

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 - type: “screw grip”

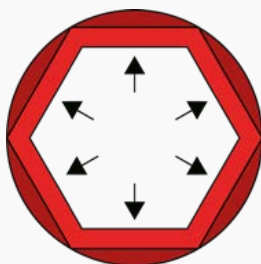
- Drill HSS
- STI Bottoming Tap HSSG
- Inserting Tool
- Tang Break Tool
- Wire Thread Inserts - type: “screw grip”
(screw locking) - length: 1,5 D
- for impact resistant and vibration resistant bolted connections (more information on page 4 - 7)
- Instruction for use



M ISO metric thread



				1,5 D	No.	€
M 3 x 0,5	EBW03	BZ003	3,2 mm	10	BS4005	21,95
M 4 x 0,7	EBW04	BZ004	4,2 mm	10	BS4007	21,95
M 5 x 0,8	EBW05	BZ005	5,2 mm	10	BS4009	21,95
M 6 x 1,0	EBW06	BZ006	6,3 mm	10	BS4010	21,95
M 8 x 1,25	EBW08	BZ008	8,3 mm	10	BS4012	31,08
M 10 x 1,25	EBW10	BZ010	10,3 mm	10	BS4015	33,02
M 10 x 1,5	EBW10	BZ010	10,4 mm	10	BS4016	33,02
M 12 x 1,75	EBW12	BZ012	12,4 mm	10	BS4021	37,38
M 14 x 2,0	EBW14		14,5 mm	5	BS4028	74,97
M 16 x 2,0	EBW14			5	BS4032	87,68
M 18 x 2,5	EBW18			5	BS4034	107,73
M 20 x 2,5	EBW20			5	BS4037	164,33
M 24 x 3,0	EBW24			5	BS4043	219,98
M 30 x 3,5	EBW30			5	BS4054	438,8



i see locking torque on page 7

BaerCoil® Wire Thread Inserts - type: “screw grip”

In addition to “free-running” insert characteristics, BaerCoil® “screw grip” thread inserts have one or more polygonformed windings, which have a clamping effect on the flanks of the inserted screw. We only recommend using screws with a higher screw property class (from 8.8 on), because of this screw locking or screw clamping effect. An elastic and flexible frictional connection is formed. The clamping torque is comparable to the indications in DIN 267 Part 15 and ISO 2320. BaerCoil® “screw grip” thread inserts are predominantly used in areas where screw connections must remain tight while exposed to tremors, constant vibrations and movements. Screw grip inserts are red-colored.



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