

BaerCoil[®]



**Thread Repair
Workshop Kits**



Installation by hand

1

Drilling

Clear the damaged thread with a standard drill bit. 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. BaerCoil® taps are suitable for blind- and through holes. It's recommended to use a suitable cutting oil.



3

Installing thread inserts

Place insert on installing tool and position the adjustable ring 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.



Installation by machine or electronic screwdriver

1

Drilling

Clear the damaged thread with a standard drill bit. Optionally you can countersink the borehole.



2

Tapping

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



3

Installing thread inserts

Position the work piece that bore and machine spindle are above each other. Set the counter nuts according the installation length (1/4 to 1/2 turn below the surface). Turn the thread insert onto the installation tool. Activate the machine so that the thread insert is screwed to the desired depth. After inserting screw the tool of the insert. Avoid any rough placement of the tool on the work piece so as to not damage the work piece, tool or thread insert.



4

Tang removal

Place the tang break tool over the tang and tap down sharply or work with a pneumatic tang break tool. For bigger sizes and spark plug use a long nose pliers to remove the tang. For bulk production automatic tang breaking tools are available, too.





BaerCoil® Thread Repair Workshop Kits - PRO

- Drill HSS
- STI Machine Tap HSSG
- Countersink HSS with 1/4" hexagon drive (bit shank)
- Machine Inserting Tool with 1/4" hexagon drive (bit shank)
- Tang Break Tool
- Wire Thread Inserts - type: "free running" - lengths **1,5 D - 2,5 D**
- **different lengths for most applications**

M 3 - M 12

					1,5 D	2,5 D	No.	€
M 3 x 0,5	KEBW03	BZ003		3,2 mm	10	5		
M 4 x 0,7	KEBW04	BZ004		4,2 mm	10	5		
M 5 x 0,8	KEBW05	BZ005	10,4 mm	5,2 mm	10	5		
M 6 x 1,0	KEBW06	BZ006		6,3 mm	10	5	B5103	177,98
M 8 x 1,25	KEBW08	BZ008		8,3 mm	10	5		
M 10 x 1,5	KEBW10	BZ010	16,5 mm	10,4 mm	5	5		
M 12 x 1,75	KEBW12	BZ012		12,4 mm	5	5		

M 5 - M 12

					1,5 D	2,5 D	No.	€
M 5 x 0,8	KEBW05	BZ005		5,2 mm	10	5		
M 6 x 1,0	KEBW06	BZ006	10,4 mm	6,3 mm	10	5		
M 8 x 1,25	KEBW08	BZ008		8,3 mm	10	5	B5106	163,28
M 10 x 1,5	KEBW10	BZ010	16,5 mm	10,4 mm	5	5		
M 12 x 1,75	KEBW12	BZ012		12,4 mm	5	5		



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