BAER GERMANY

BaerFix®

Thread Repair Kits

BaerFix® Thread Repair Kits

- Drill Bit HSS
- Inserting Tool with 1/4“ hexagonal drive
- Adapter Nut - 1/4“ hexagonal drive to 10 mm hexagonal drive
- BaerFix® Thread Insert with cutting slots
- Material: Case-hardened steel, zinc-plated
- Instruction for use

UNC Unified National Coarse Thread Series ANSI B1.1						No.	€
UNC 1/4 x 20	KEBW21	NUT	9,30 mm	5	FC001	52,60
UNC 5/16 x 18	KEBW22	NUT	11,40 mm	5	FC002	57,82
UNC 3/8 x 16	KEBW23	NUT	13,25 mm	5	FC003	75,53
UNC 7/16 x 14	KEBW24	NUT	15,25 mm	5	FC004	103,02
UNC 1/2 x 13	BEBW25*		17,00 mm	5	FC005	114,54

* Inserting Tool with 10 mm hexagonal drive instead of 1/4“ hexagonal drive

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UNF Unified National Fine Thread Series ANSI B1.1						No.	€
UNF 1/4 x 28	KEBW31	NUT	9,30 mm	5	FF001	52,60
UNF 5/16 x 24	KEBW32	NUT	11,40 mm	5	FF002	132,91
UNF 3/8 x 24	KEBW33	NUT	13,25 mm	5	FF003	68,68
UNF 7/16 x 20	KEBW34	NUT	15,25 mm	5	FF004	75,53
UNF 1/2 x 20	BEBW35*		17,00 mm	5	FF005	114,54

*Inserting Tool with 10 mm hexagonal drive instead of 1/4“ hexagonal drive

Instruction for use

1

Drilling

Clear the damaged thread with a drill bit or create a new hole in the parent material. For strong, hard and tough materials it is recommended to tap the thread (max. intermediate tap) before the installation of BaerFix® Inserts.

2

Screwing BaerFix® Insert on the inserting tool

Screw the BaerFix® Insert, with cutting slots or holes pointing downwards, on the inserting tool. Lock the BaerFix® Insert with the nut by wrench.

3

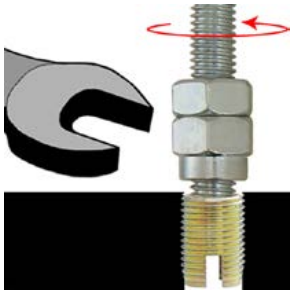
Installing the insert

Screw the BaerFix® Insert into the borehole. The BaerFix® Thread Insert is self-tapping. The inserting tool has a 1/4“ hexagonal shank and can be used by a cordless screwdriver or a wrench socket.

4

Screwing off the inserting tool

Unlock the counternut by a wrench and screw off the inserting tool. Created bolted connections with BaerFix® Inserts are vibration resistant, wear-free and have a high load capacity in materials with low shearing strength.



Installation by machine

1

Drilling

Clear the damaged thread with a drill bit or create a new hole in the parent material. For strong, hard and tough materials it is recommended to tap the thread (max. intermediate tap) before the installation of BaerFix® Inserts.

2

Configure the machine

Position the workpiece to ensure that hole and machine spindle are in alignment. Set the dimensions, speed values and driving depth (about 0,1 mm till 0,2 mm under the workpiece surface). Turn the external shell, so the stop pin can hold and drive the shell while rotating in clockwise direction. Screw the BaerFix® Insert, withcutting slots or holes pointing downwards, 2 till 4 windings on the inserting tool.

3

Installing the insert

Actuate the machine for screwing the insert into the hole, until the chosen driving depth is reached. Avoid a hard touchdown of the inserting tool on the workpiece to prevent damages on the inserting tool, thread insert or workpiece.

4

Screwing off the inserting tool

Set the machine on reverse running. The stop pin holds the shell while rotating in counterclockwise direction and screws out the inserting tool.

Please see values for speed and installation torque on page 23.

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