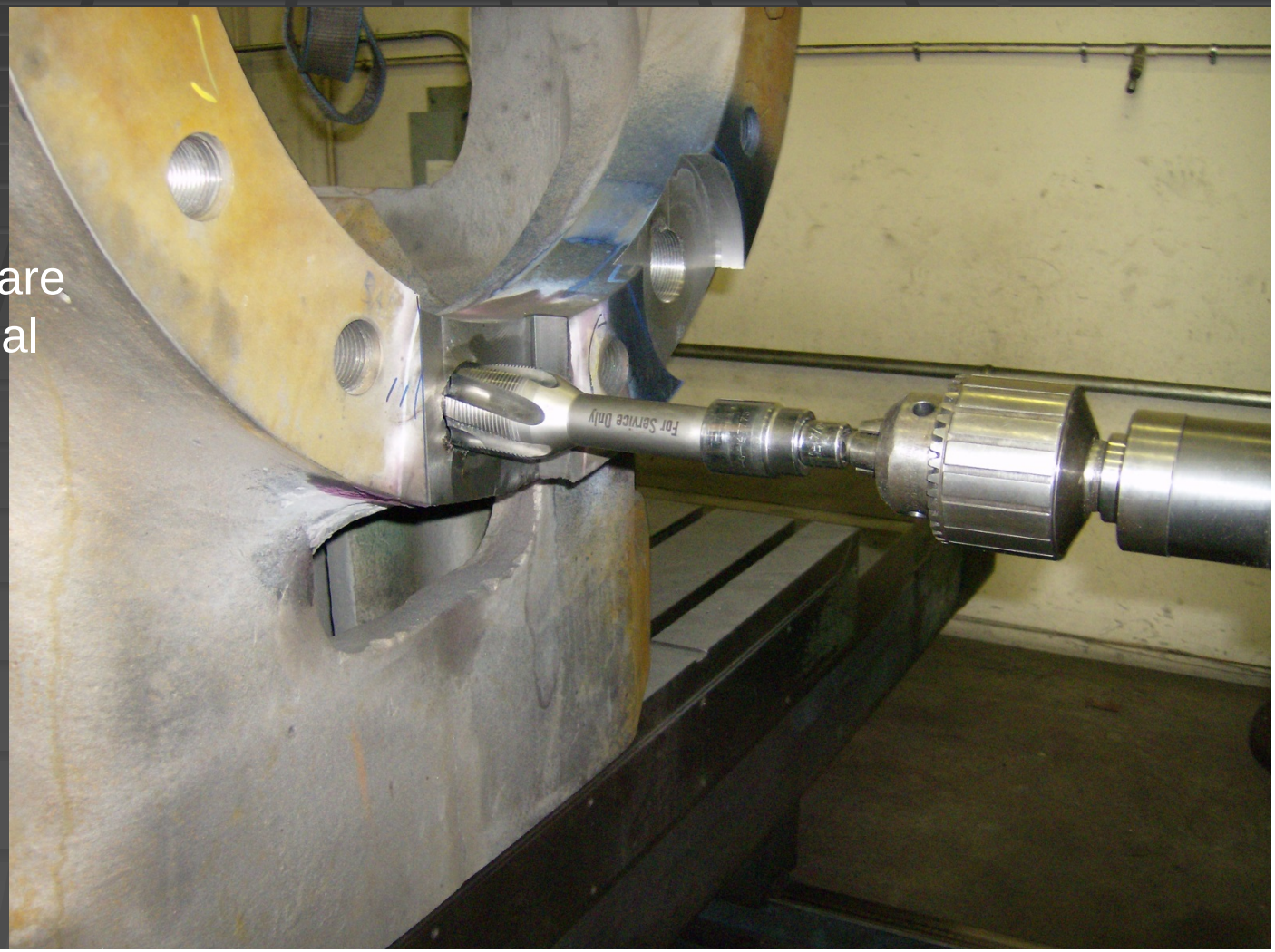
# Setting up the casting on our horizontal mill

# Drilling out the hole to the tap drill size for our Full-*Torque* thread repair inserts



# Pulled-out areas are milled to accept steel plates

- The drilled holes are tapped with special Full-Torque taps with Spiralhook threads

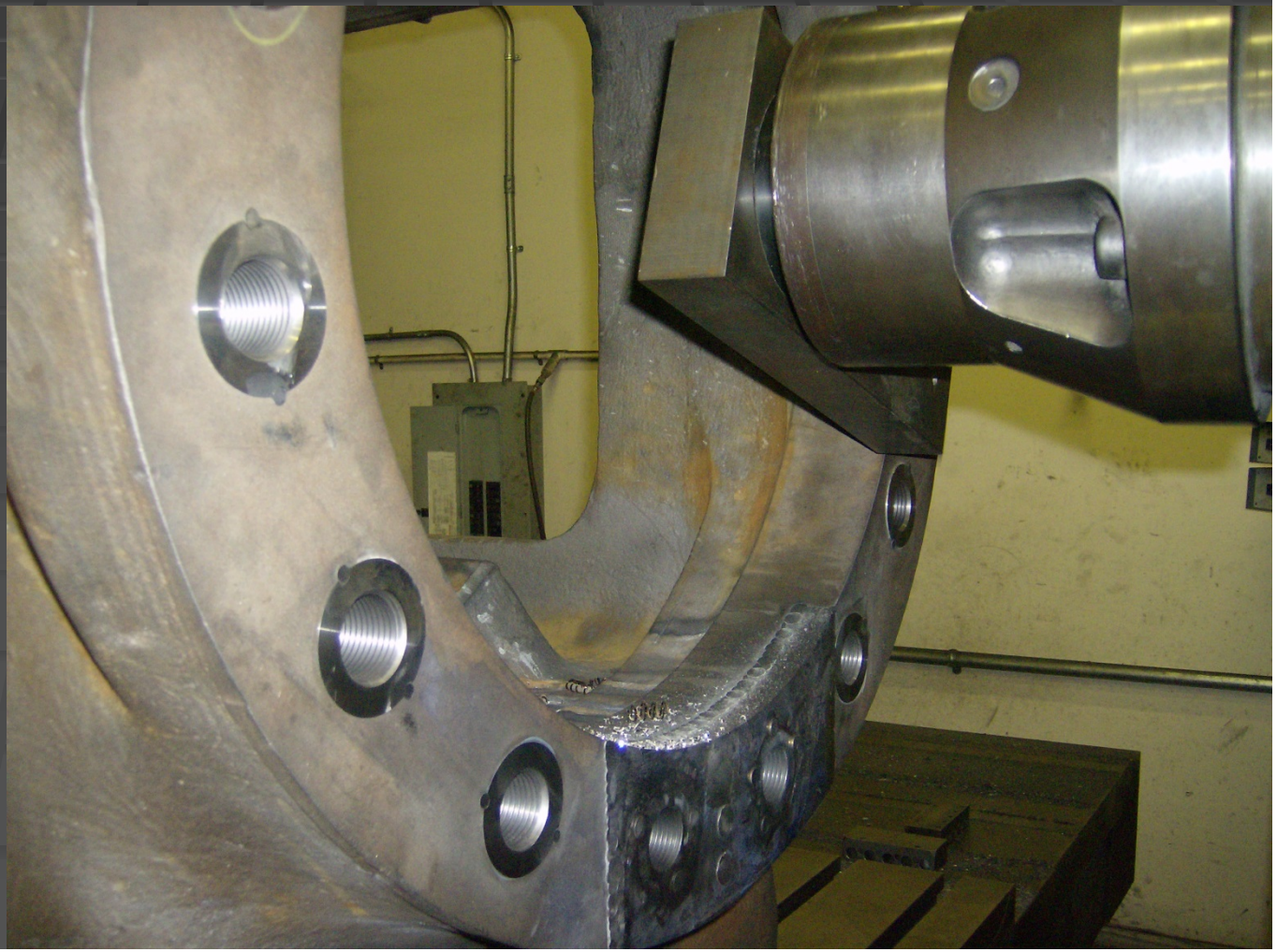


# Steel plates are fit into the milled-out areas

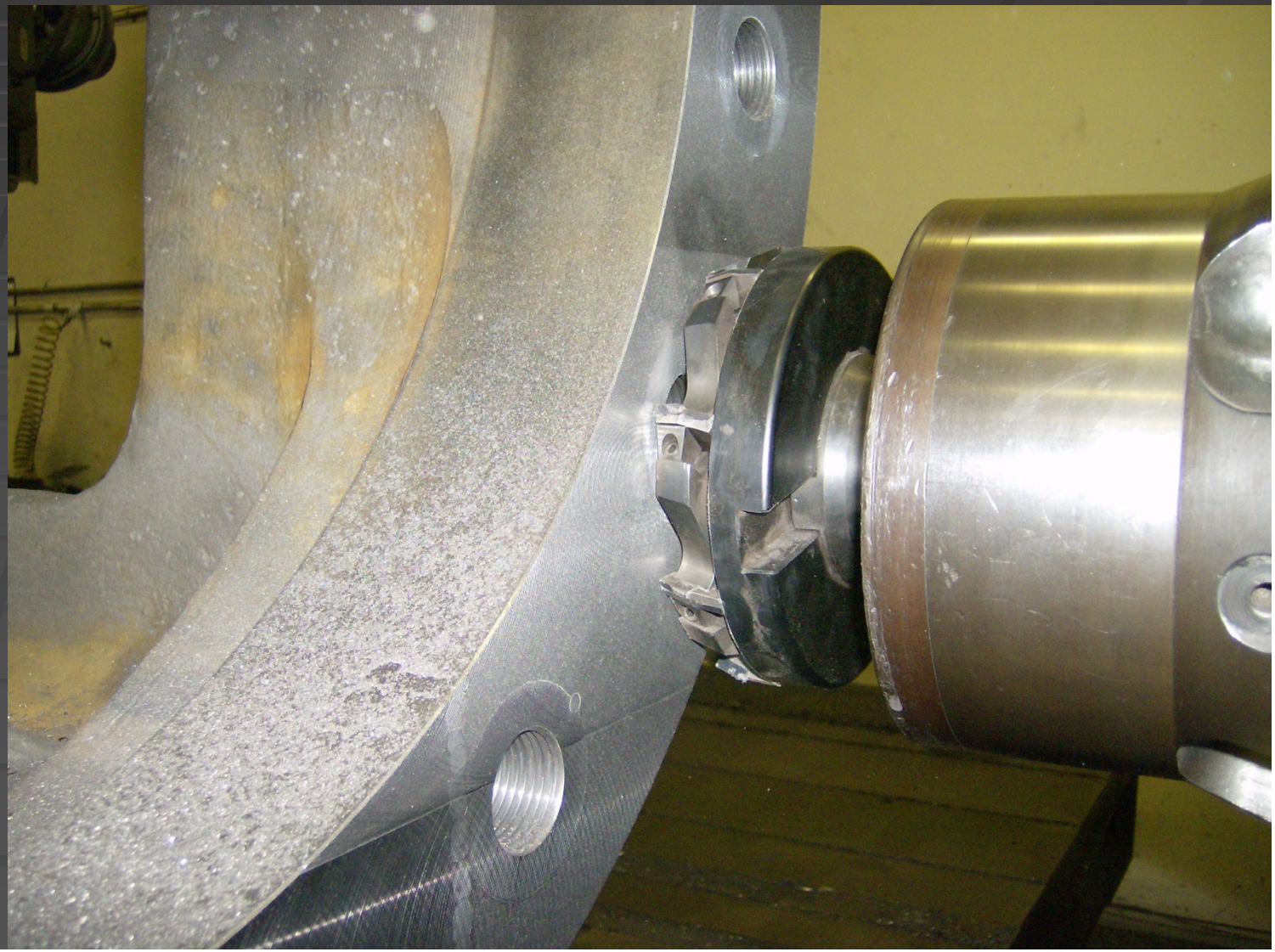
- Steel is used to add more strength to these high stress areas

# After the plates are stitched in to fill the voids the bore and face are machined

- Full-*Torque* inserts are installed to increase the strength of all of the bolt holes to make them stronger than the bolts



# Finish machining



# Completed repair is now stronger than new