

BaerCoil[®]



**Thread Repair
Workshop 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

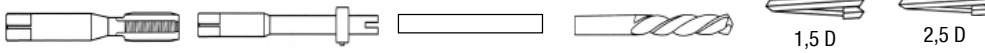
BaerCoil® wire thread inserts and tools are compatible with wire thread inserts and tools from other manufacturers, in most cases. BaerCoil® inserts are mainly manufactured according to DIN 8140 so they have the same dimensions. Other standards like DIN65536, EN2944, LN9039, LN9490, LN9499, NASM21209, 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.



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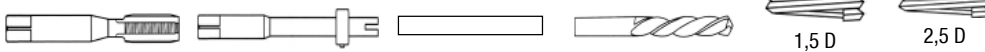
- Drill HSS
- STI Bottoming Tap HSSG
- Inserting Tool
- Tang Break Tool
- Wire Thread Inserts - type: "free running" - lengths: **1,5 D - 2,5 D**
- **different lengths for most applications**
- Instruction for use

M 3 - M 12



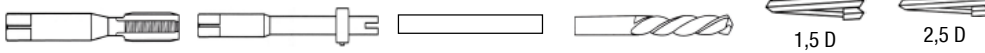
				1,5 D	2,5 D	No.	€
M 3 x 0,5	EBW03	BZ003	3,2 mm	10	5	B5101	161,91
M 4 x 0,7	EBW04	BZ004	4,2 mm	10	5		
M 5 x 0,8	EBW05	BZ005	5,2 mm	10	5		
M 6 x 1,0	EBW06	BZ006	6,3 mm	10	5		
M 8 x 1,25	EBW08	BZ008	8,3 mm	10	5		
M 10 x 1,5	EBW10	BZ010	10,4 mm	5	5		
M 12 x 1,75	EBW12	BZ012	12,4 mm	5	5		

M 5 - M 12



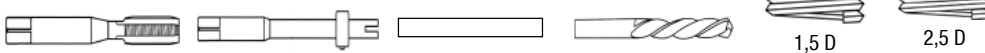
				1,5 D	2,5 D	No.	€
M 5 x 0,8	EBW05	BZ005	5,2 mm	10	5	B5104	123,38
M 6 x 1,0	EBW06	BZ006	6,3 mm	10	5		
M 8 x 1,25	EBW08	BZ008	8,3 mm	10	5		
M 10 x 1,5	EBW10	BZ010	10,4 mm	5	5		
M 12 x 1,75	EBW12	BZ012	12,4 mm	5	5		

M 5 - M 8



				1,5 D	2,5 D	No.	€
M 5 x 0,8	EBW05	BZ005	5,2 mm	10	5	B5131	86,84
M 6 x 1,0	EBW06	BZ006	6,3 mm	10	5		
M 8 x 1,25	EBW08	BZ008	8,3 mm	10	5		

M 6 - M 10



				1,5 D	2,5 D	No.	€
M 6 x 1,0	EBW06	BZ006	6,3 mm	10	5	B5130	97,76
M 8 x 1,25	EBW08	BZ008	8,3 mm	10	5		
M 10 x 1,5	EBW10	BZ010	10,4 mm	5	5		

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UNF 1/4 - 1/2"

				1,5 D	No.	€
UNF 1/4 x 28	EBW06	BZ006	6,6 mm	25		
UNF 5/16 x 24	EBW07	BZ008	8,3 mm	25		
UNF 3/8 x 24	EBW08	BZ008	9,9 mm	25	B5121	164,85
UNF 7/16 x 20	EBW10	BZ010	11,5 mm	10		
UNF 1/2 x 20	EBW12	BZ012	13,0 mm	10		

UNC 1/4 - 1/2"

				1,5 D	No.	€
UNC 1/4 x 20	EBW06	BZ006	6,7 mm	25		
UNC 5/16 x 18	EBW07	BZ008	8,3 mm	25		
UNC 3/8 x 16	EBW08	BZ008	9,9 mm	25	B5120	164,85
UNC 7/16 x 14	EBW10	BZ010	11,6 mm	10		
UNC 1/2 x 13	EBW12	BZ012	13,0 mm	10		

BSW 1/4 - 1/2"

				1,5 D	No.	€
BSW 1/4 x 20	EBW06	BZ006	6,7 mm	25		
BSW 5/16 x 18	EBW07	BZ008	8,3 mm	25		
BSW 3/8 x 16	EBW08	BZ008	9,9 mm	25	B5122	164,85
BSW 7/16 x 14	EBW10	BZ010	11,6 mm	10		
BSW 1/2 x 12	EBW12	BZ012	13,0 mm	10		

BSF 1/4 - 1/2"

				1,5 D	No.	€
BSF 1/4 x 26	EBW06	BZ006	6,6 mm	25		
BSF 5/16 x 22	EBW07	BZ008	8,3 mm	25		
BSF 3/8 x 20	EBW08	BZ008	9,9 mm	25	B5123	164,85
BSF 7/16 x 18	EBW10	BZ010	11,5 mm	10		
BSF 1/2 x 16	EBW12	BZ012	13,0 mm	10		

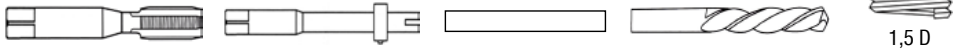


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G (BSP)

British Standard Pipe Thread DIN ISO 228



					No.	€
G (BSP) 1/8 x 28	EBW10	BZ010	10,0 mm	5	B5124	252,00
G (BSP) 1/4 x 19	EBW12	BZ012	13,5 mm	5		
G (BSP) 3/8 x 19	EBW14		17,0 mm	5		
G (BSP) 1/2 x 14	EBW22			5		

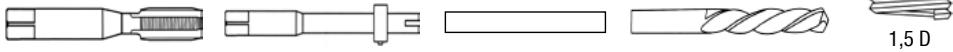
Please note:

The outside diameter of 1" pipe thread is 33.25 mm (not 25.4 mm)!

However, the length of the thread insert is calculated with the value 25.4 mm: e.g.: length 1,5 D at G 1/4 x 19: 1/4 x 25,4 mm x 1,5 = **9,525 mm**

BA

British Association Standard Thread BS 93

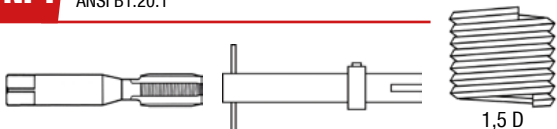


					No.	€
BA 0	EBW06	BZ006	6,2 mm	5	B5125	265,65
BA 2	EBW05	BZ005	4,9 mm	5		
BA 4	EBW03	BZ003	3,8 mm	5		
BA 6	EBW02	BZ002	2,9 mm	5		

leading time: 1 - 3 weeks

NPT

American Taper Pipe Thread
ANSI B1.20.1



				No.	€
NPT 1/8 x 27	EBW10	5	B5126	438,90	
NPT 1/4 x 19	EBW14	5			
NPT 3/8 x 18	EBW14	5			
NPT 1/2 x 14	EBW22	5			



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