

BaerCoil[®]



Thread Repair Kits





Thread repair

Besides thread reinforcement, the BaerCoil® thread insert also enable the repair of damaged threads. Rejected parts can be saved while maintaining the original thread size. Additionally, the thread is strengthened in its pull-out- and corrosion resistance. In maintenance the use of these thread inserts saves procurement- and processing costs for spare parts. BaerCoil® thread repair sets are suitable for repairing the thread size/thread type. These sets can also be used to change threads that have the same diameter, e.g. from regular thread to fine thread. The distinctive feature is that the repaired thread is decidedly more durable and firmer than the original thread (thread reinforcement).

Instruction for use

1

Drilling

Clear the damaged thread with a standard drill. Many kits include the correct drill. To repair a spark plug thread no pre-drilling is necessary if using the special spark plug tap with pilot nose. Optionally you can countersink the borehole.



2

Tapping

Use the special BaerCoil® tap for cutting the holding thread into the cleared hole. The BaerCoil® taps are suitable for blind- and through holes. It's recommended to use a suitable cutting oil.



3

Install the insert

Place insert on installing tool and position the adjustable ring so that the insert tang is centred in the tang slot. Wind insert in with light downward pressure until 1/4 to 1/2 turn below the surface. Do not turn against direction of rotation, because the tang can break.



4

Tang removal

Lift the inserting tool from tang and place the tang break tool over the tang and tap down sharply. For bigger sizes and spark plug use a long nose pliers to remove the tang.



Adjustment of length

If necessary, you can shorten BaerCoil® Wire Thread Inserts by side cutting pliers to any needed length.

Compatibility

BaerCoil® wire thread inserts and tools are compatible with wire thread inserts and tools from other manufacturers, in most cases. BaerCoil® inserts are mainly manufactured according to DIN 8140 so they have the same dimensions. Other standards like DIN65536, EN2944, LN9039, LN9490, LN9499, NASM21209, AS4736 to 4748, to 3799, MA3279 to 3281 and NASM214850 ect. are available, too. Compatibility cannot be guaranteed, so it is always recommended to test from case to case.



BaerCoil® Thread Repair Kits - PRO

- Drill HSS
- STI Machine Tap HSSG
- Machine Inserting Tool with 1/4" hexagonal drive
- Tang Break Tool
- Wire Thread Inserts - type: "free running" - lengths: **1,5 D - 2,0 D - 2,5 D**
- **different lengths for most applications**
- Instruction for use

M ISO metric thread

					1,5 D	2,0 D	2,5 D	No.	€
M 3 x 0,5	KEBW03	BZ003	3,2 mm	10	5	5	5	B40054	24,57
M 4 x 0,7	KEBW04	BZ004	4,2 mm	10	5	5	5	B40074	24,57
M 5 x 0,8	KEBW05	BZ005	5,2 mm	10	5	5	5	B40094	24,57
M 6 x 1,0	KEBW06	BZ006	6,3 mm	10	5	5	5	B40104	26,78
M 8 x 1,25	KEBW08	BZ008	8,3 mm	10	5	5	5	B40124	32,97
M 10 x 1,5	KEBW10	BZ010	10,4 mm	5	5	5	5	B40164	36,96
M 12 x 1,75	KEBW12	BZ012	12,4 mm	5	5	5	5	B40214	41,90

BaerCoil® Thread Repair Kits for blind holes

- Drill HSS
- STI Machine Tap HSSG
- Machine Inserting Tool with 1/4" hexagonal drive
- Tang Break Tool
- Wire Thread Inserts - type: "free running" - lengths: **1,5 D - 2,0 D - 2,5 D**
- **different lengths for most applications**
- Instruction for use



M ISO metric thread

					1,5 D	2,0 D	2,5 D	No.	€
M 3 x 0,5	EBW03	BZ003	10,4 mm	3,2 mm	10	5	5	B40055	38,43
M 4 x 0,7	EBW04	BZ004	10,4 mm	4,2 mm	10	5	5	B40075	38,43
M 5 x 0,8	EBW05	BZ005	10,4 mm	5,2 mm	10	5	5	B40095	38,43
M 6 x 1,0	EBW06	BZ006	10,4 mm	6,3 mm	10	5	5	B40105	38,43
M 7 x 1,0	EBW07	BZ006	10,4 mm	7,3 mm	10	5	5	B40115	57,02
M 8 x 1,25	EBW08	BZ008	10,4 mm	8,3 mm	10	5	5	B40125	57,54
M 10 x 1,5	EBW10	BZ010	16,5 mm	10,4 mm	10	5	5	B40165	59,54
M 12 x 1,5	EBW12	BZ012	16,5 mm	12,4 mm	5	5	5	B40225	75,81
M 12 x 1,75	EBW12	BZ012	16,5 mm	12,4 mm	5	5	5	B40215	75,81
M 14 x 1,5	EBW14		16,5 mm	14,4 mm	5	5		B40295	79,59
M 16 x 1,5	EBW14		16,5 mm		10			B40335	99,12
M 16 x 2,0	EBW14		16,5 mm		10			B40325	99,12



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