

The ONLY Industrial Quality Internal/External Thread Restoration Kit Available!

# In The Shop, The Field, Or At Sea; The Only Thread Restoration Kit You'll Ever Need.

AVAILABLE  
THROUGH GSA BY USING  
NSN 5136-01-513-6996  
ORDER YOURS TODAY!



The Four Star Products C5203 Tap and Die Rethreading Kit is the only commercially available American Standard and Metric kit that contains the Four Star Split Die® Thread Chasers and Gorilla® Thread Pitch/Bolt Sizer. It's comprised of 100% industrial quality, professional grade thread repair tools, protected by a lifetime warranty. These thread restoration tools are ideal for automotive, heavy equipment, marine and small component repair operations. Every tool in the C5203 kit meets or exceeds the government standard published for thread repair equipment used today by U.S. Army and Marine Corps combat and support units, and aboard U.S. Navy warships.



**FACT:** Replacement nuts, bolts and threaded components are not always available and can be costly.

**THE C5203 KIT:** Reduces the need to find or buy replacement fasteners or threaded components, and provides the peace of mind of knowing the repaired fastener is the original, and eliminates the concern that aftermarket replacements are too long/short or the correct hardness. The Gorilla also makes finding suitable bolts and nuts a snap.

**FACT:** Military and commercial equipment frequently have both American Standard and Metric threads installed, increasing the potential for cross-threading. Threads can also be damaged by excessive load and wear.

**THE C5203 KIT:** Includes the Gorilla® Bolt Sizer/Thread Pitch Gauge that allows accurate measurement of diameters and thread pitch of internal and external threads to quickly and accurately identify National Coarse, National Fine or Metric, and the hardness of most bolts. This kit consists of the rethreading taps and split dies necessary to repair the National Coarse, National Fine sizes between 1/4 - 9/16, and metric sizes 6mm-14mm, normally found on today's equipment.

**FACT:** The first few threads carry most of the torque and load, and are the ones damaged most frequently, which requires difficult, and time consuming thread filing on hardened bolts, and makes starting a standard tap straight into a threaded hole nearly impossible.

**THE C5203 KIT:** Includes the Split Die® Thread Chasers. Simply place behind the damaged area and rotate over the damaged threads with a standard socket or box wrench. The internal rethreading taps are designed for easy use, tapered to start in a hole where the first few threads are damaged.

**FACT:** Installing thread inserts and coils to repair internal/female threads is time consuming and won't fix external/male threads. Installing inserts properly takes time and significant skill and expensive installation kits, and should be used only when unavoidable.

**THE C5203 KIT:** Our rethreading taps allow repair of most threaded holes, that are not stripped completely, in a couple of minutes.

**FACT:** Standard taps and dies are designed to cut new threads, not fix existing threads.

**THE C5203 KIT:** The Split Dies® and rethreading taps' cutting surfaces are different than standard taps and dies and are built to a specific hardness to restore damaged threads rather than cut a new path through metal.

**FACT:** The fastest and least expensive way to fix threads is with industrial quality thread chasers and thread taps.

**THE C5203 KIT:** Contains only industrial quality, professional grade components manufactured in the USA. Rockwell hardness, marking, and finish of each component passes our Triple Check Quality Control inspection. Since 1988, thousands of Four Star Products' Thread Repair Kits have been sold for use in commercial and industrial facilities, and the U.S. Military. Don't be fooled by thread repair kits made for occasional use with "as seen on TV" prices.

**FACT:** For successful thread repair, a repair kit needs industrial quality tools that are manufactured to perform in any environment.

**THE C5203 KIT:** Stores these quality tools in a compact container. Every component is designed to be used daily with only normal cleaning and preservation. Built to last a lifetime with a 100% manufacturers warranty that covers the entire kit. This kit requires no specialized training, techniques or additional tools to accomplish thread restoration in most applications.

# The Simple Time Saver™

It took a career mechanic to make it happen, but the old ways of thread repair are now obsolete!

The Simple Time Saver™ — the Split Die Thread Repair System — is a revolutionary, patented system for repairing damaged threads on bolts and studs. With the Split Die Thread Repair System, what used to take hours can now be accomplished in minutes — without the frustration... without the skinned knuckles... without the loss of commission or profit.

The benefits of the Split Die Thread Repair System have been demonstrated over years of use and documented in a broad range of field applications. The versatility of this product is virtually endless.

## Here's what our customers say:

It took only 20 minutes using Four Star's Split Die Repair Tool to rethread the motor shaft on a centrifuge unit. To disassemble, machine thread, and reassemble would have taken 5 hours. We realized a savings of 4 hours, 40 minutes or \$313 on this first use.

*National Institutes of Health  
Bethesda, Maryland*

In the tire sales and auto repair business the most common problem is wheel stud damage. This damage usually occurs on the end or halfway down the stud's threads.

By applying the Split Die beneath the damaged area we are able to accurately clean the outer threads. Other chasers or dies actually try to make new threads that would not always match inner threads, in essence creating two different sets of thread pitch, making it impossible to properly seat the lug.

We use "The Simple Time Saver" more than once per day, saving between \$18 and \$36 per wheel, and it's improved our customer relations significantly.

*Southern Tire & Auto  
Lexington Park, Maryland*

Many times a stud is damaged at the very end. A normal die cannot repair this damage because it has no threads to catch as a starting point. Using the Split Die Thread Repair Tool, a wheel stud that had to be replaced can now be repaired, saving up to an hour in labor and \$19 on each stud that needs to be repaired.

*Waldorf Tire  
Waldorf, Maryland*

Reduced downtime on punch press and pump repairs by 50% to 60%. Avoided complete teardown of equipment using the Four Star product. The tools paid for themselves the first time they were used.

*Square "D" Company  
Lexington, Kentucky*

***The Simple Time Saver can pay for itself with the very first use. And it's designed and manufactured to last a lifetime. Start cutting your costs and increasing profits. Order The Simple Time Saver™ today!***

***All Four Star products are unconditionally guaranteed. Return the damaged item and a replacement will be sent.***

# The Gorilla™

## Stainless Steel Bolt Sizer/Thread Pitch Gauge

This popular (over 100,000 sold), revolutionary tool is a union between the thread pitch gauge and bolt sizer. Used by the United States Armed Forces, it's designed for use under the most extreme conditions, where speed, accuracy and durability are essential to survival.

**99% STAINLESS STEEL**, it's not only rust proof, but virtually indestructible. Valuable to both the novice and professional, the Gorilla fits in the palm of your hand. Only 3½" in length, 1½" wide and ½" thick, its slim profile will comfortably slip into your pocket and the predrilled 3/16" hole will allow you to attach the Gorilla to your tool belt. Edges on the top and bottom plate, as well as the bolt sizer blades, have been rounded over.

It will accurately measure the thread pitch on your bolts, and its slim blade design will also indicate the thread pitch on nuts as small as ¼" or 5mm in metric. The bolt sizer blades are machine stamped with both the bolt diameter and the correct wrench size needed for installation. From now on you'll take only one wrench or socket from your tool box, no more guessing with a handful of tools. The back panel has a clearly marked bolt grade chart, a valuable feature when trying to match materials in the field.

The Gorilla is built using center assembly locking screws, ensuring a lifetime of service. Black oxidized tension wheels are ribbed for a firm non-slip grip. Loosening the tension wheels will allow you to easily select the blade you need, and slide the others safely back into the tool's frame. Realizing that the Gorilla will be used in many difficult situations, finger notches were cut into the tool, allowing you to maintain a firm hold.

### Three tools-in-one: Bolt Sizer, Thread Pitch Gauge, and Bolt Grade Chart, all in one tough, compact unit.

Bolt sizer blades are marked with bolt diameter and wrench size.

All markings are machine stamped for durability.

Edges on bolt sizer blades and top and bottom plate are rounded over.

Bolt sizer blades start at ¼" and increase in 1/16" intervals to 1"; metric sizes start at 5mm and go to 24mm.

Center assembly locking screws ensure a lifetime of service.

Predrilled hole to allow attachment to tool belt.

A full set of common thread pitch gauges.

Back panel has a clearly marked bolt grade chart.

Finger notches ensure a firm grip in all conditions.

Black oxidized tension wheels, ribbed for non slip grip. Easily select the blade you need and fold the rest back into the tool.

**99% Stainless Steel**

**AMERICAN STANDARD: A98** (NSN 5210-01-455-2936)  
**METRIC: M98** (NSN 5210-01-455-2937)



# Follow these steps to easy thread repair...

## Gorilla® Gauge



Proper identification of threads is imperative to proper thread repair. Using the Gorilla® Bolt Sizer you can correctly identify thread pitch and bolt size in **American Standard and Metric**. In addition, a hardness chart has been stamped into the bottom plate of the Gorilla.

**ALL TOOLS UNCONDITIONALLY GUARANTEED!**

## Split Die® Thread Chaser



- 1** Pull apart the two halves of The Simple Time Saver®, taking care not to overstretch the retainer spring.
- 2** Place the die **BEHIND** the thread damage and release the spring tension.
- 3** Turn the die **COUNTER CLOCKWISE** using standard socket until repair is complete.

## Rethreading Taps



- 1** Identify the internal thread size of the threaded hole or bolt/stud that will be used.
- 2** Select the correct size tap and place some oil on the tap's threads and start it straight by hand into the threaded hole.



- 3** Use a socket or box end wrench to turn the tap into the hole, backing out half-a-turn a few times to allow tap to clean itself.

Please use your tools in a safe manner. Always wear safety goggles; never use an air wrench; place die fully into socket and do not over stretch springs. Using excessive force when turning taps can damage or break the tool. For best results, frequently apply thread oil to the tool's cutting edges.

# FOUR STAR SETS

## C5203 Rethreading Kit NSN#5136-01-513-6996

The only commercially available, 100% industrial quality, professional grade thread repair tools in American Standard and Metric. Kit contains the Four Star Split Die® Thread Chasers and Gorilla® Thread Pitch/Bolt Sizer. Also includes rethreading taps and thread files.

### Rethreading Dies

1/4-28NF	9/16-18NF	7/16-14NC	8mm-1.25	12mm-1.25
5/16-24NF	5/8-18NF	1/2-13NC	10mm-1.00	12mm-1.50
3/8-24NF	1/4-20NC	9/16-12NC	10mm-1.25	12mm-1.75
7/16-20NF	5/16-18NC	5/8-11NC	10mm-1.50	14mm-1.50
1/2-20NF	3/8-16NC	6mm-1.00	11mm-1.50	

### Rethreading Taps

1/4-20NC	9/16-12NC	1/2-20 NF	10mm-1.25	12mm-1.75
5/16-18NC	1/4-28NF	9/16-18NF	10mm-1.50	14mm-1.50
3/8-16NC	5/16-24NF	6mm-1.00	11mm-1.50	
7/16-14NC	3/8-24NF	8mm-1.25	12mm-1.25	
1/2-13NC	7/16-20NF	10mm-1.00	12mm-1.50	

### Other Kit Items

Gorilla A98-S American Standard	Metric Thread File #8
Gorilla M98-S Metric	Thread File Handles
American Standard Thread File #1	Assortment of Springs

## S0789 Split Dies NSN#5136-01-321-6789

Set contains seven (7) Split Die Thread Chasers to fit most small-vehicle lugs for easy repair.

7/16-20NF	10mm-1.25	12mm-1.50	14mm-1.50
1/2-20NF	12mm-1.25	12mm-1.75	

## S1489 Split Dies NSN#5136-01-355-3036

Set contains fourteen (14) Split Die Thread Chasers designed for light-/heavy-duty thread repair.

1/4-20NC	7/16-14NC	5/8-11NC	3/8-24NF	9/16-18NF
5/16-18NC	1/2-13NC	1/4-28NF	7/16-20NF	5/8-18NF
3/8-16NC	9/16-12NC	5/16-24NF	1/2-20NF	

## S2089 Split Dies NSN#5136-01-321-6790

Set contains twenty (20) Split Die Thread Chasers to give the mechanic a full range of sizes. The best-selling non-metric set.

1/4-20NC	1/2-13NC	7/8-9NC	3/8-24NF	5/8-18NF
5/16-18NC	9/16-12NC	1"-8NC	7/16-20NF	3/4-16NF
3/8-16NC	5/8-11NC	1/4-28NF	1/2-20NF	7/8-14NF
7/16-14NC	3/4-10NC	5/16-24NF	9/16-18NF	1"-14NF

## S0891M Split Dies NSN#5136-01-355-3034

This metric set can get you out of a jam in a hurry. Contains eight (8) of the most popular metric Split Die Chasers.

5mm-0.80	8mm-1.00	12mm-1.50	20mm-2.50
6mm-1.00	10mm-1.25	16mm-1.50	24mm-2.00

## S1991M Split Dies NSN#5136-01-355-3035

Our largest and best-selling metric set contains eighteen (18) Split Die Thread Chasers in a full range of sizes.

5mm-0.80	9mm-1.00	10mm-1.50	12mm-1.75	20mm-2.50
6mm-1.00	9mm-1.25	11mm-1.50	14mm-1.25	24mm-3.00
8mm-1.00	10mm-1.00	12mm-1.25	14mm-1.50	
8mm-1.25	10mm-1.25	12mm-1.50	16mm-2.00	

Singles available. Call or email [fourstarproducts@olg.com](mailto:fourstarproducts@olg.com) for more information.

Kit S2089



Kit S1991M



Kit C5203



### HOW TO PLACE A GOVERNMENT ORDER

#### FOUR STAR PRODUCTS, INC

GSA CONTRACT #GS-06F-0018J • CAGE CODE 0GMC2  
FOUR STAR C5203 SET: BPA 6FEP-04-2160-E1-I

#### GORILLA TOOL COMPANY, LLC

GSA CONTRACT #GS-06F-0021J • CAGE CODE 1EZK2

ORDER DIRECTLY THROUGH GSA. Orders can be placed through automated FEDSTRIP, MILSTRIP, MUFFIN, or GSA's online ordering system known as GSA ADVANTAGE. For more information contact Kim Kittrell, Contract Specialist, phone (816) 823-1288, Fax (816) 926-5019. For ordering assistance, contact the GSA Hardware Superstore in Kansas City, MO at (816) 926-7315 or DSN: 926-7315 or 926-7316. HomePage: <http://www.r6.gsa.gov/fss/hac/hardwarestore> • Email: [r6-f6eb@gsa.gov](mailto:r6-f6eb@gsa.gov).

Prices are subject to change. Customers will be billed by GSA at the price in effect when the order is placed.



Four Star Dies are patented; #4,872,790 & #4,968,190. The Gorilla™ patent is #6,047,606. Copyright ©2005 Four Star Products, Inc.