

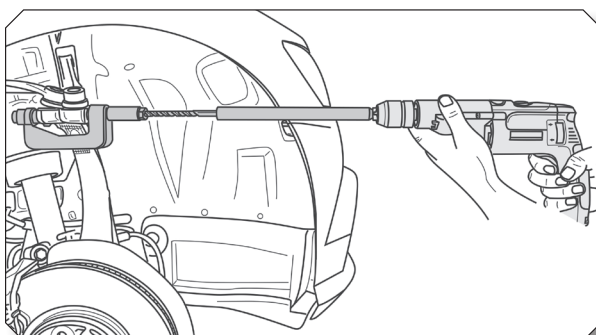


KL-0250-43 KB

Boring Tool Kit for Clamping Screws VW-AUDI



Operating instructions EN
⚠ Read and understand before use!



www.gedore-automotive.com



GEDORE Automotive GmbH

Breslauer Straße 41
78166 - Donaueschingen
Postfach 1329
78154 Donaueschingen - GERMANY

☎ +49 (0) 771 / 8 32 23-0
☎ +49 (0) 771 / 8 32 23-90
✉ info.gam@gedore.com
🌐 gedore-automotive.com

GEDORE TOOLS, INC.

Only for USA, Canada & Mexico / Sólo para EE.UU., Canadá y México
Seulement pour les USA, le Canada et le Mexique
7187 Bryhawke Circle, Suite 700
North Charleston, SC 29418, USA

☎ +1-843 / 225 50 15
☎ +1-843 / 225 50 20
✉ info@gedoretools.com
🌐 gedore.com

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EN

Manufacturer's address

GEDORE Automotive GmbH
Breslauer Straße 41 // 78166 Donaueschingen - GERMANY
☎ +49 (0)771/83223-71 // ✉ info.gam@gedore.com

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1. READ AND UNDERSTAND FOR YOUR SAFETY



Read and understand these operating instructions **before you use** the pressing device (*clamping screw boring tool VW-Audi*), and observe all safety instructions and warnings! Misuse may lead to **MODERATE** or **LIGHT INJURIES**! These operating instructions are an integral part of the boring tool. Keep them at a safe place for future reference, and always pass them on to subsequent users of the boring tool! The boring tool complies with the recognised rules of technology as well as the relevant safety regulations!

1.1 Target group

These operating instructions are **exclusively** intended for skilled personnel in specialised motor vehicle workshops!

The boring tool **may only be** used by skilled personnel in specialised motor vehicle workshops who are familiar with the basic regulations on work safety and accident prevention!

✔ **Never** allow unauthorised, inexperienced persons, minors and children, or persons with limited physical, sensory, and mental abilities to use the boring tool!

1.2 Obligations of the owner

Pursuant to the German Ordinance on Industrial Safety and Health (*BetrSichV*), employers are obliged to provide their employees with safe work equipment in accordance with the recognised rules of technology and the relevant safety regulations!

- ✔ The owner of the boring tool **must** ensure that **only** trained personnel in specialised vehicle workshops use the boring tool!
- ✔ The owner of the boring tool **must** ensure that the instructions for use are available to the user and that the user has completely read and understood the instructions for use **before** using the boring tool!
- ✔ The owner of the wheel hub the boring tool **must** ensure that the user is familiar with the basic regulations on work safety and accident prevention, and that the personal protective equipment is available to him!

1.3 Intended use

The boring tool ...

- ✔ **may only be used** be used to drill out clamping screws (with spanner size 16mm) on multi-link axles!
- ✔ **may only** be used on appropriate vehicles as specified in **Chapter 2. - Product description!**
- ✔ **may only be** driven with a suitable drilling machine up to a **maximum drilling speed of 600rpm or 900rpm!**
- ✔ **may only** be used with **GEDORE Automotive** genuine spare parts and accessories!
- ✔ **may only** be used in the way described in these operating instructions!
- ⚠ Any other use can result in **moderate or minor injuries!**

1.4 Reasonably foreseeable misuse

The boring tool ...

- ✔ **must never be used** be used to drill out screws or other parts other than those intended!
- ✔ **must never** be used with a drive other than that intended for it!
- ✔ **must never** be modified, converted, or used for other purposes without authorisation!
- ⚠ Use the boring tool **always** as intended. Any other use can result in **MODERATE** or in **MINOR INJURIES** !

1.5 Personal protective equipment

For your safety, **always** wear personal protective equipment when using the boring tool! The boring tool can bring about mechanical hazards, such as crushing, cutting, and shock injuries.



Always wear **EYE PROTECTION** (for example to DIN EN 166, OSHA 29 CFR 1910.133, ANSI Z87) when using the boring tool to protect yourself against flinging parts or particles!

When using the boring tool, flying parts or particles can cause **INJURIES** to your **eyes!**



Always wear **PROTECTIVE GLOVES** (for example to DIN EN 388, OSHA 29 CFR 1910.138, ANSI 105) when using the boring tool to protect yourself against sharp edges and crushing between parts!

When working with the boring tool, sharp edges and crushing between parts can cause **INJURIES** to your **hands!**



Always wear **SAFETY SHOES** (for example to DIN EN ISO 20345, OSHA 29 CFR 1910.136, ANSI Z41) when using the boring tool to protect yourself against dropping parts!

When working with the boring tool, dropping parts can cause **injuries to your feet and toes!**

EN

1.6 Labelling of the warnings

Warnings warn of potential **hazards**. Always observe these warnings to avoid **DEATH** or **INJURIES!**

For better differentiation, warnings in these operating instructions are classified as follows:

Warning sign	Meaning
WARNING	Indicates a hazardous situation which, if not avoided, could cause DEATH or SEVERE INJURIES .
CAUTION	Indicates a hazardous situation which, if not avoided, could cause MODERATE or MINOR INJURIES .
ATTENTION	Indicates a situation which, if not avoided, can cause damage to the tool or an object in its vicinity.
	Note on important information and useful tips.

1.7 Basic warnings

WARNING - Danger of injury from MISUSE

MISUSE can cause the boring tool to slip, break, and thus drop or parts can be hurled about. This can cause **SEVERE INJURIES!**

Read and understand these operating instructions **before using** the boring tool, and observe all safety and warning instructions for **safe use!**

Always work with the boring tool in accordance with the basic regulations on work safety and accident prevention!

Only use the boring tool as described in these operating instructions!

Always observe the vehicle-specific application procedures in the repair guide of the vehicle manufacturer!

Never use the boring tool if it is damaged or has loose parts or unauthorised modifications!

Always wear your personal protective equipment (*safety goggles, protective gloves, safety shoes*) during work!

Never beat the boring tool with a hammer or anything similar!

CAUTION - Risk of injury from ROTATING PARTS

The boring tool can cause **MEDIUM** or **LIGHT INJURY** when used by **ROTATING PARTS!**

Never use the boring tool with an unauthorised drive! Drive it **only** with a suitable drilling machine up to a **maximum drilling speed of 600rpm or 900rpm!**

Always keep hair, clothing, and gloves away from rotating parts!

Be sure to take off gloves as well as jewellery such as rings and chains which can be drawn into rotating parts, before using the boring tool!

Always wear tight-fitting work clothes when using the boring tool!

ATTENTION - Risk of DAMAGE

The vehicle and the boring tool can be **DAMAGED**.

- ✔ **Always** observe vehicle-specific application procedures in the repair guide of the vehicle manufacturer.
- ✔ When drilling, make sure there is sufficient distance to the mudguard.
- ✔ **Never** clamp the boring tool in a vice.

1.8 Basic safety instructions

For your safety, **always** observe the following safety precautions when using the boring tool in order to avoid injuries and material damage caused by misuse or unsafe handling.

- ✔ Read and understand these operating instructions **before using** the boring tool, and observe all safety and warning instructions for **safe use!**
- ✔ **Always** observe the vehicle-specific application procedures in the repair guide of the vehicle manufacturer!
- ✔ **Always** work with the boring tool in accordance with the basic regulations on work safety and accident prevention!
- ✔ **Never** use the boring tool when you are tired or under the influence of alcohol, drugs, or medication!
- ✔ **Before each use**, check the boring tool **carefully** for damage, loose parts, or unauthorised modifications. **Never** use it if you notice any such deficiencies!
- ✔ Use **only genuine GEDORE Automotive** spare parts and accessories!
- ✔ **Before using** the boring tool, make sure that **no** unauthorised persons are in the immediate environment!
- ✔ **Always** observe the **max. loading capacity** when using the boring tool, and **never** exceed it!
- ✔ **Always** keep hair, clothing, and gloves away from rotating parts!
- ✔ **Be sure to** take off gloves as well as jewellery such as rings and chains which can be drawn into rotating parts, before using the boring tool!
- ✔ **Always** wear your personal protective equipment (*safety goggles, protective gloves, safety shoes*) during work!
- ✔ Interrupt your work **immediately** if you are unsure about using the boring tool and contact **GEDORE Automotive GmbH, if necessary!**
- ✔ For safety reasons, ensure that a damaged boring tool is no longer used! Professional inspection and repair may only be carried out by specially trained personnel from **GEDORE Automotive GmbH!**
- ✔ **Always** use the boring tool as intended. Non-compliance will invalidate any warranty claim and may significantly reduce its durability!

1.9 Work environment

For your safety, **only** use the boring tool in a safe working environment.

- ✔ The workplace **must** be clean and tidy.
- ✔ The workplace **must** be sufficiently large and illuminated.
- ✔ The workplace **must** be on a solid and non-skidding floor.
- ✔ The workplace **must** be safeguarded against access of unauthorised persons.
- ✔ The workplace **must** have a room temperature between -10°C and +40°C.

1.10 Emissions

Oil for lubricating the drill can drip down when using the boring tool and pose a danger to the environment.

- ✔ **Immediately** remove dripping oil with oil binding agents or a cleaning rag, for example.
- ✔ In case of skin contact with hydraulic oil, clean the affected area **immediately** with degreasing soap and water.
- ✔ Dispose of pollutants such as oil in an **environmentally friendly** manner.

1.12 Troubleshooting

Problem: The drill's cutting performance has greatly diminished.

Reason: The drill's cutting edges are either blunt or damaged.

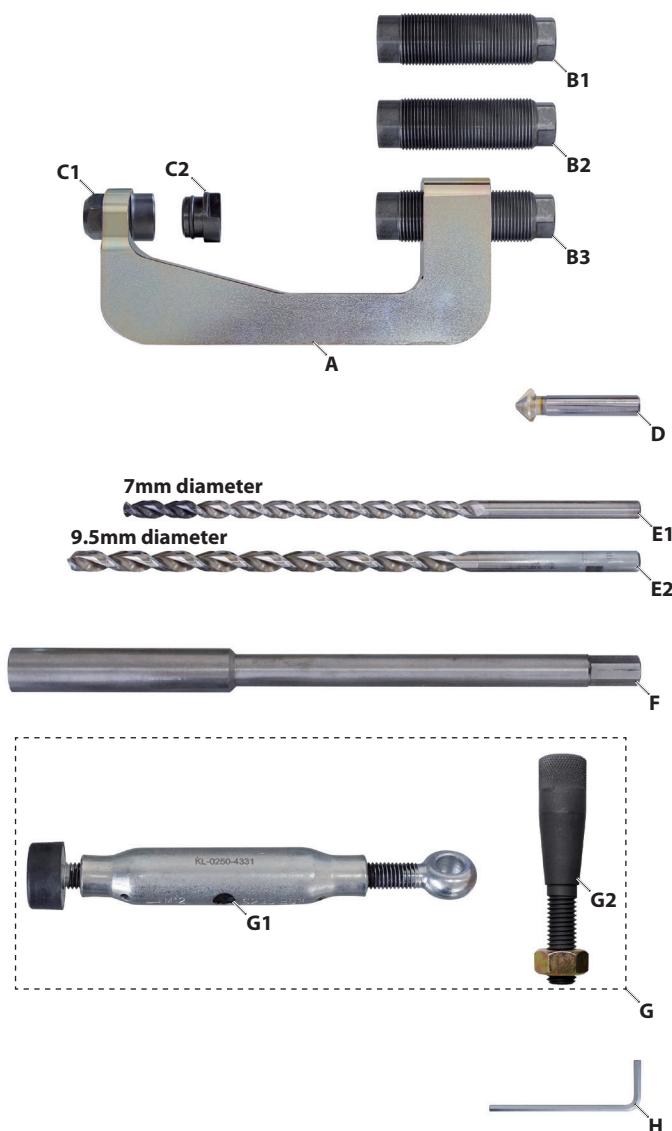
Remedy: Check the drill for damage and, if necessary, regrind the cutting edges professionally.

2. PRODUCT DESCRIPTION

2.1 KL-0250-43 KB - Boring tool kit for clamping screws, VW- AUDI

Fits VW-Audi, Seat, and Škoda vehicles with multi-link axle. Installed, for example, on the VW Passat (3B), Phaeton (3D); Audi A4 (8D, 8E, 8H, 8K); A5 (8T, 8F); A6 (4B, 4F, 4G, 4K); Q5 (8R), A7 (4G, 4K), A8 (4D, 4E, 4H, 4N); Seat Exeo (3R2, 3R5) and Škoda Superb (3U).

The boring tool set enables the quick and professional removal by boring of extremely tight clamping screws (with spanner size 16mm) on multi-link axles. Required, for example, when changing the upper or lower suspension arms and the tie bar end. This avoids a costly replacement of the entire steering knuckle with the wheel bearing unit. To avoid damage to the mudguard on vehicles with a bottom-mounted steering gear, the steering knuckle can be pre-tensioned to full lock with the help of the compressing device included in the scope of delivery.

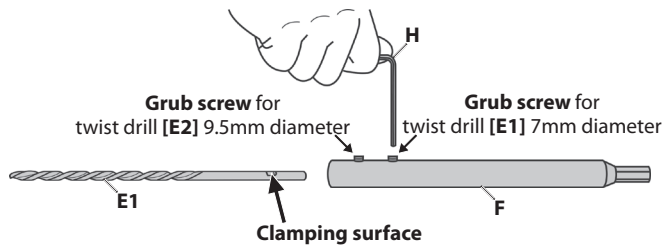


2.2 Scope of delivery

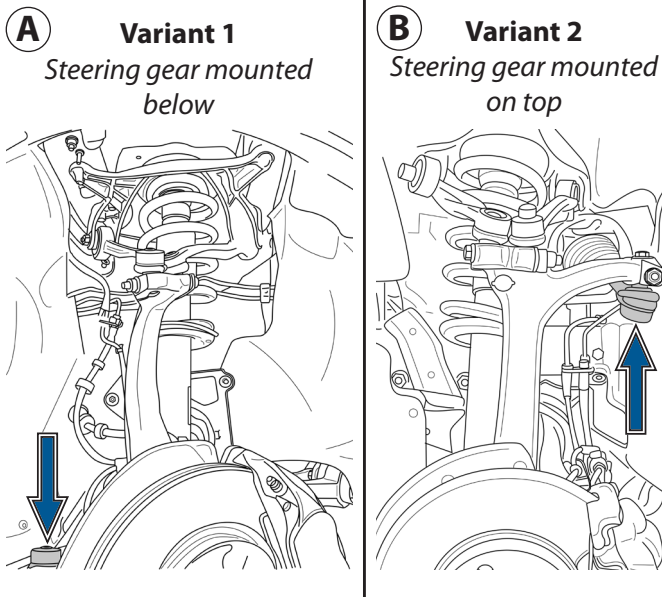
Item	Description	Qty.
A	Basic tool	1
B1	Boring sleeve, 7mm diameter	1
B2	Boring sleeve, 7mm diameter with recess	1
B3	Boring sleeve, 9.5mm diameter	1
C1	Centring insert	1
C2	Centring insert (supplement for tie rod end)	1
D	Countersink	1
E1	Twist drill, 7mm diameter with clamping surface	1
E2	Twist drill, 9.5mm diameter with clamping surface	1
F	Extension with grub screws	1
G	Clamping device	1
G1	Turnbuckle nut	1
G2	Taper screw with nut	1
H	Hexagon L key, 3mm	1
-	Foam insert	1
-	Plastic case	1

i Detailed overview of individual parts: See Chapter 7.

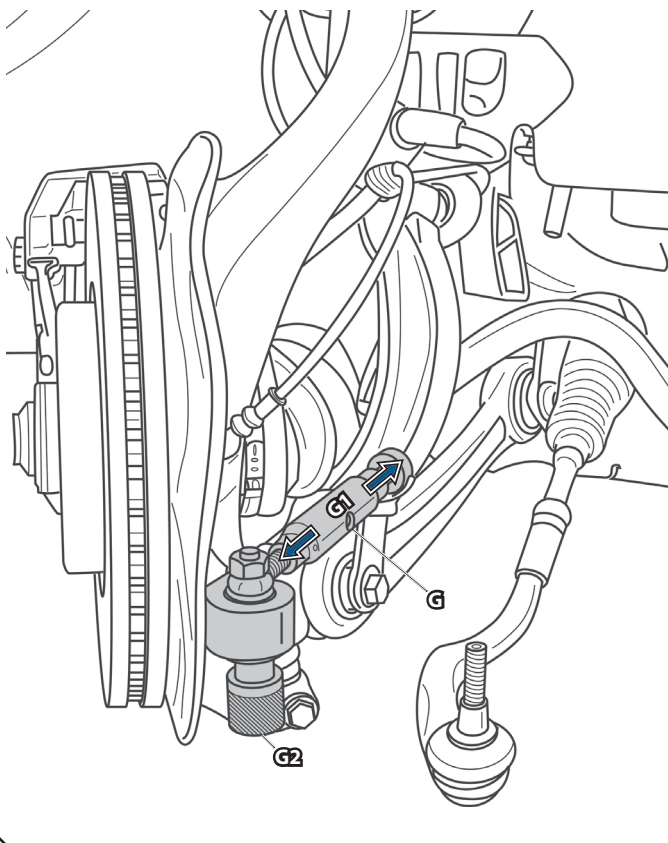
📷 1: Insert the twist drill [E..] into the extension [F].



📷 2: Overview of the different axle variants:



📷 3: Pre-load the steering knuckle to full lock.



3. PREPARATION

⚠️ WARNING

MISUSE can cause the boring tool to slip, break, and thus drop or parts can be hurled about. This can cause **SEVERE INJURIES!**

✔️ **Prior to using** the boring tool, read and understand **all** safety instructions and warnings listed in **Chapter 1**, and **always observe** them **for safe use!**

✔️ Use the boring tool as intended and **always** carry out maintenance and repair work in compliance with the regulations on occupational safety and accident prevention as well as the vehicle manufacturer's instructions!

✔️ **Before each use**, check the boring tool **carefully** for damage, loose parts, or unauthorised modifications. **Never** use it if you notice any such deficiencies!

✔️ **Always** wear your personal protective equipment (for example safety goggles, protective gloves, safety shoes) when working!

3.1 Checking the scope of delivery

Prior to preparing or using the boring tool, check that all parts of the scope of delivery are available (see chapter 2.), and follow the instructions below.

3.2 Preparing the tool

1. Insert the twist drill [E1] into the extension [F] as shown in **📷 1** and secure it via the corresponding "set screw" by using the hexagon L key [H].

ⓘ The "clamping surface" on the shank of the twist drill [E1] must be in a line with the corresponding "set screw"!

3.3 Preparing the vehicle

1. Loosen or remove all necessary parts.

2. To avoid damaging the mudguard when drilling, prepare the vehicle accordingly, depending on the axle variant **📷 2 ...**

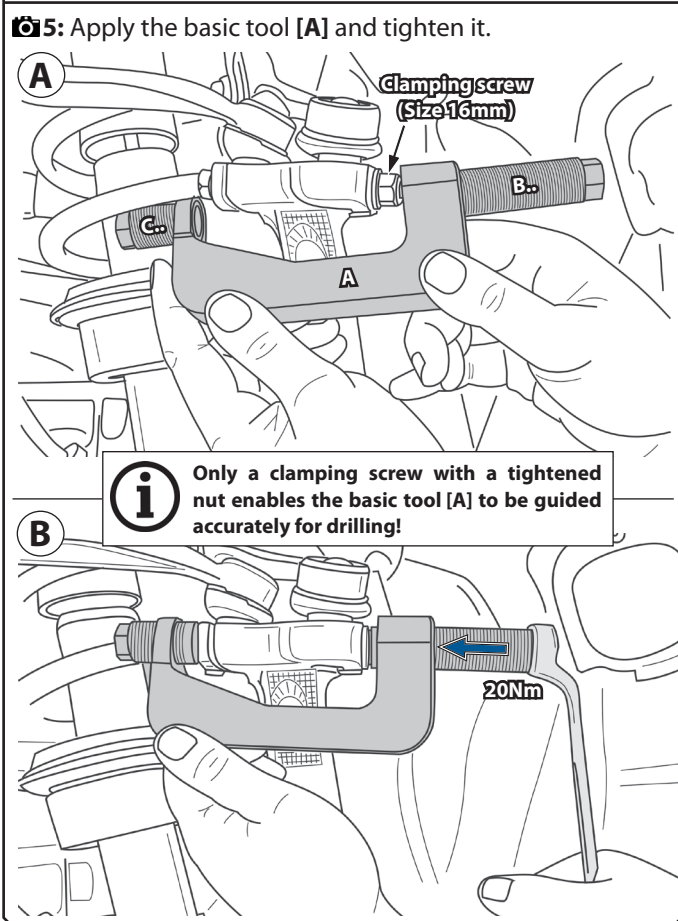
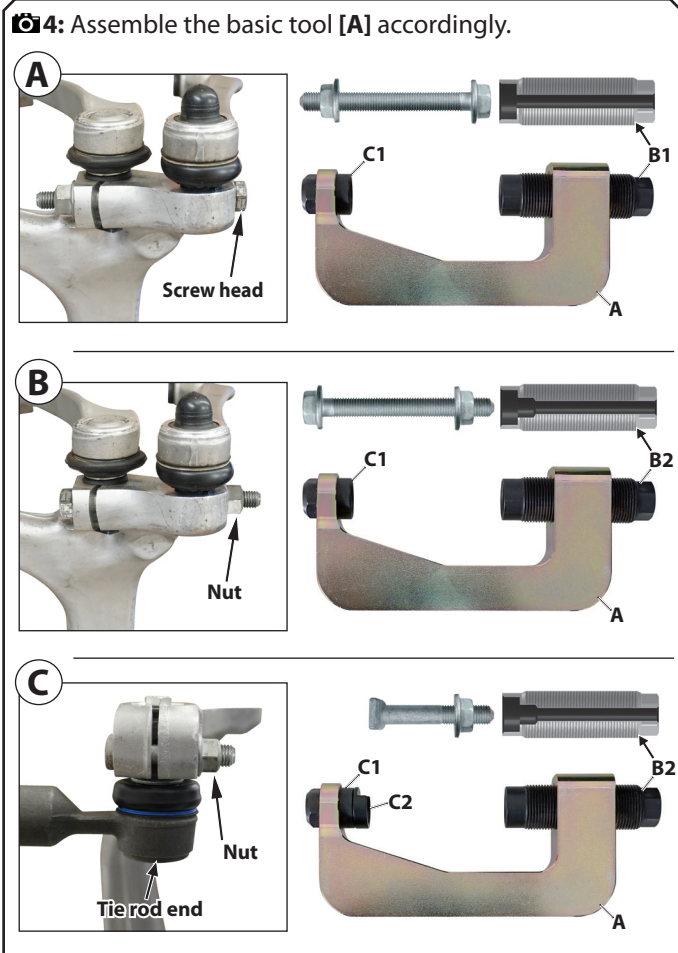
... **Variant 1 = Steering gear mounted below:** **📷 2A**

Turn the steering wheel towards the side to be drilled out and loosen the tie rod end on the steering knuckle.

Insert the tensioning device [G] on the steering knuckle as shown in **📷 3**, and support it against the suspension strut. Pre-tension the steering knuckle to full lock by turning the turnbuckle nut [G1].

... **Variant 2 = Steering gear mounted on top:** **📷 2B**

Turn the steering wheel towards the side to be drilled out and fix its position with a steering wheel lock, for example.



4. TYPICAL APPLICATION

This typical application describes how to drill out a stuck clamping screw (spanner size 16 mm) of the upper suspension arms, on a multi-link axle with **bottom-mounted** steering gear.

🔧 A clamping screw on the lower axle steering arm, on the tie rod end, or on vehicles with an **overhead** steering gear is basically drilled out according to the same principle.

4.1 Pre-drilling the clamping screw with 7mm

🔧 Boring high-tensile screws leads to an increased wear of the drills! **Pre-drilling** with **7mm** protects the **9.5mm** twist drill [E2] and thus considerably increases its service life.

1. Depending on the clamping screw, assemble the basic tool [A] accordingly ...

... Pilot-drilling a clamping screw through the screw head:
Mount the centring insert [C1] and the drill bush [B1] on the basic tool [A] as shown in 🔧 4A.

... Pilot-drilling a clamping screw through the nut:
Mount the centring insert [C1] and the drill bush [B2] on the basic tool [A] as shown in 🔧 4B.

... Pilot-drilling the clamping screw at the tie rod end:
As shown in 🔧 4C, mount the centring insert [C1] with supplement [C2] and the drill bushing [B2] to the basic tool [A].

CAUTION

Risk of damaging the steering knuckle and the boring tool.

➤ The boring tool for clamping screws is only suitable for clamping screws with a spanner size of **16mm**.

➤ Only a clamping screw with tightened nut allows precise guiding of the basic tool [A]. For this reason, a clamping screw cannot be drilled out if it has already been strongly bent or sawed off flush with the knuckle during previous removal attempts.

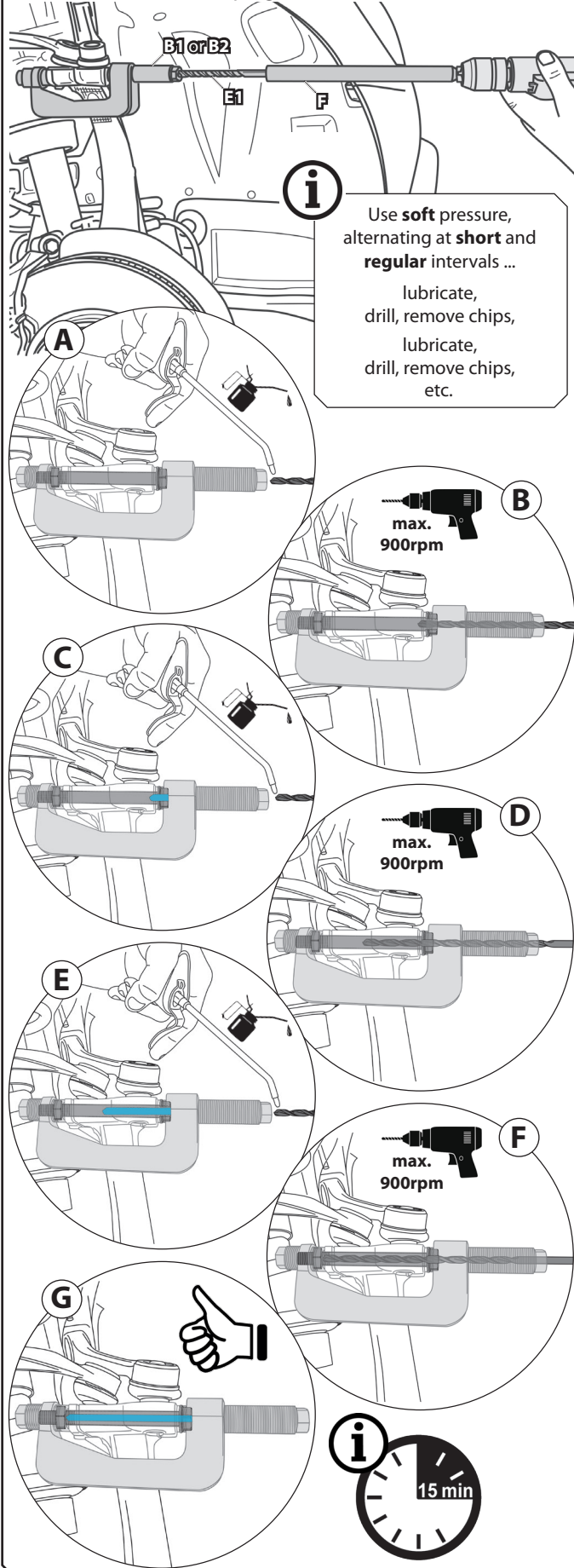
➤ Ensure that the centring insert [C..] as well as the drill bush [B..] are in full and proper contact with the clamping screw and nut.

➤ The correct composition of the basic tool [A] under **Item 1**. must be observed under all circumstances!

2. Mount the basic tool [A] as shown in 🔧 5A+B to the clamping screw with nut.

Use the basic tool [A] by screwing in the centring bush [C1] and the drill bush [B..], and tighten them with **20Nm**. afterwards.

6: Pre-drill the clamping screw.



CAUTION

When working with cutting tools, sharp edges, various parts, and flying chips can cause **INJURY** to eyes and hands!

Always wear your personal protective equipment (for example safety goggles, protective gloves, safety shoes) when working!

CAUTION

The mudguard on the vehicle and the boring tool, in particular the twist drill bit [E1], can be damaged!

Pay attention to sufficient distance to the mudguard to protect it from damage.

Please note that the drilling process takes **about 10 - 15 minutes**. This **must be** performed with soft pressure at short and regular intervals in order to ensure sufficient chip removal, cooling, and lubrication at the drill [E1].

Lubricate the twist drill [E1] sufficiently with oil while drilling out!

Drive the twist drill [E1] with **max. 900rpm**.

3. Insert the twist drill [E1] into the drill bush [B1] or [B2].

Use a drilling machine and start drilling as shown in 6A-G, with soft pressure on the twist drill [E1] and with **max. 900rpm**. While drilling, alternately lubricate the twist drill [E1] with oil, drill, remove chips, etc., in short and regular intervals.

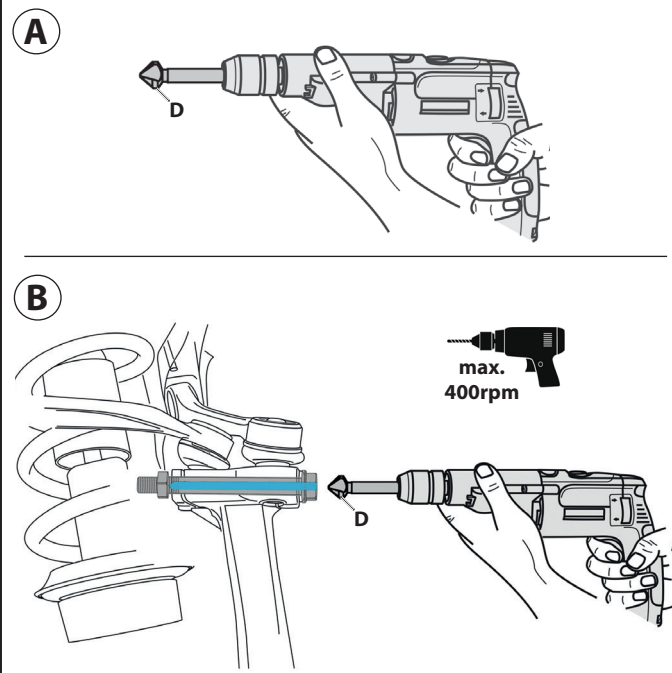
i IMPORTANT NOTE

Due to the length to be drilled of approximately 100mm (solid material) and the high strength of the clamping screw, calculate a required time interval of **approximately 10 to 15 minutes**. Accelerating the boring process leads to premature wear and damage to the twist drill [E1]!

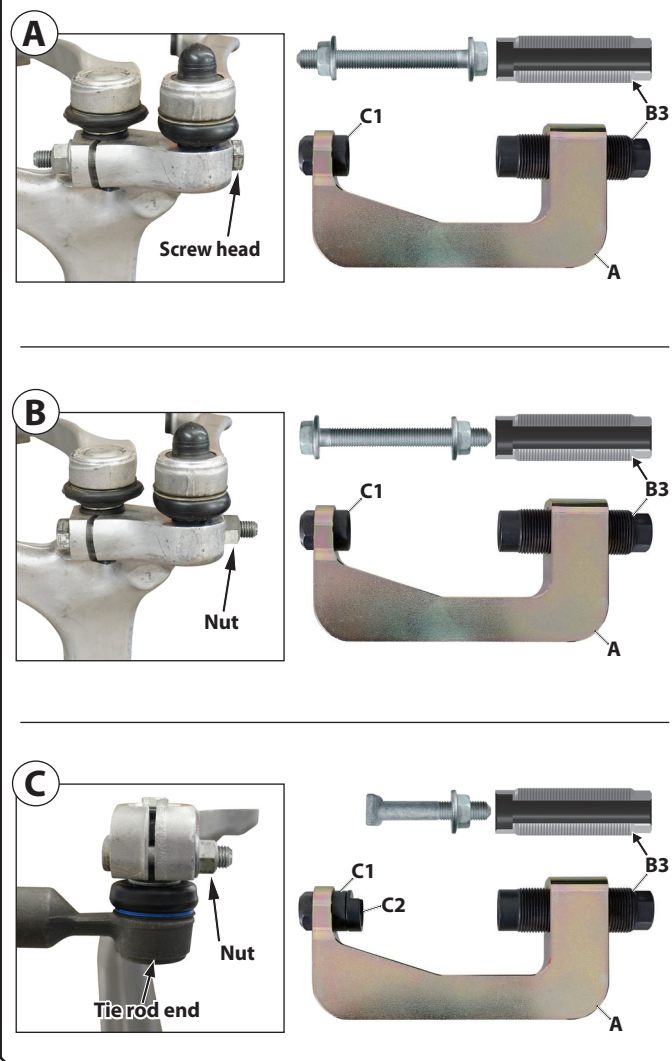
4. After pre-drilling, loosen the basic tool [A] and remove it from the clamping screw.

Also remove the twist drill [E1] from the extension [F].

📷7: Countersink the pilot-drilled clamping screw with countersink tool [D].



📷8: Assemble the basic tool [A] accordingly.



⚠CAUTION

When working with cutting tools, sharp edges, various parts, and flying chips can cause **INJURY** to eyes and hands!

► **Always** wear your personal protective equipment (for example safety goggles, protective gloves, safety shoes) when working!

CAUTION

The mudguard on the vehicle and the boring tool, in particular the countersink drill [D] can be damaged!

► Pay attention to sufficient distance to the mudguard to protect it from damage.

► Drive the countersink drill [D] with **max. 400rpm**.

5. To ensure accurate centring of the **9.5mm** twist drill [E2] when boring the clamping screw, the pre-drilled clamping screw **must** be countersunk a bit using the countersink drill [D].

Insert the countersink drill [D] into a drilling machine **📷7A** and countersink the pre-drilled clamping screw with soft pressure **📷7B**.

4.2 Drilling out the 9.5mm clamping screw

ⓘ Boring high-tensile screws leads to an increased wear of the drills! Pre-drilling with **7mm**, as described in **Chapter 4.1**, protects the **9.5mm** twist drill [E2] and thus increases its service life.

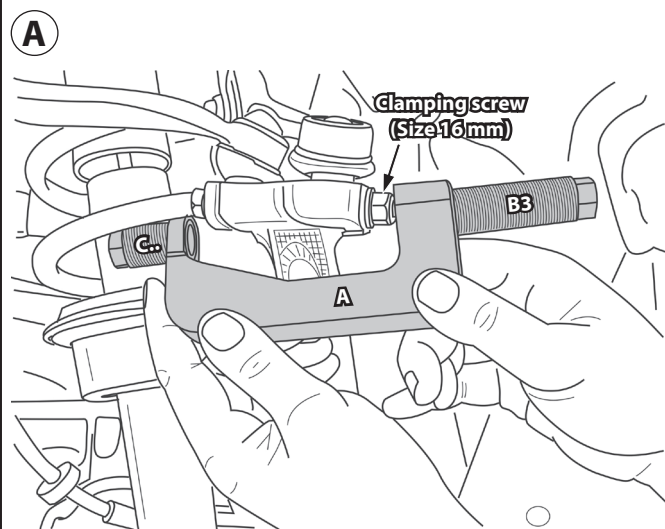
1. Depending on the clamping screw, assemble the basic tool [A] accordingly ...

... Pilot-drilling a clamping screw through the screw head:
Mount the centring insert [C1] and the drill bush [B3] on the basic tool [A] as shown in **📷8A**.

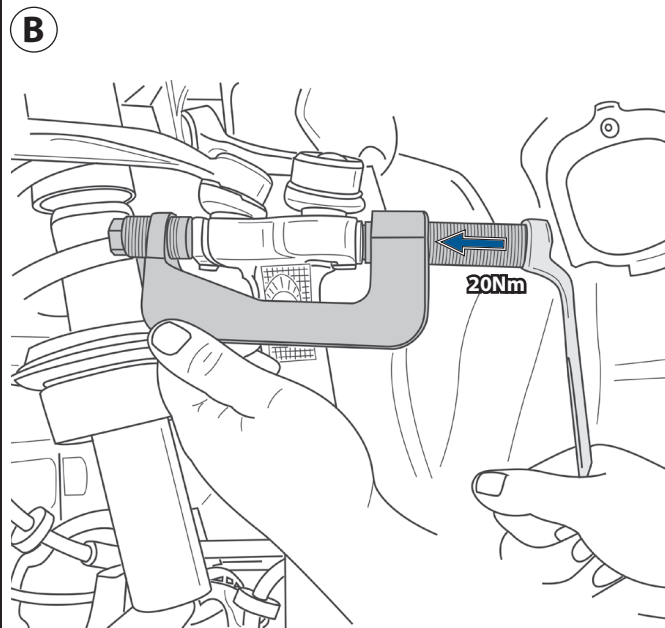
... Pilot-drilling a clamping screw through the nut:
Mount the centring insert [C1] and the drill bush [B3] on the basic tool [A] as shown in **📷8B**.

... Pilot-drilling the clamping screw at the tie rod end:
As shown in **📷8C**, mount the centring insert [C1] with supplement [C2] and the drill bushing [B3] to the basic tool [A].

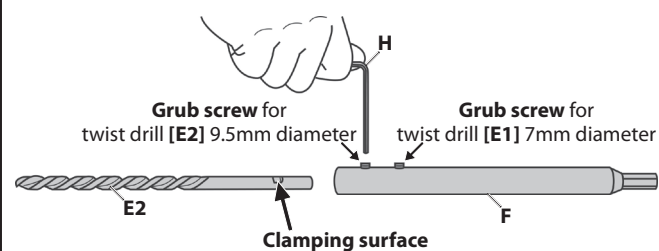
📷9: Apply the basic tool [A] and tighten it.



i Only a clamping screw with a tightened nut enables the basic tool [A] to be guided accurately for drilling!



📷10: Insert the twist drill [E2] into the extension [F].



CAUTION

Risk of damaging the steering knuckle and the boring tool.

- ▶ The boring tool for clamping screws is only suitable for clamping screws with a spanner size of **16mm**.
- ▶ Only a clamping screw with tightened nut allows precise guiding of the basic tool [A]. For this reason, a clamping screw cannot be drilled out if it has already been strongly bent or sawed off flush with the knuckle during previous removal attempts.
- ▶ Ensure that the centring insert [C..] as well as the drill bush [B..] are in full and proper contact with the clamping screw and nut.
- ▶ The correct composition of the basic tool [A] under **Item 1.** must be observed under all circumstances!

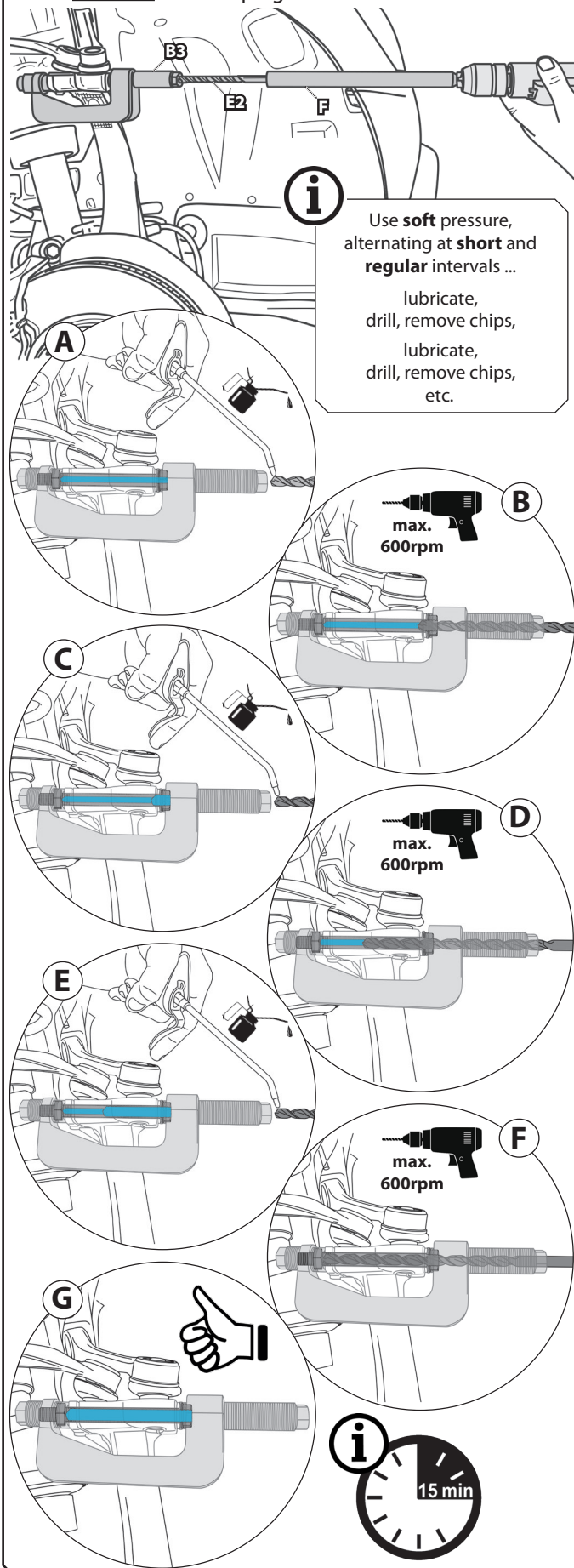
2. Mount the basic tool [A] as shown in 📷9A+B to the clamping screw with nut.

Use the basic tool [A] by screwing in the centring bush [C1] and the drill bush [B..], and tighten them with **20Nm** afterwards.

3. Insert the twist drill [E2] into the extension [F] as shown in 📷10 and secure it via the corresponding "set screw" by using the hexagon L key [H].

ⓘ The "clamping surface" on the shank of the twist drill [E2] must be in a line with the corresponding "set screw"!

📷 11: Drill out the clamping screw.



⚠ CAUTION

When working with cutting tools, sharp edges, various parts, and flying chips can cause **INJURY** to eyes and hands!

✔ **Always** wear your personal protective equipment (for example safety goggles, protective gloves, safety shoes) when working!

CAUTION

The mudguard on the vehicle and the boring tool, in particular the twist drill bit [E2], can be damaged!

✔ Pay attention to sufficient distance to the mudguard to protect it from damage.

✔ Please note that the drilling process takes **about 10 - 15 minutes**. This **must be** performed with soft pressure at short and regular intervals in order to ensure sufficient chip removal, cooling, and lubrication at the drill [E2].

✔ Lubricate the twist drill [E2] sufficiently with oil while drilling out!

✔ Drive the twist drill [E2] with **max. 600rpm**.

3. Insert the twist drill [E2] into the drill bushing [B3].

Use a drilling machine and start drilling as shown in 📷 11A-G, with soft pressure on the twist drill [E2] and **max. 600rpm**. While drilling, alternately lubricate the twist drill [E2] with oil, drill, remove chips, etc., in short and regular intervals.

📌 IMPORTANT NOTE

Due to the length to be drilled of approximately 100mm (solid material) and the high strength of the clamping screw, calculate a required time interval of **approximately 10 to 15 minutes**. Accelerating the boring process leads to premature wear and damage to the twist drill [E2]!

CAUTION

The vehicle's wing can be damaged!

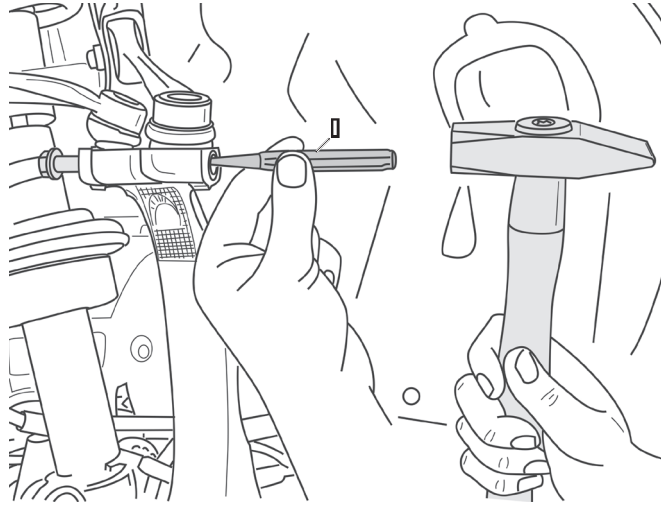
✔ Pay attention to sufficient distance to the mudguard to protect it from damage.

4. After boring, loosen the basic tool [A] and remove it from the clamping screw.

Use a punch [I] and a hammer, drive the remains of the drilled-out clamping screw out of the steering knuckle
📷 13 / page 14.

5. Perform further work on the vehicle as specified by the manufacturer.

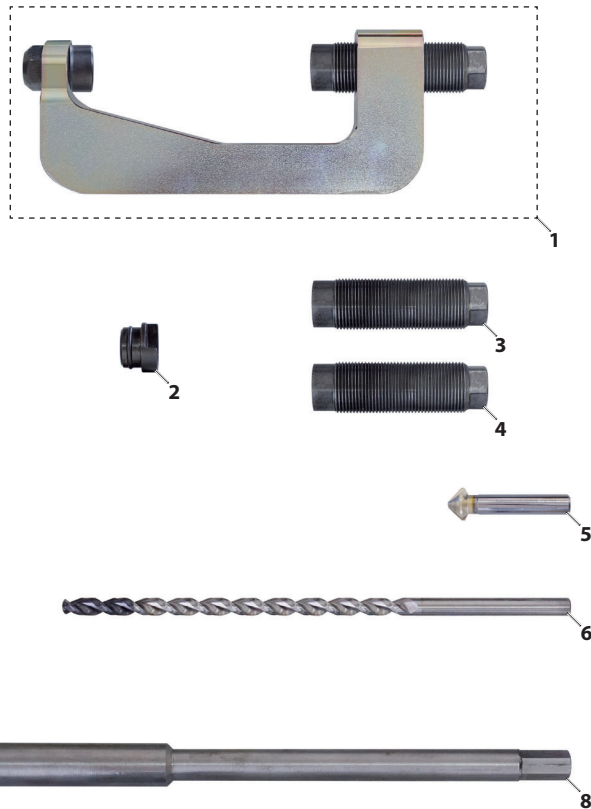
12: Removing the bored clamping screw.



Bored clamping screw



Supplement to KL-0250-43 KB



5. CARE AND STORAGE

ATTENTION

Improper care and storage can damage the boring tool. Therefore, **never** immerse the boring tool in water, solvents, or other cleaning liquids. After use, clean all parts **only** with a dry and clean cleaning cloth. To protect against corrosion, rub all metal parts with a tool care oil or wax. Store the boring tool and the operating instructions at a dry and clean place.

6. SUPPLEMENTS

With the help of the following parts, the former clamping screw boring tool kits - **KL-0250-43 K** and **KL-0250-43 KA** can be updated to the scope of delivery and the functionalities of the current boring tool kit - **KL-0250-43 KB**.

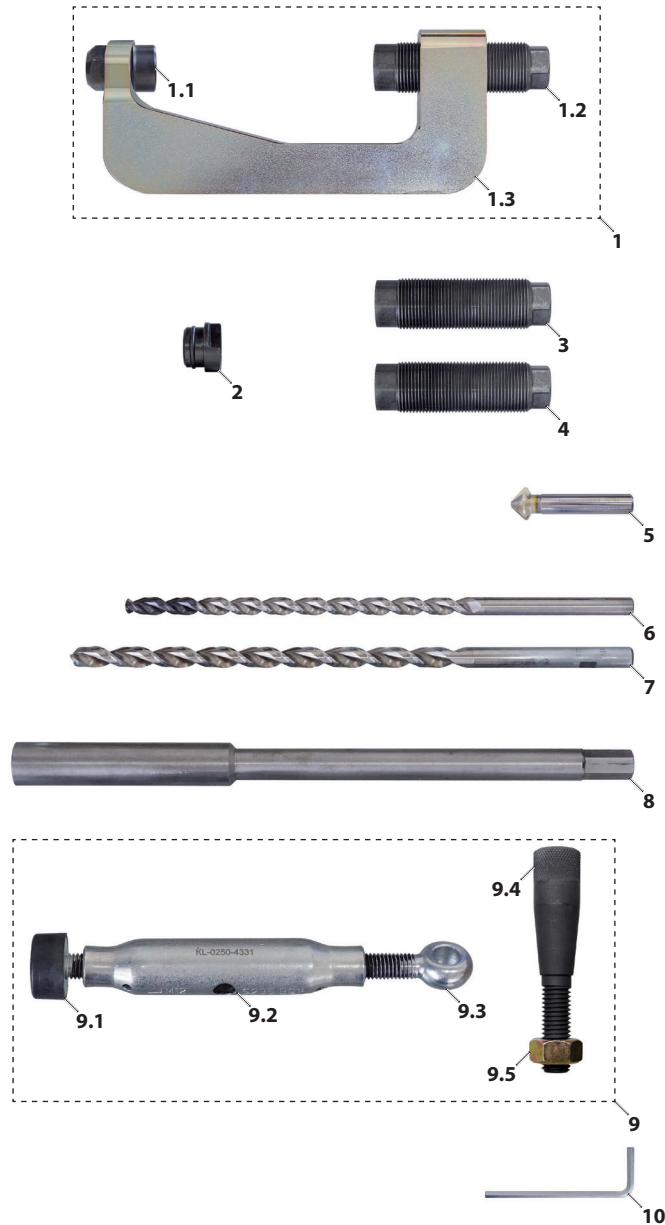
Supplement for KL-0250-43 K to update to KL-0250-43 KB

Item	Part no.	Description	Qty.
1	KL-0250-4311 B	Basic tool	1
2	KL-0250-4341	Tie rod end supplement	1
3	KL-0250-4313 A	Boring sleeve, 7mm diameter	1
4	KL-0250-4314 A	Boring sleeve, 7mm diameter with recess	1
5	KL-0250-4324	Countersink tool 12.4mm diameter	1
6	KL-0250-4323	Twist drill 7 dia.x155x225mm with clamping surface	1
8	KL-0250-4321 A	Extension with grub screws	1
-	KL-0250-4390-2 B	Foam insert	1
-	KL-4990-9374	Plastic case	1

Supplement for KL-0250-43 KA to update to KL-0250-43 KB

Item	Part no.	Description	Qty.
1	KL-0250-4311 B	Basic tool	1
3	KL-0250-4313 A	Boring sleeve, 7mm diameter	1
4	KL-0250-4314 A	Boring sleeve, 7mm diameter with recess	1
-	KL-0250-4390-2 B	Foam insert	1
-	KL-4990-9374	Plastic case	1

Overview of the single parts: KL-0250-43 EB / KB



7. REPAIR

⚠ WARNING

For safety reasons, ensure that a damaged boring tool is no longer used! Professional inspection and repair may only be carried out by specially trained experts from **GEDORE Automotive GmbH**. Improper repair can result in **DEATH** or **SEVERE INJURIES**.

8. SINGLE COMPONENT OVERVIEW

KL-0250-43 KB - Boring tool kit for clamping screws, VW-Audi

Item	Part no.	Description	Qty.
1	KL-0250-4311 B	Basic tool	1
1.1	KL-0250-4311-2	Centring insert M10	1
1.2	KL-0250-4311-3 B	Boring sleeve, 9.5mm diameter	1
1.3	KL-0250-4311-1 B	Bracket	1
2	KL-0250-4341	Tie rod end supplement	1
3	KL-0250-4313 A	Boring sleeve, 7mm diameter	1
4	KL-0250-4314 A	Boring sleeve, 7mm diameter with recess	1
5	KL-0250-4324	Countersink tool 12.4mm diameter	1
6	KL-0250-4323	Twist drill 7 dia.x155x225mm with clamping surface	1
7	KL-0250-4322	Twist drill 9.5 dia.x175x250mm with clamping surface	1
8	KL-0250-4321 A	Extension with grub screws	1
9	KL-0250-433	Clamping device	1
9.1	KL-0250-4331-2	Rubber buffer	1
9.2	KL-0250-4331-1 A	Turnbuckle nut M12	1
9.3	KL-0250-4331-3	Eyebolt M12	1
9.4	KL-0250-4332 A	Taper screw M12	1
9.5	KL-0035-0023	Hex nut M12	1
10	42 3	Hexagon L key, 3mm	1
-	KL-0250-4390-2 B	Foam insert	1
-	KL-4990-9374	Plastic case	1

9. ENVIRONMENTALLY COMPLIANT DISPOSAL

Dispose of the boring tool and the packaging material in an environmentally compatible way in accordance with the legal requirements. If necessary, ask your local authorities about environmentally friendly disposal options.

GEDORE-Werkzeugfabrik GmbH & Co. KG

Remscheider Straße 149
42899 - Remscheid
Postfach 120361
47873 Remscheid
GERMANY

Vertrieb DEUTSCHLAND

☎ +49 (0) 2191 / 596-0
☎ +49 (0) 2191 / 596-230
✉ info@gedore.com
🌐 www.gedore.com

Sales INTERNATIONAL

☎ +49 (0) 2191 / 596-910
☎ +49 (0) 2191 / 596-911
✉ info@gedore.com
🌐 www.gedore.com

GEDORE TOOLS, INC.

Only for USA, Canada & Mexico
Sólo para EE.UU., Canadá y México
Seulement pour les USA, le Canada et le Mexique
7187 Bryhawke Circle, Suite 700, North Charleston, SC 29418, USA

☎ +1-843 / 225 50 15
☎ +1-843 / 225 50 20
✉ info@gedoretools.com
🌐 www.gedoretools.com

Worldwide GEDORE service centers and offices are listed on the Internet at: www.gedore.com

GEDORE Automotive GmbH

Breslauer Straße 41
78166 - Donaueschingen
Postfach 1329
78154 Donaueschingen
GERMANY

Vertrieb DEUTSCHLAND

☎ +49 (0) 771 / 8 32 23-0
☎ +49 (0) 771 / 8 32 23-90
✉ info.gam@gedore.com
🌐 gedore-automotive.com



www.gedore-automotive.com