GENERAL PROCEDURES

Weld Nut Repair — Stripped Weld Nut

1. Depower the system. For additional information, refer to Supplemental Restraint System (SRS) Depowering and Repowering in this section.
2. Remove the component from where the weld nut is to be repaired. Refer to the appropriate removal and installation procedure in this section.
3. Inspect the weld nut and surrounding area for repair.
   - If there is not enough clearance for a larger bolt stud to go through or a larger bolt head to turn, then a threaded insert will have to be installed. Follow the instructions with the thread insert repair kit.
4. If a 6 mm weld nut is stripped, drill out the hole using a letter ‘‘H’’ or 0.26 in (6.5 mm) drill bit. Then tap, using an 8 mm by 1.25 bit.
   - Do not oversize a 6 mm weld nut by more than 8 mm.
5. If an 8 mm weld nut is stripped, drill the hole using a letter ‘‘R’’ or 0.3990 in (9.75 mm) drill bit. Then tap, using a 10 mm by 1.50 bit.
   - Do not oversize an 8 mm weld nut by more than 10 mm.
6. Obtain the appropriate oversized screw.
7. Install the attaching screw(s) to the component.
8. Tighten the attaching screws to specification. For additional information, refer to Specifications in this section.