

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

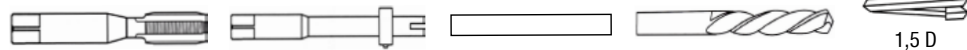
BaerCoil® wire thread inserts and tools are compatible with wire thread inserts and tools from other manufacturers, in most cases. BaerCoil® inserts are mainly manufactured according to DIN 8140 so they have the same dimensions. Other standards like DIN65536, EN2944, LN9039, LN9490, LN9499, NASM21209,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

- Drill HSS
- STI Bottoming Tap HSSG
- Inserting Tool
- Tang Break Tool
- Wire Thread Inserts - type: "free running" - length: 1,5 D
- Instruction for use



M ISO metric thread



					1,5 D	No.	€
M 2 x 0,4	EBW01	BZ001	2,1 mm	20	B4001	22,05	
M 2,2 x 0,45	EBW01	BZ001	2,3 mm	20	B4002	48,09	
M 2,5 x 0,45	EBW02	BZ002	2,6 mm	20	B4003	21,32	
M 3 x 0,5	EBW03	BZ003	3,2 mm	20	B4005	21,32	
M 3,5 x 0,6	EBW03	BZ003	3,7 mm	20	B4006	21,32	
M 4 x 0,7	EBW04	BZ004	4,2 mm	20	B4007	21,32	
M 5 x 0,8	EBW05	BZ005	5,2 mm	20	B4009	21,84	
M 6 x 0,75	EBW06	BZ006	6,3 mm	10	B0675	72,45	
M 6 x 1,0	EBW06	BZ006	6,3 mm	20	B4010	21,95	
M 7 x 1,0	EBW07	BZ006	7,3 mm	20	B4011	30,45	
M 8 x 0,75	EBW08	BZ008	8,3 mm	10	B0875	72,45	
M 8 x 1,0	EBW08	BZ008	8,3 mm	20	B4013	30,45	
M 8 x 1,25	EBW08	BZ008	8,3 mm	20	B4012	29,19	
M 9 x 1,0	EBW08	BZ008	9,3 mm	10	B0091	72,45	
M 9 x 1,25	EBW08	BZ008	9,3 mm	15	B4014	33,81	
M 10 x 1,0	EBW10	BZ010	10,3 mm	15	B4018	32,34	
M 10 x 1,25	EBW10	BZ010	10,3 mm	15	B4017	32,34	
M 10 x 1,5	EBW10	BZ010	10,4 mm	15	B4016	30,98	
M 11 x 1,0	EBW10	BZ010	11,4 mm	5	B0111	79,59	
M 11 x 1,25	EBW10	BZ010	11,4 mm	5	B1125	79,59	
M 11 x 1,5	EBW10	BZ010	11,4 mm	10	B4019	36,75	
M 12 x 1,0	EBW12	BZ012	12,3 mm	10	B4024	36,75	
M 12 x 1,25	EBW12	BZ012	12,3 mm	10	B4023	36,75	
M 12 x 1,5	EBW12	BZ012	12,4 mm	10	B4022	36,23	
M 12 x 1,75	EBW12	BZ012	12,4 mm	10	B4021	36,54	
M 13 x 1,25	EBW12		13,25 mm	5	B1315	103,95	
M 13 x 1,5	EBW12		13,25 mm	5	B1325	93,45	
M 14 x 1,0	EBW14		14,4 mm	10	B4031	41,16	
M 14 x 1,25	EBW14		14,4 mm	10	B4030	41,16	
M 14 x 1,5	EBW14		14,4 mm	10	B4029	40,43	
M 14 x 2,0	EBW14		14,5 mm	10	B4028	40,64	
M 15 x 1,5	EBW14			5	B1515	132,30	
M 15 x 2,0	EBW14			5	B1520	132,30	
M 16 x 1,5	EBW14			10	B4033	49,56	
M 16 x 2,0	EBW14			10	B4032	49,56	

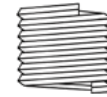
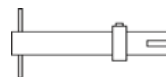
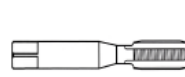
For sizes bigger than M 13 use a long nose pliers to remove the tang.



BaerCoil® Thread Repair Kits

- STI Bottoming Tap HSSG
- Inserting Tool
- Wire Thread Inserts - type: "free running" - length: 1,5 D
- Instruction for use

M ISO metric thread



1,5 D

No.

€

M	EBW	1,5 D	No.	€
M 18 x 1,5	EBW18	5	B4036	60,90
M 18 x 2,0	EBW18	5	B4035	60,90
M 18 x 2,5	EBW18	5	B4034	60,90
M 20 x 1,5	EBW20	5	B4039	66,15
M 20 x 2,0	EBW20	5	B4038	66,15
M 20 x 2,5	EBW20	5	B4037	66,15
M 22 x 1,5	EBW22	5	B4042	76,65
M 22 x 2,0	EBW22	5	B4041	76,65
M 22 x 2,5	EBW22	5	B4040	76,65
M 24 x 1,5	EBW24	5	B4045	88,20
M 24 x 2,0	EBW24	5	B4044	88,20
M 24 x 3,0	EBW24	5	B4043	88,20
M 26 x 1,5	EBW26	5	B4049	250,00
M 27 x 1,5	EBW27	5	B4052	250,00
M 27 x 2,0	EBW27	5	B4051	250,00
M 27 x 3,0	EBW27	5	B4050	250,00
M 28 x 1,5	EBW28	5	B4053	250,00
M 30 x 1,5	EBW30	5	B4056	305,00
M 30 x 2,0	EBW30	5	B4055	305,00
M 30 x 3,5	EBW30	5	B4054	305,00
M 33 x 2,0	EBW33	5	B4058	315,00
M 33 x 3,5	EBW33	5	B4057	315,00
M 36 x 1,5	EBW36	5	B4063	330,00
M 36 x 2,0	EBW36	5	B4062	330,00
M 36 x 3,0	EBW36	5	B4061	330,00
M 36 x 4,0	EBW36	5	B0364	330,00
M 39 x 2,0	EBW39	5	B0392	1.047,90
M 39 x 4,0	EBW39	5	B0394	535,00
M 42 x 2,0	EBW42	5	B0422	1.047,90
M 42 x 3,0	EBW42	5	B0423	535,00
M 42 x 4,0	EBW42	5	B0424	1.047,90

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UNC

Unified National Coarse Thread Series ANSI B1.1

					1,5 D	No.	€
UNC 2 x 56	EBW01	BZ001	2,3 mm	20	B4100	31,00	
UNC 3 x 48	EBW02	BZ002	2,6 mm	10	B4348	69,30	
UNC 4 x 40	EBW03	BZ003	3,0 mm	20	B4101	28,46	
UNC 5 x 40	EBW03	BZ003	3,4 mm	20	B4106	28,46	
UNC 6 x 32	EBW03	BZ003	3,7 mm	20	B4102	28,46	
UNC 8 x 32	EBW04	BZ004	4,5 mm	20	B4103	28,46	
UNC 10 x 24	EBW04	BZ004	5,2 mm	20	B4104	28,46	
UNC 12 x 24	EBW05	BZ005	5,8 mm	10	B4105	28,46	
UNC 1/4 x 20	EBW06	BZ006	6,7 mm	20	B4107	25,20	
UNC 5/16 x 18	EBW07	BZ006	8,3 mm	20	B4108	29,82	
UNC 3/8 x 16	EBW08	BZ008	9,9 mm	15	B4109	32,97	
UNC 7/16 x 14	EBW10	BZ010	11,6 mm	10	B4110	37,50	
UNC 1/2 x 13	EBW12	BZ012	13,0 mm	10	B4111	41,20	
UNC 9/16 x 12	EBW14			10	B4112	55,00	
UNC 5/8 x 11	EBW14			10	B4113	55,00	



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UNC

Unified National Coarse Thread Series ANSI B1.1

					1,5 D	No.	€
UNC 11/16x11	EBW16			5	B41116	294,00	
UNC 3/4 x 10	EBW18			5	B4114	70,45	
UNC 7/8 x 9	EBW22			5	B4115	85,45	
UNC 1"x 8	EBW24			5	B4116	81,45	
UNC 1.1/8 x 7	EBW26			10	B4117	300,00	
UNC 1.1/4 x 7	EBW30			10	B4118	330,50	
UNC 1.3/8 x 6	EBW31			10	B4119	372,00	
UNC 1.1/2 x 6	EBW36			10	B4120	443,00	



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UNF

Unified National Coarse Thread Series ANSI B1.1

					1,5 D	No.	€
UNF	2 x 64	EBW01	BZ001	2,3 mm	10	B41201	121,59
UNF	3 x 56	EBW02	BZ002	2,6 mm	10	B4356	121,59
UNF	4 x 48	EBW03	BZ003	3,0 mm	20	B41202	28,46
UNF	6 x 40	EBW03	BZ003	3,7 mm	20	B4121	28,46
UNF	8 x 36	EBW04	BZ004	4,4 mm	20	B4122	28,46
UNF	10 x 32	EBW05	BZ005	5,1 mm	20	B4123	28,46
UNF	1/4 x 28	EBW06	BZ006	6,6 mm	20	B4125	25,60
UNF	5/16 x 24	EBW07	BZ006	8,2 mm	20	B4126	31,40
UNF	3/8 x 24	EBW08	BZ008	9,8 mm	15	B4127	33,40
UNF	7/16 x 20	EBW10	BZ010	11,5 mm	10	B4128	37,58
UNF	1/2 x 20	EBW12	BZ012	13,0 mm	10	B4129	41,25
UNF	9/16 x 18	EBW14			10	B4130	55,08
UNF	5/8 x 18	EBW14			10	B4131	55,08

* prices on request

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UNF

Unified National Coarse Thread Series ANSI B1.1

			1,5 D	No.	€
UNF	3/4 x 16	EBW20	5	B4132	70,50
UNF	7/8 x 14	EBW22	5	B4133	86,60
UNF	1" x 12	EBW24	5	B4134	95,10
UNF	1" x 14	EBW24	5	B41351	*
UNF	1.1/8 x 12	EBW30	5	B4137	300,50
UNF	1.1/4 x 12	EBW31	5	B4138	330,80
UNF	1.3/8 x 12	EBW36	5	B4139	370,70
UNF	1.1/2 x 12	EBW39	5	B4140	443,10



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BSW

British Standard Whitworth Coarse Thread Series BS 84

				1,5 D	No.	€
BSW 1/8 x 40	EBW03	BZ003	3,4 mm	20	B4141	31,00
BSW 3/16 x 24	EBW05	BZ005	5,0 mm	20	B4142	31,00
BSW 1/4 x 20	EBW06	BZ006	6,7 mm	20	B4143	28,00
BSW 5/16 x 18	EBW07	BZ006	8,3 mm	20	B4144	35,00
BSW 3/8 x 16	EBW08	BZ008	9,9 mm	15	B4145	38,00
BSW 7/16 x 14	EBW10	BZ010	11,6 mm	10	B4146	41,00
BSW 1/2 x 12	EBW12	BZ012	13,0 mm	10	B4147	44,00
BSW 9/16 x 12	EBW14			5	B4148	58,10
BSW 5/8 x 11	EBW14			5	B4149	58,10

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BSW

Unified National Coarse Thread Series ANSI B1.1

				1,5 D	No.	€
BSW 11/16x11	EBW16			5	B4153	*
BSW 3/4 x10	EBW18			5	B4150	75,60
BSW 7/8 x 9	EBW22			5	B4151	89,90
BSW 1" x 8	EBW24			4	B4152	86,80
BSW 1.1/8 x 7	EBW26			5	B4154	*
BSW 1.1/4 x 7	EBW30			5	B4155	*
BSW 1.3/8 x 6	EBW31			5	B4156	*
BSW 1.1/2 x 6	EBW36			5	B4157	*

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BSF British Standard Whitworth Fine Thread Series BS 84

					1,5 D	No.	€
BSF 3/16 x 32	EBW04	BZ004	5,0 mm	20	B4162	31,00	
BSF 7/32 x 28	EBW05	BZ005	5,8 mm	10	B4177	*	
BSF 1/4 x 26	EBW06	BZ006	6,6 mm	20	B4163	28,00	
BSF 9/32 x 26	EBW06	BZ006	7,3 mm	10	B4178	*	
BSF 5/16 x 22	EBW07	BZ008	8,3 mm	20	B4165	35,00	
BSF 3/8 x 20	EBW08	BZ008	9,9 mm	15	B4166	38,00	
BSF 7/16 x 18	EBW10	BZ010	11,5 mm	10	B4167	41,00	
BSF 1/2 x 16	EBW12	BZ012	13,0 mm	10	B4168	44,00	
BSF 9/16 x 16	EBW14			5	B4169	58,10	
BSF 5/8 x 14	EBW14			5	B4170	58,10	

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BSF British Standard Whitworth Fine Thread Series BS 84

					No.	€
BSF 11/16x 14	EBW16	5	B4171	*		
BSF 3/4 x 12	EBW18	5	B4172	75,60		
BSF 13/16x 12	EBW18	5	B4173	*		
BSF 7/8 x 11	EBW22	5	B4174	89,90		
BSF 1" x 10	EBW24	4	B4176	86,80		
BSF 1.1/8 x 9	EBW30	5	B4179	*		
BSF 1.1/4 x 9	EBW31	5	B4180	*		
BSF 1.3/8 x 8	EBW36	5	B4181	*		
BSF 1.1/2 x 8	EBW39	5	B4182	*		

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G (BSP) British Standard Pipe Thread DIN ISO 228

					No.	€
				2,0 D		
G 1/8 x 28	EBW10	BZ010	9,9 mm	5	B4190	56,54
G 1/4 x 19	EBW12	BZ012	13,5 mm	5	B4191	56,54
G 3/8 x 19	EBW14		17,0 mm	5	B4192	64,79
G 1/2 x 14	EBW22			5	B4193	81,18
G 5/8 x 14	EBW24			5	B4194	174,90
G 3/4 x 14	EBW26			5	B4195	174,90
G 7/8 x 14	EBW30			5	B4196	258,50
G 1" x 11	EBW36			5	B4197	258,50
G 1.1/4 x 11	EBW42			5	B4198	*
G 1.1/2 x 11	EBW50			5	B4199	*

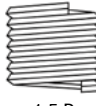
Please note:
The outside diameter of 1" pipe thread is 33.25 mm (not 25.4 mm)!
But the length of the thread insert is calculated with the value 25.4 mm:
e.g.: Length 2 D at G 1/4 x 19: 1/4 x 25.4 mm x 2 = 12.70 mm1,5

BA British Association Standard Thread BS 931,5

					No.	€
				1,5 D		
BA 0	EBW06	BZ006	6,2 mm	10	B4201	134,72
BA 1	EBW05	BZ005	5,5 mm	10	B4202	134,72
BA 2	EBW05	BZ005	4,9 mm	10	B4203	134,72
BA 3	EBW04	BZ004	4,3 mm	5	B4204	*
BA 4	EBW03	BZ003	3,8 mm	5	B4205	145,95
BA 5	EBW03	BZ003	3,2 mm	5	B4206	*
BA 6	EBW02	BZ002	2,9 mm	5	B4207	157,08

leading time: 1 - 3 weeks

BSB British Standard Brass Thread

					No.	€
				1,5 D		
BSB 1/4 x 26	EBW06	BZ006	6,6 mm	5	B4208	233,52
BSB 5/16 x 26	EBW07	BZ006	8,2 mm	5	B4209	233,52
BSB 3/8 x 26	EBW08	BZ008	9,8 mm	5	B4210	233,52
BSB 7/16 x 26	EBW10	BZ010	11,5 mm	5	B4211	242,45
BSB 1/2 x 26	EBW12	BZ012	13,0 mm	5	B4212	271,74

leading time: 1 - 3 weeks

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special sizes

				1,5 D	No.	€
UNEF 1/4 x 32	EBW06	BZ006	6,6 mm	10	B4225	179,66
Harley 1/4 x 24	EBW06	BZ006	6,6 mm	10	B4226	61,01
Harley 7/16 x 16	EBW10	BZ010	11,5 mm	10	B4227	69,41
Cummins 11/16x16	EBW14			10	B4228	596,40
Carburetor 7/8 x 20	EBW22			10	B4229	672,53
Carburetor 1" x 20	EBW24			10	B4230	416,33

BSC

British Standard Cycle Thread RS 811

				1,5 D	No.	€
BSC 5/16 x 26	EBW07	BZ006	8,2 mm	10	B4220	193,10
BSC 3/8 x 26	EBW08	BZ008	9,8 mm	10	B4221	233,52
BSC 7/16 x 26	EBW10	BZ010	11,5 mm	5	B4222	242,45
BSC 1/2 x 26	EBW12	BZ012	13,0 mm	5	B4223	271,74

leading time: 1 - 3 weeks

NPT

American Taper Pipe Thread
ANSI B1.20.1

				1,5 D	No.	€
NPT 1/8 x 27	EBW10	10			B4231	260,19
NPT 1/4 x 19	EBW14	10			B4232	260,19
NPT 3/8 x 18	EBW14	10			B4233	260,19
NPT 1/2 x 14	EBW22	5			B4234	259,35
NPT 3/4 x 14	EBW26	5			B4235	394,80
NPT 1" x 11,5	EBW36	5			B4236	418,95

leading time: 1 - 3 weeks

8 - UN

Unified Thread Series
8 TPI ANSI B1.1

				1,5 D	No.	€
1.1/8 x 8	EBW26	5			B4240	743,19
1.1/4 x 8	EBW30	5			B4241	806,82
1.3/8 x 8	EBW31	5			B4242	918,75
1.1/2 x 8	EBW36	4			B4243	1.031,31
1.5/8 x 8	EBW39	4			B4244	1.199,63
1.3/4 x 8	EBW42	4			B4245	1.330,35
1.7/8 x 8	EBW42	4			B4246	1.517,67
2" x 8	EBW42	4			B4247	1.704,78

leading time: 1 - 3 weeks





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