

KL-0132-5.. /-6..

Universal Glow Plug Tool Series



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1. READ AND UNDERSTAND FOR YOUR SAFETY



Read and understand these operating instructions **before using** the glow plug tool (*universal glow plug tool series*) and observe all safety and warning instructions! Misuse can result in **SEVERE INJURIES**! These operating instructions are an integral part of the glow plug tool. Keep them at a safe place for future reference, and always pass them on to subsequent users of the glow plug tool! The glow plug 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 glow plug 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 glow plug 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 glow plug tool **must** ensure that **only** trained personnel in specialised vehicle workshops use the glow plug tool!

▼ The owner of the glow 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 glow plug tool!

▼ The owner of the glow plug 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 glow plug tool ...

▼ **may only be used** with diesel engines with M10x1 glow plug thread for boring out torn glow plugs, for recutting and cleaning the glow plug mounting thread as well as for pulling the glow plug element!

▼ **may only** be driven with a suitable drilling machine up to a drilling speed of **600rpm!**

▼ **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 **DEATH** or **SEVERE INJURIES!**

1.4 Reasonably foreseeable misuse

The glow plug tool ...

▼ **must never** be used for boring out, recutting and pulling out of other parts than those intended for it!

▼ **must never** be used with an impulse or impact wrench or a drive other than that intended for it!

▼ **must never** be modified, converted, or used for other purposes without authorisation!

⚠ Use the glow plug tool **always** as intended. Any other use can result in **DEATH** or in **SEVERE INJURIES!**

1.5 Personal protective equipment

For your safety, **always** wear personal protective equipment when using the glow plug tool! The glow plug 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 glow plug tool to protect yourself against flinging parts or particles!

▼ When using the glow plug tool, flying parts or particles can cause **SEVERE INJURIES** to your **eyes!**







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

▼ When working with the glow plug tool, dropping parts can cause **SEVERE INJURIES** to your **feet and toes!**

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 SERIOUS INJURIES .
 CAUTION	Indicates a hazardous situation which, if not avoided, could cause MODERATE or MINOR INJURIES .
 CAUTION	Indicates a situation which, if not avoided, could cause damage to the tool or an object in its vicinity.
 i	Note on important information and useful tips.

1.7 Basic safety instructions and warnings

CAUTION - There is a risk of accident and injury if this is not observed.

When using the glow plug tool, **always** observe the following safety and warning instructions as well as measures to avoid **SERIOUS INJURY** as well as property damage due to hazards, misuse, abuse and unsafe handling!

- ✔ Read and understand these operating instructions **before using** the glow plug tool and **always** observe all safety and warning instructions for **safe use!**
- ✔ **Always** work with the glow plug tool in accordance with the basic regulations on work safety, accident prevention and environmental protection!
- ✔ **Always** use the glow plug tool as intended. **GEDORE Automotive GmbH** accepts no liability or warranty or guarantee claims for injuries and damage resulting from improper use or infringement of the safety regulations.
- ✔ **Before each use**, check the glow plug tool **carefully** for damage, loose parts, or unauthorised modifications. **Never** use it if you notice any such deficiencies! Professional inspection and repair may only be carried out by specially trained personnel from **GEDORE Automotive GmbH!**
- ✔ **Only** use original spare parts and accessories from **GEDORE Automotive GmbH** for the glow plug tool!
- ✔ **Always** observe the vehicle-specific manufacturer's specifications when working with the glow plug tool!
- ✔ **Never** use the glow plug tool with an impulse or impact wrench or any other drive than intended!
- ✔ **Only** drive the glow plug tool with a suitable drill up to the **maximum permissible speed!**
- ✔ **Never** use the glow plug tool when you are tired or under the influence of alcohol, drugs, or medication!
- ✔ **Before using** the glow plug tool, make sure that **no** unauthorised persons are in the direct vicinity!
- ✔ **Always** keep hair and clothing away from rotating parts and remove gloves and jewellery that could be drawn into rotating parts **before using** the glow plug tool!
- ✔ **Always** wear tight-fitting work clothes when using the glow plug tool!
- ✔ Always wear your personal protective equipment, e.g. safety goggles, safety shoes, **if necessary!**
- ✔ Interrupt your work **immediately** if you are unsure about using the glow plug tool and contact **GEDORE Automotive GmbH, if necessary!**

1.8 Work environment

For your safety, **only** use the glow plug 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.

1.9 Emissions

Oil for lubricating the drill can drip down when using the glow plug 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.
- ✔ **Always** dispose of pollutants such as oil in an **environmentally friendly manner**.

2. Product description

2.1 KL-0132-5.. /-6.. - Universal glow plug tool series

The universal glow plug tool series enables a quick and professional removal of a torn glow plug and the maintenance of the mounting thread on the cylinder head.

KL-0132-52 KB - Glow plug tool kit M10x1

Particularly suitable for VW-Audi (2.5, 2.7, 3.0 V6 TDI), BMW (M47, N47, B47, N57), Mercedes (OM 611, 612, 613, 646, 647, 648 CDI) and Ford (2.0 EcoBlue) due to vehicle-specific guide sleeves.

Fits universally for diesel engines with M10x1 glow plug thread, e.g. on Opel, Peugeot, Renault, and many more.

For boring out torn glow plugs, for recutting the mounting thread as well as for pulling the glow plug element.

Particular vehicle-specific guide sleeves for precise centring, straight guidance and exact drilling depth.

Can be also used without guide sleeves for a lot of diesel engines with M10x1 mounting thread.

Necessary accessories

KL-0369-300 A - Turning lathe operator

KL-0369-303 A - Mounting tool for guide sleeves*

*consisting of: Impact extractor - **KL-0049-100 A** + base body - **KL-0369-3031 B**

Alternative accessories

KL-0369-305 A - Extraction tool for glow plugs

(For the extraction of stuck glow plug elements)



KL-0132-55 KA - Glow plug tool kit M8x1

Due to vehicle-specific guide sleeves especially suitable for, e.g. Mercedes (OM639, OM640, OM642, OM651 CDI) and Fiat (1.3, 2.3, 3.0 JTD)

Fits universally for diesel engines with M8x1 glow plug thread.

For boring out torn glow plugs, for recutting the mounting thread as well as for pulling the glow plug element.

Particular vehicle-specific guide sleeves for precise centring, straight guidance and exact drilling depth.

Can be also used without guide sleeves for a lot of diesel engines with M8x1 mounting thread.

Necessary accessories

KL-0369-300 A - Turning lathe operator

KL-0049-100 A - Impact extractor

Alternative accessories

KL-0369-305 A - Extraction tool for glow plugs

(For the extraction of stuck glow plug elements)



KL-0132-57 K - Glow plug thread repair kit M8x1 + M10x1

Fits universally for diesel engines with M8x1+ M10x1 glow plug thread.

For the repair of defective glow plug mounting threads on the cylinder head, by extension and insertion of a threaded bushing.

Necessary accessories

KL-0283-7021 A - Core drill for M10

KL-0283-7022 - Tap M10x1



KL-0132-62 KB - Universal glow plug tool kit M10x1,.25

Fits universally for diesel engines with M10x1.25 glow plug thread.

Especially suitable for, e.g. Opel, Mazda, Ford, Hyundai, Kia, Nissan and Toyota 1.4 - 3.0 (D / DI / DTI / TD / CRDi / CDTi) diesel engines and many more.

For boring out torn glow plugs, for recutting the mounting thread as well as for pulling the glow plug element.

Necessary accessories

KL-0369-300 A - Turning lathe operator

KL-0049-100 A - Impact extractor

Alternative accessories

KL-0369-305 A - Extraction tool for glow plugs
(For the extraction of stuck glow plug elements)



2.2 Scope of delivery / Overview of the single parts

① Prior to using the glow plug tool, check to ensure that all the parts included in the scope of delivery are available.

		Glow plug tool kits			
		KL-0132-52 KB	KL-0132-55 KA	KL-0132-57 K	KL-0132-62 KB
Basic tools... A	Item				
KL-0126-221 - Magnetic lifter, flexible	A1	●	●		●
KL-0369-306 - Tool holder for taps UNC	A2	●	●		●
KL-4007-2510 - Adapter 3/8" for drill	A3	●	●		●
Tap UNC... B					
KL-1383-2241 - Tap 12-24 UNC	B1		●		
KL-0369-3056 - Tap 1/4"-20 UNC	B2	●			●
Pull bolt... C					
KL-0132-5501 - Pull bolt 12-24 UNC for impact extractor	C1		●		
KL-0132-5202 - Pull bolt 1/4"-20 UNC for impact extractor	C2	●			●
Threaded sleeves... D					
KL-1383-2234 - Threaded sleeves M10x1 to M8x1 (10 pieces)	D1			●	
KL-0369-3023 - Threaded sleeves M12x1 to M10x1 (10 pieces)	D2			●	
Guide sleeves... E					
KL-0132-5504 Guide sleeve for M8 (Fiat JTD)	E1		●		
KL-0132-5505 Guide sleeve for M8 (Mercedes)	E2		●		
KL-0283-7003 - Guide sleeve for M10 (VW-Audi)	E3	●			
KL-0283-7004 Guide sleeve for M10 (BMW)	E4	●			
KL-0132-5201 Guide sleeve for M10 (Mercedes)	E5	●			
KL-0283-7005 Guide sleeve for M10 (Ford)	E6	●			
KL-0369-3015 - Centring sleeve for KL-0283-7005	E7	●			
Core drill... F					
KL-0132-5502 A - Core drill for M8	F1		●		
KL-0283-7021 A - Core drill for M10	F2	●		Accessories	●
KL-0283-7031 B - Core drill for M12	F3			●	
Tap... G					
KL-0132-5503 - Tap M8x1	G1		●		
KL-0283-7022 - Tap M10x1	G2	●		Accessories	
KL-0132-6201 - Tap M10x1,25	G3				●
KL-0283-7032 A - Tap M12x1	G4			●	
Storage Systems:					
KL-4990-2001 - Plastic box 53x107x18mm	-			●2x	
KL-0132-5290-1 B- Foam insert	-	●			
KL-0132-5790-1 - Foam insert	-			●	
KL-4990-9224 - Plastic case	-	●		●	
KL-0132-5590 A- Plastic case	-		●		●

3. TYPICAL APPLICATION

This typical application example describes the maintenance of a cylinder head with torn glow plug step by step.

Chapter 3.1 Prepare glow plug = Insert guide sleeve and boring out or shorten glow plug middle electrode.

Chapter 3.2 Boring out the glow plug = Boring out the glow plug and recutting the glow plug mounting thread.

Chapter 3.3 Removing the glow plug element = Removing the glow plug element of the glow plug on the cylinder head.

Chapter 3.4 Repairing the mounting thread, if necessary = Repairing a damaged glow plug mounting thread.

3.1 Preparing the glow plug

1: Select guide sleeve [E..]

1. Depending on the motor, select the appropriate guide sleeve [E..] from the table.

① The boring out of a glow plug can be executed **with** or **without** a vehicle-specific guide sleeve [E..].

Using a vehicle-specific guide sleeve ensures a precise centring, straight guidance and exact drilling depth. When drilling **without** a guide sleeve, you **must** pay attention to this **yourself!**

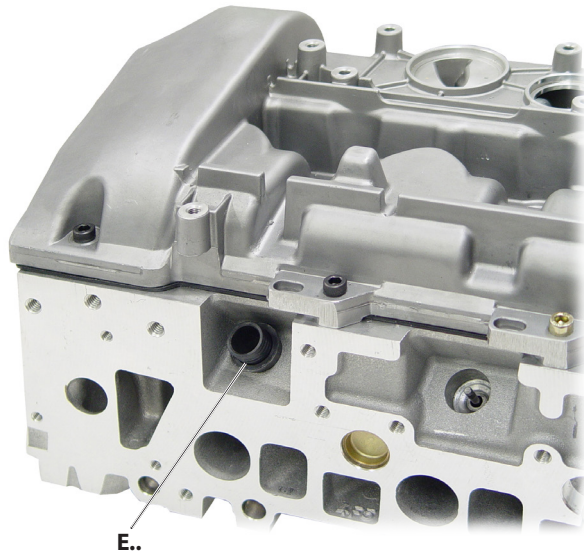
Guide sleeves... E	Item	Suitable for Diesel engines for example on...
KL-0132-5504 - Guide sleeve (Fiat JTD)	E1	... Fiat 2.3, 3.0 (JTD)
KL-0132-5505 - Guide sleeve (Mercedes)	E2	... Mercedes OM639, OM640, OM642, OM651 (CDI) ...Fiat 1.3 (JTD)
KL-0283-7003 - Guide sleeve (VW-Audi)	E3	...VW-Audi 2.5, 2.7, 3.0 V6 (TDI)
KL-0283-7004 - Guide sleeve (BMW)	E4	...BMW (M47, N47, B47, N57)
KL-0132-5201 - Guide sleeve (Mercedes)	E5	...Mercedes OM611, OM612, OM613, OM646, OM647, OM648 (CDI)
KL-0283-7005 - Guide sleeve (Ford)	E6	...Ford 2.0 (EcoBlue)
KL-0369-3015 - Centring sleeve for KL-0283-7005	E7	
<u>Without</u> vehicle-specific guide sleeve	-	...VW-Audi, BMW, Mini, Mercedes, Fiat, Ford, Opel, Renault, Peugeot, Mazda, Hyundai, Honda, Kia, Nissan Renault, Toyota (D / DI / DTI / TD / TDI / CDI / CRDi / CDTi / JTD / EcoBlue) and many more.

📷2: Insert guide sleeve [E..] on the glow plug bore.

2. Insert the selected guide sleeve [E..] completely at the glow plug bore.

If the guide sleeve [E..] has been selected correctly, it should sit cleanly and without play in the glow plug bore.

ⓘ The guide sleeve [E6] and centring sleeve [E7] must also be fixed as described in 📷3.



e.g. Fiat / Mercedes



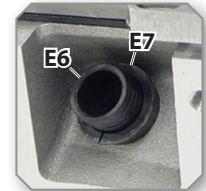
e.g. VW-Audi / BMW



e.g. Mercedes



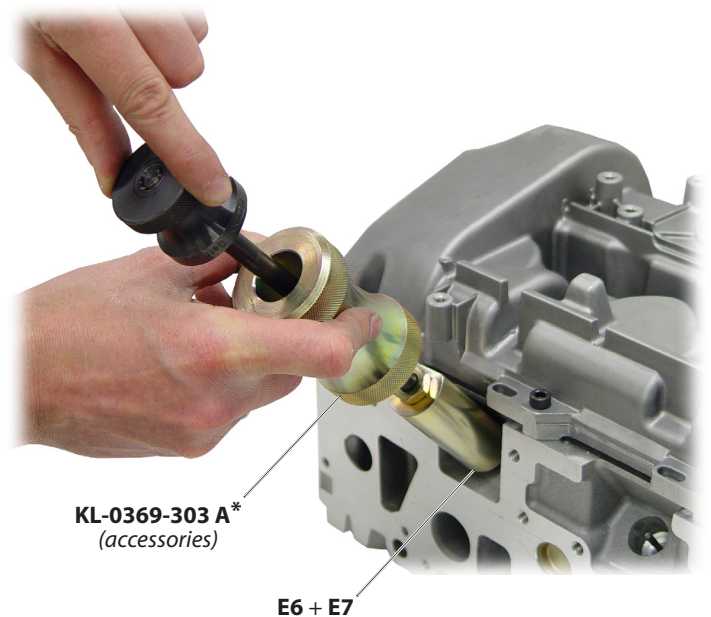
e.g. Ford



📷3: Only when using the guide sleeve [E6] and centring sleeve [E7], fix them additionally.

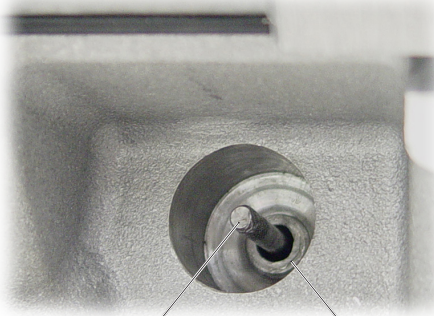
3. Using the **assembly tool - KL-0369-303 A*** - available as an accessory, additionally tighten the guide sleeve [E6] and centring sleeve [E7] in the glow plug hole by lightly tapping them.

ⓘ The sleeves [E6] + [E7] are removed later in reverse order!



* KL-0369-303 A consisting of: Impact extractor - KL-0049-100 A + base body - KL-0369-3031 B

4: If the centre electrode of the torn glow plug is protruding, drill it out or shorten it.



Middle electrode
of the glow plug

Collar
of the glow plug

ⓘ If the middle electrode of the torn glow plug is protruding, it must first be drilled down to the collar of the glow plug. This ensures that the core drill [F.] has a clean guide when drilling out the glow plug later.

Alternatively, the centre electrode can also be shortened using the roller extractor **KL-0369-300 A**, which is available as an *accessory*. However, the subsequent drilling of the glow plug must be carried out very carefully, otherwise the core drill [F.] may jam in the hole and be damaged!

CAUTION

When boring out chips can fling around and lead to **INJURIES** of the eyes. It is therefore essential to wear safety goggles!

CAUTION

The drill may be damaged. Therefore, carry out the drilling process carefully under slight pressure with a little oil and a maximum drilling speed of approx. **600rpm!**

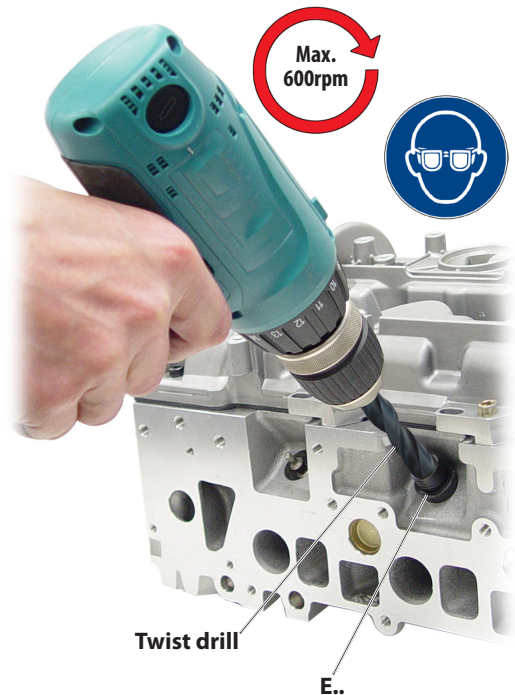
The cylinder head may be damaged! Therefore, only drill the middle electrode up to the collar of the glow plug at most!

4. Use a conventional twist drill on a drill to match the inside diameter of the guide sleeve [E..].

Now drill the middle electrode of the glow plug under slight pressure up to the collar of the glow plug. Interrupt the drilling process several times to remove chips and oil the twist drill.



Twist drill



Max.
600rpm



Twist drill

E..



As an alternative, use the roller extractor **KL-0369-300 A** (accessory).

Glow plug middle electrode

5: Insert the adapter [A3] together with a suitable socket into a drill.



Drill

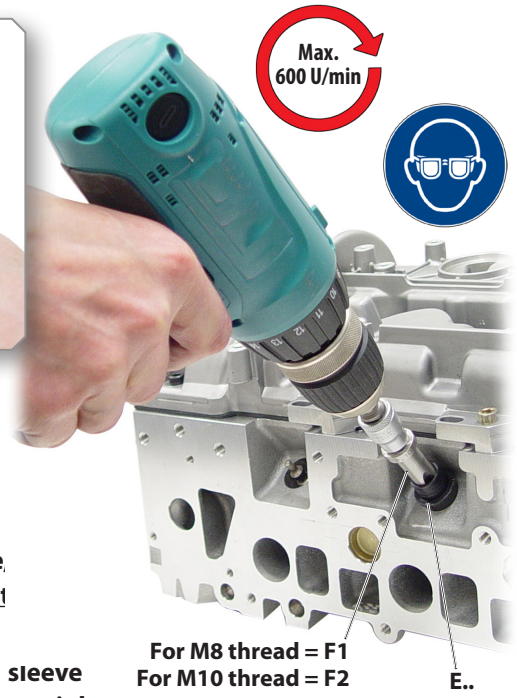
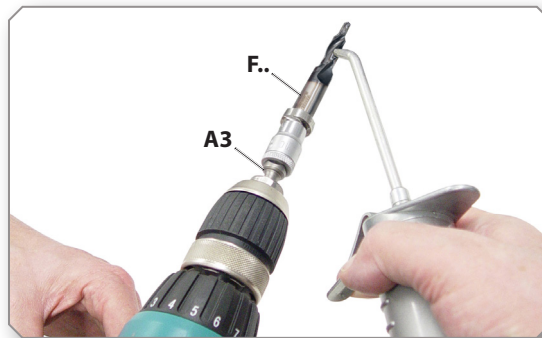
A3

3/8"
size (waf) 10mm

5. Insert the adapter [A3] together with a socket spanner insert (3/8" - size (waf) 10mm) on the drill.

3.2 Boring out the glow plug

📷6: Coat the core drill [F1] or [F2] with oil and drill out the glow plug.



⚠️ CAUTION

When boring out chips can fling around and lead to **INJURIES** of the eyes. It is therefore essential to wear safety goggles!

CAUTION

The core drill [F..] and cylinder head may be damaged. Therefore, carry out the drilling process carefully under slight pressure with a little oil and a maximum drilling speed of approx. 600rpm!

The cylinder head can be damaged when drilling without a guide sleeve [E..]. Therefore, when drilling without a guide sleeve, always ensure straight guidance and exact drilling depth!

- Depending on the glow plug thread, insert a suitable core drill bit [F..] into the drill.
Now drill out the glow plug under slight pressure until the core drill bit [F..] rests on the guide sleeve [E..]. Interrupt the drilling process several times to remove chips and oil the core drill.

For M8 thread = F1
For M10 thread = F2

E..

📷7: Coat the tap [G..] with spirit and recut the glow plug receiving thread.



CAUTION

The tap [G..] and cylinder head may be damaged. Therefore, always add a little spirit to the tap during the cutting process! When recutting without a guide sleeve [E..], always ensure straight guidance and exact drilling depth yourself!

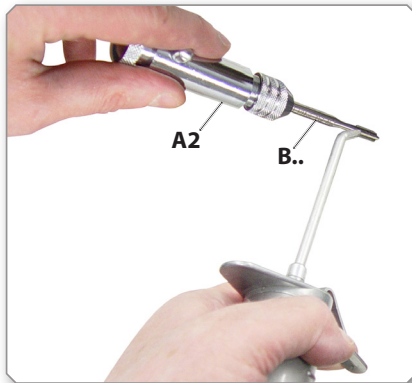
- Insert the tap [G..] on a T-handle with a socket, size (waf) 10mm, or similar.
Now recut the glow plug mounting thread until the tap [G..] rests on the guide sleeve [E..]. Interrupt the cutting process several times to remove chips and add spirit to the tap.

M8x1 thread = G1
M10x1 thread = G2
M10x1,25 thread = G3

E..

3.3 Removing the glow plug element

8: Coat tap [B..] with oil and cut a 5mm deep thread on the glow plug.

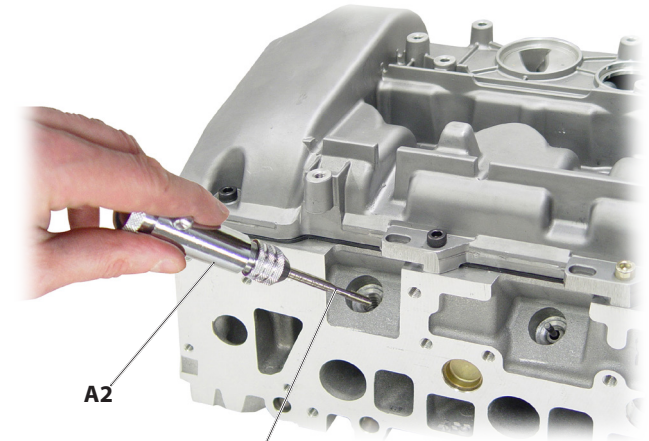


CAUTION

The tap [B..] can be damaged.
Therefore, always add a little oil to the tap during the cutting process!

1. First remove the guide sleeve [E..].

Now insert the tap [B..] into the tool holder [A2] and cut a **5mm** deep thread into the glow plug. Interrupt the cutting process several times to remove chips and oil the tap.



For M8 glow plugs = B1
For M10 glow plugs = B2

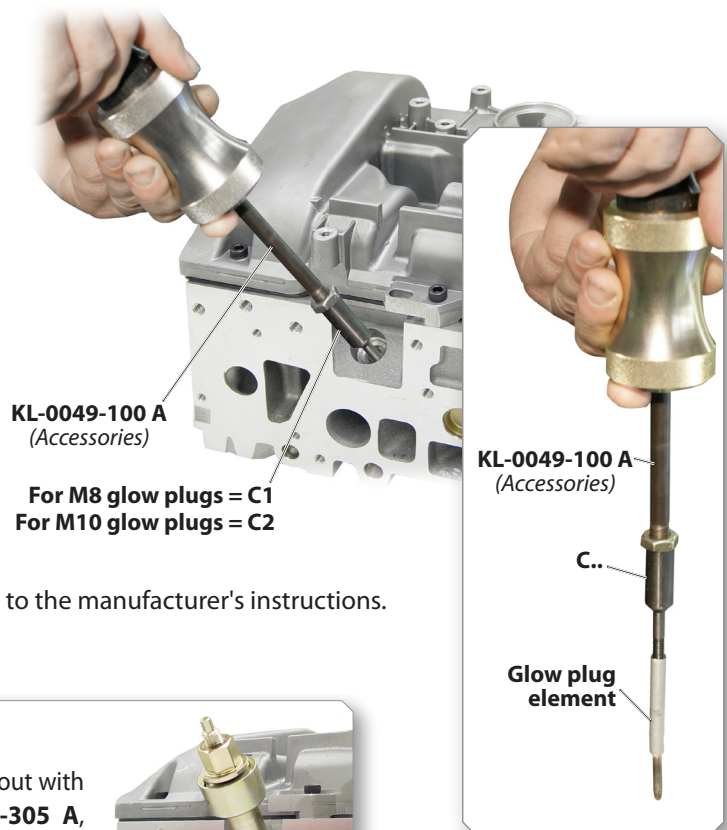
9: Screw in the pull bolt [C..] on the glow plug element and pull it out.

CAUTION

The engine may be damaged!
Therefore, remove any chips and impurities before pulling out the glow plug element!

2. Screw the pull bolt [C..] together with the **impact extractor** - KL-0049-100 A, available as an accessory, completely into the glow plug.

Now pull the glow plug out of the cylinder head by pressing the impact weight.



KL-0049-100 A
(Accessories)

For M8 glow plugs = C1
For M10 glow plugs = C2

KL-0049-100 A
(Accessories)

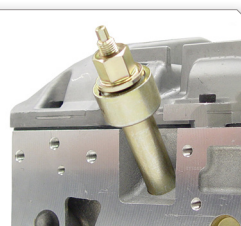
C..

Glow plug element

3. Finally, check the glow plug mounting thread.

- If this is OK, screw in the glow plug according to the manufacturer's instructions.
- If this is damaged, continue with **chapter 3.4**

① Extremely stuck glow plugs can be pulled out with the help of the **extraction tool KL-0369-305 A**, which is available as an accessory.



3.4 Repairing the defective mounting thread, if necessary

📷 10: Coat the core drill [F2] or [F3] with spirit and drill out the damaged glow plug mounting hole.

⚠ CAUTION

When boring out chips can fling around and lead to **INJURIES** of the eyes. It is therefore essential to wear safety goggles!

CAUTION

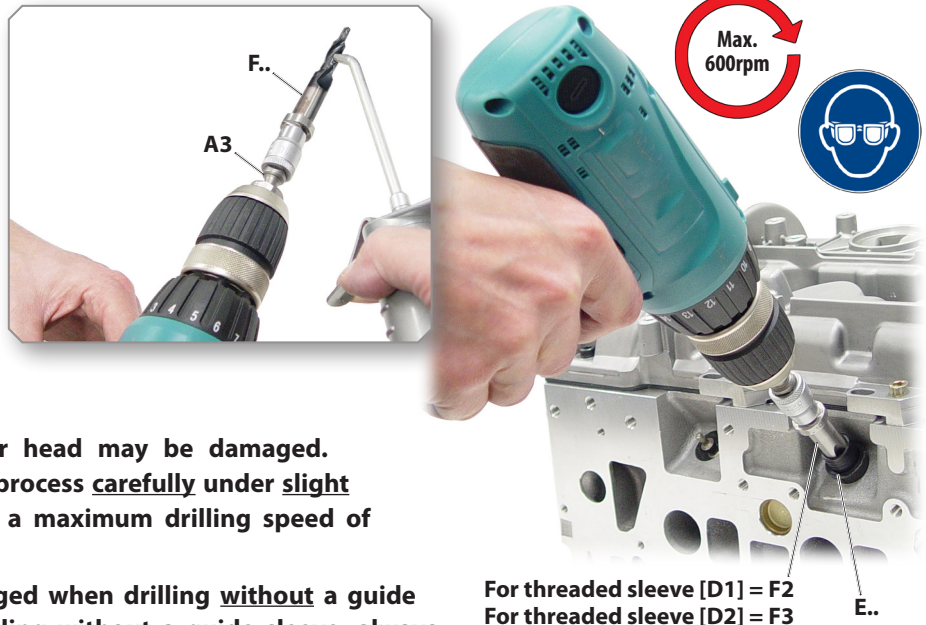
The core drill [F..] and cylinder head may be damaged. Therefore, carry out the drilling process carefully under slight pressure with a little spirit and a maximum drilling speed of approx. **600rpm**!

The cylinder head can be damaged when drilling without a guide sleeve [E..]. Therefore, when drilling without a guide sleeve, always ensure straight guidance and exact drilling depth!

The motor can be damaged by chips. For this reason, close the glow plug mounting hole downwards before drilling, for example with a sawed-off glow plug!

1. To insert a threaded sleeve [D..], depending on the glow plug thread use the appropriate core drill [F..] on the drill.

Drill the glow plug mounting hole under slight pressure until the core drill [F..] rests on the guide sleeve [E..]. Interrupt the drilling process several times to remove chips and add spirit to the core drill.



For threaded sleeve [D1] = F2
For threaded sleeve [D2] = F3

Sawed-off glow plug

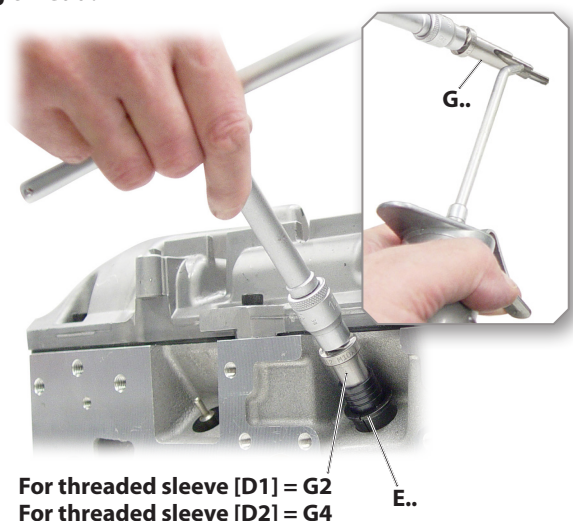
📷 11: Coat the tap [G4] with spirit and cut the glow plug mounting thread.

⚠ CAUTION

The tap [G4] and cylinder head may be damaged. Therefore, always add a little spirit to the tap during the cutting process! When cutting without a guide sleeve [E..], always ensure straight guidance and exact drilling depth yourself!

2. Depending on the glow plug thread, use the appropriate tap [G..] on a T-handle with socket spanner insert, **size (waf) 10mm** - or similar.

Now cut the glow plug mounting thread for the **threaded sleeve [D..]** until the tap [G..] rests on the guide sleeve [E..]. Interrupt the cutting process several times to remove chips and add spirit to the tap.



For threaded sleeve [D1] = G2
For threaded sleeve [D2] = G4

3. Then remove the guide sleeve [E..] from the glow plug hole and cut the thread again with the tap [G..] until it stops. The thread depth must be at least **15mm** in order to be able to fully screw in the threaded sleeve [D..] later.

12: Screw in the appropriate threaded sleeve [D..] on the cylinder head.

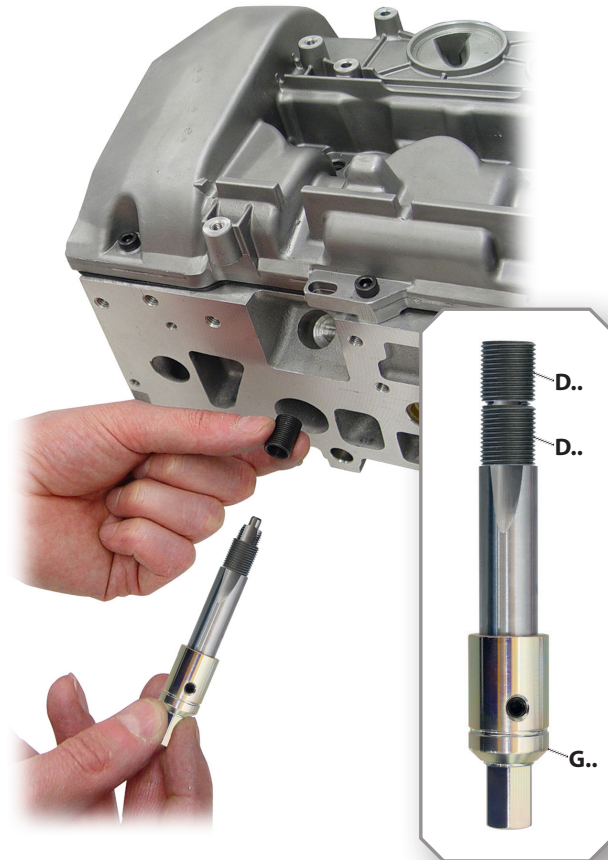
CAUTION

The cylinder head and the glow plug can be damaged. Therefore, always screw in the threaded sleeve [D..] all the way to the stop on the cylinder head so that the collar of the threaded sleeve does not protrude from the glow plug bore under any circumstances!

4. Depending on the glow plug thread, screw two suitable threaded sleeves [D..] onto a tap [G..]. The second threaded sleeve only serves as a screwing aid!

Now screw one threaded sleeve completely into the glow plug hole as far as it will go. Then jerk the tap [G..] out again so that the one threaded sleeve [D..] remains in the cylinder head.

5. Finally, screw in the glow plug according to the manufacturer's instructions.



4. CARE / STORAGE

CAUTION

Improper care and storage can cause damage to the glow plug tool. **Never** immerse the glow plug 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 clutch glow plug tool and the operating instructions at a dry and clean place.

5. REPAIR

WARNING

For safety reasons, ensure that a damaged glow plug 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**.

6. ENVIRONMENTALLY COMPLIANT DISPOSAL

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