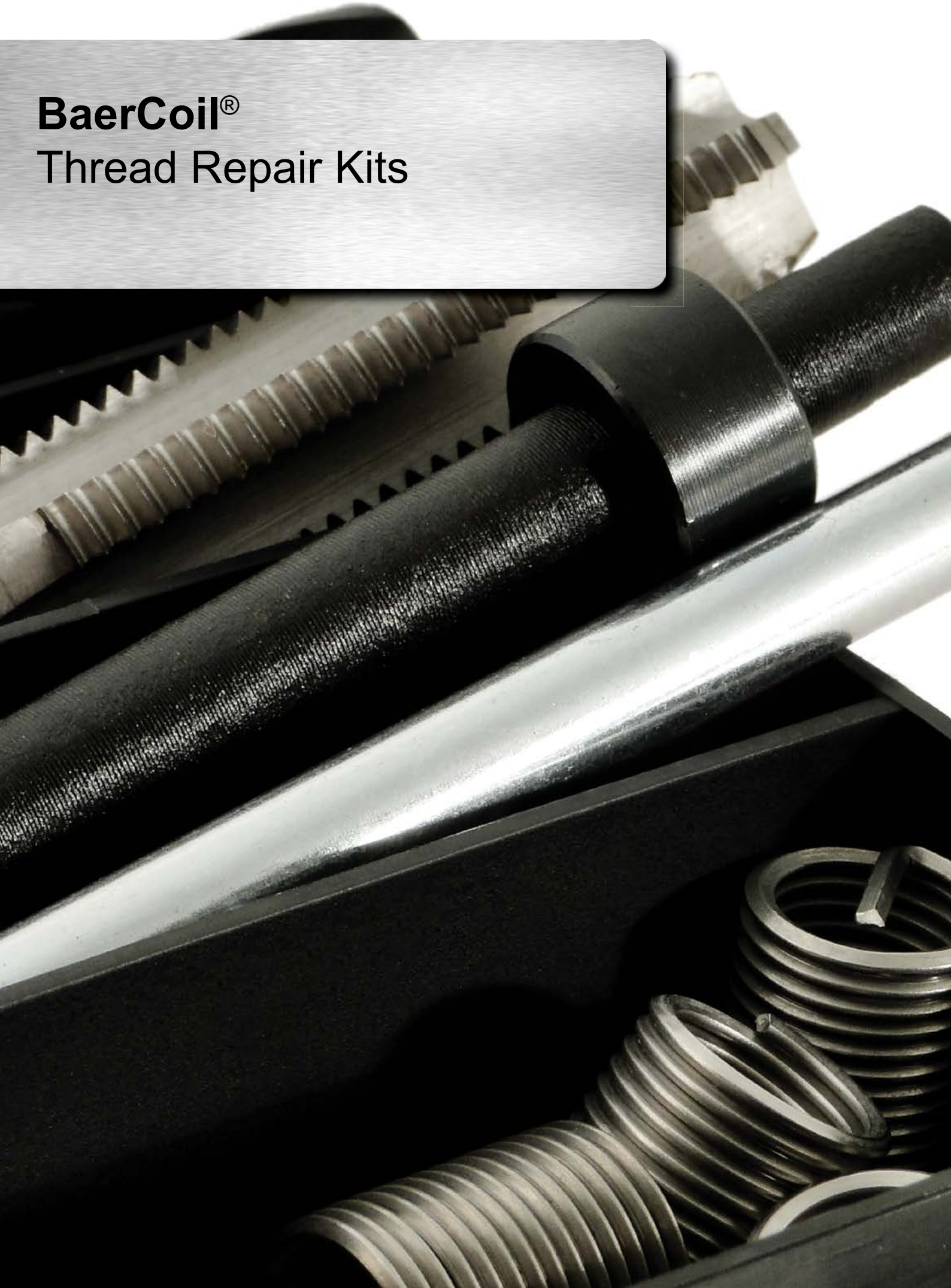
BaerCoil®
Thread Repair Kits



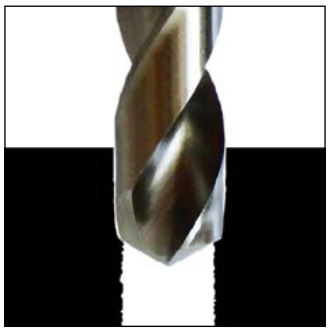
Thread repair

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.	€
M 3 x 0,5	EBW03	BZ003	3,2 mm	10	5	5	B40052	20,40
M 4 x 0,7	EBW04	BZ004	4,2 mm	10	5	5	B40072	20,30
M 5 x 0,8	EBW05	BZ005	5,2 mm	10	5	5	B40092	20,80
M 6 x 1,0	EBW06	BZ006	6,3 mm	10	5	5	B40102	20,90
M 7 x 1,0	EBW07	BZ006	7,3 mm	10	5	5	B40112	29,00
M 8 x 1,0	EBW08	BZ008	8,3 mm	10	5	5	B40132	29,00
M 8 x 1,25	EBW08	BZ008	8,3 mm	10	5	5	B40122	28,80
M 10 x 1,0	EBW10	BZ010	10,3 mm	10	5	5	B40182	31,00
M 10 x 1,25	EBW10	BZ010	10,3 mm	10	5	5	B40172	31,00
M 10 x 1,5	EBW10	BZ010	10,4 mm	10	5	5	B40162	30,80
M 12 x 1,25	EBW12	BZ012	12,3 mm	10	5	5	B40232	34,80
M 12 x 1,5	EBW12	BZ012	12,4 mm	5	5	5	B40222	34,90
M 12 x 1,75	EBW12	BZ012	12,4 mm	5	5	5	B40212	35,00
M 14 x 1,5	EBW14		14,4 mm	3	3	3	B40292	39,20
M 14 x 2,0	EBW14		14,4 mm	3	3	3	B40282	39,20