

# BaerCoil®

Thread Reinforcement  
Thread Repair

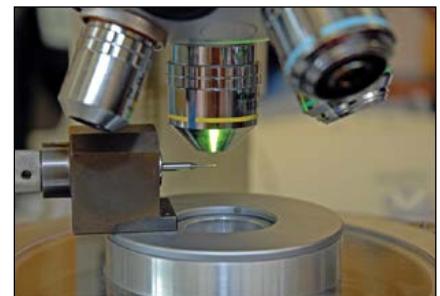




## Precision and Quality

Good quality is the best marketing, because satisfied customers underline our success. Our most important principle which inspires us is the commitment for products of the highest standards to meet the requirements of our customers to their utmost satisfaction - a mission we try to fulfill for our corporate philosophy every day.

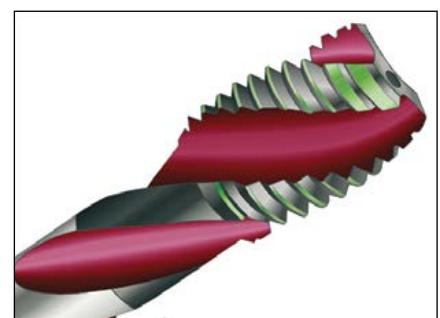
Our quality check starts with the receipt of goods and continues until the outgoing of the products. At BAER Company customer satisfaction does not come by chance. Ongoing quality testings also influence all new product developments. New ideas and the most modern production facilities improve our products and make them even more precise.



## Development and Improvement

Essential for the sustainability of our work is to invest continuously the long-term in new innovative products. Highest efforts in research and development focus on the needs of our customers. Our tools represent practical and reliable solutions which support an efficient and easy application.

Our cooperations with other industries, companies and research institutes make a strong networking possible. New inspirations are created in innovations, are produced, tested and adapted for practice. This way we are always up to the latest standards of knowledge related to thread technologies. All members of our company contribute to our innovations with their individual know-how.



## Tradition and Experience

For more than 35 years we have been engaged in what we can do best: threading technology. With this far-reaching treasure trove of experience we have established ourselves as an expert by whom our customers can profit. We are proud to be a family company.

Our identification with the company is even stronger and more distinctive. Each customer, each modernization is at the same time an affair of the heart.

Tradition combined with innovation and progress - make us a flexible and competent partner when it is about threading tools.

Our claim: to contribute to a successful future and to develop tools which meet all kinds of requirements of our customers.



## Distributors

To ensure further deliveries to the customer as soon as possible at home and abroad, we are expanding our distributor network.

BAER-distributors benefit from:

- The largest full range of products - for best price performance ratio
- Quality and reliability - for the highest demands
- Decades of experience in threading technology
- Reliable partnership - flexible and easy
- Sale supporting materials
- Exclusive products
- Exclusive sale territories
- Qualified product and sales trainings
- Attractive terms and conditions
- Innovative products



**Content**

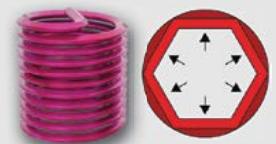
BaerCoil® Wire Thread Inserts - type: "free running"

9 - 13



BaerCoil® Wire Thread Inserts - type: "screw grip"

14 - 17

**BaerCoil® Wire Thread Inserts**Special materials: **Bronze**, **Stainless Steel AISI 316 (V4A)**Aerospace industry standards: **LN 9039**, **LN 9499**, **DIN 65536**

18 - 19

BaerCoil® Tangless® CoilThread® Wire Thread Inserts  
without tang

20 - 21



BaerCoil® Thread Repair Kits

22 - 35



BaerCoil® Thread Repair Workshop Kits

36 - 43



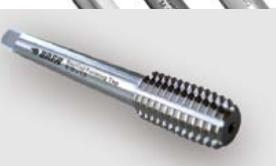
BaerCoil® Taps

44 - 51



BaerCoil® Forming Taps

52 - 53



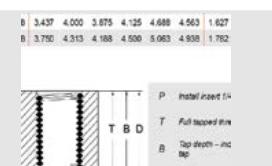
BaerCoil® Inserting Tools

54 - 61



Technical Data

62 - 68

**BAER Vertriebs GmbH**

Robert-Bosch-Str. 5

68542 Heddeshheim

Germany

Tel: +49 (0) 6203 4048 790

Fax: +49 (0) 6203 4048 791

E-Mail: info@baercoil.com

[www.baercoil.com](http://www.baercoil.com)**BaerCoil® Catalog 2017**



# BaerCoil® Thread Reinforcement & Thread Repair

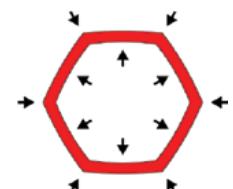
## BaerCoil® Wire Thread Inserts - typee: "free running"

BaerCoil® thread inserts are made from austenitic chromium-nickel steel (stainless steel AISI 304 with a material tensile strength of at least 1400 N/mm<sup>2</sup>). In production the wire is swaged in cold-form to a rhombic cross-section, which ensures performance and maximum space utilization. With BaerCoil® thread inserts you achieve a better thread connection in regard to wear resistance, thread abrasion, surface finish, corrosion- and heat resistance than with any other single screw connection.



## BaerCoil® Wire Thread Inserts - typee: "screw grip"

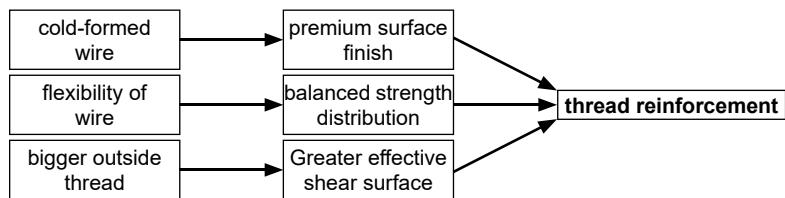
In addition to "free-running" insert characteristics, BaerCoil® "screw grip" thread inserts have one or more polygon-formed windings, which have a clamping effect on the flanks of the inserted screw. We only recommend using screws with a higher screw property class (from 8.8 on) because of this screw 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 impacts, constant vibrations and movements.



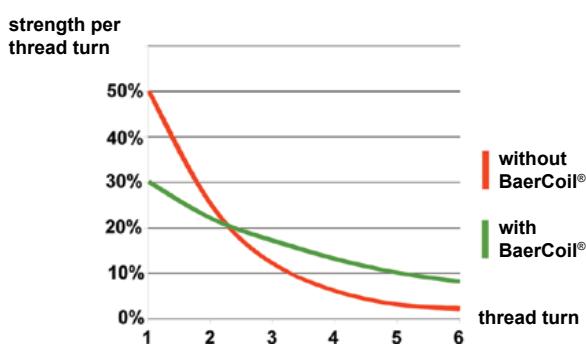
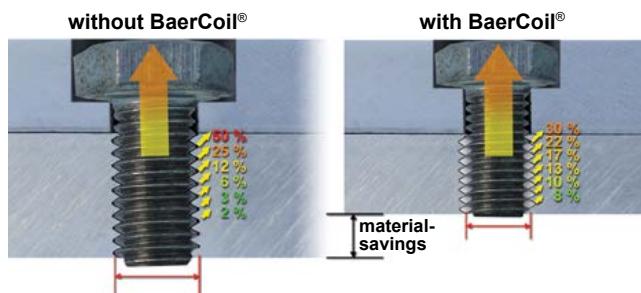
see locking torque values on page 7

## Thread Reinforcement and higher tensile strength

BaerCoil® thread inserts reinforce and increase the pull-out strength especially in materials with low shear strength, as e.g.: aluminum or magnesium.



example from test results	
material	Magnesium
thread - length	M 10 x 1,5 - 10 mm
pull-out strength without BaerCoil	3540 kg/mm <sup>2</sup>
pull-out strength with BaerCoil	4570 kg/mm <sup>2</sup>
relative increase	about 29 %



## Premium surface finish

BaerCoil® thread inserts have a premium surface finish (about 2.5 µm) and are made predominantly from stainless steel (AISI 304) or other materials with a hardness (min. 425 HV 0,2) that far exceeds normal screw connections. For repetitive screw connections these properties ensure, among other things, a higher and consistent tension force at the same torque strength. This leads to a better utilization of yield strength. The torsion tension is up to 90% less than for threads without BaerCoil® thread inserts.

## Balanced strength distribution

Threads with BaerCoil® inserts more evenly distribute static and dynamic workloads to the individual thread turns. The flexibility of the inserts compensates for the rise- and angle errors, achieving an ideal force transmission from the bolt to the thread of the nut.

## Greater effective shear surface

The BaerCoil® wire thread insert has a greater effective shear surface than a normal screw connection with cut thread turns. The shear surface refers to the contact surface of the wire thread insert or screw with the cut outer thread. The greater this surface, the less the force that affects a square mm.

## Protection against wear of a thread

BaerCoil® thread inserts protect the thread against wear and damage in all metals and their alloys, as e.g. aluminum, magnesium, titanium, copper, steel, plastic and other materials. The thread insert is very hard and has a premium surface finish. Since the surface has minimal roughness, less friction force affects the thread when inserting the screw. The decrease in thread friction force also minimizes wear.

## Corrosion-resistance

BaerCoil® thread inserts also have excellent corrosion-resistance properties. This ensures applicability in almost all materials and under most conditions.

## Flexibility

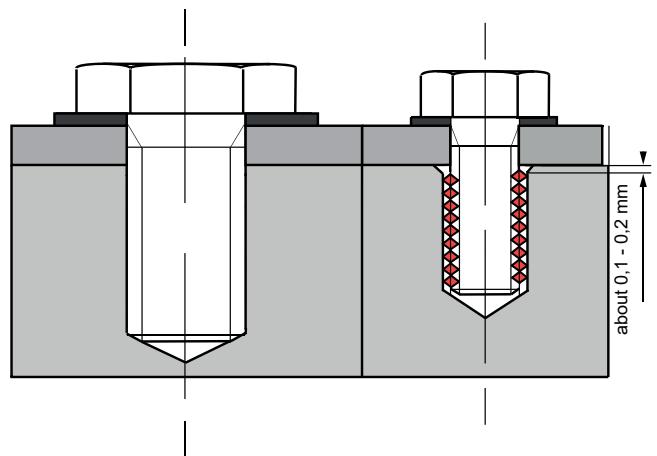
BaerCoil® thread inserts were constructed to be axially and radially elastic. This ensures that each winding can adjust independently and thereby compensate for rise- and angle errors that exist between the inner thread and the screw. The force is distributed evenly to all thread turns.

## Reductions of weight and space

The reduction in weight is an uncontested and important design element for many products. Due to the high thread resilience of BaerCoil® thread inserts, the usage of smaller thread diameters and shorter thread lengths is possible. The extremely high resilience of the cladded thread allows for, depending on material and size, material savings of up to ca. 10 - 30 %. BaerCoil® thread inserts save material, building space and weight while fulfilling the same or higher requirements.

## Minimize total costs

Since less material is needed, BaerCoil® inserts reduce production costs while still providing the required solidity of the thread connection. Moreover, follow-up costs are very low: Lighter vehicles and aircrafts require less gasoline or kerosene. Expensive spare parts and elaborate installations can be avoided with thread cladding, and damaged threads can be repaired easily.



## Thread Repair

Besides thread reinforcement, the BaerCoil® thread insert also facilitates the repair of damaged threads. Rejected parts can be salvaged 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.



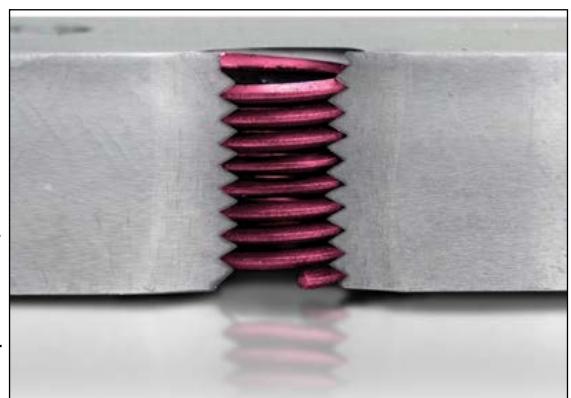
## Applications

BaerCoil® thread inserts are especially well suited for the following materials:

- Aluminum and aluminum alloys
- Brass, bronze, cast-iron
- Magnesium alloys
- Steels etc.

Application examples:

- Motor vehicle industry: Motor, transmission, radiator, vehicle body parts, oil drain etc.
- Aerospace: Engines, assembly parts reinforcement etc.
- Electronic- and laboratory technology: Medical devices, capacitors, casings etc.
- Household appliances: Hole punch, iron, pocket calculator, cameras, cell phones
- Facility- and device construction: Pumps, construction machines, various components etc.
- Military devices: Airplanes, weapons, tanks, scopes etc.

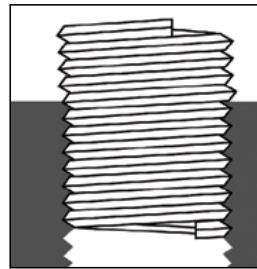




## Design

The outer diameter of non-installed BaerCoil® thread inserts is larger by a fixed measure than the receiving thread. This is necessary in order to apply radial pressure during installation to the inner thread of the receiving thread. This radial pressure safely and firmly seats the thread insert in the receiving thread. Additional securing elements are, therefore, not required. The thread insert adjusts to the thread turns and slightly expands in length. This is why the length of the thread insert can only be measured when installed since it lengthens while being pressed together as it adjusts to the cut thread.

Each thread insert size is available in 5 lengths. Lengths range from 1 x, 1.5 x, 2 x, 2.5 x and 3 times the size of the thread diameter. Other lengths are available upon request.



## Materials

	Material	Tensile Strength	Temperature resistance	Examples of use	
	Stainless Steel V2A AISI 304 X5CrNi18-10 Material-No.: 1.4301	>1400 N/mm²	315°C long-term 425°C short-term	standard applications for all property classes and materials for Thread Repair and Thread Reinforcement	
	Stainless Steel V4A AISI 316 Ti X6CrNiMoTi17-12-2 Material-No.: 1.4571	>1400 N/mm²	315°C long-term 425°C short-term	- increased corrosion protection - low thread friction - for high alloyed CrNi steel screws	general lightweight construction sea water and chlorine-containing water
	Inconel X750 NiCr15Fe7TiAl Material-No.: 2.4669	>1150 N/mm²	550°C long-term 750°C short-term	- high thermal load - high corrosion protection	
	Nimonic 90 NiCr20Co18Ti Material-No.: 2.4632	>1150 N/mm²	600°C long-term 900°C short-term		
	Bronze CuSn6 CW452K Material-No.: 2.1020	> 900 N/mm²	250°C long-term 300°C short-term	- translation threads - CrNi screws - Cu workpieces - non-magnetic	applications in sea water best electric conductivity

## Surface treatments

surface treatments	color	applications
cadmium plating	iridescent yellow	provides high corrosion resistance and lubrication to prevent galling - suitable up to 250°C
zinc plating	white	provides corrosion resistance as an alternative to cadmium
silver plating	silver white	to reduce galling of threads at high temperatures
cadmium plate & olive drab	olive drab	as specified on US military specs such as NASM21209.
Dry Film Lubricated	grey	additional lubrication in high friction applications - recommended for use with screw grip inserts
BaerCoilGuard	glossy black	Prevents galvanic corrosion between insert and patent material. Eliminates the need for zinc primers. Improves installation productivity.

## 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.

## Screw property class

tensile strength of mounting material	4.6	5.6	6.6	8.8	9.8	10.9	12.9	14.9
< 100 N/mm <sup>2</sup>	1,5 D	1,5 D	2,0 D	2,5 D	3,0 D			
100 - 150 N/mm <sup>2</sup>	1,5 D	1,5 D	2,0 D	2,0 D	2,5 D	2,5 D	2,5 D	3,0 D
150 - 200 N/mm <sup>2</sup>	1,0 D	1,5 D	1,5 D	1,5 D	2,0 D	2,0 D	2,5 D	2,5 D
200 - 250 N/mm <sup>2</sup>	1,0 D	1,0 D	1,5 D	1,5 D	1,5 D	2,0 D	2,5 D	2,5 D
250 - 300 N/mm <sup>2</sup>	1,0 D	1,0 D	1,0 D	1,0 D	1,5 D	1,5 D	2,0 D	2,0 D
300 - 350 N/mm <sup>2</sup>	1,0 D	1,0 D	1,0 D	1,0 D	1,5 D	1,5 D	1,5 D	2,0 D
350 - 400 N/mm <sup>2</sup>	1,0 D	1,5 D	1,5 D	1,5 D				
> 400 N/mm <sup>2</sup>	1,0 D	1,5 D	1,5 D	1,5 D				

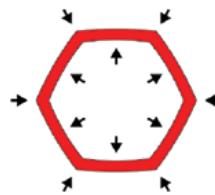
Temperature limits for validity: aluminium alloys max. 300°C, magnesium alloys max. 100°C. For design of screwed connections under thermal stress, the changes of temperature-dependent material parameters must be taken into account. Intermediate lengths are available, too. For these guide values, the screw is the weaker joint member. Lengths can be shorter than recommended nominal lengths if tests confirm this.

## Locking Torque for BaerCoil® Wire Thread Inserts - type: „screw grip“

thread dimension	max. locking torque [Nm]	min. locking torque 15 <sup>th</sup> cycle [Nm]	thread dimension	max. locking torque [Nm]	min. locking torque 15 <sup>th</sup> cycle
M 2 x 0.4	0.12	0,003	UNC 2 x 56	20 oz-in	3 oz-in
M 2.2 x 0.45	0.14	0.02	UNC 3 x 48	32 oz-in	7 oz-in
M 2.5 x 0.45	0.22	0.06	UNC 4 x 40	48 oz-in	10 oz-in
M 3 x 0.5	0.44	0.1	UNC 5 x 40	75 oz-in	13 oz-in
M 3.5 x 0.6	0.68	0.12	UNC 6 x 32	6 lb-in	1 lb-in
M 4 x 0.7	0.9	0.16	UNC 8 x 32	9 lb-in	1.5 lb-in
M 5 x 0.8	1.6	0.3	UNC 10 x 24	13 lb-in	2 lb-in
M 6 x 1.0	3	0.4	UNC 12 x 24	24 lb-in	3 lb-in
M 7 x 1.0	4.4	0.6	UNC 1/4 x 20	30 lb-in	4.5 lb-in
M 8 x 1.25	6	0.8	UNC 5/16 x 18	60 lb-in	7.5 lb-in
M 10 x 1.5	10	1.4	UNC 3/8 x 16	80 lb-in	12 lb-in
M 12 x 1.75	15	2.2	UNC 7/16 x 14	100 lb-in	16.5 lb-in
M 14 x 2.0	23	3	UNC 1/2 x 13	150 lb-in	24 lb-in
M 16 x 2.0	32	4.2	UNC 9/16 x 12	200 lb-in	30 lb-in
M 18 x 2.5	42	5.5	UNC 5/8 x 11	300 lb-in	40 lb-in
M 20 x 2.5	54	7	UNC 3/4 x 10	400 lb-in	60 lb-in
M 22 x 2.5	70	9	UNC 7/8 x 9	600 lb-in	82 lb-in
M 24 x 3.0	80	11	UNC 1" x 8	800 lb-in	110 lb-in
M 27 x 3.0	95	12	UNC 1 1/8" x 7	900 lb-in	137 lb-in
M 30 x 3.5	110	14	UNC 1 1/4" x 7	1000 lb-in	165 lb-in
M 33 x 3.5	125	16	UNC 1 3/8" x 6	1150 lb-in	185 lb-in
M 36 x 4.0	140	18	UNC 1 1/2" x 6	1350 lb-in	210 lb-in

BaerCoil® Thread Inserts - type: „screw grip“ (screw locking) are red colored

Please find them on page 15





## 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.

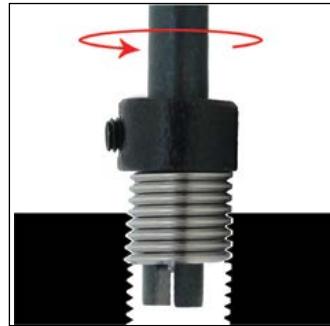
### 2. Tapping

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.

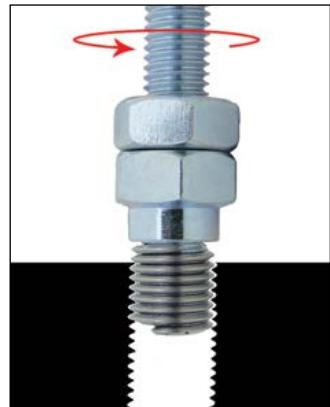
### 2. Tapping

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.



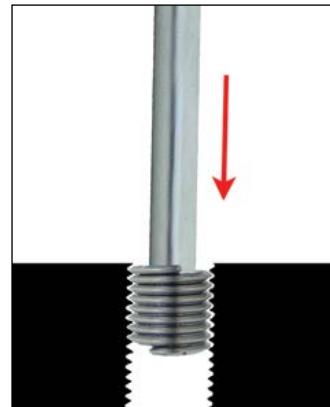
### 3. Installing thread inserts

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® Wire Thread Inserts

type: “free running”





## BaerCoil® Wire Thread Inserts - type: "free running" - material: stainless steel 304

DIN 8140 with reduced diameter for better installation

Tolerance ISO 2 (6H)

**M**



Diameter x Pitch	pack. unit	1,0 D		1,5 D		2,0 D		2,5 D		3,0 D	
		1,0 x Diameter	Item-No.:	1,5 x Diameter	Item-No.:	2,0 x Diameter	Item-No.:	2,5 x Diameter	Item-No.:	3,0 x Diameter	Item-No.:
<b>M 22 x 2,0</b>	25	1-B7243-1	40,65 €	1-B7243-15	67,02 €	1-B7243-2	92,76 €	1-B7243-25	115,58 €	1-B7243-3	141,36 €
<b>M 22 x 1,5</b>	25	1-B7244-1	37,62 €	1-B7244-15	50,81 €	1-B7244-2	56,17 €	1-B7244-25	75,94 €	1-B7244-3	91,45 €
<b>M 22 x 2,5</b>	25	1-B7242-1	48,50 €	1-B7242-15	71,16 €	1-B7242-2	87,69 €	1-B7242-25	110,82 €	1-B7242-3	159,20 €
<b>M 24 x 1,5</b>	25	1-B7247-1	43,37 €	1-B7247-15	75,23 €	1-B7247-2	89,76 €	1-B7247-25	117,62 €	1-B7247-3	131,37 €
<b>M 24 x 2,0</b>	25	1-B7246-1	43,04 €	1-B7246-15	76,59 €	1-B7246-2	83,60 €	1-B7246-25	132,30 €	1-B7246-3	152,83 €
<b>M 24 x 3,0</b>	25	1-B7245-1	66,91 €	1-B7245-15	98,45 €	1-B7245-2	118,86 €	1-B7245-25	166,18 €	1-B7245-3	245,70 €
<b>M 26 x 1,5</b>	5			1-B7349-15	17,29 €						
<b>M 27 x 1,5</b>	5			1-B7352-15	17,29 €						
<b>M 27 x 2,0</b>	5			1-B7351-15	17,29 €						
<b>M 27 x 3,0</b>	5	1-BE273-1	15,33 €	1-BE273-15	24,11 €	1-BE273-2	30,13 €				
<b>M 28 x 1,5</b>	5	1-B7353-1	*	1-B7353-15	50,92 €						
<b>M 30 x 1,5</b>	5	1-B7356-1	54,67 €	1-B7356-15	61,51 €						
<b>M 30 x 2,0</b>	5	1-B7355-1	48,87 €	1-B7355-15	23,04 €						
<b>M 30 x 3,5</b>	5	1-B7354-1	39,08 €	1-B7354-15	45,00 €	1-B7354-2	62,08 €				
<b>M 33 x 2,0</b>	5	1-B7358-1	50,49 €	1-B7358-15	61,20 €						
<b>M 33 x 3,5</b>	5	1-B7357-1	58,09 €	1-B7357-15	68,00 €	1-B7357-2	80,64 €				
<b>M 36 x 1,5</b>	5			1-B7363-15	78,59 €						
<b>M 36 x 2,0</b>	5			1-B7362-15	71,76 €						
<b>M 36 x 3,0</b>	5			1-B7361-15	85,43 €						
<b>M 36 x 4,0</b>	5	1-BE364-1	30,99 €	1-BE364-15	48,13 €	1-BE364-2	64,35 €				
<b>M 39 x 2,0</b>	5			1-BE392-15	182,99 €						
<b>M 39 x 4,0</b>	5			1-BE394-15	107,98 €						
<b>M 42 x 2,0</b>	5			1-BE422-15	306,14 €						
<b>M 42 x 3,0</b>	5			1-BE423-15	306,14 €						
<b>M 42 x 4,0</b>	5			1-BE424-15	306,14 €						

\* on request

### For Spark Plug

Diameter x Pitch	pack. unit	8,4 mm		12,4 mm		16,4 mm	
		Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit
<b>M 14 x 1,25</b>	50	1-B7128	19,95 €	1-B7228	25,52 €	1-B7328	32,53 €
	10	2-B7128	9,98 €	2-B7228	12,13 €	2-B7328	14,89 €
<b>M 18 x 1,5</b>	10	1-B7238-127	7,11 €	1-B7238-159	11,68 €	1-B7238-167	14,59 €

## BaerCoil® Wire Thread Inserts on strip feed type: "free running" - material: stainless steel 304



BaerCoil® Wire Thread Inserts on strip feed are especially used in the bulk production to speed up the inserting process.

Diameter x Pitch	M	1,0 D		1,5 D		2,0 D	
		1,0 x Diameter	Item-No.:	1,5 x Diameter	Item-No.:	2,0 x Diameter	Item-No.:
<b>M 3 x 0,5</b>		B7205-1MAG		B7205-15MAG		B7205-2MAG	
<b>M 4 x 0,7</b>		B7207-1MAG		B7207-15MAG		B7207-2MAG	
<b>M 5 x 0,8</b>		B7208-1MAG		B7208-15MAG		B7208-2MAG	
<b>M 6 x 1,0</b>		B7209-1MAG		B7209-15MAG		B7209-2MAG	
<b>M 8 x 1,25</b>		B7211-1MAG		B7211-15MAG		B7211-2MAG	
<b>M 10 x 1,5</b>		B7215-1MAG		B7215-15MAG		B7215-2MAG	

Please inquire prices, quantities and other dimensions.



## BaerCoil® Wire Thread Inserts - type: "free running" - material: stainless steel 304

### UNC



Diameter x Threads per inch	pack. unit	1,0 D		1,5 D		2,0 D		2,5 D		3,0 D	
		1,0 x Diameter	Item-No.:	Price per unit	1,5 x Diameter	Item-No.:	Price per unit	2,0 x Diameter	Item-No.:	Price per unit	2,5 x Diameter
<b>UNC 2 x 56</b>	100	1-B8200-1	28,47 €		1-B8200-15	24,34 €		1-B8200-2	25,05 €	1-B8200-25	35,63 €
	10							2-B8200-25	12,47 €		
<b>UNC 3 x 48</b>	100	1-B8213-1	26,76 €		1-B8213-15	28,93 €		1-B8213-2	29,99 €	1-B8213-3	89,40 €
	100	1-B8201-1	29,33 €		1-B8201-15	30,07 €		1-B8201-2	32,07 €	1-B8201-3	48,96 €
<b>UNC 4 x 40</b>	10				2-B8201-15	12,43 €					
<b>UNC 5 x 40</b>	100	1-B8202-1	31,90 €		1-B8202-15	37,07 €		1-B8202-2	42,76 €	1-B8202-25	51,73 €
	10				2-B8202-15	9,59 €				2-B8202-25	16,18 €
<b>UNC 6 x 32</b>	100	1-B8203-1	19,33 €		1-B8203-15	20,76 €		1-B8203-2	21,71 €	1-B8203-25	26,01 €
	10				2-B8203-15	6,10 €		2-B8203-2	6,25 €	2-B8203-25	7,57 €
<b>UNC 8 x 32</b>	100	1-B8204-1	16,20 €		1-B8204-15	17,34 €		1-B8204-2	17,97 €	1-B8204-25	21,72 €
	10				2-B8204-15	5,56 €		2-B8204-2	6,20 €	2-B8204-25	7,24 €
<b>UNC 10 x 24</b>	100	1-B8205-1	18,14 €		1-B8205-15	19,01 €		1-B8205-2	22,51 €	1-B8205-25	24,00 €
	10				2-B8205-15	6,34 €		2-B8205-2	7,50 €	2-B8205-25	8,00 €
<b>UNC 12 x 24</b>	100	1-B8206-1	25,53 €		1-B8206-15	21,72 €		1-B8206-2	30,35 €	1-B8206-25	36,41 €
	10				2-B8206-15	7,24 €				2-B8206-25	12,14 €
<b>UNC 1/4 x 20</b>	100	1-B8207-1	17,73 €		1-B8207-15	21,71 €		1-B8207-2	25,19 €	1-B8207-25	29,33 €
	10				2-B8207-15	7,24 €		2-B8207-2	7,23 €	2-B8207-25	7,94 €
<b>UNC 5/16 x 18</b>	100	1-B8208-1	24,55 €		1-B8208-15	29,90 €		1-B8208-2	36,98 €	1-B8208-25	48,24 €
	10				2-B8208-15	8,16 €		2-B8208-2	9,30 €	2-B8208-25	11,71 €
<b>UNC 3/8 x 16</b>	100	1-B8209-1	35,71 €		1-B8209-15	39,61 €		1-B8209-2	48,94 €	1-B8209-25	65,20 €
	10				2-B8209-15	11,10 €		2-B8209-2	11,78 €	2-B8209-25	15,07 €
<b>UNC 7/16 x 14</b>	100	1-B8210-1	48,23 €		1-B8210-15	53,09 €		1-B8210-2	66,38 €	1-B8210-25	114,61 €
	10				2-B8210-15	14,70 €		2-B8210-2	19,01 €	2-B8210-25	24,91 €
<b>UNC 1/2 x 13</b>	100	1-B8211-1	59,49 €		1-B8211-15	66,01 €		1-B8211-2	95,59 €	1-B8211-25	132,12 €
	10				2-B8211-15	16,41 €				2-B8211-25	28,40 €
<b>UNC 9/16 x 12</b>	50	1-B8212-1	39,28 €		1-B8212-15	44,28 €		1-B8212-2	79,05 €	1-B8212-25	140,53 €
	10				2-B8212-15	17,10 €				2-B8212-25	30,07 €
<b>UNC 5/8 x 11</b>	50	1-B8214-1	38,83 €		1-B8214-15	56,11 €		1-B8214-2	101,90 €	1-B8214-25	146,12 €
	10	2-B8214-1	13,83 €		2-B8214-15	19,91 €				2-B8214-25	58,00 €
<b>UNC 3/4 x 10</b>	25	1-B8215-1	35,19 €		1-B8215-15	53,23 €		1-B8215-2	72,00 €	1-B8215-25	90,20 €
	10	2-B8215-1	9,11 €		2-B8215-15	12,70 €				1-B8215-3	112,20 €
<b>UNC 7/8 x 9</b>	10	1-B8218-1	27,04 €		1-B8218-15	39,49 €		1-B8218-2	63,75 €	1-B8218-25	67,75 €
<b>UNC 1" x 8</b>	10	1-B8219-1	59,10 €		1-B8219-15	61,56 €		1-B8219-2	85,65 €	1-B8219-25	102,51 €
<b>UNC 1.1/8" x 7</b>	5				1-B8320-15	49,73 €					
<b>UNC 1.1/4" x 7</b>	5				1-B8321-15	52,28 €					
<b>UNC 1.3/8" x 6</b>	5				1-B8322-15	84,15 €					
<b>UNC 1.1/2" x 6</b>	5				1-B8323-15	105,57 €					

### UNF

Diameter x Threads per inch	pack. unit	1,0 D		1,5 D		2,0 D		2,5 D		3,0 D	
		1,0 x Diameter	Item-No.:	Price per unit	1,5 x Diameter	Item-No.:	Price per unit	2,0 x Diameter	Item-No.:	Price per unit	2,5 x Diameter
<b>UNF 2 x 64</b>	100	1-B8287-1	94,88 €		1-B8287-15	103,12 €		1-B8287-2	108,10 €	1-B8287-25	238,68 €
<b>UNF 3 x 56</b>	100	1-B8288-1	31,60 €		1-B8288-15	34,37 €		1-B8288-2	37,00 €	1-B8288-3	131,58 €
<b>UNF 4 x 48</b>	100	1-B8290-1	28,46 €		1-B8290-15	30,94 €		1-B8290-2	32,13 €	1-B8290-3	91,80 €
<b>UNF 5 x 44</b>	100	1-B8289-1	56,93 €		1-B8289-15	30,93 €		1-B8289-2	143,42 €	1-B8289-3	263,16 €
<b>UNF 6 x 40</b>	100	1-B8291-1	26,57 €		1-B8291-15	28,87 €		1-B8291-2	29,98 €	1-B8291-3	56,10 €
<b>UNF 8 x 36</b>	100	1-B8292-1	26,57 €		1-B8292-15	28,87 €		1-B8292-2	29,98 €	1-B8292-3	97,92 €
<b>UNF 10 x 32</b>	100	1-B8293-1	18,14 €		1-B8293-15	18,95 €		1-B8293-2	20,53 €	1-B8293-3	45,90 €
<b>UNF 1/4 x 28</b>	100	1-B8225-1	24,57 €		1-B8225-15	21,71 €		1-B8225-2	24,53 €	1-B8225-3	66,30 €
<b>UNF 5/16 x 24</b>	100	1-B8226-1	26,01 €		1-B8226-15	29,83 €		1-B8226-2	34,53 €	1-B8226-3	68,59 €
<b>UNF 3/8 x 24</b>	100	1-B8227-1	34,19 €		1-B8227-15	40,92 €		1-B8227-2	45,20 €	1-B8227-3	127,50 €
<b>UNF 7/16 x 20</b>	100	1-B8228-1	38,75 €		1-B8228-15	44,71 €		1-B8228-2	58,14 €	1-B8228-3	137,70 €
<b>UNF 1/2 x 20</b>	100	1-B8229-1	40,40 €		1-B8229-15	50,53 €		1-B8229-2	58,14 €	1-B8229-3	142,80 €
<b>UNF 9/16 x 18</b>	50	1-B8230-1	43,35 €		1-B8230-15	40,24 €		1-B8230-2	61,27 €	1-B8230-3	153,00 €
<b>UNF 5/8 x 18</b>	50	1-B8231-1	51,00 €		1-B8231-15	48,96 €		1-B8231-2	68,85 €	1-B8231-3	153,00 €
<b>UNF 3/4 x 16</b>	25	1-B8233-1	38,34 €		1-B8233-15	52,83 €		1-B8233-2	56,50 €	1-B8233-3	114,75 €
<b>UNF 7/8 x 14</b>	10	1-B8235-1	27,99 €		1-B8235-15	32,85 €		1-B8235-2	59,16 €	1-B8235-3	88,74 €
<b>UNF 1" x 12</b>	10	1-B8237-1	43,86 €		1-B8237-15	51,87 €		1-B8237-2	70,46 €	1-B8237-3	102,00 €
<b>UNF 1.1/8" x 12</b>	5				1-B8238-15	73,95 €					
<b>UNF 1.1/4" x 12</b>	5				1-B8239-15	74,97 €					
<b>UNF 1.3/8" x 12</b>	5				1-B8240-15	182,07 €					
<b>UNF 1.1/2" x 12</b>	5				1-B8241-15	188,70 €					



# BaerCoil® Wire Thread Inserts

type: “screw grip”



## BaerCoil® Wire Thread Inserts - type: "screw grip" - material: 304 stainless steel

DIN 8140 with reduced diameter for better installation

Tolerance ISO 2 (6H)



**M**

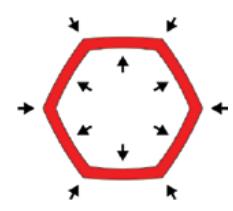
Diameter x Pitch	pack. unit	<b>1,0 D</b> 1,0 x Diameter		<b>1,5 D</b> 1,5 x Diameter		<b>2,0 D</b> 2,0 x Diameter		<b>2,5 D</b> 2,5 x Diameter		<b>3,0 D</b> 3,0 x Diameter	
		Item-No.:	Price per unit								
<b>M 2 x 0,4</b>	100	1-B6102-1	17,39 € <sup>1</sup>	1-B6102-15	21,92 € <sup>1</sup>	1-B6102-2	*	1-B6102-25	28,14 € <sup>1</sup>	1-B6102-3	31,86 € <sup>1</sup>
	10			2-B6102-15	8,32 € <sup>1</sup>	2-B6102-2	*	2-B6102-25	10,69 € <sup>1</sup>	2-B6102-3	12,11 € <sup>1</sup>
<b>M 2,2 x 0,45</b>	100	1-B6125-1	20,15 € <sup>1</sup>	1-B6125-15	21,95 € <sup>1</sup>	1-B6125-2	26,78 € <sup>1</sup>	1-B6125-25	28,10 € <sup>1</sup>	1-B6125-3	31,85 € <sup>1</sup>
<b>M 2,5 x 0,45</b>	100	1-B6126-1	*								
<b>M 3 x 0,5</b>	100	1-B6103-1	19,59 €	1-B6103-15	14,52 €	1-B6103-2	16,36 €	1-B6103-25	18,57 €	1-B6103-3	*
	10	2-B6103-1	6,86 €	2-B6103-15	5,52 €	2-B6103-2	6,22 €			2-B6103-3	*
<b>M 3,5 x 0,6</b>	100	1-B6135-1	11,50 € <sup>1</sup>	1-B6135-15	14,08 € <sup>1</sup>	1-B6135-2	16,71 € <sup>1</sup>	1-B6135-25	19,75 € <sup>1</sup>	1-B6135-3	22,85 € <sup>1</sup>
<b>M 4 x 0,7</b>	100	1-B6104-1	14,47 €	1-B6104-15	20,86 €	1-B6104-2	27,80 €	1-B6104-25	21,54 €	1-B6104-3	22,00 €
	10	2-B6104-1	5,50 €	2-B6104-15	7,30 €	2-B6104-2	9,73 €	2-B6104-25	7,54 €	2-B6104-3	7,70 €
<b>M 5 x 0,8</b>	100	1-B6105-1	12,86 €	1-B6105-15	18,28 €	1-B6105-2	16,81 €	1-B6105-25	19,90 €	1-B6105-3	23,65 €
	10	2-B6105-1	5,10 €	2-B6105-15	6,40 €	2-B6105-2	6,05 €	2-B6105-25	7,40 €	2-B6105-3	8,20 €
<b>M 6 x 1,0</b>	100	1-B6106-1	22,50 €	1-B6106-15	16,81 €	1-B6106-2	27,00 €	1-B6106-25	25,15 €	1-B6106-3	26,72 €
	10	2-B6106-1	7,80 €	2-B6106-15	5,50 €	2-B6106-2	8,80 €	2-B6106-25	7,67 €	2-B6106-3	7,90 €
<b>M 7 x 1,0</b>	100	1-B6107-1	20,52 €	1-B6107-15	27,23 €	1-B6107-2	35,21 €	1-B6107-25	43,77 €	1-B6107-3	51,59 €
	10	2-B6107-1	6,20 €	2-B6107-15	7,52 €	2-B6107-2	9,07 €	2-B6107-25	10,74 €	2-B6107-3	12,26 €
<b>M 8 x 1,0</b>	100	1-B6181-1	20,57 €	1-B6181-15	27,26 €	1-B6181-2	35,22 €	1-B6181-25	43,87 €	1-B6181-3	47,36 €
	10	2-B6181-1	6,20 €	2-B6181-15	7,52 €	2-B6181-2	9,07 €	2-B6181-25	10,74 €	2-B6181-3	12,26 €
<b>M 8 x 1,25</b>	100	1-B6108-1	20,57 €	1-B6108-15	27,26 €	1-B6108-2	35,22 €	1-B6108-25	47,36 €	1-B6108-3	46,43 €
	10	2-B6108-1	6,20 €	2-B6108-15	7,52 €	2-B6108-2	9,07 €	2-B6108-25	10,74 €	2-B6108-3	12,02 €
<b>M 10 x 1,25</b>	100	1-B6101-1	28,15 €	1-B6101-15	40,73 €	1-B6101-2	52,83 €	1-B6101-25	64,59 €	1-B6101-3	76,54 €
	10	2-B6101-1	7,53 €	2-B6101-15	9,99 €	2-B6101-2	12,34 €	2-B6101-25	14,64 €	2-B6101-3	16,96 €
<b>M 10 x 1,5</b>	100	1-B6110-1	28,15 €	1-B6110-15	40,73 €	1-B6110-2	52,83 €	1-B6110-25	69,84 €	1-B6110-3	76,54 €
	10	2-B6110-1	7,53 €	2-B6110-15	9,99 €	2-B6110-2	12,34 €	2-B6110-25	15,81 €	2-B6110-3	16,96 €
<b>M 12 x 1,25</b>	100			1-B6112-15	56,79 €	1-B6112-2	75,79 €	1-B6112-25	94,31 €		
<b>M 12 x 1,5</b>	100			1-B6115-15	59,05 €	1-B6115-2	78,18 €				
<b>M 12 x 1,75</b>	100	1-B6127-1	41,75 €	1-B6127-15	56,59 €	1-B6127-2	81,86 €	1-B6127-25	101,67 €	1-B6127-3	112,21 €
	10	2-B6127-1	10,34 €	2-B6127-15	13,12 €	2-B6127-2	18,17 €	2-B6127-25	22,02 €	2-B6127-3	24,20 €
<b>M 14 x 2,0</b>	50	1-B6114-1	30,86 €	1-B6114-15	46,08 €	1-B6114-2	61,67 €	1-B6114-25	96,59 €	1-B6114-3	110,93 €
	10	2-B6114-1	13,46 €	2-B6114-15	20,19 €	2-B6114-2	26,27 €	2-B6114-25	38,33 €		
<b>M 16 x 2,0</b>	50	1-B6116-1	37,04 €	1-B6116-15	59,53 €	1-B6116-2	116,32 €	1-B6116-25	119,89 €	1-B6116-3	149,48 €
	10	2-B6116-1	16,48 €	2-B6116-15	24,48 €			2-B6116-25	48,96 €		
<b>M 18 x 2,5</b>	25	1-B6119-1	38,42 €	1-B6119-15	58,30 €						
	10	2-B6119-1	29,81 €	2-B6119-15	44,16 €						
<b>M 20 x 1,5</b>	25	1-B6120-1	180,34 €	1-B6120-15	185,64 €	1-B6120-2	334,15 €				
<b>M 20 x 2,5</b>	25	1-BS7240-1	42,50 €	1-BS7240-15	72,64 €	1-BS7240-2	92,94 €	1-BS7240-25	117,41 €		
	10	2-BS7240-1	35,20 €	2-BS7240-15	58,70 €	2-BS7240-2	74,53 €	2-BS7240-25	93,62 €		
<b>M 24 x 2,0</b>	25					1-BS7246-2	75,17 €				
	10					2-BS7246-2	60,68 €				
<b>M 24 x 3,0</b>	25	1-BS7245-1	81,88 €	1-BS7245-15	122,66 €	1-BS7245-2	162,10 €	1-BS7245-25	397,80 €		
	10	2-BS7245-1	65,90 €	2-BS7245-15	45,90 €	2-BS7245-2	128,48 €				
<b>M 30 x 3,5</b>	5	1-BS7354-1	29,71 €	1-BS7354-15	45,15 €	1-BS7354-2	69,02 €				
<b>M 36 x 4,0</b>	5			1-BES364-15	81,63 €	1-BES364-2	109,12 €				

\* on request

<sup>1</sup> prices only available for remainder of stock

## BaerCoil® Wire Thread Inserts - type: "screw grip"

In addition to "free-running" insert characteristics, BaerCoil® "screw grip" thread inserts have one or more polygon-formed 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.



see locking torque on page 7



## BaerCoil® Wire Thread Inserts - type: "screw grip" - material: stainless steel 304

### UNC



Diameter x Threads per inch	pack. unit	1,0 D 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit								
<b>UNC 2 x 56</b>	100	1-B6201-1	10,82 €	1-B6200-15	51,00 €	1-B6200-2	51,00 €	1-B6200-25	66,25 €		
<b>UNC 4 x 40</b>	100			1-B6201-15	45,90 €	1-B6201-2	46,92 €	1-B6201-25	53,00 €	1-B6201-3	56,10 €
<b>UNC 6 x 32</b>	100	1-B6203-1	12,77 €	1-B6203-15	13,70 €	1-B6203-2	16,80 €	1-B6203-25	47,70 €	1-B6203-3	51,00 €
<b>UNC 8 x 32</b>	100	1-B6204-1	35,70 €	1-B6204-15	35,70 €	1-B6204-2	35,70 €	1-B6204-25	42,40 €	1-B6204-3	45,90 €
<b>UNC 10 x 24</b>	100			1-B6205-15	56,10 €	1-B6205-2	56,10 €	1-B6205-25	63,60 €	1-B6205-3	66,30 €
<b>UNC 1/4 x 20</b>	100	1-B6207-1	45,90 €	1-B6207-15	21,88 €	1-B6207-2	56,10 €	1-B6207-25	33,53 €	1-B6207-3	81,60 €
<b>UNC 5/16 x 18</b>	100	1-B6208-1	56,10 €	1-B6208-15	33,50 €	1-B6208-2	76,50 €	1-B6208-25	55,14 €	1-B6208-3	122,40 €
<b>UNC 3/8 x 16</b>	100	1-B6209-1	56,10 €	1-B6209-15	44,80 €	1-B6209-2	76,50 €	1-B6209-25	106,00 €	1-B6209-3	122,40 €
<b>UNC 7/16 x 14</b>	100	1-B6210-1	127,50 €	1-B6210-15	132,60 €	1-B6210-2	132,60 €	1-B6210-25	174,90 €	1-B6210-3	188,70 €
<b>UNC 1/2 x 13</b>	100	1-B6211-1	127,50 €	1-B6211-15	132,60 €	1-B6211-2	137,70 €	1-B6211-25	190,80 €	1-B6211-3	219,30 €
<b>UNC 5/8 x 11</b>	50	1-B6214-1	96,90 €	1-B6214-15	102,00 €	1-B6214-2	112,20 €	1-B6214-25	137,80 €	1-B6214-3	204,00 €
<b>UNC 3/4 x 10</b>	25	1-B6216-1	52,28 €	1-B6216-15	68,85 €	1-B6216-2	82,88 €				
<b>UNC 7/8 x 9</b>	10	1-B6218-1	45,39 €	1-B6218-15	58,65 €	1-B6218-2	72,93 €				
<b>UNC 1" x 8</b>	10	1-B6219-1	60,18 €	1-B6219-15	80,07 €	1-B6219-2	108,63 €	1-B6219-25	135,15 €		

### UNF



Diameter x Threads per inch	pack. unit	1,0 D 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit								
<b>UNF 6 x 40</b>	100	1-B6291-1	45,90 €	1-B6291-15	48,96 €	1-B6291-2	54,06 €			1-B6291-3	66,30 €
<b>UNF 8 x 36</b>	100	1-B6292-1	88,74 €	1-B6292-15	94,86 €	1-B6292-2	97,92 €	1-B6292-25	110,16 €		
<b>UNF 10 x 32</b>	100	1-B6293-1	35,70 €	1-B6293-15	40,80 €	1-B6293-2	45,90 €	1-B6293-25	48,96 €	1-B6293-3	56,10 €
<b>UNF 1/4 x 28</b>	100	1-B6225-1	45,90 €	1-B6225-15	19,55 €	1-B6225-2	24,30 €	1-B6225-25	28,66 €	1-B6225-3	76,50 €
<b>UNF 5/16 x 24</b>	100	1-B6226-1	40,80 €	1-B6226-15	26,00 €	1-B6226-2	56,10 €	1-B6226-25	71,40 €	1-B6226-3	127,50 €
<b>UNF 3/8 x 24</b>	100	1-B6227-1	51,00 €	1-B6227-15	28,91 €	1-B6227-2	66,30 €	1-B6227-25	50,18 €		
<b>UNF 7/16 x 20</b>	100	1-B6228-1	61,20 €	1-B6228-15	45,53 €	1-B6228-2	76,50 €	1-B6228-25	72,65 €	1-B6228-3	142,80 €
<b>UNF 1/2 x 20</b>	100			1-B6229-15	52,53 €	1-B6229-2	96,90 €	1-B6229-25	127,50 €	1-B6229-3	153,00 €
<b>UNF 9/16 x 18</b>	50	1-B6230-1	56,10 €	1-B6230-15	61,20 €	1-B6230-2	68,85 €				
<b>UNF 5/8 x 18</b>	50	1-B6231-1	63,75 €	1-B6231-15	71,40 €	1-B6231-2	86,70 €	1-B6231-25	127,50 €	1-B6231-3	168,30 €
<b>UNF 3/4 x 16</b>	25	1-B6233-1	57,38 €	1-B6233-15	59,93 €	1-B6233-2	66,30 €	1-B6233-25	110,93 €	1-B6233-3	123,68 €
<b>UNF 7/8 x 14</b>	10	1-B6235-1	48,45 €	1-B6235-15	50,49 €	1-B6235-2	72,93 €				
<b>UNF 1" x 12</b>	10	1-B6237-1	54,57 €	1-B6237-15	62,22 €	1-B6237-2	71,91 €				

### Harley-Davidson

Diameter x Threads per inch	pack. unit	1,0 D 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit								
<b>1/4 x 24</b>	10			2-B6305-15	6,17 €						
<b>7/16 x 16</b>	10			2-B6308-15	9,26 €						

### BA



Diameter	pack. unit	1,0 D 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit								
<b>BA 0</b>	100	1-B6470-1	33,89 €	1-B6470-15	44,08 €	1-B6470-2	52,90 €	1-B6470-25	64,65 €	1-B6470-3	74,77 €
<b>BA 2</b>	100	1-B6471-1	34,78 €	1-B6471-15	40,93 €	1-B6471-2	50,30 €	1-B6471-25	56,45 €	1-B6471-3	64,99 €
<b>BA 3</b>	100			1-B6472-15	34,65 €						
<b>BA 4</b>	100	1-B6473-1	32,60 €	1-B6473-15	35,06 €	1-B6473-2	42,57 €	1-B6473-25	45,45 €	1-B6473-3	51,26 €
<b>BA 6</b>	100	1-B6474-1	27,41 €	1-B6474-15	29,66 €	1-B6474-2	35,54 €	1-B6474-25	37,04 €	1-B6474-3	41,62 €

## BaerCoil® Wire Thread Inserts - type: "screw grip" - material: stainless steel 304

### BSW



Diameter x Threads per inch	pack. unit	1,0 D		1,5 D		2,0 D		2,5 D		3,0 D	
		1,0 x Diameter	Item-No.:	1,5 x Diameter	Item-No.:	2,0 x Diameter	Item-No.:	2,5 x Diameter	Item-No.:	3,0 x Diameter	Item-No.:
<b>BSW 3/16 x 24</b>	100			1-B6242-15	35,70 €	1-B6242-2	45,90 €	1-B6242-25	51,00 €	1-B6242-3	56,10 €
<b>BSW 1/4 x 20</b>	100			1-B6243-15	43,25 €	1-B6243-2	55,64 €	1-B6243-25	65,43 €	1-B6243-3	76,76 €
<b>BSW 5/16 x 18</b>	100	1-B6244-1	47,33 €	1-B6244-15	68,09 €	1-B6244-2	88,43 €	1-B6244-25	108,02 €	1-B6244-3	129,13 €
<b>BSW 3/8 x 16</b>	100	1-B6245-1	58,45 €	1-B6245-15	84,25 €	1-B6245-2	110,16 €				
<b>BSW 7/16 x 14</b>	100			1-B6246-15	94,30 €	1-B6246-2	142,70 €	1-B6246-25	189,92 €		
<b>BSW 1/2 x 12</b>	100	1-B6247-1	207,83 €	1-B6247-15	316,81 €	1-B6247-2	422,64 €	1-B6247-25	531,47 €	1-B6247-3	671,57 €
<b>BSW 5/8 x 11</b>	50	1-B6249-1	177,48 €								

### BSF

Diameter x Threads per inch	pack. unit	1,0 D		1,5 D		2,0 D		2,5 D		3,0 D	
		1,0 x Diameter	Item-No.:	1,5 x Diameter	Item-No.:	2,0 x Diameter	Item-No.:	2,5 x Diameter	Item-No.:	3,0 x Diameter	Item-No.:
<b>BSF 1/4 x 26</b>	100	1-B6263-1	46,31 €	1-B6263-15	60,28 €	1-B6263-2	73,19 €	1-B6263-25	86,70 €	1-B6263-3	100,32 €
<b>BSF 5/16 x 22</b>	100	1-B6265-1	65,08 €	1-B6265-15	91,70 €	1-B6265-2	116,79 €	1-B6265-25	143,87 €	1-B6265-3	178,50 €
<b>BSF 3/8 x 20</b>	100	1-B6266-1	87,77 €	1-B6266-15	126,33 €	1-B6266-2	163,46 €	1-B6266-25	204,00 €	1-B6266-3	242,61 €
<b>BSF 7/16 x 18</b>	100	1-B6267-1	163,20 €	1-B6267-15	187,43 €	1-B6267-2	246,38 €	1-B6267-25	316,20 €		
<b>BSF 1/2 x 16</b>	100	1-B6268-1	141,22 €	1-B6268-15	210,83 €	1-B6268-2	279,02 €	1-B6268-25	347,77 €		
<b>BSF 9/16 x 16</b>	50	1-B6269-1	102,92 €	1-B6269-15	153,31 €						
<b>BSF 5/8 x 14</b>	50	1-B6270-1	146,68 €	1-B6270-15	219,71 €	1-B6270-2	293,51 €				
<b>BSF 3/4 x 12</b>	25	1-B6272-1	212,72 €	1-B6272-15	259,74 €	1-B6272-3	503,42 €				
<b>BSF 7/8 x 11</b>	10			1-B6274-15	127,50 €						
<b>BSF 1" x 10</b>	10			1-B6276-15	171,21 €	1-B6276-2	227,56 €				

## BaerCoil® Wire Thread Inserts on strip feed type: "screw grip" - material: stainless steel 304

BaerCoil® Wire Thread Inserts on strip feed are especially used in the bulk production to speed up the inserting process.



### M

Diameter x pitch	1,0 D			1,5 D			2,0 D		
	1,0 x Diameter	Item-No.:	1,5 x Diameter	Item-No.:	2,0 x Diameter	Item-No.:			
<b>M 3 x 0,5</b>		B6103-1MAG			B6103-15MAG		B6103-25MAG		
<b>M 4 x 0,7</b>		B6104-1MAG			B6104-15MAG		B6104-25MAG		
<b>M 5 x 0,8</b>		B6105-1MAG			B6105-15MAG		B6105-25MAG		
<b>M 6 x 1,0</b>		B6106-1MAG			B6106-15MAG		B6106-25MAG		
<b>M 8 x 1,25</b>		B6108-1MAG			B6108-15MAG		B6108-25MAG		
<b>M 10 x 1,5</b>		B7215-1MAG			B7215-15MAG		B7215-2MAG		

Please inquire prices, quantities and other dimensions.

You can find more information to our screw locking BaerCoil® Wire Thread Inserts type: "screw grip" from page 4 - 7.



# BaerCoil® Wire Thread Inserts

## special materials

## aerospace industry standards

### BaerCoil® Wire Thread Inserts - type: "free running" - material: bronze CuSn6

DIN 8140 with reduced diameter for better installation

Tolerance ISO 2 (6H)

**M**



Diameter x Pitch	VPE	1,0 D		1,5 D		2,0 D			
		1,0 x Diameter	Item-No.:	Price per unit	1,5 x Diameter	Item-No.:	Price per unit	2,0 x Diameter	Item-No.:
<b>M 3 x 0,5</b>	100	1-B7205-1B	31,93 €	1-B7205-15B	33,39 €	1-B7205-2B	39,16 €		
<b>M 4 x 0,7</b>	100	1-B7207-1B	29,75 €	1-B7207-15B	30,86 €	1-B7207-2B	34,86 €		
<b>M 5 x 0,8</b>	100	1-B7208-1B	33,39 €	1-B7208-15B	34,51 €	1-B7208-2B	35,57 €		
<b>M 6 x 1,0</b>	100	1-B7209-1B	36,43 €	1-B7209-15B	36,43 €	1-B7209-2B	41,29 €		
<b>M 8 x 1,25</b>	100	1-B7211-1B	36,33 €	1-B7211-15B	39,21 €	1-B7211-2B	43,61 €		
<b>M 10 x 1,5</b>	100	1-B7215-1B	37,95 €	1-B7215-15B	40,48 €	1-B7215-2B	56,01 €		
<b>M 12 x 1,75</b>	100	1-B7221-1B	70,43 €	1-B7221-15B	74,68 €	1-B7221-2B	79,89 €		
<b>M 16 x 2,0</b>	100	1-B7234-1B	150,93 €	1-B7234-15B	155,93 €	1-B7234-2B	195,60 €		
<b>M 20 x 2,5</b>	100	1-B7239-1B	484,15 €	1-B7239-15B	565,45 €	1-B7239-2B	708,33 €		

### BaerCoil® Wire Thread Inserts - type: "free running" - material: stainless steel 316

DIN 8140 with reduced diameter for better installation

Tolerance ISO 2 (6H)

**M**



Diameter x Pitch	VPE	1,0 D		1,5 D		2,0 D			
		1,0 x Diameter	Item-No.:	Price per unit	1,5 x Diameter	Item-No.:	Price per unit	2,0 x Diameter	Item-No.:
<b>M 3 x 0,5</b>	100	1-B7205-1V4A	29,09 €	1-B7205-15V4A	31,62 €	1-B7205-2V4A	32,89 €		
<b>M 4 x 0,7</b>	100	1-B7207-1V4A	25,30 €	1-B7207-15V4A	27,32 €	1-B7207-2V4A	28,49 €		
<b>M 5 x 0,8</b>	100	1-B7208-1V4A	31,62 €	1-B7208-15V4A	33,54 €	1-B7208-2V4A	35,42 €		
<b>M 6 x 1,0</b>	100	1-B7209-1V4A	33,54 €	1-B7209-15V4A	37,95 €	1-B7209-2V4A	43,01 €		
<b>M 8 x 1,25</b>	100	1-B7211-1V4A	36,68 €	1-B7211-15V4A	41,74 €	1-B7211-2V4A	49,33 €		
<b>M 10 x 1,5</b>	100	1-B7215-1V4A	45,54 €	1-B7215-15V4A	50,60 €	1-B7215-2V4A	56,92 €		
<b>M 12 x 1,75</b>	100	1-B7221-1V4A	69,57 €	1-B7221-15V4A	77,82 €	1-B7221-2V4A	86,01 €		

**BaerCoil® Metric Wire Thread Inserts for aerospace industry**  
**type: „LN 9039“ - free running - material: stainless steel 304**

delivery time &amp; prices on request

| LN stand. = Item-No |
|---------------------|---------------------|---------------------|---------------------|---------------------|---------------------|
| LN9039-00025        | LN9039-04120        | LN9039-08200        | LN9039-12360        | LN9039-16480        | LN9039-20540        |
| LN9039-00037        | LN9039-04150        | LN9039-09100        | LN9039-13120        | LN9039-17160        | LN9039-21200        |
| LN9039-00050        | LN9039-04180        | LN9039-09150        | LN9039-13180        | LN9039-17240        | LN9039-21300        |
| LN9039-01030        | LN9039-05070        | LN9039-09200        | LN9039-13240        | LN9039-17320        | LN9039-21400        |
| LN9039-01045        | LN9039-05105        | LN9039-10100        | LN9039-14140        | LN9039-18180        | LN9039-22200        |
| LN9039-01060        | LN9039-05140        | LN9039-10150        | LN9039-14210        | LN9039-18270        | LN9039-22300        |
| LN9039-02040        | LN9039-06080        | LN9039-10200        | LN9039-14280        | LN9039-18360        | LN9039-22400        |
| LN9039-02060        | LN9039-06120        | LN9039-10250        | LN9039-14350        | LN9039-18450        | LN9039-23200        |
| LN9039-02080        | LN9039-06160        | LN9039-10300        | LN9039-14420        | LN9039-18540        | LN9039-23300        |
| LN9039-03050        | LN9039-07080        | LN9039-11120        | LN9039-15140        | LN9039-19180        | LN9039-23400        |
| LN9039-03075        | LN9039-07120        | LN9039-11180        | LN9039-15210        | LN9039-19270        | LN9499-23300        |
| LN9039-03100        | LN9039-07160        | LN9039-11240        | LN9039-15280        | LN9039-19360        | LN9499-23400        |
| LN9039-03125        | LN9039-07200        | LN9039-12120        | LN9039-16160        | LN9039-20180        |                     |
| LN9039-03150        | LN9039-07240        | LN9039-12180        | LN9039-16240        | LN9039-20270        |                     |
| LN9039-04060        | LN9039-08100        | LN9039-12240        | LN9039-16320        | LN9039-20360        |                     |
| LN9039-04090        | LN9039-08150        | LN9039-12300        | LN9039-16400        | LN9039-20450        |                     |

**BaerCoil® Metric Wire Thread Inserts for aerospace industry**

**type: „LN 9499-1“ - „screw grip“ - material: stainless steel 304**

delivery time &amp; prices on request

| LN stand. = Item-No |
|---------------------|---------------------|---------------------|---------------------|---------------------|---------------------|
| LN9499-00025        | LN9499-04060        | LN9499-08100        | LN9499-12240        | LN9499-16320        | LN9499-20360        |
| LN9499-00037        | LN9499-04090        | LN9499-08150        | LN9499-12300        | LN9499-16400        | LN9499-20450        |
| LN9499-00050        | LN9499-04120        | LN9499-08200        | LN9499-12360        | LN9499-16480        | LN9499-20540        |
| LN9499-01030        | LN9499-04150        | LN9499-09100        | LN9499-13120        | LN9499-17160        | LN9499-21200        |
| LN9499-01045        | LN9499-04180        | LN9499-09150        | LN9499-13180        | LN9499-17240        | LN9499-21300        |
| LN9499-01060        | LN9499-05070        | LN9499-09200        | LN9499-13240        | LN9499-17320        | LN9499-21400        |
| LN9499-02040        | LN9499-05105        | LN9499-10100        | LN9499-14140        | LN9499-18180        | LN9499-22200        |
| LN9499-02060        | LN9499-05140        | LN9499-10150        | LN9499-14210        | LN9499-18270        | LN9499-22300        |
| LN9499-02080        | LN9499-06080        | LN9499-10200        | LN9499-14280        | LN9499-18360        | LN9499-22400        |
| LN9499-02100        | LN9499-06120        | LN9499-10250        | LN9499-14350        | LN9499-18450        | LN9499-23200        |
| LN9499-02120        | LN9499-06160        | LN9499-10300        | LN9499-14420        | LN9499-18540        | LN9499-23300        |
| LN9499-03050        | LN9499-07080        | LN9499-11120        | LN9499-15140        | LN9499-19180        | LN9499-23400        |
| LN9499-03075        | LN9499-07120        | LN9499-11180        | LN9499-15210        | LN9499-19270        |                     |
| LN9499-03100        | LN9499-07160        | LN9499-11240        | LN9499-15280        | LN9499-19360        |                     |
| LN9499-03125        | LN9499-07200        | LN9499-12120        | LN9499-16160        | LN9499-20180        |                     |
| LN9499-03150        | LN9499-07240        | LN9499-12180        | LN9499-16240        | LN9499-20270        |                     |

**BaerCoil® Metric Wire Thread Inserts for aerospace industry**

**type: „DIN65536“ - „screw grip“ - material: bronze CuSn6**

delivery time &amp; prices on request

Non-magnetic bronze inserts with best electric conductivity

| DIN stand. = Item-No |
|----------------------|----------------------|----------------------|----------------------|----------------------|----------------------|
| DIN65536-01 025 A    | DIN65536-03 040 A    | DIN65536-05 060 A    | DIN65536-07 080 A    | DIN65536-09 100 A    | DIN65536-11 120 A    |
| DIN65536-01 037 A    | DIN65536-03 060 A    | DIN65536-05 090 A    | DIN65536-07 120 A    | DIN65536-09 150 A    | DIN65536-11 180 A    |
| DIN65536-01 050 A    | DIN65536-03 080 A    | DIN65536-05 120 A    | DIN65536-07 160 A    | DIN65536-09 200 A    | DIN65536-11 240 A    |
| DIN65536-02 030 A    | DIN65536-04 050 A    | DIN65536-06 080 A    | DIN65536-08 100 A    | DIN65536-10 120 A    |                      |
| DIN65536-02 045 A    | DIN65536-04 075 A    | DIN65536-06 120 A    | DIN65536-08 150 A    | DIN65536-10 180 A    |                      |
| DIN65536-02 060 A    | DIN65536-04 100 A    | DIN65536-06 160 A    | DIN65536-08 200 A    | DIN65536-10 240 A    |                      |



# BaerCoil® Tangless® CoilThread® Wire Thread Inserts





# 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 - Mix

Drill HSS

STI Bottoming Tap HSSG

Inserting Tool

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.	€
<b>M 3 x 0,5</b>	EBW03	BZ003	3,2 mm	10	5	5	B40052	19,90
<b>M 4 x 0,7</b>	EBW04	BZ004	4,2 mm	10	5	5	B40072	19,90
<b>M 5 x 0,8</b>	EBW05	BZ005	5,2 mm	10	5	5	B40092	19,90
<b>M 6 x 1,0</b>	EBW06	BZ006	6,3 mm	10	5	5	B40102	19,90
<b>M 7 x 1,0</b>	EBW07	BZ006	7,3 mm	10	5	5	B40112	28,20
<b>M 8 x 1,0</b>	EBW08	BZ008	8,3 mm	10	5	5	B40132	28,20
<b>M 8 x 1,25</b>	EBW08	BZ008	8,3 mm	10	5	5	B40122	28,20
<b>M 10 x 1,0</b>	EBW10	BZ010	10,3 mm	10	5	5	B40182	29,95
<b>M 10 x 1,25</b>	EBW10	BZ010	10,3 mm	10	5	5	B40172	29,95
<b>M 10 x 1,5</b>	EBW10	BZ010	10,4 mm	10	5	5	B40162	29,95
<b>M 12 x 1,25</b>	EBW12	BZ012	12,3 mm	10	5	5	B40232	33,90
<b>M 12 x 1,5</b>	EBW12	BZ012	12,4 mm	5	5	5	B40222	33,90
<b>M 12 x 1,75</b>	EBW12	BZ012	12,4 mm	5	5	5	B40212	33,90
<b>M 14 x 1,5</b>	EBW14		14,4 mm	3	3	3	B40292	39,00
<b>M 14 x 2,0</b>	EBW14		14,4 mm	3	3	3	B40282	39,00

## BaerCoil® Thread Repair Kits for spark plug

STI Tap HSSG with pilot nose for spark plug

Inserting Tool

Wire Thread Inserts - type: "free running" - different lengths  
**different lengths for all applications**

Instruction for use

					No.	€
M 10 x 1,0	EBW10	10 mm 5	15 mm 5	20 mm 5	ZKG010	39,90
M 12 x 1,25	EBW12	12 mm 5	18 mm 5	24 mm 5	ZKG012	39,90
M 14 x 1,25	EBW14	8,4 mm 5	12,4 mm 5	16,4 mm 5	ZKG014	39,90
M 18 x 1,5	EBW18	12,7 mm 5	15,9 mm 5	16,7 mm 5	ZKG018	89,50



## BaerCoil® Thread Repair Kits for spark plug

mit long tools

STI Tap with pilot nose HSSG - **120 mm long** - for spark plug

Inserting Tool with extension sleeve

Wire Thread Inserts - type: "free running" - different lengths

Instruction for use

					No.	€
M 12 x 1,25	EBW12	12 mm 5	18 mm 5	24 mm 5	ZKG012L	69,90
M 14 x 1,25	EBW14	8,4 mm 5	12,4 mm 5	16,4 mm 5	ZKG014L	89,90



## BaerCoil® Thread Repair Kits for oil drain plug

Drill HSS

STI Bottoming Tap HSSG

Inserting Tool

Wire Thread Inserts - type: "free running" - different lengths

**different lengths for all applications**

Instruction for use

					No.	€
M 12 x 1,5	EBW12	12,4 mm	12 mm 5	18 mm 5	B40223	33,90
M 14 x 1,5	EBW14	14,4 mm	14 mm 5	21 mm 5	B40293	39,80
M 16 x 1,5	EBW16		16 mm 5	24 mm 5	B40333	49,90





## 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

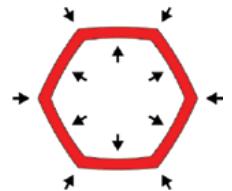


**M** ISO metric thread

				1,5 D	No.	€
<b>M 3 x 0,5</b>	EBW03	BZ003	3,2 mm	10	BS4005	19,90
<b>M 4 x 0,7</b>	EBW04	BZ004	4,2 mm	10	BS4007	19,90
<b>M 5 x 0,8</b>	EBW05	BZ005	5,2 mm	10	BS4009	19,90
<b>M 6 x 1,0</b>	EBW06	BZ006	6,3 mm	10	BS4010	19,90
<b>M 8 x 1,25</b>	EBW08	BZ008	8,3 mm	10	BS4012	28,20
<b>M 10 x 1,5</b>	EBW10	BZ010	10,4 mm	10	BS4016	29,95
<b>M 12 x 1,75</b>	EBW12	BZ012	12,4 mm	10	BS4021	33,90
<b>M 14 x 2,0</b>	EBW14		14,5 mm	5	BS4028	68,00
<b>M 16 x 2,0</b>	EBW14			5	BS4032	79,50
<b>M 18 x 2,5</b>	EBW18			5	BS4034	97,70
<b>M 20 x 2,5</b>	EBW20			5	BS4037	149,00
<b>M 24 x 3,0</b>	EBW24			5	BS4043	199,50
<b>M 30 x 3,5</b>	EBW30			5	BS4054	398,00

## BaerCoil® Wire Thread Inserts - type: "screw grip"

In addition to "free-running" insert characteristics, BaerCoil® "screw grip" thread inserts have one or more polygon-formed 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.



see locking torque on page 7

## 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.	€
<b>M 3 x 0,5</b>	KEBW03	BZ003	3,2 mm	10	5	5	B40054	22,50	
<b>M 4 x 0,7</b>	KEBW04	BZ004	4,2 mm	10	5	5	B40074	22,50	
<b>M 5 x 0,8</b>	KEBW05	BZ005	5,2 mm	10	5	5	B40094	22,50	
<b>M 6 x 1,0</b>	KEBW06	BZ006	6,3 mm	10	5	5	B40104	24,50	
<b>M 8 x 1,25</b>	KEBW08	BZ008	8,3 mm	10	5	5	B40124	29,90	
<b>M 10 x 1,5</b>	KEBW10	BZ010	10,4 mm	5	5	5	B40164	33,50	
<b>M 12 x 1,75</b>	KEBW12	BZ012	12,4 mm	5	5	5	B40214	38,00	

## BaerCoil® Thread Repair Kits for blind holes

Drill HSS

STI Bottoming Tap HSSE for blind holes with spiral flute

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.	€
<b>M 3 x 0,5</b>	EBW03	BZ003	10,4 mm	3,2 mm	10	5	5	B40055	35,20
<b>M 4 x 0,7</b>	EBW04	BZ004	10,4 mm	4,2 mm	10	5	5	B40075	35,20
<b>M 5 x 0,8</b>	EBW05	BZ005	10,4 mm	5,2 mm	10	5	5	B40095	35,20
<b>M 6 x 1,0</b>	EBW06	BZ006	10,4 mm	6,3 mm	10	5	5	B40105	35,20
<b>M 7 x 1,0</b>	EBW07	BZ006	10,4 mm	7,3 mm	10	5	5	B40115	52,20
<b>M 8 x 1,25</b>	EBW08	BZ008	10,4 mm	8,3 mm	10	5	5	B40125	52,20
<b>M 10 x 1,5</b>	EBW10	BZ010	16,5 mm	10,4 mm	10	5	5	B40165	54,00
<b>M 12 x 1,5</b>	EBW12	BZ012	16,5 mm	12,4 mm	5	5	5	B40225	68,80
<b>M 12 x 1,75</b>	EBW12	BZ012	16,5 mm	12,4 mm	5	5	5	B40215	68,80
<b>M 14 x 1,5</b>	EBW14		16,5 mm	14,4 mm	5	5		B40295	72,20
<b>M 16 x 2,0</b>	EBW14		16,5 mm		10			B40325	89,90



## 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	EBW01	BZ001	2,1 mm	20	B4001	19,90
<b>M 2 x 0,4</b>	EBW01	BZ001	2,3 mm	20	B4002	45,80
<b>M 2,2 x 0,45</b>	EBW01	BZ002	2,6 mm	20	B4003	19,90
<b>M 2,5 x 0,45</b>	EBW02	BZ003	3,2 mm	20	B4005	19,60
<b>M 3 x 0,5</b>	EBW03	BZ003	3,7 mm	20	B4006	32,90
<b>M 3,5 x 0,6</b>	EBW03	BZ004	4,2 mm	20	B4007	19,60
<b>M 4 x 0,7</b>	EBW04	BZ005	5,2 mm	20	B4009	19,90
<b>M 5 x 0,8</b>	EBW05	BZ006	6,3 mm	10	B0675	69,00
<b>M 6 x 0,75</b>	EBW06	BZ006	6,3 mm	20	B4010	19,90
<b>M 6 x 1,0</b>	EBW06	BZ006	7,3 mm	20	B4011	28,00
<b>M 7 x 1,0</b>	EBW07	BZ006	8,3 mm	10	B0875	69,00
<b>M 8 x 0,75</b>	EBW08	BZ008	8,3 mm	20	B4013	28,20
<b>M 8 x 1,0</b>	EBW08	BZ008	8,3 mm	20	B4012	26,50
<b>M 8 x 1,25</b>	EBW08	BZ008	9,3 mm	10	B0091	69,00
<b>M 9 x 1,0</b>	EBW08	BZ008	9,3 mm	15	B4014	31,00
<b>M 9 x 1,25</b>	EBW08	BZ010	10,3 mm	15	B4018	29,80
<b>M 10 x 1,0</b>	EBW10	BZ010	10,3 mm	15	B4017	29,80
<b>M 10 x 1,25</b>	EBW10	BZ010	10,4 mm	15	B4016	28,30
<b>M 10 x 1,5</b>	EBW10	BZ010	11,4 mm	5	B0111	75,80
<b>M 11 x 1,0</b>	EBW10	BZ010	11,4 mm	5	B1125	75,80
<b>M 11 x 1,25</b>	EBW10	BZ010	11,4 mm	10	B4019	35,00
<b>M 11 x 1,5</b>	EBW10	BZ012	12,3 mm	10	B4024	35,00
<b>M 12 x 1,0</b>	EBW12	BZ012	12,3 mm	10	B4023	35,00
<b>M 12 x 1,25</b>	EBW12	BZ012	12,4 mm	10	B4022	33,50
<b>M 12 x 1,5</b>	EBW12	BZ012	12,4 mm	10	B4021	33,50
<b>M 13 x 1,25</b>	EBW12		13,25 mm	5	B1315	99,00
<b>M 13 x 1,5</b>	EBW12		13,25 mm	5	B1325	89,00
<b>M 14 x 1,0</b>	EBW14		14,4 mm	10	B4031	39,00
<b>M 14 x 1,25</b>	EBW14		14,4 mm	10	B4030	39,00
<b>M 14 x 1,5</b>	EBW14		14,4 mm	10	B4029	37,00
<b>M 14 x 2,0</b>	EBW14		14,5 mm	10	B4028	37,00
<b>M 15 x 1,5</b>	EBW14			5	B1515	126,00
<b>M 15 x 2,0</b>	EBW14			5	B1520	126,00
<b>M 16 x 1,5</b>	EBW14			10	B4033	46,90
<b>M 16 x 2,0</b>	EBW14			10	B4032	46,90

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

## BaerCoil® Thread Repair Kits

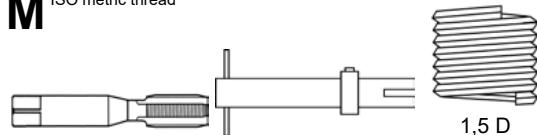
STI Bottoming Tap HSSG

Inserting Tool

Wire Thread Inserts - type: "free running" - length: 1,5 D

Instruction for use

**M** ISO metric thread



1,5 D      No.      €

<b>M 18 x 1,5</b>	EBW18	5	B4036	56,00
<b>M 18 x 2,0</b>	EBW18	5	B4035	69,00
<b>M 18 x 2,5</b>	EBW18	5	B4034	69,00
<b>M 20 x 1,5</b>	EBW20	5	B4039	77,50
<b>M 20 x 2,0</b>	EBW20	5	B4038	77,50
<b>M 20 x 2,5</b>	EBW20	5	B4037	77,50
<b>M 22 x 1,5</b>	EBW22	5	B4042	92,00
<b>M 22 x 2,0</b>	EBW22	5	B4041	92,00
<b>M 22 x 2,5</b>	EBW22	5	B4040	92,00
<b>M 24 x 1,5</b>	EBW24	5	B4045	104,00
<b>M 24 x 2,0</b>	EBW24	5	B4044	104,00
<b>M 24 x 3,0</b>	EBW24	5	B4043	104,00
<b>M 30 x 3,5</b>	EBW30	5	B4046	269,00
<b>M 39 x 2,0</b>	EBW39	5	B0392	998,00
<b>M 39 x 4,0</b>	EBW39	5	B0394	998,00
<b>M 42 x 2,0</b>	EBW42	5	B0422	998,00
<b>M 42 x 3,0</b>	EBW42	5	B0423	998,00
<b>M 42 x 4,0</b>	EBW42	5	B0424	998,00



## BaerCoil® Thread Repair Kits

STI-Taps, set of 2 pcs. HSSG

Inserting Tool

Wire Thread Inserts - type: "free running" - length: 1,5 D

Instruction for use

**M** ISO metric thread



1,5 D      No.      €

<b>M 26 x 1,5</b>	EBW26	5	B4049	244,00
<b>M 27 x 1,5</b>	EBW27	5	B4052	262,00
<b>M 27 x 2,0</b>	EBW27	5	B4051	262,00
<b>M 27 x 3,0</b>	EBW27	5	B4050	262,00
<b>M 28 x 1,5</b>	EBW28	5	B4053	262,00
<b>M 30 x 1,5</b>	EBW30	5	B4056	330,00
<b>M 30 x 2,0</b>	EBW30	5	B4055	330,00
<b>M 30 x 3,5</b>	EBW30	5	B4054	330,00
<b>M 33 x 2,0</b>	EBW33	5	B4058	380,00
<b>M 33 x 3,5</b>	EBW33	5	B4057	380,00
<b>M 36 x 1,5</b>	EBW36	5	B4063	420,00
<b>M 36 x 2,0</b>	EBW36	5	B4062	420,00
<b>M 36 x 3,0</b>	EBW36	5	B4061	420,00
<b>M 36 x 4,0</b>	EBW36	5	B0364	420,00



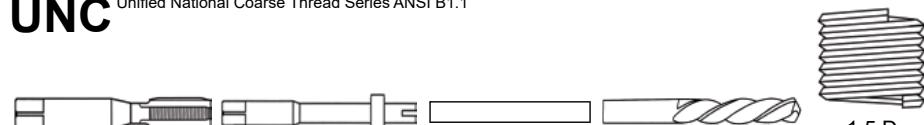


## BaerCoil® Thread Repair Kits

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



### UNC Unified National Coarse Thread Series ANSI B1.1



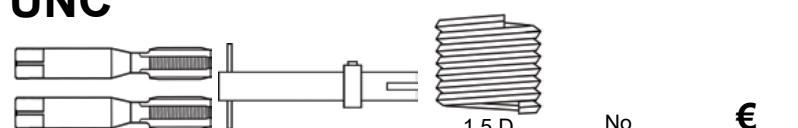
UNC	No.	€
2 x 56	EBW01	2,3 mm
3 x 48	EBW02	2,6 mm
4 x 40	EBW03	3,0 mm
5 x 40	EBW03	3,4 mm
6 x 32	EBW03	3,7 mm
8 x 32	EBW04	4,5 mm
10 x 24	EBW04	5,2 mm
12 x 24	EBW05	5,8 mm
1/4 x 20	EBW06	6,7 mm
5/16 x 18	EBW07	8,3 mm
3/8 x 16	EBW08	9,9 mm
7/16 x 14	EBW10	11,6 mm
1/2 x 13	EBW12	13,0 mm
9/16 x 12	EBW14	
5/8 x 11	EBW14	
11/16x11	EBW16	
3/4 x 10	EBW18	
7/8 x 9	EBW22	
1"x 8	EBW24	
	1,5 D	
	No.	
		66,00
		66,00
		27,00
		27,00
		27,00
		27,00
		27,00
		27,00
		27,00
		23,00
		27,00
		27,00
		29,90
		35,00
		38,80
		51,80
		156,00
		280,00
		147,00
		179,00
		170,00

## BaerCoil® Thread Repair Kits

STI-Taps, set of 2 pcs. HSSG  
Inserting Tool  
Wire Thread Inserts - type: "free running" - length: 1,5 D  
Instruction for use



### UNC Unified National Coarse Thread Series ANSI B1.1



UNC	No.	€
1.1/8 x 7	EBW26	10
1.1/4 x 7	EBW30	10
1.3/8 x 6	EBW31	10
1.1/2 x 6	EBW36	10
	1,5 D	
	No.	
		399,00
		453,20
		543,40
		633,60

## 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



### UNF Unified National Fine Thread Series ANSI B1.1



UNF	No.	No.	€
2 x 64	EBW01	BZ001	2,3 mm
3 x 56	EBW02	BZ002	2,6 mm
4 x 48	EBW03	BZ003	3,0 mm
6 x 40	EBW03	BZ003	3,7 mm
8 x 36	EBW04	BZ004	4,4 mm
10 x 32	EBW05	BZ005	5,1 mm
1/4 x 28	EBW06	BZ006	6,6 mm
5/16 x 24	EBW07	BZ006	8,2 mm
3/8 x 24	EBW08	BZ008	9,8 mm
7/16 x 20	EBW10	BZ010	11,5 mm
1/2 x 20	EBW12	BZ012	13,0 mm
9/16 x 18	EBW14		10
5/8 x 18	EBW14		10
3/4 x 16	EBW20		5
7/8 x 14	EBW22		5
1" x 12	EBW24		5
1" x 14	EBW24		5
			B41351 *

\* prices on request

## BaerCoil® Thread Repair Kits

STI-Taps, set of 2 pcs. HSSG  
 Inserting Tool  
 Wire Thread Inserts - type: "free running" - length: 1,5 D  
 Instruction for use

### UNF Unified National Fine Thread Series ANSI B1.1

UNF	No.	No.	€
1.1/8 x 12	EBW30	5	B4137 392,90
1.1/4 x 12	EBW31	5	B4138 449,00
1.3/8 x 12	EBW36	5	B4139 534,40
1.1/2 x 12	EBW39	5	B4140 633,60



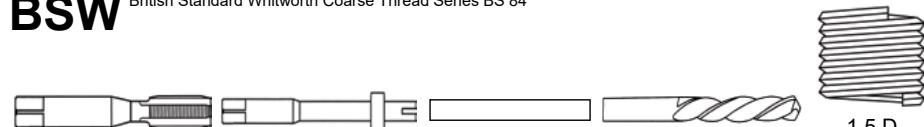


## BaerCoil® Thread Repair Kits

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



### BSW British Standard Whitworth Coarse Thread Series BS 84



BSW	No.	No.	1,5 D	No.	€
1/8 x 40	EBW03	BZ003	3,4 mm	20	B4141 55,90
3/16 x 24	EBW05	BZ005	5,0 mm	20	B4142 55,90
1/4 x 20	EBW06	BZ006	6,7 mm	20	B4143 49,90
5/16 x 18	EBW07	BZ006	8,3 mm	20	B4144 52,90
3/8 x 16	EBW08	BZ008	9,9 mm	15	B4145 57,70
7/16 x 14	EBW10	BZ010	11,6 mm	10	B4146 63,40
1/2 x 12	EBW12	BZ012	13,0 mm	10	B4147 68,00
9/16 x 12	EBW14			5	B4148 114,00
5/8 x 11	EBW14			5	B4149 114,90
11/16x11	EBW16			5	B4153 *
3/4 x 10	EBW18			5	B4150 147,40
7/8 x 9	EBW22			5	B4151 179,10
1" x 8	EBW24			4	B4152 170,80

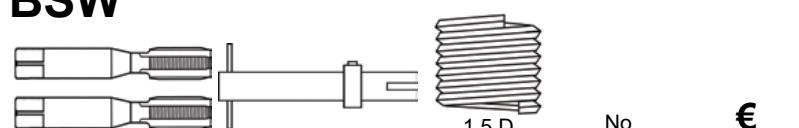
\* prices on request

## BaerCoil® Thread Repair Kits

STI-Taps, set of 2 pcs. HSSG  
Inserting Tool  
Wire Thread Inserts - type: "free running" - length: 1,5 D  
Instruction for use



### BSW British Standard Whitworth Coarse Thread Series BS 84



BSW	No.	No.	1,5 D	No.	€
1 1/8 x 7	EBW26		5	B4154	*
1 1/4 x 7	EBW30		5	B4155	*
1 3/8 x 6	EBW31		5	B4156	*
1 1/2 x 6	EBW36		5	B4157	*

\* prices on request

## 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



**BSF** British Standard Whitworth Fine Thread Series BS 84

			1,5 D	No.	€
<b>BSF 3/16 x 32</b>	EBW04	BZ004	5,0 mm	20	B4162 55,90
<b>BSF 7/32 x 28</b>	EBW05	BZ005	5,8 mm	10	B4177 *
<b>BSF 1/4 x 26</b>	EBW06	BZ006	6,6 mm	20	B4163 49,90
<b>BSF 9/32 x 26</b>	EBW06	BZ006	7,3 mm	10	B4178 *
<b>BSF 5/16 x 22</b>	EBW07	BZ008	8,3 mm	20	B4165 52,90
<b>BSF 3/8 x 20</b>	EBW08	BZ008	9,9 mm	15	B4166 57,70
<b>BSF 7/16 x 18</b>	EBW10	BZ010	11,5 mm	10	B4167 63,40
<b>BSF 1/2 x 16</b>	EBW12	BZ012	13,0 mm	10	B4168 68,00
<b>BSF 9/16 x 16</b>	EBW14			5	B4169 114,00
<b>BSF 5/8 x 14</b>	EBW14			5	B4170 114,90
<b>BSF 11/16x 14</b>	EBW16			5	B4171 *
<b>BSF 3/4 x 12</b>	EBW18			5	B4172 147,40
<b>BSF 13/16x 12</b>	EBW18			5	B4173 *
<b>BSF 7/8 x 11</b>	EBW22			5	B4174 179,10
<b>BSF 1" x 10</b>	EBW24			4	B4176 179,10

\* prices on request

## BaerCoil® Thread Repair Kits

STI-Taps, set of 2 pcs. HSSG  
 Inserting Tool  
 Wire Thread Inserts - type: "free running" - length: 1,5 D  
 Instruction for use



**BSF** British Standard Whitworth Fine Thread Series BS 84

			1,5 D	No.	€
<b>BSF 1.1/8 x 9</b>	EBW30		5	B4179	*
<b>BSF 1.1/4 x 9</b>	EBW31		5	B4180	*
<b>BSF 1.3/8 x 8</b>	EBW36		5	B4181	*
<b>BSF 1.1/2 x 8</b>	EBW39		5	B4182	*

\* prices on request



## 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



### G (BSP) British Standard Pipe Thread DIN ISO 228



2,0 D

No.

€

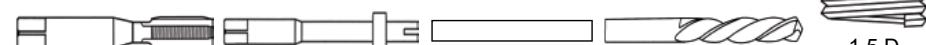
<b>G 1/8 x 28</b>	EBW10	BZ010	9,9 mm	5	B4190	48,00
<b>G 1/4 x 19</b>	EBW12	BZ012	13,5 mm	5	B4191	48,00
<b>G 3/8 x 19</b>	EBW14		17,0 mm	5	B4192	55,00
<b>G 1/2 x 14</b>	EBW22			5	B4193	69,00
<b>G 5/8 x 14</b>	EBW24			5	B4194	149,00
<b>G 3/4 x 14</b>	EBW26			5	B4195	149,00
<b>G 7/8 x 14</b>	EBW30			5	B4196	220,00
<b>G 1" x 11</b>	EBW36			5	B4197	220,00
<b>G 1.1/4 x 11</b>	EBW42			5	B4198	*
<b>G 1.1/2 x 11</b>	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  $\frac{1}{2}$  D at G 1/4 x 19:  
 $1/4 \times 25,4 \text{ mm} \times \frac{1}{2} = 12,70 \text{ mm}$

### BA British Association Standard Thread BS 93



1,5 D

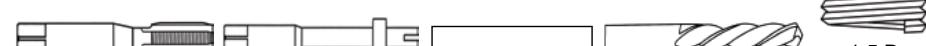
No.

€

<b>BA 0</b>	EBW06	BZ006	6,2 mm	10	B4201	128,30
<b>BA 1</b>	EBW05	BZ005	5,5 mm	10	B4202	128,30
<b>BA 2</b>	EBW05	BZ005	4,9 mm	10	B4203	128,30
<b>BA 3</b>	EBW04	BZ004	4,3 mm	5	B4204	*
<b>BA 4</b>	EBW03	BZ003	3,8 mm	5	B4205	139,00
<b>BA 5</b>	EBW03	BZ003	3,2 mm	5	B4206	*
<b>BA 6</b>	EBW02	BZ002	2,9 mm	5	B4207	149,60

leading time: 1 - 3 weeks

### BSB British Standard Brass Thread



1,5 D

No.

€

<b>BSB 1/4 x 26</b>	EBW06	BZ006	6,6 mm	5	B4208	222,40
<b>BSB 5/16 x 26</b>	EBW07	BZ006	8,2 mm	5	B4209	222,40
<b>BSB 3/8 x 26</b>	EBW08	BZ008	9,8 mm	5	B4210	222,40
<b>BSB 7/16 x 26</b>	EBW10	BZ010	11,5 mm	5	B4211	230,90
<b>BSB 1/2 x 26</b>	EBW12	BZ012	13,0 mm	5	B4212	258,80

\* prices on request

leading time: 1 - 3 weeks

## 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



### special sizes

			1,5 D	No.	€
UNEF 1/4 x 32	EBW06	BZ006	6,6 mm	10	B4225 171,10
Harley 1/4 x 24	EBW06	BZ006	6,6 mm	10	B4226 56,40
Harley 7/16 x 16	EBW10	BZ010	11,5 mm	10	B4227 63,50
Cummins 11/16x16	EBW14			10	B4228 568,00
Carburetor 7/8 x 20	EBW22			10	B4229 640,50
Carburetor 1" x 20	EBW24			10	B4230 396,50

### BSC British Standard Cycle Thread RS 811

			1,5 D	No.	€
BSC 5/16 x 26	EBW07	BZ006	8,2 mm	10	B4220 183,90
BSC 3/8 x 26	EBW08	BZ008	9,8 mm	10	B4221 222,40
BSC 7/16 x 26	EBW10	BZ010	11,5 mm	5	B4222 230,90
BSC 1/2 x 26	EBW12	BZ012	13,0 mm	5	B4223 258,80

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	247,80
NPT 1/4 x 19	EBW14	10		B4232	247,80
NPT 3/8 x 18	EBW14	10		B4233	247,80
NPT 1/2 x 14	EBW22	5		B4234	247,00
NPT 3/4 x 14	EBW26	5		B4235	376,00
NPT 1" x 11,5	EBW36	5		B4236	399,00

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	707,80
1.1/4 x 8	EBW30	5		B4241	768,40
1.3/8 x 8	EBW31	5		B4242	875,00
1.1/2 x 8	EBW36	4		B4243	982,20
1.5/8 x 8	EBW39	4		B4244	1142,50
1.3/4 x 8	EBW42	4		B4245	1267,00
1.7/8 x 8	EBW42	4		B4246	1445,40
2" x 8	EBW42	4		B4247	1623,60

leading time: 1 - 3 weeks

# BaerCoil® Thread Repair Workshop Kits



## BaerCoil® Thread Repair Workshop Kits

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.	€
<b>M 3 x 0,5</b>	EBW03	BZ003	3,2 mm	10	5		
<b>M 4 x 0,7</b>	EBW04	BZ004	4,2 mm	10	5		
<b>M 5 x 0,8</b>	EBW05	BZ005	5,2 mm	10	5		
<b>M 6 x 1,0</b>	EBW06	BZ006	6,3 mm	10	5	B5101	148,50
<b>M 8 x 1,25</b>	EBW08	BZ008	8,3 mm	10	5		
<b>M 10 x 1,5</b>	EBW10	BZ010	10,4 mm	5	5		
<b>M 12 x 1,75</b>	EBW12	BZ012	12,4 mm	5	5		

## M 5 - M 12

				1,5 D	2,5 D	No.	€
<b>M 5 x 0,8</b>	EBW05	BZ005	5,2 mm	10	5		
<b>M 6 x 1,0</b>	EBW06	BZ006	6,3 mm	10	5		
<b>M 8 x 1,25</b>	EBW08	BZ008	8,3 mm	10	5	B5104	111,90
<b>M 10 x 1,5</b>	EBW10	BZ010	10,4 mm	5	5		
<b>M 12 x 1,75</b>	EBW12	BZ012	12,4 mm	5	5		

## M 5 - M 8

				1,5 D	2,5 D	No.	€
<b>M 5 x 0,8</b>	EBW05	BZ005	5,2 mm	10	5		
<b>M 6 x 1,0</b>	EBW06	BZ006	6,3 mm	10	5	B5131	79,50
<b>M 8 x 1,25</b>	EBW08	BZ008	8,3 mm	10	5		

## M 6 - M 10

				1,5 D	2,5 D	No.	€
<b>M 6 x 1,0</b>	EBW06	BZ006	6,3 mm	10	5		
<b>M 8 x 1,25</b>	EBW08	BZ008	8,3 mm	10	5	B5130	89,50
<b>M 10 x 1,5</b>	EBW10	BZ010	10,4 mm	5	5		



## BaerCoil® Thread Repair Workshop Kit for spark plug

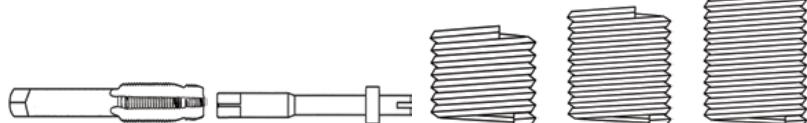
STI Tap HSSG with pilot nose, for spark plug

Inserting Tool

Wire Thread Inserts - type: "free running"

**different lengths for most applications**

Instruction for use



No.

€



M 10 x 1,0	EBW10	10 mm 5	15 mm 5	20 mm 5		
M 12 x 1,25	EBW12	12 mm 5	18 mm 5	24 mm 5	B5113	129,90
M 14 x 1,25	EBW14	8,4 mm 5	12,4 mm 5	16,4 mm 5		

## BaerCoil® Thread Repair Workshop Kit for oil drain plug

Drill HSS

STI Bottoming Tap HSSG

Inserting Tool

Wire Thread Inserts - type: "free running"

**different lengths for most applications**

Instruction for use



M 12 x 1,5	EBW12	12,4 mm	12 mm 5	18 mm 5		
M 14 x 1,5	EBW14	14,4 mm	14 mm 5	21 mm 5	B5157	119,90
M 16 x 1,5	EBW14		16 mm 5	24 mm 5		

## BaerCoil® Thread Repair Workshop Kits

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



### M 6 - M 14 x 1,5<sup>2</sup>

				1,5 D	2,5 D	No.	€
<b>M 6 x 1,0</b>	EBW06	BZ006	6,3 mm	10	5		
<b>M 8 x 1,25</b>	EBW08	BZ008	8,3 mm	10	5		
<b>M 10 x 1,5</b>	EBW10	BZ010	10,4 mm	5	5		
<b>M 12 x 1,75</b>	EBW12	BZ012	12,4 mm	5	5		
<b>M 14 x 1,5<sup>2</sup></b>	EBW14		14,4 mm	5	5	B5116	139,50

<sup>2</sup> for oil drain plug thread

### M 6 - M 14 x 1,25<sup>1</sup>

				1,5 D	2,5 D	No.	€
<b>M 6 x 1,0</b>	EBW06	BZ006	6,3 mm	10	5		
<b>M 8 x 1,25</b>	EBW08	BZ008	8,3 mm	10	5		
<b>M 10 x 1,5</b>	EBW10	BZ010	10,4 mm	5	5		
<b>M 12 x 1,75</b>	EBW12	BZ012	12,4 mm	5	5		
<b>M 14 x 1,25<sup>1</sup></b>	EBW14			8,4 mm 5	12,4 mm 5	16,4 mm 5	B5108 139,50

<sup>1</sup> for spark plug thread

### automotive - special

				1,5 D	2,5 D	No.	€
<b>M 6 x 1,0</b>	EBW06	BZ006	6,3 mm	10	5		
<b>M 10 x 1,0<sup>1</sup></b>	EBW10			10 mm 5	15 mm 5	20 mm 5	
<b>M 12 x 1,25<sup>1</sup></b>				12 mm 5	18 mm 5	24 mm 5	
<b>M 12 x 1,5<sup>2</sup></b>	EBW12	BZ012	12,4 mm	12 mm 5	18 mm 5		
<b>M 14 x 1,25<sup>1</sup></b>				8,4 mm 5	12,4 mm 5	16,4 mm 5	
<b>M 14 x 1,5<sup>2</sup></b>	EBW14		14,4 mm	14 mm 5	21 mm 5		B5109 189,50

<sup>1</sup> for spark plug thread

<sup>2</sup> for oil drain plug thread



## BaerCoil® Thread Repair Workshop Kits - “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 3 - M 12

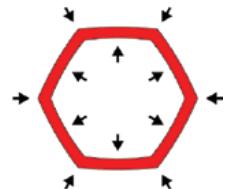
				1,5 D	No.	€
<b>M 3 x 0,5</b>	EBW03	BZ003	3,2 mm	20	B5153	159,50
<b>M 4 x 0,7</b>	EBW04	BZ004	4,2 mm	20		
<b>M 5 x 0,8</b>	EBW05	BZ005	5,2 mm	20		
<b>M 6 x 1,0</b>	EBW06	BZ006	6,3 mm	20		
<b>M 8 x 1,25</b>	EBW08	BZ008	8,3 mm	20		
<b>M 10 x 1,5</b>	EBW10	BZ010	10,4 mm	10		
<b>M 12 x 1,75</b>	EBW12	BZ012	12,4 mm	10		

### M 5 - M 12

				1,5 D	No.	€
<b>M 5 x 0,8</b>	EBW05	BZ005	5,2 mm	20	B5154	139,50
<b>M 6 x 1,0</b>	EBW06	BZ006	6,3 mm	20		
<b>M 8 x 1,25</b>	EBW08	BZ008	8,3 mm	20		
<b>M 10 x 1,5</b>	EBW10	BZ010	10,4 mm	10		
<b>M 12 x 1,75</b>	EBW12	BZ012	12,4 mm	10		

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

In addition to “free-running” insert characteristics, BaerCoil® “screw grip” thread inserts have one or more polygon-formed 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.



see locking torque on page 7

## 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.	€
<b>M 3 x 0,5</b>	KEBW03	BZ003		3,2 mm	10	5		
<b>M 4 x 0,7</b>	KEBW04	BZ004		4,2 mm	10	5		
<b>M 5 x 0,8</b>	KEBW05	BZ005	10,4 mm	5,2 mm	10	5		
<b>M 6 x 1,0</b>	KEBW06	BZ006		6,3 mm	10	5		
<b>M 8 x 1,25</b>	KEBW08	BZ008		8,3 mm	10	5		
<b>M 10 x 1,5</b>	KEBW10	BZ010	16,5 mm	10,4 mm	5	5	B5103	169,50
<b>M 12 x 1,75</b>	KEBW12	BZ012		12,4 mm	5	5		

### M 5 - M 12

					1,5 D	2,5 D	No.	€
<b>M 5 x 0,8</b>	KEBW05	BZ005		5,2 mm	10	5		
<b>M 6 x 1,0</b>	KEBW06	BZ006	10,4 mm	6,3 mm	10	5		
<b>M 8 x 1,25</b>	KEBW08	BZ008		8,3 mm	10	5		
<b>M 10 x 1,5</b>	KEBW10	BZ010	16,5 mm	10,4 mm	5	5	B5106	149,50
<b>M 12 x 1,75</b>	KEBW12	BZ012		12,4 mm	5	5		



## BaerCoil® Thread Repair Workshop 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



### 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		
UNC 7/16 x 14	EBW10	BZ010	11,6 mm	10		
UNC 1/2 x 13	EBW12	BZ012	13,0 mm	10	B5120	149,90

### 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		
UNF 7/16 x 20	EBW10	BZ010	11,5 mm	10		
UNF 1/2 x 20	EBW12	BZ012	13,0 mm	10	B5121	149,90

### 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		
BSW 7/16 x 14	EBW10	BZ010	11,6 mm	10		
BSW 1/2 x 12	EBW12	BZ012	13,0 mm	10	B5122	149,90

### 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		
BSF 7/16 x 18	EBW10	BZ010	11,5 mm	10		
BSF 1/2 x 16	EBW12	BZ012	13,0 mm	10	B5123	149,90

## BaerCoil® Thread Repair Workshop 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



### G (BSP) British Standard Pipe Thread DIN ISO 228

				1,5 D	No.	€
G (BSP) 1/8 x 28	EBW10	BZ010	10,0 mm	5		
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		
					B5124	229,00

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 Britisch Association Standard Thread BS 93

				1,5 D	No.	€
BA 0	EBW06	BZ006	6,2 mm	5		
BA 2	EBW05	BZ005	4,9 mm	5		
BA 4	EBW03	BZ003	3,8 mm	5		
BA 6	EBW02	BZ002	2,9 mm	5		
					B5125	240,90

leading time: 1 - 3 weeks

### NPT American Taper Pipe Thread ANSI B1.20.1

		1,5 D	No.	€
NPT 1/8 x 27	EBW10	5		
NPT 1/4 x 19	EBW14	5		
NPT 3/8 x 18	EBW14	5		
NPT 1/2 x 14	EBW22	5		
			B5126	398,00

leading time: 1 - 3 weeks

# BaerCoil® Taps



## BaerCoil® Taps

The BaerCoil® tap dimensions are different in diameter than normal taps. They have a larger diameter than standard taps in order to hold the wire thread insert while maintaining the same dimension. STI- or EG taps are made according to exact standards and in high-performance high-speed steel (HSS or HSSE). If a BaerCoil® thread insert is installed in a correctly cut receiving thread, the required thread tolerance for the installed screw is achieved.



## Coatings and surface treatments

Coated taps can be supplied on request. Especially TiN coated taps are on stock.

## Thread designations

<b>M</b>	ISO metric thread
<b>UNC</b>	Unified National Coarse Thread Series ANSI B1.1
<b>UNF</b>	Unified National Fine Thread Series ANSI B1.1
<b>BSW</b>	British Standard Whitworth Coarse Thread Series BS 84
<b>BSF</b>	British Standard Whitworth Fine Thread Series BS 84
<b>G (BSP)</b>	British Standard Pipe Thread DIN ISO 228
<b>BA</b>	British Association Standard Thread BS 93
<b>BSB</b>	British Standard Brass Thread
<b>BSC</b>	British Standard Cycle Thread RS 811
<b>NPT</b>	American Taper Pipe Thread ANSI B1.20.1
<b>8 - UN</b>	Unified Thread Series 8 TPI ANSI B1.1

## Compatibility

Important: BaerCoil® taps are compatible with wire thread inserts and taps from other manufacturers. They are often called "STI" or "EG" taps. Compatibility cannot be guaranteed, so it is always recommended to test from case to case.

## Tap lead-in chamfer

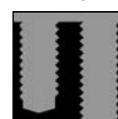


Bottoming tap  
chamfer: Form D (3-4 pitches)  
for through hole and blind hole

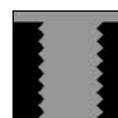
chip removal



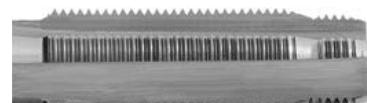
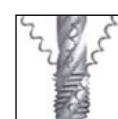
hole type



Machine tap  
chamfer: Form B (about 4 pitches)  
for through hole



Machine tap  
chamfer: Form C (2-3 pitches)  
for blind hole



Tap with pilot nose  
for thread repair









## BaerCoil® Taps with pilot nose

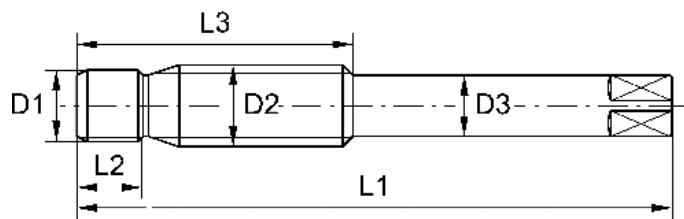
HSSG	EG	works standard
	STI	

M	D1	D2	D3	L1	L2	<input type="checkbox"/>	No.	€
M 6 x 1,0	6,0	7,30	8,0	70	8	28	6,3 B3630	12,00
M 8 x 1,25	8,0	9,62	8,0	75	8	32	6,3 B3631	13,00
M 10 x 1,0*	10,0	11,30	8,0	73	8	32	6,3 B3632	16,00
M 10 x 1,5	10,0	11,95	9,0	80	9	37	7,1 B3633	16,70
M 12 x 1,25*	12,0	13,62	11,0	81	8	33	9,0 B3634	21,00
M 12 x 1,25*	12,0	13,62	11,0	120	8	33	9,0 B3634L	28,90
M 14 x 1,25*	14,0	15,57	12,5	90	8	48	10,0 B3635	24,00
M 14 x 1,25*	14,0	15,57	12,5	120	8	48	10,0 B3635L	38,70
M 18 x 1,5*	18,0	19,95	16,0	116	10	47	12,5 B3636	48,10

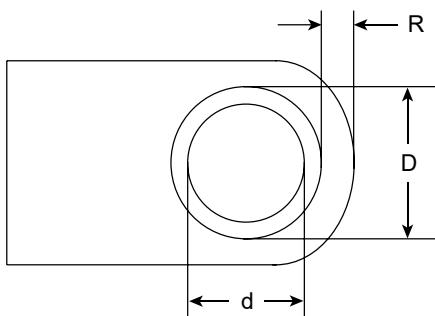
\* dimensions for spark plug threads



- for tapping internal threads in damaged metric threads
- no pre-drilling needed
- mainly used for repairing spark plug thread
- for through holes and very deep blind holes



### Minimum wall thickness



d = nominal diameter  
D = outside diameter of holding thread  
R = residual wall thickness

$$R \text{ (min)} = 0,375 \times D$$

The minimum wall thickness mainly depends on individual operating data.

These define material strength and length of thread engagement. The indicated guide value formulas apply to aluminum, cast and wrought alloys and the length of thread engagement of BaerCoil Wire Thread Insert of 1.5 D.



## BaerCoil® Machine taps - ECO for Wire Thread Inserts

<b>HSSE</b>	
<b>EG</b>	
<b>STI</b>	



through hole

<b>HSSE</b>	
<b>EG</b>	
<b>STI</b>	

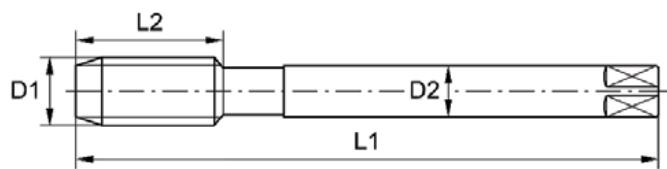


blind hole

M	D1	D2	L1	L2	<input type="checkbox"/>		No.	€
M 3 x 0,5	3,65	4,0	53	13,0	3,15	3,2	B3505	10,80
M 3,5 x 0,6	4,28	4,5	53	13,0	3,55	3,7	B3506	10,80
M 4 x 0,7	4,91	5,0	58	16,0	4,00	4,2	B3507	11,50
M 5 x 0,8	6,04	6,3	66	19,0	5,00	5,3	B3508	11,50
M 6 x 1,0	7,30	8,0	72	22,0	6,30	6,3	B3509	11,50
M 7 x 1,0	8,30	9,0	72	22,0	7,10	7,3	B3510	15,30
M 8 x 1,0	9,30	10,0	80	24,0	8,00	8,3	B3512	16,50
M 8 x 1,25	9,62	10,0	80	24,0	8,00	8,3	B3511	16,50
M 10 x 1,0	11,20	8,0	85	25,0	6,30	10,3	B3517	19,50
M 10 x 1,5	11,95	9,0	89	29,0	7,10	10,4	B3515	19,50
M 12 x 1,25	13,62	11,2	95	30,0	9,00	12,3	B3522	26,00
M 12 x 1,5	13,95	11,2	95	30,0	9,00	12,4	B3521	26,00
M 12 x 1,75	14,27	11,2	95	30,0	9,00	12,4	B3520	21,00
M 14 x 1,25	15,57	12,5	102	32,0	10,00	14,4	B3529	29,00
M 14 x 1,5	15,95	12,5	102	32,0	10,00	14,5	B3528	29,00
M 14 x 2,0	16,60	12,5	102	32,0	10,00	14,5	B3527	26,00
M 16 x 2,0	18,60	14,0	112	37,0	11,20	16,5	B3533	39,00

M	D1	D2	L1	L2	<input type="checkbox"/>		No.	€
M 2 x 0,4	2,52	2,8	44,5	9,5	2,24	2,1	B3704	15,90
M 3 x 0,5	3,65	4,0	53	13,0	3,15	3,2	B3705	11,00
M 3,5 x 0,6	4,28	4,5	53	13,0	3,55	3,7	B3706	15,50
M 4 x 0,7	4,91	5,0	58	16,0	4,00	4,2	B3707	12,20
M 5 x 0,8	6,04	6,3	66	19,0	5,00	5,3	B3708	12,20
M 6 x 1,0	7,30	8,0	72	22,0	6,30	6,3	B3709	12,20
M 7 x 1,0	8,30	9,65	72	33,0	7,30	7,3	B3710	16,10
M 8 x 1,0	9,30	10,0	80	24,0	8,00	8,3	B3712	19,50
M 8 x 1,25	9,62	10,0	80	24,0	8,00	8,3	B3711	16,10
M 10 x 1,0	11,20	8,0	85	25,0	6,30	10,3	B3717	23,50
M 10 x 1,5	11,95	9,0	89	29,0	7,10	10,4	B3715	18,80
M 12 x 1,25	13,62	11,2	95	30,0	9,00	12,3	B3722	29,80
M 12 x 1,5	13,95	11,2	95	30,0	9,00	12,4	B3721	29,80
M 12 x 1,75	14,27	11,2	95	30,0	9,00	12,4	B3720	21,00
M 14 x 1,25	15,57	12,5	102	32,0	10,00	14,4	B3729	29,80
M 14 x 1,5	15,95	12,5	102	32,0	10,00	14,5	B3728	35,00
M 14 x 2,0	16,60	12,5	102	32,0	10,00	14,5	B3727	39,00
M 16 x 2,0	18,60	14,0	112	37,0	11,20	16,5	B3733	42,80
M 18 x 1,5	19,95	16,5	113	51,0	12,40	18,5	B3737	48,00

Harley	D1	D2	L1	L2	<input type="checkbox"/>		No.	€
1/4 x 24	7,8	8,0	69	29	6,3	6,5	B3351	39,90
7/16 x 16	13,2	10,8	91	42	8,2	11,5	B3352	39,90





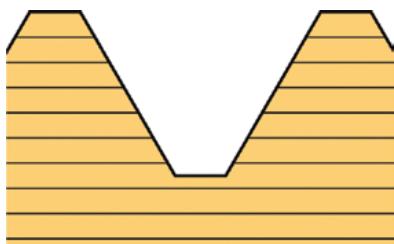
# BaerCoil® Forming Taps



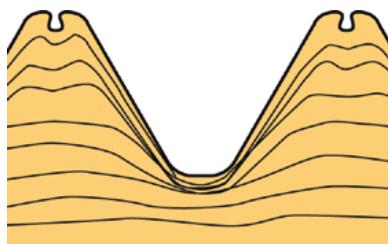
## BaerCoil® Forming Taps

The thread is formed and not cut. Specialized BaerCoil® forming taps, which form and plasticize the material, are used for this purpose. The parent thread material is compressed to make it stronger.

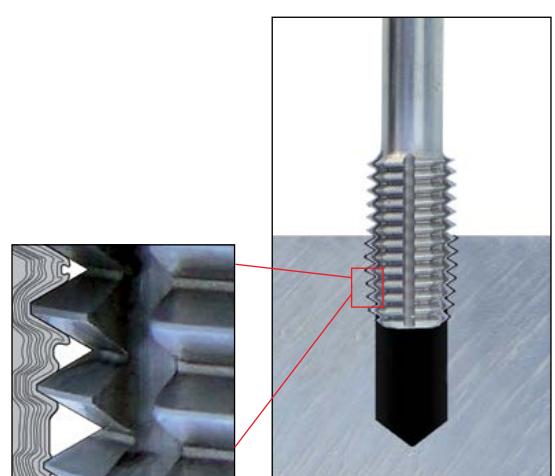
Result: The thread into which the BaerCoil® wire thread insert is turned has a significantly **higher load capacity**. The process of thread forming is **faster** and produces a **better surface** than thread cutting. Additionally there are **no chips**, and the thread forming tap has a **longer life time**.



Grain structure of a cutted thread



Grain structure of a formed thread  
The parent material gets compressed, will be strengthened and the resistance of the thread gets increased



## BaerCoil® System for strongest bolted connection

The BaerCoil® System's combination of thread forming and wire thread insert make modern dimensions possible for construction, development and improvement of previous building components.

Cryogenic Materialtests - CryoMaK within the Institute for Technical Physics at the Institute of Technology in Karlsruhe – KIT – have conducted pull-out strength tests. And customers, after performing internal tests, are already taking advantage of the system and have integrated it into their production process.

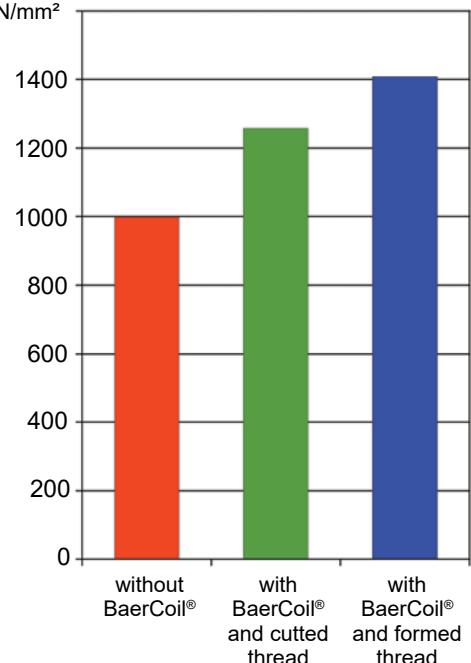
### Advantages:

- increased pull out strength and torque of the formed threads
- creates a better surface quality
- no problems with chip
- longer tool lifetime

### Materials:

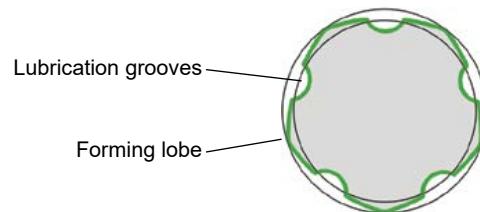
- stainless steel materials up to 950 N/mm<sup>2</sup>
- construction steels up to 800 N/mm<sup>2</sup>
- heat-treatable steels up to 1000 N/mm<sup>2</sup>
- aluminium alloys
- zinc alloys
- copper alloys

tensile strength  
N/mm<sup>2</sup>



## BaerCoil® Forming Taps

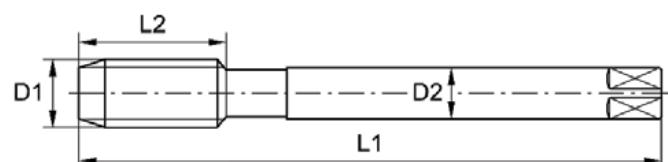
HSSE	EG	2-3 x P	Form C	works standard
TIN	STI			



M	D1	D2	L1	L2	No.	€
M 2 x 0,4	2,54	2,8	50	9,0	2,10	2,35
M 2,5 x 0,45	3,11	3,5	56	10,0	2,70	2,90
M 3 x 0,8	3,68	4,5	63	12,0	3,40	3,40
M 4 x 0,7	4,94	6,0	70	14,0	4,90	4,60
M 5 x 0,8	6,07	6,0	80	16,0	4,90	5,65
M 6 x 1,0	7,34	8,0	90	18,0	6,20	6,85
M 8 x 1,25	9,67	10,0	99	20,0	8,00	9,05
M 10 x 1,5	11,99	9,0	100	22,0	7,00	11,30
M 12 x 1,75	14,33	11,0	110	25,0	9,00	13,50
					B3620	68,50

Please inquire further thread standards and dimensions.

i Find forming speeds on page 63



# BaerCoil® Inserting Tools



## BaerCoil® Inserting Tools

with locking ring for depth stop



M	M	UNC UNF	BSW BSF	BA G (BSP) NPT	UNE F Harley BSC BSB	length	<input type="checkbox"/>	No.	€
M 3 x 0,5	M 3,5 x 0,6	UNC 4 x 40 UNC 5 x 40 UNC 6 x 32 UNF 4 x 48 UNF 6 x 40	BSW 1/8 x 40	5 BA		100	5	EBW03	5,10
M 4 x 0,7		UNC 8 x 32 UNC 10 x 24 UNF 8 x 36	BSF 3/16 x 32	4 BA 3 BA		100	5	EBW04	5,10
M 5 x 0,8		UNC 12 x 24 UNF 10 x 32	BSW 3/16 x 24 BSF 7/32 x 28	2 BA 1 BA		100	5	EBW05	5,10
M 6 x 1,0 M 6 x 0,75		UNC 1/4 x 20 UNF 1/4 x 28 BSF 9/32 x 26	BSW 1/4 x 20 BSF 1/4 x 26	0 BA	UNE 1/4 x 32 Harley 1/4 x 24 BSB 1/4 x 26	100	5	EBW06	5,10
M 7 x 1,0		UNC 5/16 x 18 UNF 5/16 x 24	BSW 5/16 x 18 BSF 5/16 x 22		BSC 5/16 x 26 BSB 5/16 x 26	100	7	EBW07	5,90
M 8 x 1,25 M 8 x 1,0 M 8 x 0,75	M 9 x 1,25	UNC 3/8 x 16 UNF 3/8 x 24	BSW 3/8 x 16 BSF 3/8 x 20		BSC 3/8 x 26 BSB 3/8 x 26	100	7	EBW08	5,90
M 10 x 1,5 M 10 x 1,25 M 10 x 1,0	M 11 x 1,5	UNC 7/16 x 14 UNF 7/16 x 20	BSW 7/16 x 14 BSF 7/16 x 18	G 1/8 x 28 NPT 1/8 x 27	Harley 7/16 x 16 BSC 7/16 x 26 BSB 7/16 x 26	100	7	EBW10	6,30
M 12 x 1,75 M 12 x 1,5 M 12 x 1,25	M 12 x 1,0	UNC 1/2 x 13 UNF 1/2 x 20	BSW 1/2 x 12 BSF 1/2 x 16	G 1/4 x 19	BSC 1/2 x 26 BSB 1/2 x 26	100	7	EBW12	7,50
M 14 x 2,0 M 14 x 1,5 M 14 x 1,25 M 14 x 1,0	M 15 x 2,0	UNC 9/16 x 12 UNC 5/8 x 11 UNF 9/16 x 18 UNF 5/8 x 18	BSW 9/16 x 12 BSW 5/8 x 11 BSF 9/16 x 16 BSF 5/8 x 14	G 3/8 x 19 NPT 1/4 x 19	11/16 x 16	100	7	EBW14	8,80

### 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® Inserting Tools

with locking ring for depth stop



M	UNC UNF	BSW BSF	G (BSP) NPT	8-UN	No.	€
M 2 x 0,4	UNC 2 x 56				EBW01	12,50
M 2,2 x 0,45	UNF 2 x 64					
M 2,5 x 0,45	UNC 3 x 48		BA 6		EBW02	12,50
UNF 3 x 56						
M 18 x 2,5		BSW 3/4 x 10				
M 18 x 2,0	UNC 3/4 x 10	BSF 3/4 x 12			EBW18	23,90
M 18 x 1,5		BSF 13/16 x 12				
M 20 x 2,5						
M 20 x 2,0	UNF 3/4 x 16				EBW20	23,90
M 20 x 1,5						
M 22 x 2,5	UNC 7/8 x 9	BSW 7/8 x 9	G 1/2 x 14			
M 22 x 2,0	UNF 7/8 x 14	BSF 7/8 x 11	NPT 1/2 x 14		EBW22	29,90
M 22 x 1,5						
M 24 x 3,0	UNC 1" x 8	BSW 1" x 8				
M 24 x 2,0	UNF 1" x 12	BSF 1" x 10		1" x 20	EBW24	29,90
M 24 x 1,5	UNF 1" x 14					
M 26 x 1,5			G 3/4 x 14			
M 27 x 2,0	UNC 1.1/8" x 7	BSW 1.1/8" x 7	NPT 3/4 x 14	UN 1.1/8" x 8	EBW26	62,90
M 27 x 1,5						
M 28 x 1,5					EBW28	34,90
M 30 x 3,5	UNC 1.1/4" x 7	BSW 1.1/4" x 7				
M 30 x 3,0	UNF 1.1/8" x 12	BSF 1.1/8" x 9		UN 1.1/4" x 8	EBW30	62,90
M 30 x 2,0	UNC 1.3/8" x 6	BSW 1.3/8" x 6				
M 30 x 1,5	UNF 1.1/4" x 12	BSF 1.1/4" x 9	G 7/8 x 14	UN 1.3/8" x 8	EBW31	62,90
M 33 x 3,5						
M 33 x 2,0					EBW33	47,80
M 36 x 4,0	UNC 1.1/2" x 6	BSW 1.1/2" x 6	G 1" x 11	UN 1.1/2" x 8	EBW36	62,90
M 36 x 3,0	UNF 1.3/8" x 12	BSF 1.3/8" x 8	NPT 1" x 11,5			
M 36 x 1,5				UN 1.5/8" x 8		
M 39 x 4,0						
M 39 x 3,0	UNF 1.1/2" x 12	BSF 1.1/2" x 8			EBW39	71,90
M 39 x 2,0						
M 42 x 4,5				UN 1.3/4" x 8		
M 42 x 4,0				UN 1.7/8" x 8		
M 42 x 3,0			G 1.1/4 x 11	UN 2" x 8	EBW42	71,90
M 42 x 2,0						

## BaerCoil® Machine Inserting Tool

for „free running“ Wire Thread Inserts  
with 1/4“ hexagonal drive  
and depth stop



	Length			No.	€
M 3 x 0,5	46,00 mm	5,50 mm	1/4"	KEBW03	8,60
M 4 x 0,7	48,00 mm	7,00 mm	1/4"	KEBW04	8,60
M 5 x 0,8	57,00 mm	8,00 mm	1/4"	KEBW05	8,60
M 6 x 1,0	62,00 mm	10,00 mm	1/4"	KEBW06	8,60
M 7 x 1,0	72,00 mm	11,00 mm	1/4"	KEBW07	8,60
M 8 x 1,25	72,00 mm	13,00 mm	1/4"	KEBW08	10,50
M 10 x 1,0	77,00 mm	17,00 mm	1/4"	KEBW1010	11,70
M 10 x 1,5	82,00 mm	17,00 mm	1/4"	KEBW10	11,70
M 12 x 1,25	79,00 mm	19,00 mm	1/4"	KEBW1212	12,90
M 12 x 1,5	79,00 mm	19,00 mm	1/4"	KEBW1215	12,90
M 12 x 1,75	92,00 mm	19,00 mm	1/4"	KEBW12	12,90
M 14 x 1,5	94,00 mm	21,00 mm	1/4"	KEBW1415	12,90
M 14 x 2,0	94,00 mm	21,00 mm	1/4"	KEBW1420	12,90
UNC 1/4 x 20	62,00 mm	7/16 "	1/4"	KEBW21	8,60
UNC 5/16 x 18	67,00 mm	1/2 "	1/4"	KEBW22	8,60
UNC 3/8 x 16	77,00 mm	9/16 "	1/4"	KEBW23	10,50
UNC 7/16 x 14	87,00 mm	11/16 "	1/4"	KEBW24	11,70
UNC 1/2 x 13	97,00 mm	3/4 "	1/4"	KEBW25	10,50
UNF 1/4 x 28	62,00 mm	7/16 "	1/4"	KEBW31	8,60
UNF 5/16 x 24	67,00 mm	1/2 "	1/4"	KEBW32	8,60
UNF 3/8 x 24	77,00 mm	9/16 "	1/4"	KEBW33	10,50
UNF 7/16 x 20	87,00 mm	11/16 "	1/4"	KEBW34	11,70
UNF 1/2 x 20	97,00 mm	3/4 "	1/4"	KEBW35	10,50

## BaerCoil® Extracting Tools



M	UNC UNF	BSW BSF		No.	€
M 2 – M 4	UNC 2 x 56 – UNC 8 x 32 UNF 2 x 64 – UNF 8 x 36	BSW 1/8	BA 3 – BA 6		B7051 44,50
M 3 – M 10	UNC 4 x 40 – UNC 3/8 UNF 4 x 48 – UNF 3/8	BSW 3/16 – BSW 3/8 BSF 3/16 – BSF 3/8	BA 0 – BA 2 G 1/8 BSB 1/4 x 26 – BSB 3/8 x 26 BSC 5/16 x 26 – BSC 3/8 x 26	NPT 1/8 x 27 UNEF 1/4 x 32 Harley 1/4 x 24	B7052 26,90
M 11 – M 24	UNC 3/8 – UNC 1" UNF 3/8 – UNF 1" UNF 1" x 14	BSW 3/8 – BSW 1" BSF 3/8 – BSF 1"	G 1/4 x 19 – G 5/8 x 14 BSB 3/8 x 26 – BSB 1/2 x 26 BSC 3/8 x 26 – BSC 1/2 x 26 NPT 1/4 x 19 – NPT 1/2 x 14	Harley 7/16 x 16 Cummins 11/16 x 16 Carburetor 7/8 x 20 Carburetor 1" x 20	B7053 32,20
M 20 – M 39	UNC 1.1/8" – UNC 1.1/2" UNF 1.1/8" – UNF 1.1/8"	BSW 1.1/8" – BSW 1.1/2" BSF 1.1/8" – BSF 1.1/2"	G 1/2 – G 1" NPT 1/2 – NPT 1"	UN 1.1/8" – UN 1.1/2"	B7054 106,90
M 38 – M 65				UN 1.5/8" – UN 2"	B7055 142,50



## BaerCoil® Tang Break Tool



M	M	UNC UNF	BSW BSF	BA G (BSP) NPT	UNEF Harley BSC BSB	Länge	No.	€
M 2 x 0,4	M 2,2 x 0,45	UNC 2 x 56 UNF 2 x 64					BZ001	5,30
M 2,5 x 0,45		UNC 3 x 48 UNF 3 x 56		6 BA			BZ002	5,30
M 3 x 0,5	M 3,5 x 0,6	UNC 4 x 40 UNC 5 x 40 UNC 6 x 32 UNF 4 x 48 UNF 6 x 40	BSW 1/8 x 40	5 BA		100	BZ003	2,20
M 4 x 0,7		UNC 8 x 32 UNC 10 x 24 UNF 8 x 36	BSF 3/16 x 32	4 BA 3 BA		100	BZ004	2,20
M 5 x 0,8		UNC 12 x 24 UNF 10 x 32	BSW 3/16 x 24 BSF 7/32 x 28	2 BA 1 BA		100	BZ005	2,20
M 6 x 1,0 M 6 x 0,75	M 7 x 1,0	UNC 1/4 x 20 UNF 1/4 x 28 UNC 5/16 x 18 UNF 5/16 x 24	BSW 1/4 x 20 BSF 1/4 x 26 BSF 9/32 x 26 BSW 5/16 x 18 BSF 5/16 x 22	0 BA	UNEF 1/4 x 32 Harley 1/4 x 24 BSB 1/4 x 26 BSC 5/16 x 26 BSB 5/16 x 26	100	BZ006	2,20
M 8 x 1,25	M 9 x 1,25	UNC 3/8 x 16	BSW 3/8 x 16		BSC 3/8 x 26			
M 8 x 1,0	M 9 x 1,0	UNF 3/8 x 24	BSF 3/8 x 20		BSB 3/8 x 26	100	BZ008	2,50
M 8 x 0,75								
M 10 x 1,5	M 11 x 1,5	UNC 7/16 x 14	BSW 7/16 x 14	G 1/8 x 28	Harley 7/16 x 16			
M 10 x 1,25	M 11 x 1,25	UNF 7/16 x 20	BSF 7/16 x 18	NPT 1/8 x 27	BSC 7/16 x 26 BSB 7/16 x 26	100	BZ010	2,50
M 10 x 1,0	M 11 x 1,0							
M 12 x 1,75		UNC 1/2 x 13	BSW 1/2 x 12		BSC 1/2 x 26			
M 12 x 1,5	M 12 x 1,0	UNF 1/2 x 20	BSF 1/2 x 16	G 1/4 x 19	BSB 1/2 x 26	100	BZ012	3,00
M 12 x 1,25								

## BaerCoil® Countersink HSSG

with 1/4" hexagonal drive  
to countersink a borehole



Ø	M	UNC UNF	BSW BSF			No.	€	
10,4	M 3 – M 8	UNC 4 x 40 – UNC 5/16 UNF 4 x 48 – UNF 5/16	BSW 3/16 – BSW 5/16 BSF 3/16 – BSF 5/16	BA 0 – BA 6 G 1/8 BSB 1/4 x 26 – BSB 5/16 x 26 BSC 5/16 x 26	NPT 1/8 x 27 UNEF 1/4 x 32 Harley 1/4 x 24	1/4"	B9402	8,90
16,5	M 8 – M 15	UNC 5/16 – UNC 9/16 UNF 5/16 – UNF 9/16	BSW 5/16 – BSW 9/16 BSF 5/16 – BSF 9/16	G 1/4 x 19 BSB 3/8 x 26 – BSB 1/2 x 26 BSC 3/8 x 26 – BSC 1/2 x 26	NPT 1/4 x 19 Harley 7/16 x 16	1/4"	B9403	9,90

**BaerCoil® Drill Bits**

DIN 338 - HSS straight shank drill bit



DIN 338-A - HSS reduced shank drill bit (13 or 16 mm)



DIN 345 - HSS morse taper shank drill bit

<b>Ø</b>	<b>M</b>	<b>M</b>	<b>UNC</b>	<b>UNF</b>	<b>BSW</b>	<b>BSF</b>	<b>DIN</b>	<b>No.</b>	<b>€</b>
2,10 mm	M 2 x 0,4						338	16121	0,60
2,30 mm	M 2,2 x 0,45		UNC 2 x 56	UNF 2 x 64			338	16123	0,60
2,60 mm	M 2,5 x 0,45		UNC 3 x 48	UNF 3 x 56			338	16126	0,70
3,00 mm			UNC 4 x 40	UNF 4 x 48			338	16130	0,60
3,20 mm	M 3 x 0,5						338	16132	0,60
3,30 mm				UNF 5 x 44			338	16133	0,60
3,40 mm			UNC 5 x 40		BSW 1/8 x 40		338	16134	0,70
3,70 mm	M 3,5 x 0,6		UNC 6 x 32	UNF 6 x 40			338	16137	0,80
4,20 mm	M 4 x 0,7						338	16142	0,80
4,40 mm				UNF 8 x 36			338	16144	1,20
4,50 mm			UNC 8 x 32				338	16145	1,20
5,00 mm					BSW 3/16 x 24	BSF 3/16 x 32	338	16150	1,30
5,10 mm				UNF 10 x 32			338	16151	1,50
5,20 mm	M 5 x 0,8		UNC 10 x 24				338	16152	1,50
5,80 mm			UNC 12 x 24			BSF 7/32 x 28	338	16158	1,80
6,30 mm	M 6 x 1,0	M 6 x 0,75					338	16163	1,95
6,60 mm				UNF 1/4 x 28		BSF 1/4 x 26	338	16166	2,20
6,70 mm			UNC 1/4 x 20		BSW 1/4 x 20		338	16167	2,20
7,30 mm	M 7 x 1,0					BSF 9/32 x 26	338	16173	2,50
8,20 mm	M 8 x 0,75			UNF 5/16 x 24			338	16182	3,50
8,30 mm	M 8 x 1,25	M 8 x 1,0	UNC 5/16 x 18		BSW 5/16 x 18	BSF 5/16 x 22	338	16183	3,50
9,30 mm	M 9 x 1,25	M 9 x 1,0					338	16193	3,90
9,80 mm				UNF 3/8 x 24			338	16198	4,50
9,90 mm			UNC 3/8 x 16		BSW 3/8 x 16	BSF 3/8 x 20	338	16199	4,50
10,30 mm	M 10 x 1,0	M 10 x 1,25					338	161103	5,50
10,40 mm	M 10 x 1,5						338	161104	5,50
11,30 mm	M 11 x 1,0						338	161113	6,90
11,40 mm	M 11 x 1,5	M 11 x 1,25					338	161114	6,90
11,50 mm				UNF 7/16 x 20		BSF 7/16 x 18	338	161115	6,90
11,60 mm			UNC 7/16 x 14		BSW 7/16 x 14		338	161116	6,90
12,30 mm	M 12 x 1,0	M 12 x 1,25					338	161123	8,90
12,40 mm	M 12 x 1,75	M 12 x 1,5					338	161124	8,90
13,00 mm			UNC 1/2 x 13	UNF 1/2 x 20	BSW 1/2 x 12	BSF 1/2 x 16	338	161130	8,90
13,25 mm	M 13 x 1,25	M 13 x 1,5					338-A	130133	33,50
14,40 mm	M 14 x 1,0	M 14 x 1,25					338-A	111144	33,50
14,50 mm	M 14 x 2,0	M 14 x 1,5		UNF 9/16 x 18		BSF 9/16 x 16	338-A	111145	16,00
14,75 mm			UNC 9/16 x 12		BSW 9/16 x 12		345	130147	49,00
15,50 mm	M 15 x 2,0	M 15 x 1,5					338-A	111155	21,80
16,25 mm				UNF 5/8 x 18		BSF 5/8 x 14	345	130162	49,00
16,50 mm	M 16 x 2,0	M 16 x 1,5	UNC 5/8 x 11		BSW 5/8 x 11		338-A	111165	24,20
18,00 mm			UNC 11/16x11		BSW 11/16x11	BSF 11/16x14	338-A	111180	29,00
18,50 mm	M 18 x 2,5	M 18 x 2,0 M 18 x 1,5					338-A	111185	29,80
19,50 mm				UNF 3/4 x 16		BSF 3/4 x 12	338-A	111195	33,00
19,75 mm			UNC 3/4 x 10		BSW 3/4 x 10		345	130197	49,00
20,50 mm	M 20 x 2,5	M 20 x 2,0 M 20 x 1,5					338-A	111205	48,00
22,50 mm	M 22 x 2,5	M 22 x 2,0 M 22 x 1,5		UNF 7/8 x 14		BSF 7/8 x 11	345	130225	55,50
23,00 mm			UNC 7/8 x 9		BSW 7/8 x 9		338-A	111230	58,00
24,50 mm	M 24 x 3,0	M 24 x 2,0 M 24 x 1,5		UNF 1" x 12/14	BSW 1" x 8	BSF 1" x 10	345	130245	55,50
26,00 mm			UNC 1" x 8	UNF 1" x 12/14	BSW 1" x 8	BSF 1" x 10	338-A	111260	79,00



## BaerCoil® Drill Bits



DIN 338 - HSS straight shank drill bit



DIN 338-A - HSS reduced shank drill bit (13 or 16 mm)



DIN 345 - HSS Morse taper shank drill bit

Ø	M	M	UNC	UNF	BSW	BSF	DIN	No.	€
26,50 mm	M 26 x 1,5						345	130265	89,00
27,50 mm	M 27 x 2,0	M 27 x 1,5					345	130275	89,00
28,50 mm	M 28 x 1,5						345	130285	97,00
29,50 mm			UNC 1.1/8" x 7	UNF 1.1/8" x 12	BSW 1.1/8" x 7	BSF 1.1/8" x 9	345	130295	119,00
30,50 mm	M 30 x 3,5	M 30 x 2,0 M 30 x 1,5					345	130305	120,00
32,50 mm				UNF 1.1/4" x 12		BSF 1.1/4" x 9	345	130325	153,00
33,00 mm			UNC 1.1/4" x 7		BSW 1.1/4" x 7		345	130330	165,00
33,50 mm	M 33 x 3,5	M 33 x 2,0					345	130335	171,00
36,00 mm			UNC 1.3/8" x 6	UNF 1.3/8" x 12	BSW 1.3/8" x 6	BSF 1.3/8" x 8	345	130360	198,00
36,50 mm	M 36 x 3,0	M 36 x 2,0 M 36 x 1,5					345	130365	219,00
37,00 mm	M 36 x 4,0						345	130370	252,00
39,00 mm			UNC 1.1/2" x 6	UNF 1.1/2" x 12	BSW 1.1/2" x 6	BSF 1.1/2" x 8	345	130390	255,00
39,50 mm	M 39 x 2,0						345	130395	255,00
40,00 mm	M 39 x 4,0						345	130400	255,00
42,50 mm	M 42 x 2,0						345	130425	296,00
43,00 mm	M 42 x 4,5	M 42 x 3,0					345	130430	296,00
	M 42 x 4,0	M 42 x 2,0							

Ø	G (BSP)	BSB	BSC	NPT	BA	DIN	No.	€	
2,90 mm					BA 6		338	16129	0,60
3,20 mm					BA 5		338	16132	0,60
3,80 mm					BA 4		338	16138	0,80
4,30 mm					BA 3		338	16143	1,20
4,90 mm					BA 2		338	16149	1,30
5,50 mm					BA 1		338	16155	1,80
6,20 mm					BA 0		338	16162	1,95
6,60 mm		BSB 1/4 x 26			UNEF 1/4 x 32 Harley 1/4 x 24		338	16166	2,20
8,20 mm		BSB 5/16 x 26	BSC 5/16 x 26				338	16182	3,50
9,80 mm		BSB 3/8 x 26	BSC 3/8 x 26				338	16198	4,50
9,90 mm	G 1/8 x 28			NPT 1/8 x 27			338	16199	4,50
11,50 mm		BSB 7/16 x 26	BSC 7/16 x 26			Harley 7/16 x 16	338	161115	6,90
13,00 mm		BSB 1/2 x 26	BSC 1/2 x 26				338	161130	8,90
13,50 mm	G 1/4 x 19			NPT 1/4 x 19			338-A	111135	25,80
17,00 mm	G 3/8 x 19			NPT 3/8 x 18			338-A	111170	25,80
18,00 mm						Cummins 11/16x16	338-A	111180	29,00
21,50 mm	G 1/2 x 14			NPT 1/2 x 14			338-A	111215	45,00
22,50 mm						Carburetor 7/8 x 20	345	130225	58,00
23,50 mm	G 5/8 x 14						345	130235	58,00
26,00 mm						Carburetor 1" x 20	338-A	111260	75,00
27,00 mm	G 3/4 x 14			NPT 3/4 x 14			338-A	111270	84,00
28,50 mm						UN 1.1/8" x 8	345	130285	98,00
32,00 mm						UN 1.1/4" x 8	345	130320	148,00
33,50 mm	G 1" x 11			NPT 1" x 11,5			345	130335	171,00
35,00 mm						UN 1.3/8" x 8	345	130350	196,00
38,00 mm						UN 1.1/2" x 8	345	130380	252,00
41,00 mm						UN 1.5/8" x 8	345	130410	255,00
42,50 mm	G 1.1/4" x 11						345	130425	276,00
44,50 mm						UN 1.3/4" x 8	345	130445	309,00
47,50 mm						UN 1.7/8" x 8	345	130475	396,00
48,50 mm	G 1.1/2" x 11						345	130485	396,00

## BaerCoil® further product range - on request

### BaerCoil® Machine Inserting Tools

BaerCoil® Machine Inserting Tools are suitable for installing inserts in large-volume productions.

Our program - on request:

- air motor
- electric installation tool
- auto tang break off tool
- adaptor
- prewinder
- spacer sets
- mandrel
- spare and wear parts

Advantages:

- minimises the in-place cost
- speeds the operation up
- high accuracy of precisely installing insert after insert
- greater productivity



### BaerCoil® Thread Gauges for Wire Thread Inserts

Gauges are available in both 4H or 5H class of fits for metric threads, 2B or 3B for Unified threads and close medium for Whitworth threads. Class of fit of the finished assembly is dependant on the accuracy of the tapped hole.

The result shows if the tapped hole for wire thread inserts gauges correctly. It is not possible to gauge the installed inserts, because they are flexible.



### TwinCoil

The TwinCoil system consists of two BaerCoil® inserts. An outer wire thread insert installed into an oversize tapped hole which then has an inner wire thread insert fitted inside to give a standard female thread. The outer insert is installed into the TwinCoil tapped hole (larger than a conventional wire thread insert tapped hole) and is the same nominal length as the original thread. The outer insert is always a "free running" type insert. The inner insert however can be either free running or screw grip dependant on the application.

Applications:

- to correct out-of-position holes
- to salvage wire thread insert holes that have become worn or stripped
- to correct tapped holes that gauge oversize



### BaerCoil® wire thread inserts and custom-made products

This catalog just contains the standard product range of BaerCoil® Wire Thread Inserts and tools.

Further available thread standards:

Harley, UNEF, UNS, BSC, BSB, BSPT, NPT, NPTF, MJ, UNJC, 8-UN, 12-UN, 16-UN

Custom-made inserts and larger sizes after consultation, sending of sample or detailed drawing.



# BaerCoil®

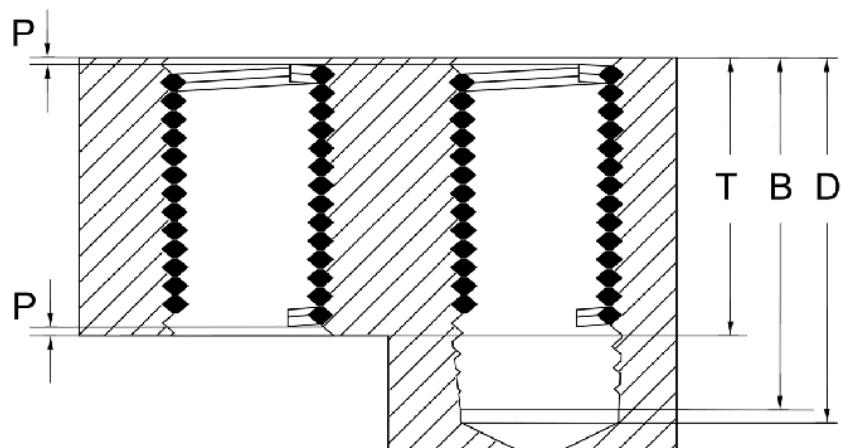
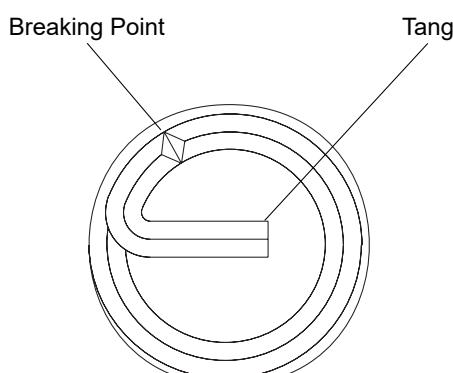
## Technical Data



## Technical Data for BaerCoil® Wire Thread Inserts

DIN 8140 with reduced diameter for better installation

M	1,0 D			1,5 D			2,0 D			2,5 D			3,0 D			F (mm)	
	T	D	B	T	D	B	T	D	B	T	D	B	T	D	B	min.	max.
M 2 x 0.4	2.00	3.80	3.40	3.00	4.80	4.40	4.00	5.80	5.40	5.00	6.80	6.40	6.00	7.80	7.40	2.48	2.70
M 2.2 x 0.45	2.20	4.23	3.78	3.30	5.33	4.88	4.40	6.43	5.98	5.50	7.53	7.08	6.60	8.63	8.18		
M 2.5 x 0.45	2.50	4.52	4.07	3.75	5.78	5.33	5.00	7.03	6.58	6.25	8.28	7.83	7.50	9.53	9.08	3.04	3.70
M 3 x 0.5	3.00	5.25	4.75	4.50	6.75	6.25	6.00	8.25	7.75	7.50	9.75	9.25	9.00	11.25	10.75	3.60	4.35
M 3.5 x 0.6	3.50	6.20	5.60	5.25	7.95	7.35	7.00	9.70	9.10	8.75	11.45	10.85	10.50	13.20	12.60	4.22	4.95
M 4 x 0.7	4.00	7.15	6.45	6.00	9.15	8.45	8.00	11.15	10.45	10.00	13.15	12.45	12.00	15.15	14.45	4.83	5.60
M 4.5 x 0.75	4.50	7.88	7.13	6.75	10.13	9.38	9.00	12.38	11.63	11.25	14.63	13.88	13.50	16.88	16.13		
M 5 x 0.8	5.00	8.60	7.80	7.50	11.10	10.30	10.00	13.60	12.80	12.50	16.10	15.30	15.00	18.60	17.80	5.94	6.80
M 6 x 1.0	6.00	10.50	9.50	9.00	13.50	12.50	12.00	16.50	15.50	15.00	19.50	18.50	18.00	22.50	21.50	7.17	7.95
M 7 x 1.0	7.00	11.50	10.50	10.50	15.00	14.00	14.00	18.50	17.50	17.50	22.00	21.00	21.00	25.50	24.50	8.17	9.20
M 8 x 1.0	8.00	12.50	11.50	12.00	16.50	15.50	16.00	20.50	19.50	20.00	24.50	23.50	24.00	28.50	27.50	9.17	10.25
M 8 x 1.25	8.00	13.63	12.38	12.00	17.63	16.38	16.00	21.63	20.38	20.00	25.63	24.38	24.00	29.63	28.38	9.45	10.35
M 9 x 1.0	9.00	13.50	12.50	13.50	18.00	17.00	18.00	22.50	21.50	22.50	27.00	26.00	27.00	31.50	30.50	10.17	11.23
M 9 x 1.25	9.00	14.63	13.38	13.50	19.13	17.88	18.00	23.63	22.38	22.50	28.13	26.88	27.00	32.63	31.38	10.45	11.16
M 10 x 1.0	10.00	14.50	13.50	15.00	19.50	18.50	20.00	24.50	23.50	25.00	29.50	28.50	30.00	34.50	33.50	11.17	12.50
M 10 x 1.25	10.00	15.63	14.38	15.00	20.63	19.38	20.00	25.63	24.38	25.00	30.63	29.38	30.00	35.63	34.38	11.45	12.65
M 10 x 1.5	10.00	16.75	15.25	15.00	21.75	20.25	20.00	26.75	25.25	25.00	31.75	30.25	30.00	36.75	35.25	11.74	12.50
M 11 x 1.25	11.00	16.62	15.37	16.50	22.12	20.87	22.00	27.62	26.37	27.50	33.12	31.87	33.00	38.62	37.37	12.47	13.76
M 11 x 1.5	11.00	17.75	16.25	16.50	23.25	21.75	22.00	28.75	27.25	27.50	34.25	32.75	33.00	39.75	38.25	12.74	13.59
M 12 x 1.25	12.00	17.63	16.38	18.00	23.63	22.38	24.00	29.63	27.38	30.00	35.63	34.38	36.00	41.63	40.38	13.47	15.00
M 12 x 1.5	12.00	18.75	17.25	18.00	24.00	23.25	24.00	30.75	29.25	30.00	36.75	35.25	36.00	42.75	41.25	13.75	15.20
M 12 x 1.75	12.00	19.88	18.13	18.00	25.88	24.13	24.00	31.88	30.13	30.00	37.88	36.13	36.00	43.88	42.13	14.03	15.00
M 14 x 1.25	14.00	19.62	18.37	21.00	26.62	25.37	28.00	33.62	32.37	35.00	40.62	39.37	42.00	47.62	46.37	15.47	17.03
M 14 x 1.5	14.00	20.75	19.25	21.00	27.75	26.25	28.00	34.75	33.25	35.00	41.75	40.25	42.00	48.75	47.25	15.75	17.25
M 14 x 2.0	14.00	23.00	21.00	21.00	30.00	28.00	28.00	37.00	35.00	35.00	44.00	42.00	42.00	51.00	49.00	16.31	17.35
M 16 x 1.5	16.00	22.75	21.25	24.00	30.75	29.25	32.00	38.75	37.25	40.00	46.75	45.25	48.00	54.75	53.25	17.75	19.60
M 16 x 2.0	16.00	25.00	23.00	24.00	33.00	31.00	32.00	41.00	39.00	40.00	49.00	47.00	48.00	57.00	55.00	18.31	19.60
M 18 x 1.5	18.00	24.75	23.25	27.00	33.75	32.25	36.00	42.75	41.25	45.00	51.75	50.25	54.00	60.75	59.25	19.75	21.85
M 18 x 2.0	18.00	27.00	25.00	27.00	36.00	34.00	36.00	45.00	43.00	45.00	54.00	52.00	54.00	63.00	61.00	20.31	21.85
M 18 x 2.5	18.00	29.25	26.75	27.00	38.25	35.75	36.00	47.25	44.75	45.00	56.25	53.75	54.00	65.25	62.75	20.86	22.00



P Installed insert 1/4 – 1/2 pitch below the surface

T Length of Insert, when installed

B Tap depth – including threads chamfer of plug tap

D Drill depth (min.) - excluding point

F Free coil diameter







## Forming speeds for BaerCoil® Forming Taps

materials	tensile strength	forming speed in m/min	recommended lubrication
construction steels, free-macining steels, cold-extrusion steels etc.	< 600 N/mm <sup>2</sup>	20 - 80	Cutting oil/ Emulsion
construction steels, heat-treatable steels, cast steels etc.	< 800 N/mm <sup>2</sup>	20 - 60	Cutting oil/ Emulsion
heat-treatable steels, cold-extrusion steels, nitriding steels etc.	< 1000 N/mm <sup>2</sup>	10 - 40	Cutting oil
corrosion and acid proof steels ferritic, martensitic	< 950 N/mm <sup>2</sup>	10 - 25 (with emulsion just limitedly applicable)	Cutting oil
corrosion and acid proof steels austenitic	< 950 N/mm <sup>2</sup>	10 - 25 (with emulsion just limitedly applicable)	Cutting oil
aluminium wrought alloys	< 550 N/mm <sup>2</sup>	15 - 40	Cutting oil/ Emulsion
aluminium cast alloys	Si < 12%	15 - 40	Cutting oil/ Emulsion
pure copper	< 400 N/mm <sup>2</sup>	20 - 40	Cutting oil/ Emulsion
copper-zinc alloys (brass long-chipping)	< 550 N/mm <sup>2</sup>	40 - 80	Emulsion

forming (cutting) speed [m/min] = (diameter \* π \* number of rotation) / 1000

number of rotation n [1/min] = (cutting speed in m/min \* 1000) / (diameter \* π)

feed programming [mm/min] = number of rotation \* pitch

Please notice that the mentioned cutting speeds are only for orientation.

The right cutting speed is depend on lubrication and application.



**BAER Vertriebs GmbH**

Robert-Bosch-Str. 5

68542 Heddesheim

Germany

Tel: +49 (0) 6203 4048 790

Fax: +49 (0) 6203 4048 791

E-Mail: info@baercoil.com

[www.baercoil.com](http://www.baercoil.com)

# BaerCoil®

Wire Thread Inserts for  
thread reinforcement and thread repair

- DIN 8140, DIN 65536, NASM 21209 and other standards
- AISI 304, AISI 316 Ti, Inconel X750, bronze and other materials



BAER Vertriebs GmbH

Robert-Bosch-Str. 5

68542 Heddesheim

Germany

Tel: +49 (0) 6203 4048 790

Fax: +49 (0) 6203 4048 791

E-Mail: info@baercoil.com

[www.baercoil.com](http://www.baercoil.com)

