



BaerFix[®]

Thread Repair Kits





BaerFix® Thread Repair Kits - ECO

- 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

M	ISO metric thread				No.	€
M 2 x 0,4	EBS02*		4,20 mm	5	F001	20,54
M 2,5 x 0,45	EBS025*		4,20 mm	5	F002	20,54
M 3 x 0,5	KEBW03	NUT	4,70 mm	5	F003	20,54
M 4 x 0,7	KEBW04	NUT	6,10 mm	5	F004	20,54
M 5 x 0,8	KEBW05	NUT	7,50 mm	5	F005	21,63
M 6 x 1,0	KEBW06	NUT	9,30 mm	5	F006	20,54
M 8 x 1,25	KEBW08	NUT	11,40 mm	5	F008	22,82
M 10 x 1,5	KEBW10	NUT	13,25 mm	5	F010	28,59
M 12 x 1,5	KEBW1215	NUT	15,25 mm	5	F0125	59,07
M 12 x 1,75	KEBW12	NUT	15,25 mm	5	F012	33,15
M 14 x 1,5	BEBW1415*		17,00 mm	5	F0145	63,04
M 14 x 2,0	BEBW1420*		17,00 mm	5	F014	71,07
M 16 x 2,0	EBS16**		19,00 mm	5	F016	73,36
M 18 x 2,5	EBS18**		21,00 mm	5	F018	97,49
M 20 x 2,5	EBS20**		25,00 mm	5	F020	97,49

* Inserting Tool with 12 mm hexagonal drive instead of 1/4" hexagonal drive

** with EBS-Inserting Tool instead of Inserting Tool with 1/4" hexagonal drive

BaerFix® Thread Repair Kits - PRO

- Drill Bit HSS
- Countersink HSS with 1/4" hexagonal drive
- 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



M	ISO metric thread				No.	€
M 3 x 0,5	KEBW03	NUT	10,4 mm	4,70 mm	F003P	32,72
M 4 x 0,7	KEBW04	NUT	10,4 mm	6,10 mm	F004P	32,72
M 5 x 0,8	KEBW05	NUT	10,4 mm	7,50 mm	F005P	32,72
M 6 x 1,0	KEBW06	NUT	10,4 mm	9,30 mm	F006P	32,72
M 8 x 1,25	KEBW08	NUT	16,5 mm	11,40 mm	F008P	37,28
M 10 x 1,5	KEBW10	NUT	16,5 mm	13,25 mm	F010P	44,56
M 12 x 1,75	KEBW12	NUT	16,5 mm	15,25 mm	F012P	51,63

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

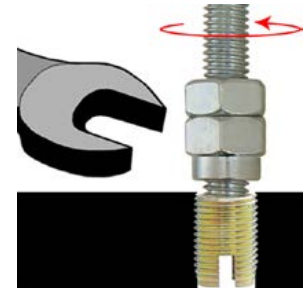
Screw the BaerFix® Insert into the borehole. The BaerFix® Thread Insert is self-tapping. The inserting tool has a 1/4" hexagonal shank and can be used by a cordless screwdriver or a wrench socket.



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, with cutting 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.



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



BAER Vertriebs GmbH
Robert-Bosch-Str. 5
68542 Heddesheim
Germany

Tel: +49 (0) 6203 4048 790
Fax: +49 (0) 6203 4048 791
E-Mail: info@baercoil.com
www.baerfix.com

BaerFix[®]