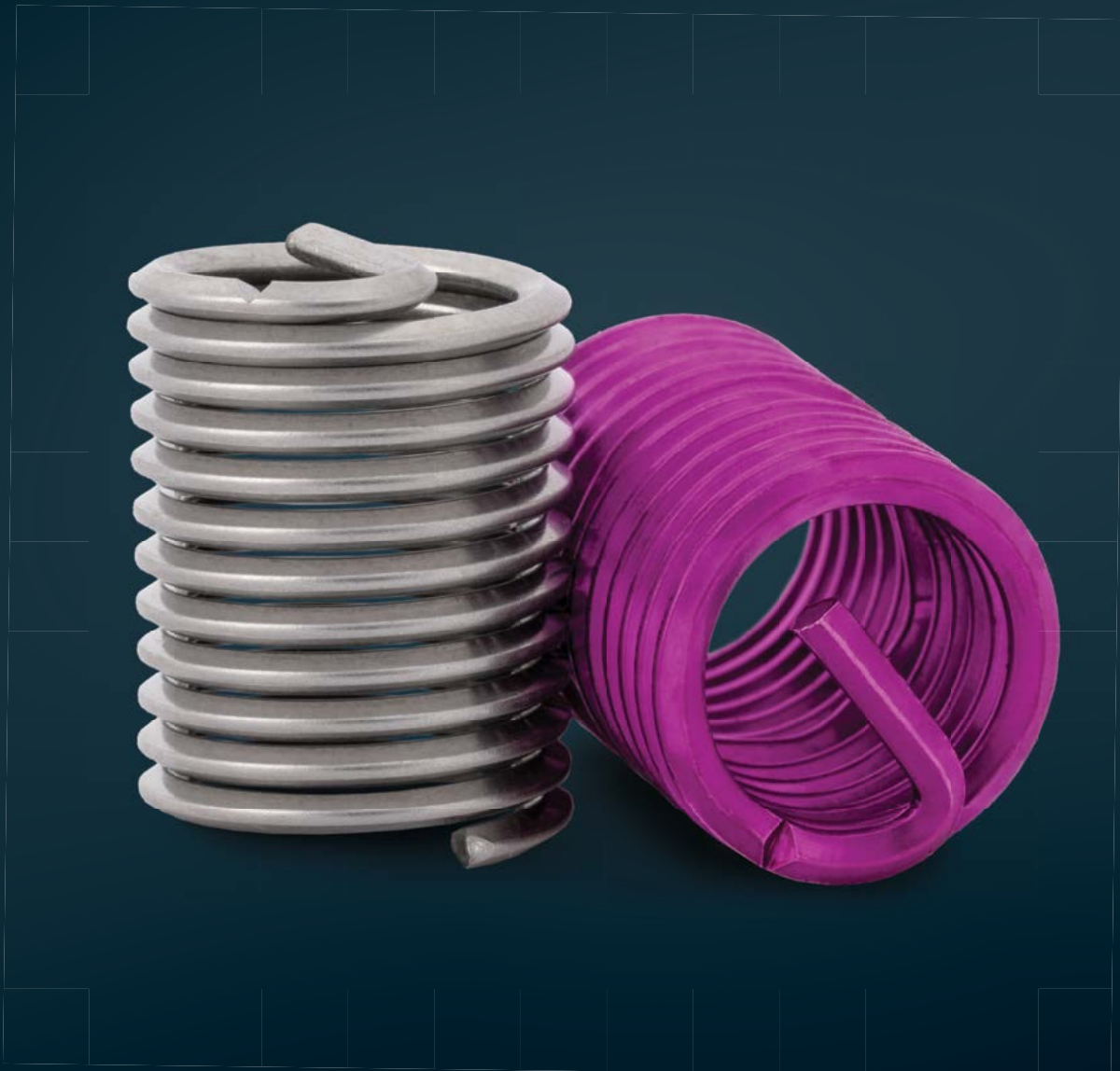




# BaerCoil<sup>®</sup>

WIRE THREAD INSERTS



[WWW.BAERCOIL.COM](http://WWW.BAERCOIL.COM)

2019



## 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










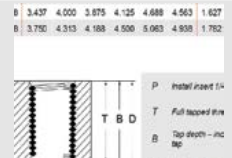
For ensure further deliveries to the customer as soon as possible at home and abroad, we are expanding our distributor network.

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



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**BaerCoil®**  
**Catalog 2019**



# BaerCoil® Thread Reinforcement & Thread Repair

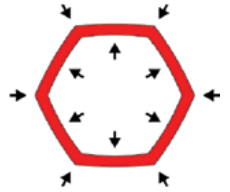
## BaerCoil® Wire Thread Inserts - type: "free running"

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 - type: "screw grip"

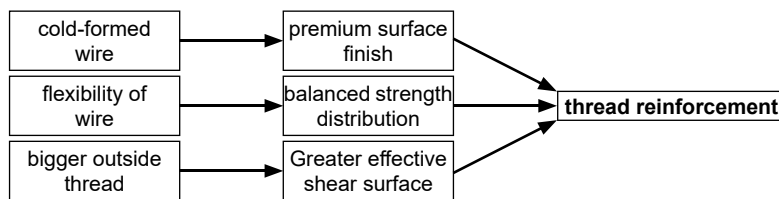
In addition to "free-running" insert characteristics, BaerCoil® "screw grip" thread inserts have one or more polygon-formed windings, which have a clamping effect on the flanks of the inserted screw. We only recommend using screws with a higher screw property class (from 8.8 on) because of this screw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



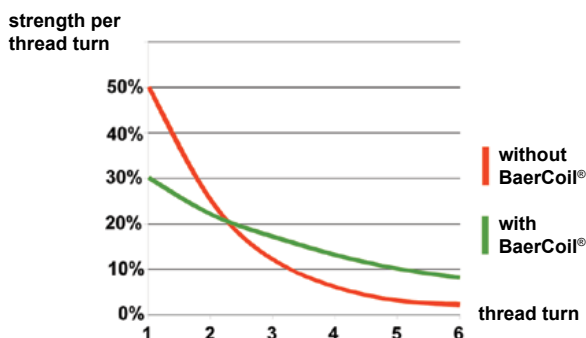
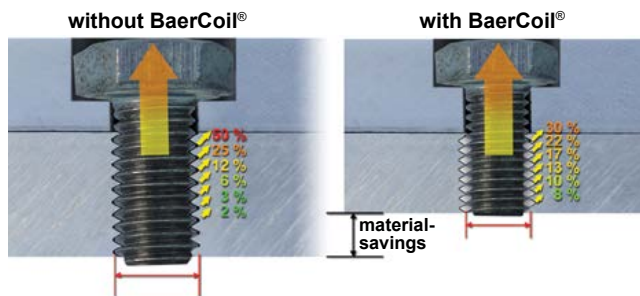
**i** see locking torque values on page 7

## 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

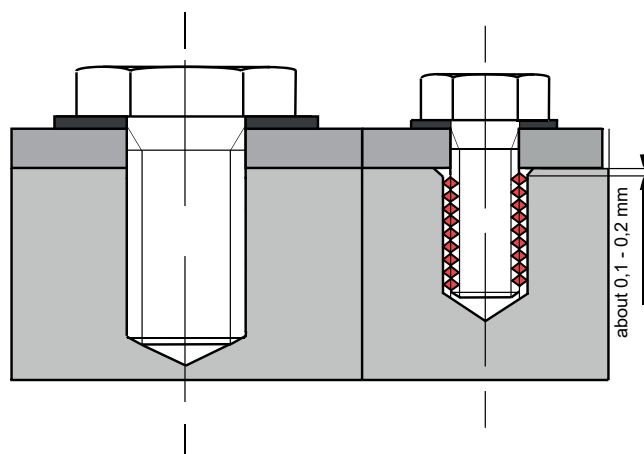
BaerCoil® thread inserts also have excellent corrosion-resistance properties. This ensures applicability in almost all materials and under most conditions.

## 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 clad 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.



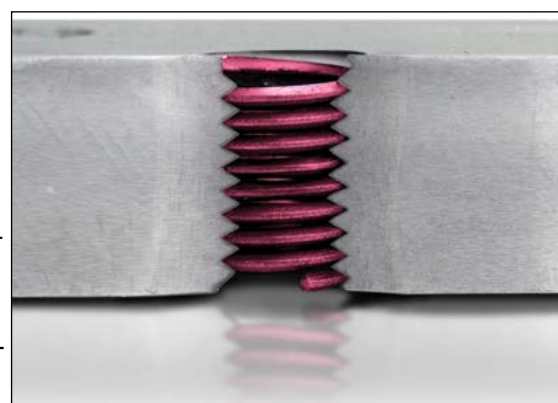
## Applications

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.

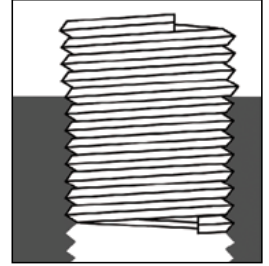








## Design

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<br>AISI 304<br>X5CrNi18-10<br>Material-No.: 1.4301          | >1400 N/mm <sup>2</sup> | 315°C long-term<br>425°C short-term | standard applications for all property classes and materials for Thread Repair and Thread Reinforcement |   |
|    | Stainless Steel V4A<br>AISI 316 Ti<br>X6CrNiMoTi17-12-2<br>Material-No.: 1.4571 | >1400 N/mm <sup>2</sup> | 315°C long-term<br>425°C short-term | - increased corrosion protection<br>- low thread friction<br>- for high alloyed CrNi steel screws       | general lightweight construction<br>sea water and chlorine-containing water                             |
|   | Inconel X750<br>NiCr15Fe7TiAl<br>Material-No.: 2.4669                           | >1150 N/mm <sup>2</sup> | 550°C long-term<br>750°C short-term | - high thermal load<br>- high corrosion protection  | - aerospace technology<br>- turbocharger<br>- aeroplane engines<br>- turbines<br>- thermal power plants |
|  | Bronze<br>CuSn6<br>CW452K<br>Material-No.: 2.1020                               | > 900 N/mm <sup>2</sup> | 250°C long-term<br>300°C short-term | - translation threads<br>- CrNi screws<br>- Cu workpieces<br>- non-magnetic                             | applications in sea water<br>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 |

## 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

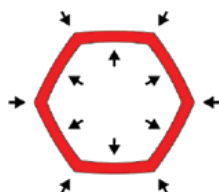
| tensile strength of mounting material | screw property class |       |       |       |       |       |       |       |
|---------------------------------------|----------------------|-------|-------|-------|-------|-------|-------|-------|
|                                       | 4.6                  | 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                | 1,0 D | 1,0 D | 1,0 D | 1,0 D | 1,5 D | 1,5 D | 1,5 D |
| > 400 N/mm <sup>2</sup>               | 1,0 D                | 1,0 D | 1,0 D | 1,0 D | 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-department 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

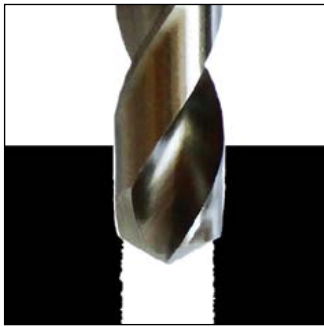




## Installation by hand

### 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.



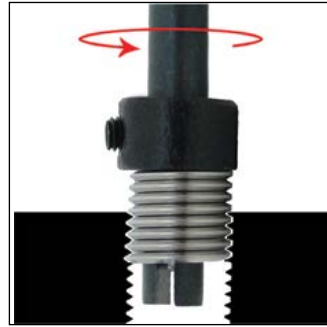
### 2. Tapping

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.



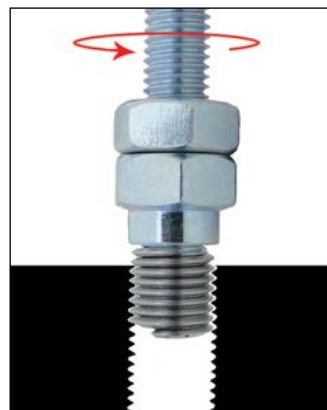
### 2. Tapping

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.



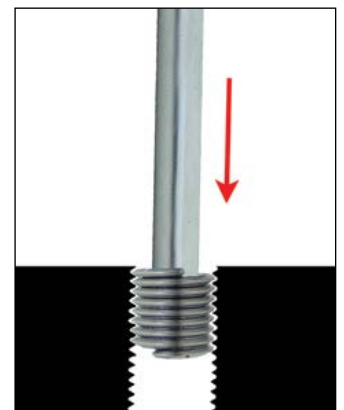
### 3. Installing thread inserts

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 |                | 1,5 x Diameter |                | 2,0 x Diameter |                | 2,5 x Diameter |                | 3,0 x Diameter |                |
|                  |            | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit |
| M 2 x 0,4        | 100        | 1-B7202-1      | *              | 1-B7202-15     | 16,48 €        | 1-B7202-2      | 17,20 €        | 1-B7202-25     | 18,23 €        | 1-B7202-3      | 20,39 €        |
|                  | 10         | 2-B7202-1      | 11,95 €        | 2-B7202-15     | 6,27 €         | 2-B7202-2      | 6,55 €         | 2-B7202-25     | 6,90 €         | 2-B7202-3      | 7,73 €         |
| M 2,2 x 0,45     | 100        | 1-B7203-1      | 14,21 €        | 1-B7203-15     | 14,63 €        | 1-B7203-2      | 18,03 €        | 1-B7203-25     | 18,95 €        | 1-B7203-3      | 21,53 €        |
|                  | 100        | 1-B7204-1      | 22,61 €        | 1-B7204-15     | 22,76 €        | 1-B7204-2      | 18,13 €        | 1-B7204-25     | 18,98 €        | 1-B7204-3      | 21,48 €        |
| M 2,5 x 0,45     | 10         | 2-B7204-1      | 8,59 €         | 2-B7204-15     | 8,65 €         | 2-B7204-2      | 6,34 €         |                |                |                |                |
|                  | 100        | 1-B7205-1      | 12,52 €        | 1-B7205-15     | 13,34 €        | 1-B7205-2      | 14,29 €        | 1-B7205-25     | 14,91 €        | 1-B7205-3      | 16,89 €        |
| M 3 x 0,5        | 10         | 2-B7205-1      | 4,91 €         | 2-B7205-15     | 5,01 €         | 2-B7205-2      | 4,88 €         | 2-B7205-25     | 5,02 €         | 2-B7205-3      | 5,40 €         |
|                  | 100        | 1-B7206-1      | 10,69 €        | 1-B7206-15     | 11,75 €        | 1-B7206-2      | 14,08 €        | 1-B7206-25     | 15,20 €        | 1-B7206-3      | 19,57 €        |
| M 3,5 x 0,6      | 100        | 1-B7207-1      | 12,22 €        | 1-B7207-15     | 11,71 €        | 1-B7207-2      | 13,45 €        | 1-B7207-25     | 16,12 €        | 1-B7207-3      | 18,93 €        |
|                  | 10         | 2-B7207-1      | 4,33 €         | 2-B7207-15     | 4,45 €         | 2-B7207-2      | 4,73 €         | 2-B7207-25     | 5,24 €         | 2-B7207-3      | 5,79 €         |
| M 4,5 x 0,75     | 100        | 1-BE4575-1     | *              | 1-BE4575-15    | *              | 1-BE4575-2     | *              | 1-BE4575-25    | *              | 1-BE4575-3     | *              |
|                  | 100        | 1-B7208-1      | 12,88 €        | 1-B7208-15     | 13,34 €        | 1-B7208-2      | 14,50 €        | 1-B7208-25     | 16,89 €        | 1-B7208-3      | 18,73 €        |
| M 5 x 0,8        | 10         | 2-B7208-1      | 4,64 €         | 2-B7208-15     | 4,74 €         | 2-B7208-2      | 4,92 €         | 2-B7208-25     | 5,40 €         | 2-B7208-3      | 5,76 €         |
|                  | 100        | 1-BE675-1      | *              | 1-BE675-15     | *              | 1-BE675-2      | *              |                |                |                |                |
| M 6 x 1,0        | 100        | 1-B7209-1      | 11,12 €        | 1-B7209-15     | 14,65 €        | 1-B7209-2      | 18,01 €        | 1-B7209-25     | 22,52 €        | 1-B7209-3      | 25,27 €        |
|                  | 10         | 2-B7209-1      | 4,26 €         | 2-B7209-15     | 4,95 €         | 2-B7209-2      | 5,61 €         | 2-B7209-25     | 6,49 €         | 2-B7209-3      | 7,02 €         |
| M 7 x 1,0        | 100        | 1-B7210-1      | 14,08 €        | 1-B7210-15     | 17,52 €        | 1-B7210-2      | 22,45 €        | 1-B7210-25     | 28,37 €        | 1-B7210-3      | 33,01 €        |
|                  | 10         | 2-B7210-1      | 4,84 €         | 2-B7210-15     | 5,52 €         | 2-B7210-2      | 6,48 €         | 2-B7210-25     | 7,64 €         | 2-B7210-3      | 8,54 €         |
| M 8 x 0,75       | 100        | 1-BE875-1      | *              | 1-BE875-15     | *              | 1-BE875-2      | *              |                |                |                |                |
|                  | 100        | 1-B7212-1      | 16,26 €        | 1-B7212-15     | 22,10 €        | 1-B7212-2      | 26,47 €        | 1-B7212-25     | 31,68 €        | 1-B7212-3      | 37,73 €        |
| M 8 x 1,0        | 10         | 2-B7212-1      | 5,27 €         | 2-B7212-15     | 6,41 €         | 2-B7212-2      | 7,26 €         | 2-B7212-25     | 8,28 €         | 2-B7212-3      | 9,46 €         |
|                  | 100        | 1-B7211-1      | 17,88 €        | 1-B7211-15     | 23,72 €        | 1-B7211-2      | 30,62 €        | 1-B7211-25     | 38,08 €        | 1-B7211-3      | 44,91 €        |
| M 8 x 1,25       | 10         | 2-B7211-1      | 5,59 €         | 2-B7211-15     | 6,73 €         | 2-B7211-2      | 8,06 €         | 2-B7211-25     | 9,53 €         | 2-B7211-3      | 10,87 €        |
|                  | 100        | 1-BE91-1       | *              | 1-BE91-15      | 32,74 €        | 1-BE91-2       | *              |                |                |                |                |
| M 9 x 1,0        | 10         |                |                | 2-BE91-15      | 9,40 €         |                |                |                |                |                |                |
|                  | 100        | 1-B7213-1      | 22,39 €        | 1-B7213-15     | 29,22 €        | 1-B7213-2      | 37,31 €        | 1-B7213-25     | 51,04 €        | 1-B7213-3      | 57,86 €        |
| M 9 x 1,25       | 10         | 2-B7213-1      | 6,63 €         | 2-B7213-15     | 7,96 €         | 2-B7213-2      | 9,53 €         | 2-B7213-25     | 11,38 €        | 2-B7213-3      | 13,79 €        |
|                  | 100        | 1-B7217-1      | 21,33 €        | 1-B7217-15     | 30,48 €        | 1-B7217-2      | 38,58 €        | 1-B7217-25     | 44,63 €        | 1-B7217-3      | 52,58 €        |
| M 10 x 1,0       | 10         | 2-B7217-1      | 6,31 €         | 2-B7217-15     | 8,10 €         | 2-B7217-2      | 9,62 €         | 2-B7217-25     | 10,80 €        | 2-B7217-3      | 12,36 €        |
|                  | 100        | 1-B7216-1      | 23,16 €        | 1-B7216-15     | 35,34 €        | 1-B7216-2      | 42,23 €        | 1-B7216-25     | 53,21 €        | 1-B7216-3      | 62,08 €        |
| M 10 x 1,25      | 10         | 2-B7216-1      | 6,62 €         | 2-B7216-15     | 8,99 €         | 2-B7216-2      | 10,34 €        | 2-B7216-25     | 12,48 €        | 2-B7216-3      | 14,20 €        |
|                  | 100        | 1-B7215-1      | 27,11 €        | 1-B7215-15     | 37,56 €        | 1-B7215-2      | 47,01 €        | 1-B7215-25     | 57,52 €        | 1-B7215-3      | 73,65 €        |
| M 10 x 1,5       | 10         | 2-B7215-1      | 7,30 €         | 2-B7215-15     | 9,55 €         | 2-B7215-2      | 11,76 €        | 2-B7215-25     | 13,94 €        | 2-B7215-3      | 16,51 €        |
|                  | 100        | 1-BE111-1      | *              | 1-BE111-15     | *              | 1-BE111-2      | *              |                |                |                |                |
| M 11 x 1,0       | 100        |                |                | 1-BE1125-15    | 68,77 €        | 1-BE1125-2     | *              |                |                |                |                |
|                  | 10         |                |                | 2-BE1125-15    | 10,79 €        |                |                |                |                |                |                |
| M 11 x 1,25      | 100        | 1-B7219-1      | 32,74 €        | 1-B7219-15     | 52,23 €        | 1-B7219-2      | 62,78 €        | 1-B7219-25     | 77,90 €        | 1-B7219-3      | 101,27 €       |
|                  | 10         | 2-B7219-1      | 8,64 €         | 2-B7219-15     | 12,44 €        | 2-B7219-2      | 14,46 €        | 2-B7219-25     | 17,40 €        |                |                |
| M 12 x 1,0       | 100        | 1-B7224-1      | 29,43 €        | 1-B7224-15     | 41,95 €        | 1-B7224-2      | 54,56 €        | 1-B7224-25     | 67,93 €        | 1-B7224-3      | 85,10 €        |
|                  | 10         | 2-B7224-1      | 8,01 €         | 2-B7224-15     | 10,31 €        | 2-B7224-2      | 12,89 €        | 2-B7224-25     | 15,48 €        |                |                |
| M 12 x 1,25      | 100        | 1-B7223-1      | 30,13 €        | 1-B7223-15     | 42,93 €        | 1-B7223-2      | 55,73 €        | 1-B7223-25     | 69,52 €        | 1-B7223-3      | 77,65 €        |
|                  | 10         | 2-B7223-1      | 8,21 €         | 2-B7223-15     | 10,79 €        | 2-B7223-2      | 13,40 €        | 2-B7223-25     | 16,17 €        | 2-B7223-3      | 17,88 €        |
| M 12 x 1,5       | 100        | 1-B7222-1      | 36,53 €        | 1-B7222-15     | 51,04 €        | 1-B7222-2      | 67,78 €        | 1-B7222-25     | 83,06 €        | 1-B7222-3      | 94,46 €        |
|                  | 10         | 2-B7222-1      | 9,56 €         | 2-B7222-15     | 12,20 €        | 2-B7222-2      | 15,46 €        | 2-B7222-25     | 16,49 €        | 2-B7222-3      | 20,65 €        |
| M 12 x 1,75      | 100        | 1-B7221-1      | 35,90 €        | 1-B7221-15     | 51,31 €        | 1-B7221-2      | 63,86 €        | 1-B7221-25     | 88,87 €        | 1-B7221-3      | 108,39 €       |
|                  | 10         | 2-B7221-1      | 9,24 €         | 2-B7221-15     | 13,51 €        | 2-B7221-2      | 17,32 €        | 2-B7221-25     | 21,01 €        | 2-B7221-3      | 24,93 €        |
| M 13 x 1,25      | 50         | 1-BE1325-1     | *              | 1-BE1325-15    | *              | 1-BE1325-2     | *              |                |                |                |                |
|                  | 50         | 1-BE1315-1     | *              | 1-BE1315-15    | *              | 1-BE1315-2     | *              |                |                |                |                |
| M 14 x 1,0       | 50         | 1-B7228-1      | 18,20 €        | 1-B7228-15     | 26,57 €        | 1-B7228-2      | 35,16 €        | 1-B7228-25     | 45,12 €        | 1-B7228-3      | 53,71 €        |
|                  | 10         | 2-B7228-1      | 9,36 €         | 2-B7228-15     | 13,76 €        | 2-B7228-2      | 15,97 €        | 2-B7228-25     | 19,86 €        | 2-B7228-3      | 23,18 €        |
| M 14 x 1,25      | 50         | 1-B7227-1      | 17,56 €        | 1-B7227-15     | 33,79 €        | 1-B7227-2      | 33,96 €        | 1-B7227-25     | 43,61 €        | 1-B7227-3      | 64,69 €        |
|                  | 10         | 2-B7227-1      | 8,95 €         | 2-B7227-15     | 14,29 €        | 2-B7227-2      | 15,35 €        | 2-B7227-25     | 19,11 €        | 2-B7227-3      | 29,04 €        |
| M 14 x 1,5       | 50         | 1-B7226-1      | 23,47 €        | 1-B7226-15     | 31,63 €        | 1-B7226-2      | 41,78 €        | 1-B7226-25     | 53,21 €        | 1-B7226-3      | 68,14 €        |
|                  | 10         | 2-B7226-1      | 11,40 €        | 2-B7226-15     | 14,46 €        | 2-B7226-2      | 18,90 €        | 2-B7226-25     | 22,91 €        | 2-B7226-3      | 29,39 €        |
| M 14 x 2,0       | 50         | 1-B7225-1      | 26,85 €        | 1-B7225-15     | 39,13 €        | 1-B7225-2      | 53,53 €        | 1-B7225-25     | 73,03 €        | 1-B7225-3      | 90,70 €        |
|                  | 10         | 2-B7225-1      | 12,58 €        | 2-B7225-15     | 17,74 €        | 2-B7225-2      | 22,98 €        | 2-B7225-25     | 30,97 €        | 2-B7225-3      | 37,97 €        |
| M 15 x 1,5       | 50         | 1-BE1515-1     | *              | 1-BE1515-15    | *              | 1-BE1515-2     | *              |                |                |                |                |
|                  | 50         | 1-B7235-1      | 29,46 €        | 1-B7235-15     | 43,36 €        | 1-B7235-2      | 58,00 €        | 1-B7235-25     | 77,43 €        | 1-B7235-3      | 91,51 €        |
| M 16 x 1,5       | 10         | 2-B7235-1      | 13,74 €        | 2-B7235-15     | 19,31 €        | 2-B7235-2      | 24,85 €        | 2-B7235-25     | 32,41 €        | 2-B7235-3      | 36,44 €        |
|                  | 50         | 1-B7234-1      | 29,85 €        | 1-B7234-15     | 43,17 €        | 1-B7234-2      | 54,13 €        | 1-B7234-25     | 82,80 €        | 1-B7234-3      | 134,16 €       |
| M 16 x 2,0       | 10         | 2-B7234-1      | 14,08 €        | 2-B7234-15     | 19,14 €        | 2-B7234-2      | 26,42 €        | 2-B7234-25     | 34,53 €        | 2-B7234-3      | 54,65 €        |
|                  | 25         | 1-B7238-1      | 18,27 €        | 1-B7238-15     | 39,93 €        | 1-B7238-2      | 47,52 €        | 1-B7238-25     | 50,01 €        | 1-B7238-3      | 54,00 €        |
| M 18 x 2,0       | 25         | 1-B7237-1      | 25,57 €        | 1-B7237-15     | 34,60 €        | 1-B7237-2      | 46,64 €        | 1-B7237-25     | 70,37 €        | 1-B7237-3      | 84,86 €        |
|                  | 25         | 1-B7236-1      | 26,81 €        | 1-B7236-15     | 41,44 €        | 1-B7236-2      | 55,88 €        | 1-B7236-25     | 70,39 €        | 1-B7236-3      | 84,68 €        |
| M 20 x 1,5       | 25         | 1-B7241-1      | 26,17 €        | 1-B7241-15     | 33,31 €        | 1-B7241-2      | 42,83 €        | 1-B7241-25     | 54,96 €        | 1-B7241-3      | 77,62 €        |
|                  | 25         | 1-B7240-1      | 28,23 €        | 1-B7240-15     | 39,82 €        | 1-B7240-2      | 54,63 €        | 1-B7240-25     | 86,90 €        | 1-B7240-3      | 104,76 €       |
| M 20 x 2,5       | 25         | 1-B7239-1      | 33,59 €        | 1-B7239-15     | 43,74 €        | 1-B7239-2      | 67,99 €        | 1-B7239-25     | 91,42 €        | 1-B7239-3      | 108,41 €       |

\* on request

## 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<br>1,0 x Diameter |                | 1,5 D<br>1,5 x Diameter |                | 2,0 D<br>2,0 x Diameter |                | 2,5 D<br>2,5 x Diameter |                | 3,0 D<br>3,0 x Diameter |                |
|------------------|------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|
|                  |            | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit |
| M 22 x 2,0       | 25         | 1-B7243-1               | 41,87 €        | 1-B7243-15              | 69,03 €        | 1-B7243-2               | 95,54 €        | 1-B7243-25              | 119,04 €       | 1-B7243-3               | 145,60 €       |
| M 22 x 1,5       | 25         | 1-B7244-1               | 38,75 €        | 1-B7244-15              | 52,33 €        | 1-B7244-2               | 57,86 €        | 1-B7244-25              | 78,22 €        | 1-B7244-3               | 94,20 €        |
| M 22 x 2,5       | 25         | 1-B7242-1               | 49,96 €        | 1-B7242-15              | 73,29 €        | 1-B7242-2               | 90,32 €        | 1-B7242-25              | 114,15 €       | 1-B7242-3               | 163,98 €       |
| M 24 x 1,5       | 25         | 1-B7247-1               | 44,67 €        | 1-B7247-15              | 77,48 €        | 1-B7247-2               | 92,45 €        | 1-B7247-25              | 121,14 €       | 1-B7247-3               | 135,31 €       |
| M 24 x 2,0       | 25         | 1-B7246-1               | 44,34 €        | 1-B7246-15              | 78,89 €        | 1-B7246-2               | 86,11 €        | 1-B7246-25              | 136,27 €       | 1-B7246-3               | 157,41 €       |
| M 24 x 3,0       | 25         | 1-B7245-1               | 68,92 €        | 1-B7245-15              | 101,40 €       | 1-B7245-2               | 122,43 €       | 1-B7245-25              | 171,16 €       | 1-B7245-3               | 253,07 €       |
| M 26 x 1,5       | 5          |                         |                | 1-B7349-15              | 17,81 €        |                         |                |                         |                |                         |                |
| M 27 x 1,5       | 5          |                         |                | 1-B7352-15              | 17,81 €        |                         |                |                         |                |                         |                |
| M 27 x 2,0       | 5          |                         |                | 1-B7351-15              | 17,81 €        |                         |                |                         |                |                         |                |
| M 27 x 3,0       | 5          | 1-BE273-1               | 15,79 €        | 1-BE273-15              | 24,84 €        | 1-BE273-2               | 31,03 €        |                         |                |                         |                |
| M 28 x 1,5       | 5          | 1-B7353-1               |                | 1-B7353-15              | 52,45 €        |                         |                |                         |                |                         |                |
| M 30 x 1,5       | 5          | 1-B7356-1               | 56,31 €        | 1-B7356-15              | 63,35 €        |                         |                |                         |                |                         |                |
| M 30 x 2,0       | 5          | 1-B7355-1               | 50,33 €        | 1-B7355-15              | 23,73 €        |                         |                |                         |                |                         |                |
| M 30 x 3,5       | 5          | 1-B7354-1               | 40,25 €        | 1-B7354-15              | 46,35 €        | 1-B7354-2               | 63,94 €        |                         |                |                         |                |
| M 33 x 2,0       | 5          | 1-B7358-1               | 52,00 €        | 1-B7358-15              | 63,04 €        |                         |                |                         |                |                         |                |
| M 33 x 3,5       | 5          | 1-B7357-1               | 59,83 €        | 1-B7357-15              | 70,04 €        | 1-B7357-2               | 83,06 €        |                         |                |                         |                |
| M 36 x 1,5       | 5          |                         |                | 1-B7363-15              | 80,95 €        |                         |                |                         |                |                         |                |
| M 36 x 2,0       | 5          |                         |                | 1-B7362-15              | 73,91 €        |                         |                |                         |                |                         |                |
| M 36 x 3,0       | 5          |                         |                | 1-B7361-15              | 87,99 €        |                         |                |                         |                |                         |                |
| M 36 x 4,0       | 5          | 1-BE364-1               | 31,92 €        | 1-BE364-15              | 49,58 €        | 1-BE364-2               | 66,28 €        |                         |                |                         |                |
| M 39 x 2,0       | 5          |                         |                | 1-BE392-15              | 188,48 €       |                         |                |                         |                |                         |                |
| M 39 x 4,0       | 5          |                         |                | 1-BE394-15              | 111,22 €       |                         |                |                         |                |                         |                |
| M 42 x 2,0       | 5          |                         |                | 1-BE422-15              | 315,33 €       |                         |                |                         |                |                         |                |
| M 42 x 3,0       | 5          |                         |                | 1-BE423-15              | 315,33 €       |                         |                |                         |                |                         |                |
| M 42 x 4,0       | 5          |                         |                | 1-BE424-15              | 315,33 €       |                         |                |                         |                |                         |                |

\* 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 |
| M 14 x 1,25      | 50         | 1-B7128     | 20,55 €        | 1-B7228     | 26,29 €        | 1-B7328     | 33,50 €        |
|                  | 10         | 2-B7128     | 10,07 €        | 2-B7228     | 12,25 €        | 2-B7328     | 15,04 €        |
| M 18 x 1,5       | 10         | 12,7 mm     |                | 16,7 mm     |                |             |                |
|                  |            | 1-B7238-127 | 7,33 €         | 1-B7238-159 | 12,03 €        | 1-B7238-167 | 15,02 €        |

## 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.

**M**



| Diameter x Pitch | 1,0 D<br>1,0 x Diameter | 1,5 D<br>1,5 x Diameter | 2,0 D<br>2,0 x Diameter |
|------------------|-------------------------|-------------------------|-------------------------|
|                  | Item-No.:               | Item-No.:               | Item-No.:               |
| M 3 x 0,5        | B7205-1MAG              | B7205-15MAG             | B7205-2MAG              |
| M 4 x 0,7        | B7207-1MAG              | B7207-15MAG             | B7207-2MAG              |
| M 5 x 0,8        | B7208-1MAG              | B7208-15MAG             | B7208-2MAG              |
| M 6 x 1,0        | B7209-1MAG              | B7209-15MAG             | B7209-2MAG              |
| M 8 x 1,25       | B7211-1MAG              | B7211-15MAG             | B7211-2MAG              |
| M 10 x 1,5       | 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<br>Threads per inch | pack.<br>unit | 1,0 D<br>1,0 x Diameter |                | 1,5 D<br>1,5 x Diameter |                | 2,0 D<br>2,0 x Diameter |                | 2,5 D<br>2,5 x Diameter |                | 3,0 D<br>3,0 x Diameter |                |
|--------------------------------|---------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|
|                                |               | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit |
| UNC 2 x 56                     | 100           | 1-B8200-1               | 29,32 €        | 1-B8200-15              | 25,07 €        | 1-B8200-2               | 25,80 €        | 1-B8200-25              | 36,70 €        | 1-B8200-3               | 50,88 €        |
| UNC 3 x 48                     | 100           | 1-B8213-1               | 27,56 €        | 1-B8213-15              | 29,80 €        | 1-B8213-2               | 30,89 €        | 1-B8213-25              | 43,60 €        | 1-B8213-3               | 92,08 €        |
| UNC 4 x 40                     | 100           | 1-B8201-1               | 30,21 €        | 1-B8201-15              | 30,97 €        | 1-B8201-2               | 33,03 €        | 1-B8201-25              | 43,60 €        | 1-B8201-3               | 50,43 €        |
| UNC 5 x 40                     | 100           | 1-B8202-1               | 32,86 €        | 1-B8202-15              | 38,18 €        | 1-B8202-2               | 44,04 €        | 1-B8202-25              | 53,28 €        | 1-B8202-3               | 86,67 €        |
| UNC 6 x 32                     | 100           | 1-B8203-1               | 19,91 €        | 1-B8203-15              | 21,38 €        | 1-B8203-2               | 22,36 €        | 1-B8203-25              | 26,79 €        | 1-B8203-3               | 49,38 €        |
| UNC 8 x 32                     | 100           | 1-B8204-1               | 16,69 €        | 1-B8204-15              | 17,86 €        | 1-B8204-2               | 18,51 €        | 1-B8204-25              | 22,37 €        | 1-B8204-3               | 52,53 €        |
| UNC 10 x 24                    | 100           | 1-B8205-1               | 18,68 €        | 1-B8205-15              | 19,58 €        | 1-B8205-2               | 23,19 €        | 1-B8205-25              | 24,72 €        | 1-B8205-3               | 68,29 €        |
| UNC 12 x 24                    | 100           | 1-B8206-1               | 26,30 €        | 1-B8206-15              | 22,37 €        | 1-B8206-2               | 31,26 €        | 1-B8206-25              | 37,50 €        | 1-B8206-3               | 98,23 €        |
| UNC 1/4 x 20                   | 100           | 1-B8207-1               | 18,26 €        | 1-B8207-15              | 22,36 €        | 1-B8207-2               | 25,95 €        | 1-B8207-25              | 30,21 €        | 1-B8207-3               | 68,29 €        |
| UNC 5/16 x 18                  | 100           | 1-B8208-1               | 25,29 €        | 1-B8208-15              | 30,80 €        | 1-B8208-2               | 38,09 €        | 1-B8208-25              | 49,69 €        | 1-B8208-3               | 99,81 €        |
| UNC 3/8 x 16                   | 100           | 1-B8209-1               | 36,78 €        | 1-B8209-15              | 40,80 €        | 1-B8209-2               | 50,41 €        | 1-B8209-25              | 67,16 €        | 1-B8209-3               | 147,82 €       |
| UNC 7/16 x 14                  | 100           | 1-B8210-1               | 49,68 €        | 1-B8210-15              | 54,68 €        | 1-B8210-2               | 68,37 €        | 1-B8210-25              | 118,05 €       | 1-B8210-3               | 157,59 €       |
| UNC 1/2 x 13                   | 100           | 1-B8211-1               | 61,27 €        | 1-B8211-15              | 67,99 €        | 1-B8211-2               | 98,46 €        | 1-B8211-25              | 136,08 €       | 1-B8211-3               | 183,86 €       |
| UNC 9/16 x 12                  | 50            | 1-B8212-1               | 40,46 €        | 1-B8212-15              | 45,61 €        | 1-B8212-2               | 81,42 €        | 1-B8212-25              | 144,75 €       | 1-B8212-3               | 173,87 €       |
| UNC 5/8 x 11                   | 50            | 1-B8214-1               | 39,99 €        | 1-B8214-15              | 57,79 €        | 1-B8214-2               | 104,96 €       | 1-B8214-25              | 150,50 €       | 1-B8214-3               | 178,87 €       |
| UNC 3/4 x 10                   | 25            | 1-B8215-1               | 36,25 €        | 1-B8215-15              | 54,83 €        | 1-B8215-2               | 74,16 €        | 1-B8215-25              | 92,91 €        | 1-B8215-3               | 115,57 €       |
| UNC 7/8 x 9                    | 10            | 1-B8218-1               | 27,85 €        | 1-B8218-15              | 40,67 €        | 1-B8218-2               | 65,66 €        | 1-B8218-25              | 69,78 €        | 1-B8218-3               | 86,20 €        |
| UNC 1" x 8                     | 10            | 1-B8219-1               | 60,87 €        | 1-B8219-15              | 63,41 €        | 1-B8219-2               | 88,22 €        | 1-B8219-25              | 105,59 €       | 1-B8219-3               | 119,24 €       |
| UNC 1.1/8" x 7                 | 5             |                         |                | 1-B8320-15              | 51,22 €        |                         |                |                         |                |                         |                |
| UNC 1.1/4" x 7                 | 5             |                         |                | 1-B8321-15              | 53,85 €        |                         |                |                         |                |                         |                |
| UNC 1.3/8" x 6                 | 5             |                         |                | 1-B8322-15              | 86,67 €        |                         |                |                         |                |                         |                |
| UNC 1.1/2" x 6                 | 5             |                         |                | 1-B8323-15              | 108,74 €       |                         |                |                         |                |                         |                |

## UNF

| Diameter x<br>Threads per inch | pack.<br>unit | 1,0 D<br>1,0 x Diameter |                | 1,5 D<br>1,5 x Diameter |                | 2,0 D<br>2,0 x Diameter |                | 2,5 D<br>2,5 x Diameter |                | 3,0 D<br>3,0 x Diameter |                |
|--------------------------------|---------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|
|                                |               | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit |
| UNF 2 x 64                     | 100           | 1-B8287-1               | 97,73 €        | 1-B8287-15              | 106,21 €       | 1-B8287-2               | 111,34 €       | 1-B8287-25              | 245,84 €       | 1-B8287-3               | 271,05 €       |
| UNF 3 x 56                     | 100           | 1-B8288-1               | 32,55 €        | 1-B8288-15              | 35,40 €        | 1-B8288-2               | 38,11 €        | 1-B8288-25              | 39,58 €        | 1-B8288-3               | 135,53 €       |
| UNF 4 x 48                     | 100           | 1-B8290-1               | 29,31 €        | 1-B8290-15              | 31,87 €        | 1-B8290-2               | 33,09 €        | 1-B8290-25              | 39,58 €        | 1-B8290-3               | 94,55 €        |
| UNF 5 x 44                     | 100           | 1-B8289-1               | 58,64 €        | 1-B8289-15              | 31,86 €        | 1-B8289-2               | 147,72 €       | 1-B8289-25              | 245,84 €       | 1-B8289-3               | 271,05 €       |
| UNF 6 x 40                     | 100           | 1-B8291-1               | 27,37 €        | 1-B8291-15              | 29,74 €        | 1-B8291-2               | 30,88 €        | 1-B8291-25              | 36,96 €        | 1-B8291-3               | 57,78 €        |
| UNF 8 x 36                     | 100           | 1-B8292-1               | 27,37 €        | 1-B8292-15              | 29,74 €        | 1-B8292-2               | 30,88 €        | 1-B8292-25              | 36,96 €        | 1-B8292-3               | 100,86 €       |
| UNF 10 x 32                    | 100           | 1-B8293-1               | 18,68 €        | 1-B8293-15              | 19,52 €        | 1-B8293-2               | 21,15 €        | 1-B8293-25              | 26,75 €        | 1-B8293-3               | 47,28 €        |
| UNF 1/4 x 28                   | 100           | 1-B8225-1               | 25,31 €        | 1-B8225-15              | 22,36 €        | 1-B8225-2               | 25,27 €        | 1-B8225-25              | 40,39 €        | 1-B8225-3               | 68,29 €        |
| UNF 5/16 x 24                  | 100           | 1-B8226-1               | 26,79 €        | 1-B8226-15              | 30,72 €        | 1-B8226-2               | 35,57 €        | 1-B8226-25              | 53,33 €        | 1-B8226-3               | 70,65 €        |
| UNF 3/8 x 24                   | 100           | 1-B8227-1               | 35,22 €        | 1-B8227-15              | 42,15 €        | 1-B8227-2               | 46,56 €        | 1-B8227-25              | 62,08 €        | 1-B8227-3               | 131,33 €       |
| UNF 7/16 x 20                  | 100           | 1-B8228-1               | 39,91 €        | 1-B8228-15              | 46,05 €        | 1-B8228-2               | 59,88 €        | 1-B8228-25              | 73,47 €        | 1-B8228-3               | 141,83 €       |
| UNF 1/2 x 20                   | 100           | 1-B8229-1               | 41,61 €        | 1-B8229-15              | 52,05 €        | 1-B8229-2               | 59,88 €        | 1-B8229-25              | 73,48 €        | 1-B8229-3               | 147,08 €       |
| UNF 9/16 x 18                  | 50            | 1-B8230-1               | 44,65 €        | 1-B8230-15              | 41,45 €        | 1-B8230-2               | 63,11 €        | 1-B8230-25              | 75,69 €        | 1-B8230-3               | 157,59 €       |
| UNF 5/8 x 18                   | 50            | 1-B8231-1               | 52,53 €        | 1-B8231-15              | 50,43 €        | 1-B8231-2               | 70,92 €        | 1-B8231-25              | 83,46 €        | 1-B8231-3               | 157,59 €       |
| UNF 3/4 x 16                   | 25            | 1-B8233-1               | 39,49 €        | 1-B8233-15              | 54,41 €        | 1-B8233-2               | 58,20 €        | 1-B8233-25              | 95,14 €        | 1-B8233-3               | 118,19 €       |
| UNF 7/8 x 14                   | 10            | 1-B8235-1               | 28,83 €        | 1-B8235-15              | 33,84 €        | 1-B8235-2               | 60,93 €        | 1-B8235-25              | 65,25 €        | 1-B8235-3               | 91,40 €        |
| UNF 1" x 12                    | 10            | 1-B8237-1               | 45,18 €        | 1-B8237-15              | 53,43 €        | 1-B8237-2               | 72,57 €        | 1-B8237-25              | 96,43 €        | 1-B8237-3               | 105,06 €       |
| UNF 1.1/8" x 12                | 5             |                         |                | 1-B8238-15              | 76,17 €        |                         |                |                         |                |                         |                |
| UNF 1.1/4" x 12                | 5             |                         |                | 1-B8239-15              | 77,22 €        |                         |                |                         |                |                         |                |
| UNF 1.3/8" x 12                | 5             |                         |                | 1-B8240-15              | 187,53 €       |                         |                |                         |                |                         |                |
| UNF 1.1/2" x 12                | 5             |                         |                | 1-B8236-15              | 194,36 €       |                         |                |                         |                |                         |                |

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

## BSW




| Diameter x<br>Threads per inch | pack.<br>unit | 1,0 D<br>1,0 x Diameter |                | 1,5 D<br>1,5 x Diameter |                | 2,0 D<br>2,0 x Diameter |                | 2,5 D<br>2,5 x Diameter |                | 3,0 D<br>3,0 x Diameter |                |
|--------------------------------|---------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|
|                                |               | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit |
| BSW 1/8 x 40                   | 100           | 1-B8241-1               | 52,53 €        | 1-B8241-15              | 52,53 €        | 1-B8241-2               | 63,04 €        | 1-B8241-25              | 84,05 €        | 1-B8241-3               | 94,55 €        |
| BSW 3/16 x 24                  | 100           | 1-B8242-1               | 42,02 €        | 1-B8242-15              | 52,53 €        | 1-B8242-2               | 52,53 €        | 1-B8242-25              | 57,78 €        | 1-B8242-3               | 63,04 €        |
| BSW 1/4 x 20                   | 100           | 1-B8243-1               | 52,53 €        | 1-B8243-15              | 52,53 €        | 1-B8243-2               | 57,78 €        | 1-B8243-25              | 68,29 €        | 1-B8243-3               | 84,05 €        |
| BSW 5/16 x 18                  | 100           | 1-B8244-1               | 57,78 €        | 1-B8244-15              | 68,29 €        | 1-B8244-2               | 73,54 €        | 1-B8244-25              | 99,81 €        | 1-B8244-3               | 120,82 €       |
| BSW 3/8 x 16                   | 100           | 1-B8245-1               | 57,78 €        | 1-B8245-15              | 68,29 €        | 1-B8245-2               | 73,54 €        | 1-B8245-25              | 99,81 €        | 1-B8245-3               | 120,82 €       |
| BSW 7/16 x 14                  | 100           | 1-B8246-1               | 126,07 €       | 1-B8246-15              | 131,33 €       | 1-B8246-2               | 131,33 €       | 1-B8246-25              | 162,84 €       | 1-B8246-3               | 189,11 €       |
| BSW 1/2 x 12                   | 100           | 1-B8247-1               | 168,10 €       | 1-B8247-15              | 178,60 €       | 1-B8247-2               | 189,11 €       | 1-B8247-25              | 210,12 €       | 1-B8247-3               | 215,37 €       |
| BSW 9/16 x 12                  | 50            | 1-B8248-1               | 84,05 €        | 1-B8248-15              | 91,93 €        | 1-B8248-2               | 97,18 €        | 1-B8248-25              | 110,31 €       | 1-B8248-3               | 120,82 €       |
| BSW 5/8 x 11                   | 50            | 1-B8249-1               | 89,30 €        | 1-B8249-15              | 94,55 €        | 1-B8249-2               | 115,57 €       | 1-B8249-25              | 144,46 €       | 1-B8249-3               | 178,60 €       |
| BSW 3/4 x 10                   | 25            | 1-B8251-1               | 52,53 €        | 1-B8251-15              | 68,29 €        | 1-B8251-2               | 81,42 €        | 1-B8251-25              | 102,43 €       | 1-B8251-3               | 127,39 €       |
| BSW 7/8 x 9                    | 10            | 1-B8253-1               | 43,60 €        | 1-B8253-15              | 44,65 €        | 1-B8253-2               | 72,49 €        | 1-B8253-25              | 76,69 €        | 1-B8253-3               | 81,95 €        |
| BSW 1" x 8                     | 10            | 1-B8255-1               | 61,99 €        | 1-B8255-15              | 79,32 €        | 1-B8255-2               | 107,16 €       | 1-B8255-25              | 113,46 €       | 1-B8255-3               | 123,97 €       |
| BSW 1.1/8" x 7                 | 10            | 1-B8256-1               | 78,80 €        | 1-B8256-15              | 95,08 €        | 1-B8256-2               | 129,22 €       |                         |                |                         |                |
| BSW 1.1/4" x 7                 | 10            | 1-B8257-1               | 88,78 €        | 1-B8257-15              | 116,62 €       | 1-B8257-2               | 155,49 €       |                         |                |                         |                |
| BSW 1.3/8" x 6                 | 10            |                         |                | 1-B8258-15              | 315,18 €       |                         |                |                         |                |                         |                |
| BSW 1.1/2" x 6                 | 10            | 1-B8259-1               | 170,72 €       | 1-B8259-15              | 240,06 €       | 1-B8259-2               | 291,02 €       |                         |                |                         |                |

## BSF

| Diameter x<br>Threads per inch | pack.<br>unit | 1,0 D<br>1,0 x Diameter |                | 1,5 D<br>1,5 x Diameter |                | 2,0 D<br>2,0 x Diameter |                | 2,5 D<br>2,5 x Diameter |                | 3,0 D<br>3,0 x Diameter |                |
|--------------------------------|---------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|
|                                |               | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit |
| BSF 3/16 x 32                  | 100           | 1-B8262-1               | 72,49 €        | 1-B8262-15              | 75,64 €        | 1-B8262-2               | 81,95 €        | 1-B8262-25              | 94,55 €        | 1-B8262-3               | 104,01 €       |
| BSF 1/4 x 26                   | 100           | 1-B8263-1               | 89,30 €        | 1-B8263-15              | 99,81 €        | 1-B8263-2               | 105,06 €       | 1-B8263-25              | 115,57 €       | 1-B8263-3               | 126,07 €       |
| BSF 5/16 x 22                  | 100           | 1-B8265-1               | 99,81 €        | 1-B8265-15              | 110,31 €       | 1-B8265-2               | 115,57 €       | 1-B8265-25              | 126,07 €       | 1-B8265-3               | 183,86 €       |
| BSF 3/8 x 20                   | 100           | 1-B8266-1               | 131,33 €       | 1-B8266-15              | 147,08 €       | 1-B8266-2               | 152,34 €       | 1-B8266-25              | 168,10 €       | 1-B8266-3               | 239,54 €       |
| BSF 7/16 x 18                  | 100           | 1-B8267-1               | 225,88 €       | 1-B8267-15              | 252,14 €       | 1-B8267-2               | 262,65 €       | 1-B8267-25              | 239,54 €       | 1-B8267-3               | 286,81 €       |
| BSF 1/2 x 16                   | 100           | 1-B8268-1               | 262,65 €       | 1-B8268-15              | 288,92 €       | 1-B8268-2               | 299,42 €       | 1-B8268-25              | 346,70 €       | 1-B8268-3               | 428,64 €       |
| BSF 9/16 x 16                  | 100           | 1-B8269-1               | 299,42 €       | 1-B8269-15              | 341,45 €       | 1-B8269-2               | 357,20 €       | 1-B8269-25              | 501,14 €       | 1-B8269-3               | 583,08 €       |
| BSF 5/8 x 14                   | 50            | 1-B8270-1               | 173,35 €       | 1-B8270-15              | 199,61 €       | 1-B8270-2               | 207,49 €       | 1-B8270-25              | 376,64 €       | 1-B8270-3               | 436,52 €       |
| BSF 3/4 x 12                   | 50            | 1-B8272-1               | 225,88 €       | 1-B8272-15              | 249,52 €       | 1-B8272-2               | 323,06 €       | 1-B8272-25              | 644,54 €       | 1-B8272-3               | 740,67 €       |
| BSF 7/8 x 11                   | 25            | 1-B8274-1               | 116,88 €       | 1-B8274-15              | 124,76 €       | 1-B8274-2               | 161,53 €       | 1-B8274-25              | 434,95 €       | 1-B8274-3               | 506,65 €       |
| BSF 1" x 10                    | 10            | 1-B8276-1               | 57,78 €        | 1-B8276-15              | 68,81 €        | 1-B8276-2               | 74,59 €        | 1-B8276-25              | 225,98 €       | 1-B8276-3               | 260,02 €       |
| BSF 1.1/8" x 9                 | 10            | 1-B8277-1               | 83,00 €        | 1-B8277-15              | 99,81 €        |                         |                |                         |                |                         |                |
| BSF 1.1/4" x 9                 | 10            | 1-B8278-1               | 99,28 €        | 1-B8278-15              | 119,77 €       |                         |                |                         |                |                         |                |
| BSF 1.1/2" x 8                 | 10            |                         |                | 1-B8279-15              | 143,41 €       | 1-B8279-2               | 150,76 €       |                         |                |                         |                |

## G (BSP)



| Diameter x<br>Threads per inch | pack.<br>unit | 1,0 D<br>1,0 x Diameter |                | 1,5 D<br>1,5 x Diameter |                | 2,0 D<br>2,0 x Diameter |                | 2,5 D<br>2,5 x Diameter |                | 3,0 D<br>3,0 x Diameter |                |
|--------------------------------|---------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|
|                                |               | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit |
| G 1/8 x 28                     | 100           | 1-B8380-1               | 78,80 €        | 1-B8380-15              | 35,02 €        | 1-B8380-2               | 39,14 €        | 1-B8380-25              | 94,55 €        | 1-B8380-3               | 99,81 €        |
| G 1/4 x 19                     | 100           | 1-B8381-1               | 105,06 €       | 1-B8381-15              | 44,45 €        | 1-B8381-2               | 58,70 €        | 1-B8381-25              | 126,07 €       | 1-B8381-3               | 136,58 €       |
| G 3/8 x 19                     | 50            | 1-B8382-1               | 106,71 €       | 1-B8382-15              | 40,17 €        | 1-B8382-2               | 48,05 €        | 1-B8382-25              | 110,31 €       | 1-B8382-3               | 115,57 €       |
| G 1/2 x 14                     | 25            | 1-B8383-1               | 103,93 €       | 1-B8383-15              | 35,04 €        | 1-B8383-2               | 47,54 €        | 1-B8383-25              | 106,38 €       | 1-B8383-3               | 110,31 €       |
| G 5/8 x 14                     | 10            | 1-B8384-1               | 31,52 €        | 1-B8384-15              | 22,34 €        | 1-B8384-2               | 29,40 €        | 1-B8384-25              | 42,55 €        |                         |                |
| G 3/4 x 14                     | 5             | 1-B8385-1               | 16,81 €        | 1-B8385-15              | 13,76 €        | 1-B8385-2               | 18,62 €        | 1-B8385-25              | 24,16 €        |                         |                |
| G 7/8 x 14                     | 5             | 1-B8386-1               | 17,08 €        | 1-B8386-15              | 16,62 €        | 1-B8386-2               | 23,21 €        |                         |                |                         |                |
| G 1" x 11                      | 5             | 1-B8387-1               | 24,16 €        | 1-B8387-15              | 31,06 €        | 1-B8387-2               | 41,22 €        |                         |                |                         |                |

## BA

| Dimension | pack.<br>unit | 1,0 D<br>1,0 x Diameter |                | 1,5 D<br>1,5 x Diameter |                | 2,0 D<br>2,0 x Diameter |                | 2,5 D<br>2,5 x Diameter |                | 3,0 D<br>3,0 x Diameter |                |
|-----------|---------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|
|           |               | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit |
| BA 0      | 100           | 1-B6370-1               | 132,38 €       | 1-B6370-15              | 160,74 €       | 1-B6370-2               | 220,63 €       | 1-B6370-25              | 318,33 €       | 1-B6370-3               | 378,22 €       |
| BA 1      | 100           | 1-B6371-1               | 91,40 €        | 1-B6371-15              | 97,71 €        | 1-B6371-2               | 104,01 €       | 1-B6371-25              | 122,92 €       | 1-B6371-3               | 138,68 €       |
| BA 2      | 100           | 1-B6372-1               | 91,40 €        | 1-B6372-15              | 97,71 €        | 1-B6372-2               | 104,01 €       | 1-B6372-25              | 122,92 €       | 1-B6372-3               | 138,68 €       |
| BA 3      | 100           |                         |                | 1-B6373-15              | 236,39 €       |                         |                |                         |                |                         |                |
| BA 4      | 100           | 1-B6374-1               | 91,40 €        | 1-B6374-15              | 97,71 €        | 1-B6374-2               | 104,01 €       | 1-B6374-25              | 129,22 €       | 1-B6374-3               | 148,13 €       |
| BA 6      | 100           | 1-B6376-1               | 104,01 €       | 1-B6376-15              | 119,77 €       | 1-B6376-2               | 144,98 €       | 1-B6376-25              | 204,87 €       | 1-B6376-3               | 242,69 €       |

**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**

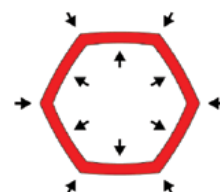


| Diameter x Pitch | pack. unit | 1,0 D<br>1,0 x Diameter |                      | 1,5 D<br>1,5 x Diameter |                      | 2,0 D<br>2,0 x Diameter |                      | 2,5 D<br>2,5 x Diameter |                      | 3,0 D<br>3,0 x Diameter |                      |
|------------------|------------|-------------------------|----------------------|-------------------------|----------------------|-------------------------|----------------------|-------------------------|----------------------|-------------------------|----------------------|
|                  |            | Item-No.:               | Price per unit       | Item-No.:               | Price per unit       | Item-No.:               | Price per unit       | Item-No.:               | Price per unit       | Item-No.:               | Price per unit       |
| M 2 x 0,4        | 100        | 1-B6102-1               | *                    | 1-B6102-15              | *                    | 1-B6102-2               | *                    | 1-B6102-25              | *                    | 1-B6102-3               | *                    |
| M 2,2 x 0,45     | 100        | 1-B6125-1               | 20,75 € <sup>1</sup> | 1-B6125-15              | 22,61 € <sup>1</sup> | 1-B6125-2               | 27,58 € <sup>1</sup> | 1-B6125-25              | 28,94 € <sup>1</sup> | 1-B6125-3               | 32,81 € <sup>1</sup> |
| M 2,5 x 0,45     | 100        | 1-B6126-1               | *                    | 1-B6126-15              | *                    | 1-B6126-2               | *                    | 1-B6126-25              | *                    | 1-B6126-3               | *                    |
| M 3 x 0,5        | 100        | 1-B6103-1               | 20,18 €              | 1-B6103-15              | 14,96 €              | 1-B6103-2               | 16,85 €              | 1-B6103-25              | 19,13 €              | 1-B6103-3               | *                    |
|                  | 10         | 2-B6103-1               | 7,07 €               | 2-B6103-15              | 5,69 €               | 2-B6103-2               | 6,41 €               | 2-B6103-25              | *                    | 2-B6103-3               | *                    |
| M 3,5 x 0,6      | 100        | 1-B6135-1               | 11,85 € <sup>1</sup> | 1-B6135-15              | 14,50 € <sup>1</sup> | 1-B6135-2               | 17,21 € <sup>1</sup> | 1-B6135-25              | 20,34 € <sup>1</sup> | 1-B6135-3               | 23,54 € <sup>1</sup> |
|                  | 100        | 1-B6104-1               | 14,90 €              | 1-B6104-15              | 21,49 €              | 1-B6104-2               | 28,63 €              | 1-B6104-25              | 22,19 €              | 1-B6104-3               | 22,66 €              |
| M 4 x 0,7        | 10         | 2-B6104-1               | 5,67 €               | 2-B6104-15              | 7,52 €               | 2-B6104-2               | 10,02 €              | 2-B6104-25              | 7,77 €               | 2-B6104-3               | 7,93 €               |
|                  | 100        | 1-B6105-1               | 13,25 €              | 1-B6105-15              | 18,83 €              | 1-B6105-2               | 17,31 €              | 1-B6105-25              | 20,50 €              | 1-B6105-3               | 24,36 €              |
| M 5 x 0,8        | 10         | 2-B6105-1               | 5,25 €               | 2-B6105-15              | 6,59 €               | 2-B6105-2               | 6,23 €               | 2-B6105-25              | 7,62 €               | 2-B6105-3               | 8,45 €               |
|                  | 100        | 1-B6106-1               | 23,18 €              | 1-B6106-15              | 17,31 €              | 1-B6106-2               | 27,81 €              | 1-B6106-25              | 25,90 €              | 1-B6106-3               | 27,52 €              |
| M 6 x 1,0        | 10         | 2-B6106-1               | 8,03 €               | 2-B6106-15              | 5,67 €               | 2-B6106-2               | 9,06 €               | 2-B6106-25              | 7,90 €               | 2-B6106-3               | 8,14 €               |
|                  | 100        | 1-B6107-1               | 21,14 €              | 1-B6107-15              | 28,05 €              | 1-B6107-2               | 36,27 €              | 1-B6107-25              | 45,08 €              | 1-B6107-3               | 53,14 €              |
| M 7 x 1,0        | 10         | 2-B6107-1               | 6,39 €               | 2-B6107-15              | 7,75 €               | 2-B6107-2               | 9,34 €               | 2-B6107-25              | 11,06 €              | 2-B6107-3               | 12,63 €              |
|                  | 100        | 1-B6181-1               | 21,19 €              | 1-B6181-15              | 28,08 €              | 1-B6181-2               | 36,28 €              | 1-B6181-25              | 44,38 €              | 1-B6181-3               | 48,78 €              |
| M 8 x 1,0        | 10         | 2-B6181-1               | 6,39 €               | 2-B6181-15              | 7,75 €               | 2-B6181-2               | 9,34 €               | 2-B6181-25              | 11,06 €              | 2-B6181-3               | 12,63 €              |
|                  | 100        | 1-B6108-1               | 21,19 €              | 1-B6108-15              | 28,08 €              | 1-B6108-2               | 36,28 €              | 1-B6108-25              | 48,78 €              | 1-B6108-3               | 47,82 €              |
| M 8 x 1,25       | 10         | 2-B6108-1               | 6,39 €               | 2-B6108-15              | 7,75 €               | 2-B6108-2               | 9,34 €               | 2-B6108-25              | 11,06 €              | 2-B6108-3               | 12,63 €              |
|                  | 100        | 1-B6101-1               | 28,99 €              | 1-B6101-15              | 41,95 €              | 1-B6101-2               | 54,41 €              | 1-B6101-25              | 66,53 €              | 1-B6101-3               | 78,84 €              |
| M 10 x 1,25      | 10         | 2-B6101-1               | 7,76 €               | 2-B6101-15              | 10,29 €              | 2-B6101-2               | 12,71 €              | 2-B6101-25              | 15,08 €              | 2-B6101-3               | 17,47 €              |
|                  | 100        | 1-B6110-1               | 28,99 €              | 1-B6110-15              | 41,95 €              | 1-B6110-2               | 54,41 €              | 1-B6110-25              | 71,94 €              | 1-B6110-3               | 78,84 €              |
| M 10 x 1,5       | 10         | 2-B6110-1               | 7,76 €               | 2-B6110-15              | 10,29 €              | 2-B6110-2               | 12,71 €              | 2-B6110-25              | 16,28 €              | 2-B6110-3               | 17,47 €              |
|                  | 100        |                         |                      | 1-B6112-15              | 58,49 €              | 1-B6112-2               | 78,06 €              | 1-B6112-25              | 97,14 €              |                         |                      |
| M 12 x 1,25      | 100        |                         |                      | 1-B6115-15              | 60,82 €              | 1-B6115-2               | 80,53 €              |                         |                      |                         |                      |
|                  | 100        | 1-B6127-1               | 43,00 €              | 1-B6127-15              | 58,29 €              | 1-B6127-2               | 84,32 €              | 1-B6127-25              | 104,72 €             | 1-B6127-3               | 115,58 €             |
| M 12 x 1,5       | 10         | 2-B6127-1               | 10,65 €              | 2-B6127-15              | 13,51 €              | 2-B6127-2               | 18,72 €              | 2-B6127-25              | 22,68 €              | 2-B6127-3               | 24,93 €              |
|                  | 50         | 1-B6114-1               | 31,79 €              | 1-B6114-15              | 47,46 €              | 1-B6114-2               | 63,52 €              | 1-B6114-25              | 99,49 €              | 1-B6114-3               | 114,26 €             |
| M 14 x 2,0       | 10         | 2-B6114-1               | 13,86 €              | 2-B6114-15              | 20,80 €              | 2-B6114-2               | 27,06 €              | 2-B6114-25              | 39,48 €              |                         |                      |
|                  | 50         | 1-B6116-1               | 38,15 €              | 1-B6116-15              | 61,32 €              | 1-B6116-2               | 119,81 €             | 1-B6116-25              | 123,49 €             | 1-B6116-3               | 153,96 €             |
| M 16 x 2,0       | 10         | 2-B6116-1               | 16,97 €              | 2-B6116-15              | 25,21 €              |                         |                      | 2-B6116-25              | 50,43 €              |                         |                      |
|                  | 25         | 1-B6119-1               | 39,57 €              | 1-B6119-15              | 60,05 €              |                         |                      |                         |                      |                         |                      |
| M 18 x 2,5       | 10         | 2-B6119-1               | 30,70 €              | 2-B6119-15              | 45,48 €              |                         |                      |                         |                      |                         |                      |
|                  | 25         | 1-B6120-1               | 185,75 €             | 1-B6120-15              | 191,21 €             | 1-B6120-2               | 344,17 €             |                         |                      |                         |                      |
| M 20 x 1,5       | 25         | 1-BS7240-1              | 43,78 €              | 1-BS7240-15             | 74,82 €              | 1-BS7240-2              | 95,73 €              | 1-BS7240-25             | 120,93 €             |                         |                      |
|                  | 10         | 2-BS7240-1              | 36,26 €              | 2-BS7240-15             | 60,46 €              | 2-BS7240-2              | 76,77 €              | 2-BS7240-25             | 96,43 €              |                         |                      |
| M 24 x 2,0       | 25         |                         |                      |                         |                      | 1-BS7246-2              | 77,43 €              |                         |                      |                         |                      |
|                  | 10         |                         |                      |                         |                      | 2-BS7246-2              | 62,50 €              |                         |                      |                         |                      |
| M 24 x 3,0       | 25         | 1-BS7245-1              | 84,34 €              | 1-BS7245-15             | 126,34 €             | 1-BS7245-2              | 166,96 €             | 1-BS7245-25             | 409,73 €             |                         |                      |
|                  | 10         | 2-BS7245-1              | 67,88 €              | 2-BS7245-15             | 47,28 €              | 2-BS7245-2              | 132,33 €             |                         |                      |                         |                      |
| M 30 x 3,5       | 5          | 1-BS7354-1              | 30,60 €              | 1-BS7354-15             | 46,50 €              | 1-BS7354-2              | 71,09 €              |                         |                      |                         |                      |
| M 36 x 4,0       | 5          |                         |                      | 1-BES364-15             | 84,08 €              | 1-BES364-2              | 112,39 €             |                         |                      |                         |                      |

\* 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.



**i** see locking torque on page 7



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

## UNC

| Diameter x<br>Threads per inch | pack.<br>unit | 1,0 D<br>1,0 x Diameter |                | 1,5 D<br>1,5 x Diameter |                | 2,0 D<br>2,0 x Diameter |                | 2,5 D<br>2,5 x Diameter |                | 3,0 D<br>3,0 x Diameter |                |
|--------------------------------|---------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|
|                                |               | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit |
| UNC 2 x 56                     | 100           |                         |                | 1-B6200-15              | 52,53 €        | 1-B6200-2               | 52,53 €        | 1-B6200-25              | 65,66 €        |                         |                |
| UNC 4 x 40                     | 100           | 1-B6201-1               | 11,15 €        | 1-B6201-15              | 47,28 €        | 1-B6201-2               | 48,33 €        | 1-B6201-25              | 52,53 €        | 1-B6201-3               | 57,78 €        |
| UNC 6 x 32                     | 100           | 1-B6203-1               | 13,15 €        | 1-B6203-15              | 14,11 €        | 1-B6203-2               | 17,30 €        | 1-B6203-25              | 47,28 €        | 1-B6203-3               | 52,53 €        |
| UNC 8 x 32                     | 100           | 1-B6204-1               | 36,77 €        | 1-B6204-15              | 36,77 €        | 1-B6204-2               | 36,77 €        | 1-B6204-25              | 42,02 €        | 1-B6204-3               | 47,28 €        |
| UNC 10 x 24                    | 100           |                         |                | 1-B6205-15              | 57,78 €        | 1-B6205-2               | 57,78 €        | 1-B6205-25              | 63,04 €        | 1-B6205-3               | 68,29 €        |
| UNC 1/4 x 20                   | 100           | 1-B6207-1               | 47,28 €        | 1-B6207-15              | 22,54 €        | 1-B6207-2               | 57,78 €        | 1-B6207-25              | 33,23 €        | 1-B6207-3               | 84,05 €        |
| UNC 5/16 x 18                  | 100           | 1-B6208-1               | 57,78 €        | 1-B6208-15              | 34,50 €        | 1-B6208-2               | 78,80 €        | 1-B6208-25              | 54,65 €        | 1-B6208-3               | 126,07 €       |
| UNC 3/8 x 16                   | 100           | 1-B6209-1               | 57,78 €        | 1-B6209-15              | 46,14 €        | 1-B6209-2               | 78,80 €        | 1-B6209-25              | 105,06 €       | 1-B6209-3               | 126,07 €       |
| UNC 7/16 x 14                  | 100           | 1-B6210-1               | 131,33 €       | 1-B6210-15              | 136,58 €       | 1-B6210-2               | 136,58 €       | 1-B6210-25              | 173,35 €       | 1-B6210-3               | 194,36 €       |
| UNC 1/2 x 13                   | 100           | 1-B6211-1               | 131,33 €       | 1-B6211-15              | 136,58 €       | 1-B6211-2               | 141,83 €       | 1-B6211-25              | 189,11 €       | 1-B6211-3               | 225,88 €       |
| UNC 5/8 x 11                   | 50            | 1-B6214-1               | 99,81 €        | 1-B6214-15              | 105,06 €       | 1-B6214-2               | 115,57 €       | 1-B6214-25              | 136,58 €       | 1-B6214-3               | 210,12 €       |
| UNC 3/4 x 10                   | 25            | 1-B6216-1               | 53,84 €        | 1-B6216-15              | 70,92 €        | 1-B6216-2               | 85,36 €        |                         |                |                         |                |
| UNC 7/8 x 9                    | 10            | 1-B6218-1               | 46,75 €        | 1-B6218-15              | 60,41 €        | 1-B6218-2               | 75,12 €        |                         |                |                         |                |
| UNC 1" x 8                     | 10            | 1-B6219-1               | 61,99 €        | 1-B6219-15              | 82,47 €        | 1-B6219-2               | 111,89 €       | 1-B6219-25              | 139,20 €       |                         |                |

## UNF

| Diameter x<br>Threads per inch | pack.<br>unit | 1,0 D<br>1,0 x Diameter |                | 1,5 D<br>1,5 x Diameter |                | 2,0 D<br>2,0 x Diameter |                | 2,5 D<br>2,5 x Diameter |                | 3,0 D<br>3,0 x Diameter |                |
|--------------------------------|---------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|
|                                |               | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit |
| UNF 6 x 40                     | 100           | 1-B6291-1               | 47,28 €        | 1-B6291-15              | 50,43 €        | 1-B6291-2               | 55,68 €        |                         |                | 1-B6291-3               | 68,29 €        |
| UNF 8 x 36                     | 100           | 1-B6292-1               | 91,40 €        | 1-B6292-15              | 97,71 €        | 1-B6292-2               | 100,86 €       | 1-B6292-25              | 113,46 €       |                         |                |
| UNF 10 x 32                    | 100           | 1-B6293-1               | 36,77 €        | 1-B6293-15              | 42,02 €        | 1-B6293-2               | 47,28 €        | 1-B6293-25              | 50,43 €        | 1-B6293-3               | 57,78 €        |
| UNF 1/4 x 28                   | 100           | 1-B6225-1               | 47,28 €        | 1-B6225-15              | 20,14 €        | 1-B6225-2               | 25,03 €        | 1-B6225-25              | 29,52 €        | 1-B6225-3               | 78,80 €        |
| UNF 5/16 x 24                  | 100           | 1-B6226-1               | 42,02 €        | 1-B6226-15              | 26,78 €        | 1-B6226-2               | 57,78 €        | 1-B6226-25              | 73,54 €        | 1-B6226-3               | 131,33 €       |
| UNF 3/8 x 24                   | 100           | 1-B6227-1               | 52,53 €        | 1-B6227-15              | 29,77 €        | 1-B6227-2               | 68,29 €        | 1-B6227-25              | 51,69 €        |                         |                |
| UNF 7/16 x 20                  | 100           | 1-B6228-1               | 63,04 €        | 1-B6228-15              | 46,90 €        | 1-B6228-2               | 78,80 €        | 1-B6228-25              | 74,83 €        | 1-B6228-3               | 147,08 €       |
| UNF 1/2 x 20                   | 100           |                         |                | 1-B6229-15              | 54,11 €        | 1-B6229-2               | 99,81 €        | 1-B6229-25              | 131,33 €       | 1-B6229-3               | 157,59 €       |
| UNF 9/16 x 18                  | 50            | 1-B6230-1               | 57,78 €        | 1-B6230-15              | 63,04 €        | 1-B6230-2               | 70,92 €        |                         |                |                         |                |
| UNF 5/8 x 18                   | 50            | 1-B6231-1               | 65,66 €        | 1-B6231-15              | 73,54 €        | 1-B6231-2               | 89,30 €        | 1-B6231-25              | 131,33 €       | 1-B6231-3               | 173,35 €       |
| UNF 3/4 x 16                   | 25            | 1-B6233-1               | 59,10 €        | 1-B6233-15              | 61,72 €        | 1-B6233-2               | 68,29 €        | 1-B6233-25              | 114,25 €       | 1-B6233-3               | 127,39 €       |
| UNF 7/8 x 14                   | 10            | 1-B6235-1               | 49,90 €        | 1-B6235-15              | 52,00 €        | 1-B6235-2               | 75,12 €        |                         |                |                         |                |
| UNF 1" x 12                    | 10            | 1-B6237-1               | 56,21 €        | 1-B6237-15              | 64,09 €        | 1-B6237-2               | 74,07 €        |                         |                |                         |                |

## Harley-Davidson

| Diameter x<br>Threads per inch | pack.<br>unit | 1,0 D<br>1,0 x Diameter |                | 1,5 D<br>1,5 x Diameter |                | 2,0 D<br>2,0 x Diameter |                | 2,5 D<br>2,5 x Diameter |                | 3,0 D<br>3,0 x Diameter |                |
|--------------------------------|---------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|
|                                |               | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit |
| 1/4 x 24                       | 10            |                         |                | 2-B6305-15              | 5,88 €         |                         |                |                         |                |                         |                |
| 7/16 x 16                      | 10            |                         |                | 2-B6308-15              | 8,83 €         |                         |                |                         |                |                         |                |

## BA

| Diameter | pack.<br>unit | 1,0 D<br>1,0 x Diameter |                | 1,5 D<br>1,5 x Diameter |                | 2,0 D<br>2,0 x Diameter |                | 2,5 D<br>2,5 x Diameter |                | 3,0 D<br>3,0 x Diameter |                |
|----------|---------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|
|          |               | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit |
| BA 0     | 100           | 1-B6470-1               | 34,91 €        | 1-B6470-15              | 45,41 €        | 1-B6470-2               | 54,48 €        | 1-B6470-25              | 66,59 €        | 1-B6470-3               | 77,01 €        |
| BA 2     | 100           | 1-B6471-1               | 35,83 €        | 1-B6471-15              | 42,16 €        | 1-B6471-2               | 51,81 €        | 1-B6471-25              | 58,14 €        | 1-B6471-3               | 66,94 €        |
| BA 3     | 100           |                         |                | 1-B6472-15              | 35,69 €        |                         |                |                         |                |                         |                |
| BA 4     | 100           | 1-B6473-1               | 33,58 €        | 1-B6473-15              | 36,11 €        | 1-B6473-2               | 43,85 €        | 1-B6473-25              | 46,81 €        | 1-B6473-3               | 52,79 €        |
| BA 6     | 100           | 1-B6474-1               | 28,23 €        | 1-B6474-15              | 30,55 €        | 1-B6474-2               | 36,60 €        | 1-B6474-25              | 38,15 €        | 1-B6474-3               | 42,86 €        |



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

### BSW

| Diameter x<br>Threads per inch | pack.<br>unit | 1,0 D<br>1,0 x Diameter |                | 1,5 D<br>1,5 x Diameter |                | 2,0 D<br>2,0 x Diameter |                | 2,5 D<br>2,5 x Diameter |                | 3,0 D<br>3,0 x Diameter |                |
|--------------------------------|---------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|
|                                |               | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit |
| <b>BSW 3/16 x 24</b>           | 100           |                         |                | 1-B6242-15              | 36,77 €        | 1-B6242-2               | 47,28 €        | 1-B6242-25              | 52,53 €        | 1-B6242-3               | 57,78 €        |
| <b>BSW 1/4 x 20</b>            | 100           |                         |                | 1-B6243-15              | 44,55 €        | 1-B6243-2               | 57,31 €        | 1-B6243-25              | 67,40 €        | 1-B6243-3               | 79,06 €        |
| <b>BSW 5/16 x 18</b>           | 100           | 1-B6244-1               | 48,75 €        | 1-B6244-15              | 70,13 €        | 1-B6244-2               | 91,09 €        | 1-B6244-25              | 111,26 €       | 1-B6244-3               | 133,01 €       |
| <b>BSW 3/8 x 16</b>            | 100           | 1-B6245-1               | 60,20 €        | 1-B6245-15              | 86,78 €        | 1-B6245-2               | 113,46 €       |                         |                |                         |                |
| <b>BSW 7/16 x 14</b>           | 100           |                         |                | 1-B6246-15              | 97,13 €        | 1-B6246-2               | 146,98 €       | 1-B6246-25              | 195,62 €       |                         |                |
| <b>BSW 1/2 x 12</b>            | 100           | 1-B6247-1               | 214,06 €       | 1-B6247-15              | 326,32 €       | 1-B6247-2               | 435,32 €       | 1-B6247-25              | 547,42 €       | 1-B6247-3               | 691,72 €       |
| <b>BSW 5/8 x 11</b>            | 50            | 1-B6249-1               | 182,80 €       |                         |                |                         |                |                         |                |                         |                |

### BSF

| Diameter x<br>Threads per inch | pack.<br>unit | 1,0 D<br>1,0 x Diameter |                | 1,5 D<br>1,5 x Diameter |                | 2,0 D<br>2,0 x Diameter |                | 2,5 D<br>2,5 x Diameter |                | 3,0 D<br>3,0 x Diameter |                |
|--------------------------------|---------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|
|                                |               | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit |
| <b>BSF 1/4 x 26</b>            | 100           | 1-B6263-1               | 47,70 €        | 1-B6263-15              | 62,09 €        | 1-B6263-2               | 75,38 €        | 1-B6263-25              | 89,30 €        | 1-B6263-3               | 103,33 €       |
| <b>BSF 5/16 x 22</b>           | 100           | 1-B6265-1               | 67,03 €        | 1-B6265-15              | 94,45 €        | 1-B6265-2               | 120,29 €       | 1-B6265-25              | 148,19 €       | 1-B6265-3               | 183,86 €       |
| <b>BSF 3/8 x 20</b>            | 100           | 1-B6266-1               | 90,40 €        | 1-B6266-15              | 130,12 €       | 1-B6266-2               | 168,36 €       | 1-B6266-25              | 210,12 €       | 1-B6266-3               | 249,89 €       |
| <b>BSF 7/16 x 18</b>           | 100           | 1-B6267-1               | 168,10 €       | 1-B6267-15              | 193,05 €       | 1-B6267-2               | 253,77 €       | 1-B6267-25              | 325,69 €       |                         |                |
| <b>BSF 1/2 x 16</b>            | 100           | 1-B6268-1               | 145,46 €       | 1-B6268-15              | 217,16 €       | 1-B6268-2               | 287,39 €       | 1-B6268-25              | 358,20 €       |                         |                |
| <b>BSF 9/16 x 16</b>           | 50            | 1-B6269-1               | 106,01 €       | 1-B6269-15              | 157,91 €       |                         |                |                         |                |                         |                |
| <b>BSF 5/8 x 14</b>            | 50            | 1-B6270-1               | 151,08 €       | 1-B6270-15              | 226,30 €       | 1-B6270-2               | 302,31 €       |                         |                |                         |                |
| <b>BSF 3/4 x 12</b>            | 25            | 1-B6272-1               | 219,10 €       | 1-B6272-15              | 267,54 €       | 1-B6272-3               | 518,52 €       |                         |                |                         |                |
| <b>BSF 7/8 x 11</b>            | 10            |                         |                | 1-B6274-15              | 131,33 €       |                         |                |                         |                |                         |                |
| <b>BSF 1" x 10</b>             | 10            |                         |                | 1-B6276-15              | 176,34 €       | 1-B6276-2               | 234,39 €       |                         |                |                         |                |

## 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<br>pitch | 1,0 D<br>1,0 x Diameter |  | 1,5 D<br>1,5 x Diameter |  | 2,0 D<br>1,5 x Diameter |  |
|---------------------|-------------------------|--|-------------------------|--|-------------------------|--|
|                     | Item-No.:               |  | Item-No.:               |  | 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 | pack. unit | 1,0 D<br>1,0 x Diameter |                | 1,5 D<br>1,5 x Diameter |                | 2,0 D<br>2,0 x Diameter |                |
|------------------|------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|
|                  |            | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit |
| M 3 x 0,5        | 100        | 1-B7205-1B              | 36,21 €        | 1-B7205-15B             | 37,86 €        | 1-B7205-2B              | 44,41 €        |
| M 4 x 0,7        | 100        | 1-B7207-1B              | 33,74 €        | 1-B7207-15B             | 34,99 €        | 1-B7207-2B              | 39,53 €        |
| M 5 x 0,8        | 100        | 1-B7208-1B              | 37,86 €        | 1-B7208-15B             | 39,14 €        | 1-B7208-2B              | 40,34 €        |
| M 6 x 1,0        | 100        | 1-B7209-1B              | 41,31 €        | 1-B7209-15B             | 44,28 €        | 1-B7209-2B              | 46,82 €        |
| M 8 x 1,25       | 100        | 1-B7211-1B              | 41,20 €        | 1-B7211-15B             | 44,46 €        | 1-B7211-2B              | 49,45 €        |
| M 10 x 1,5       | 100        | 1-B7215-1B              | 44,63 €        | 1-B7215-15B             | 47,60 €        | 1-B7215-2B              | 65,87 €        |
| M 12 x 1,75      | 100        | 1-B7221-1B              | 82,82 €        | 1-B7221-15B             | 87,82 €        | 1-B7221-2B              | 93,95 €        |
| M 16 x 2,0       | 100        | 1-B7234-1B              | 158,48 €       | 1-B7234-15B             | 163,73 €       | 1-B7234-2B              | 205,38 €       |
| M 20 x 2,5       | 100        | 1-B7239-1B              | 508,36 €       | 1-B7239-15B             | 593,72 €       | 1-B7239-2B              | 743,75 €       |

### 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 | pack. unit | 1,0 D<br>1,0 x Diameter |                | 1,5 D<br>1,5 x Diameter |                | 2,0 D<br>2,0 x Diameter |                |
|------------------|------------|-------------------------|----------------|-------------------------|----------------|-------------------------|----------------|
|                  |            | Item-No.:               | Price per unit | Item-No.:               | Price per unit | Item-No.:               | Price per unit |
| M 3 x 0,5        | 100        | 1-B7205-1V4A            | 30,54 €        | 1-B7205-15V4A           | 33,20 €        | 1-B7205-2V4A            | 34,53 €        |
| M 4 x 0,7        | 100        | 1-B7207-1V4A            | 26,57 €        | 1-B7207-15V4A           | 28,69 €        | 1-B7207-2V4A            | 29,91 €        |
| M 5 x 0,8        | 100        | 1-B7208-1V4A            | 33,20 €        | 1-B7208-15V4A           | 35,22 €        | 1-B7208-2V4A            | 37,19 €        |
| M 6 x 1,0        | 100        | 1-B7209-1V4A            | 35,22 €        | 1-B7209-15V4A           | 39,85 €        | 1-B7209-2V4A            | 45,16 €        |
| M 8 x 1,25       | 100        | 1-B7211-1V4A            | 38,51 €        | 1-B7211-15V4A           | 43,83 €        | 1-B7211-2V4A            | 51,80 €        |
| M 10 x 1,5       | 100        | 1-B7215-1V4A            | 47,82 €        | 1-B7215-15V4A           | 53,13 €        | 1-B7215-2V4A            | 59,77 €        |
| M 12 x 1,75      | 100        | 1-B7221-1V4A            | 73,05 €        | 1-B7221-15V4A           | 81,71 €        | 1-B7221-2V4A            | 90,31 €        |

## 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 | LN stand. = Item-No | LN stand. = Item-No | LN stand. = Item-No | LN stand. = Item-No | 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 | LN stand. = Item-No | LN stand. = Item-No | LN stand. = Item-No | LN stand. = Item-No | 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 | DIN stand. = Item-No | DIN stand. = Item-No | DIN stand. = Item-No | DIN stand. = Item-No | 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® Tangless® CoilThread® Wire Thread Inserts - type: „free running“**

material: stainless steel 304 delivery time: on request Inserting tools: on request

**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 |                | 1,5 x Diameter |                | 2,0 x Diameter |                | 2,5 x Diameter |                | 3,0 x Diameter |                |
|                     |            | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit |
| <b>M 2 x 0,4</b>    | 1.000      | 1-B7202-1TL    | 508,41 €       | 1-B7202-15TL   | 519,62 €       | 1-B7202-2TL    | 530,83 €       |                |                |                |                |
| <b>M 2,5 x 0,45</b> | 1.000      | 1-B7204-1TL    | 344,94 €       | 1-B7204-15TL   | 348,50 €       | 1-B7204-2TL    | 353,87 €       | 1-B7204-25TL   | 358,33 €       | 1-B7204-3TL    | 362,79 €       |
| <b>M 3 x 0,5</b>    | 1.000      | 1-B7205-1TL    | 347,92 €       | 1-B7205-15TL   | 353,76 €       | 1-B7205-2TL    | 362,63 €       | 1-B7205-25TL   | 370,02 €       | 1-B7205-3TL    | 377,40 €       |
| <b>M 4 x 0,7</b>    | 1.000      | 1-B7207-1TL    | 356,95 €       | 1-B7207-15TL   | 369,43 €       | 1-B7207-2TL    | 381,60 €       | 1-B7207-25TL   | 391,00 €       | 1-B7207-3TL    | 406,30 €       |
| <b>M 5 x 0,8</b>    | 1.000      | 1-B7208-1TL    | 357,37 €       | 1-B7208-15TL   | 374,05 €       | 1-B7208-2TL    | 393,60 €       | 1-B7208-25TL   | 411,77 €       | 1-B7208-3TL    | 429,83 €       |
| <b>M 6 x 1,0</b>    | 1.000      | 1-B7209-1TL    | 369,80 €       | 1-B7209-15TL   | 398,54 €       | 1-B7209-2TL    | 426,28 €       | 1-B7209-25TL   | 454,43 €       | 1-B7209-3TL    | 482,75 €       |
| <b>M 8 x 1,25</b>   | 1.000      | 1-B7211-1TL    | 373,04 €       | 1-B7211-15TL   | 420,27 €       | 1-B7211-2TL    | 466,17 €       | 1-B7211-25TL   | 512,71 €       | 1-B7211-3TL    | 559,30 €       |
| <b>M 10 x 1,5</b>   | 1.000      | 1-B7215-1TL    | 396,21 €       | 1-B7215-15TL   | 474,30 €       | 1-B7215-2TL    | 542,30 €       | 1-B7215-25TL   | 610,25 €       | 1-B7215-3TL    | 688,34 €       |
| <b>M 12 x 1,75</b>  | 1.000      | 1-B7221-1TL    | 485,83 €       | 1-B7221-15TL   | 600,47 €       | 1-B7221-2TL    | 714,90 €       | 1-B7221-25TL   | 829,39 €       | 1-B7221-3TL    | 943,82 €       |

**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 |                | 1,5 x Diameter |                | 2,0 x Diameter |                | 2,5 x Diameter |                | 3,0 x Diameter |                |
|                             |            | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit |
| <b>UNC 2 x 56</b>           | 1.000      | 1-B8200-1TL    | 343,24 €       | 1-B8200-15TL   | 347,44 €       | 1-B8200-2TL    | 350,36 €       | 1-B8200-25TL   | 354,82 €       | 1-B8200-3TL    | 359,60 €       |
| <b>UNC 4 x 40</b>           | 1.000      | 1-B8201-1TL    | 347,44 €       | 1-B8201-15TL   | 354,34 €       | 1-B8201-2TL    | 359,98 €       | 1-B8201-25TL   | 366,88 €       | 1-B8201-3TL    | 374,00 €       |
| <b>UNC 6 x 32</b>           | 1.000      | 1-B8203-1TL    | 339,79 €       | 1-B8203-15TL   | 347,70 €       | 1-B8203-2TL    | 355,41 €       | 1-B8203-25TL   | 363,32 €       | 1-B8203-3TL    | 370,28 €       |
| <b>UNC 8 x 32</b>           | 1.000      | 1-B8204-1TL    | 344,94 €       | 1-B8204-15TL   | 355,78 €       | 1-B8204-2TL    | 366,99 €       | 1-B8204-25TL   | 377,35 €       | 1-B8204-3TL    | 387,18 €       |
| <b>UNC 10 x 24</b>          | 1.000      | 1-B8205-1TL    | 319,76 €       | 1-B8205-15TL   | 335,38 €       | 1-B8205-2TL    | 351,05 €       | 1-B8205-25TL   | 366,99 €       | 1-B8205-3TL    | 382,39 €       |
| <b>UNC 1/4 x 20</b>         | 1.000      | 1-B8207-1TL    | 347,04 €       | 1-B8207-15TL   | 383,62 €       | 1-B8207-2TL    | 416,66 €       | 1-B8207-25TL   | 451,19 €       | 1-B8207-3TL    | 485,72 €       |
| <b>UNC 5/16 x 18</b>        | 1.000      | 1-B8208-1TL    | 334,48 €       | 1-B8208-15TL   | 383,14 €       | 1-B8208-2TL    | 429,57 €       | 1-B8208-25TL   | 476,11 €       | 1-B8208-3TL    | 520,89 €       |
| <b>UNC 3/8 x 16</b>         | 1.000      | 1-B8209-1TL    | 373,20 €       | 1-B8209-15TL   | 443,01 €       | 1-B8209-2TL    | 511,86 €       | 1-B8209-25TL   | 586,50 €       | 1-B8209-3TL    | 652,38 €       |

**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 |                | 1,5 x Diameter |                | 2,0 x Diameter |                | 2,5 x Diameter |                | 3,0 x Diameter |                |
|                             |            | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit |
| <b>UNF 10 x 32</b>          | 1.000      | 1-B8293-1TL    | 350,41 €       | 1-B8293-15TL   | 366,08 €       | 1-B8293-2TL    | 380,48 €       | 1-B8293-25TL   | 396,10 €       | 1-B8293-3TL    | 410,55 €       |
| <b>UNF 1/4 x 28</b>         | 1.000      | 1-B8225-1TL    | 378,78 €       | 1-B8225-15TL   | 409,28 €       | 1-B8225-2TL    | 434,83 €       | 1-B8225-25TL   | 462,93 €       | 1-B8225-3TL    | 490,98 €       |
| <b>UNF 5/16 x 24</b>        | 1.000      | 1-B8226-1TL    | 370,28 €       | 1-B8226-15TL   | 410,66 €       | 1-B8226-2TL    | 445,08 €       | 1-B8226-25TL   | 491,73 €       | 1-B8226-3TL    | 514,57 €       |
| <b>UNF 3/8 x 24</b>         | 1.000      | 1-B8227-1TL    | 414,22 €       | 1-B8227-15TL   | 467,77 €       | 1-B8227-2TL    | 520,68 €       | 1-B8227-25TL   | 586,18 €       | 1-B8227-3TL    | 643,13 €       |

**BaerCoil® Tangless® CoilThread® Wire Thread Inserts - type: „screw grip“**

material: stainless steel 304 delivery time: on request Inserting tools: on request

**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 |                | 1,5 x Diameter |                | 2,0 x Diameter |                | 2,5 x Diameter |                | 3,0 x Diameter |                |
|                     |            | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit |
| <b>M 2,5 x 0,45</b> | 1.000      | 1-B6126-1TL    | 374,80 €       | 1-B6126-15TL   | 378,36 €       | 1-B6126-2TL    | 383,72 €       | 1-B6126-25TL   | 388,18 €       | 1-B6126-3TL    | 392,65 €       |
| <b>M 3 x 0,5</b>    | 1.000      | 1-B6103-1TL    | 377,77 €       | 1-B6103-15TL   | 383,62 €       | 1-B6103-2TL    | 392,49 €       | 1-B6103-25TL   | 399,87 €       | 1-B6103-3TL    | 407,26 €       |
| <b>M 4 x 0,7</b>    | 1.000      | 1-B6104-1TL    | 386,80 €       | 1-B6104-15TL   | 399,29 €       | 1-B6104-2TL    | 411,45 €       | 1-B6104-25TL   | 420,86 €       | 1-B6104-3TL    | 436,16 €       |
| <b>M 5 x 0,8</b>    | 1.000      | 1-B6105-1TL    | 387,23 €       | 1-B6105-15TL   | 403,91 €       | 1-B6105-2TL    | 423,46 €       | 1-B6105-25TL   | 441,63 €       | 1-B6105-3TL    | 459,69 €       |
| <b>M 6 x 1,0</b>    | 1.000      | 1-B6106-1TL    | 399,66 €       | 1-B6106-15TL   | 428,40 €       | 1-B6106-2TL    | 456,13 €       | 1-B6106-25TL   | 484,29 €       | 1-B6106-3TL    | 512,60 €       |
| <b>M 8 x 1,25</b>   | 1.000      | 1-B6108-1TL    | 420,86 €       | 1-B6108-15TL   | 468,08 €       | 1-B6108-2TL    | 513,98 €       | 1-B6108-25TL   | 560,52 €       | 1-B6108-3TL    | 607,11 €       |
| <b>M 10 x 1,5</b>   | 1.000      | 1-B6110-1TL    | 444,02 €       | 1-B6110-15TL   | 522,11 €       | 1-B6110-2TL    | 590,11 €       | 1-B6110-25TL   | 658,06 €       | 1-B6110-3TL    | 736,15 €       |
| <b>M 12 x 1,75</b>  | 1.000      | 1-B6127-1TL    | 533,64 €       | 1-B6127-15TL   | 648,28 €       | 1-B6127-2TL    | 762,72 €       | 1-B6127-25TL   | 877,20 €       | 1-B6127-3TL    | 991,63 €       |

**UNC**

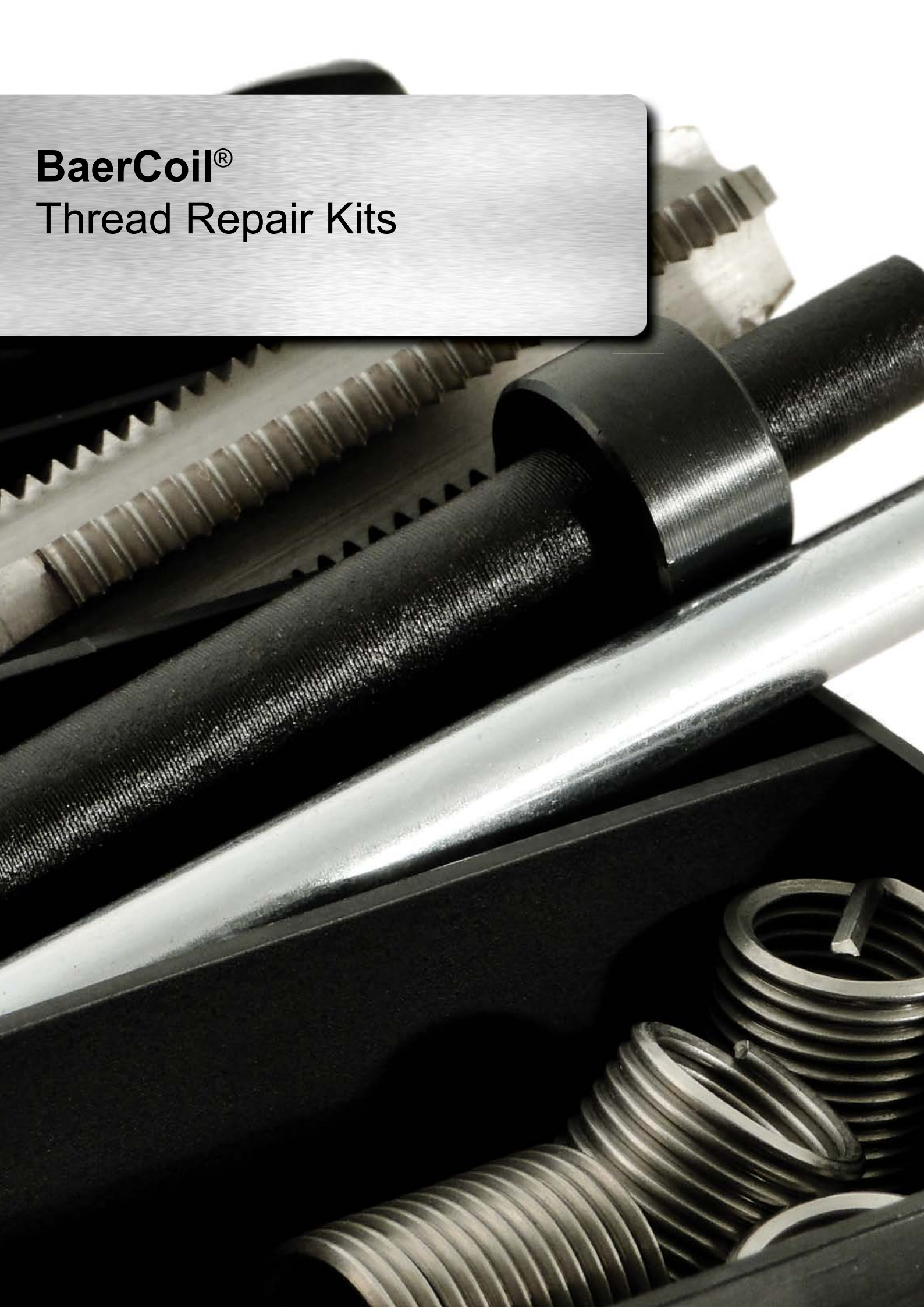
| Diameter x Threads per inch | pack. unit | 1,0 D          |                | 1,5 D          |                | 2,0 D          |                | 2,5 D          |                | 3,0 D          |                |
|-----------------------------|------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|
|                             |            | 1,0 x Diameter |                | 1,5 x Diameter |                | 2,0 x Diameter |                | 2,5 x Diameter |                | 3,0 x Diameter |                |
|                             |            | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit |
| <b>UNC 2 x 56</b>           | 1.000      | 1-B6200-1TL    | 373,10 €       | 1-B6200-15TL   | 377,29 €       | 1-B6200-2TL    | 380,22 €       | 1-B6200-25TL   | 384,68 €       | 1-B6200-3TL    | 389,46 €       |
| <b>UNC 4 x 40</b>           | 1.000      | 1-B6201-1TL    | 377,29 €       | 1-B6201-15TL   | 384,20 €       | 1-B6201-2TL    | 389,83 €       | 1-B6201-25TL   | 396,74 €       | 1-B6201-3TL    | 403,86 €       |
| <b>UNC 6 x 32</b>           | 1.000      | 1-B6203-1TL    | 369,64 €       | 1-B6203-15TL   | 377,56 €       | 1-B6203-2TL    | 385,26 €       | 1-B6203-25TL   | 393,18 €       | 1-B6203-3TL    | 400,14 €       |
| <b>UNC 8 x 32</b>           | 1.000      | 1-B6204-1TL    | 374,80 €       | 1-B6204-15TL   | 385,63 €       | 1-B6204-2TL    | 396,84 €       | 1-B6204-25TL   | 407,20 €       | 1-B6204-3TL    | 417,03 €       |
| <b>UNC 10 x 24</b>          | 1.000      | 1-B6205-1TL    | 349,62 €       | 1-B6205-15TL   | 365,23 €       | 1-B6205-2TL    | 380,91 €       | 1-B6205-25TL   | 396,84 €       | 1-B6205-3TL    | 412,25 €       |
| <b>UNC 1/4 x 20</b>         | 1.000      | 1-B6207-1TL    | 377,45 €       | 1-B6207-15TL   | 413,47 €       | 1-B6207-2TL    | 446,52 €       | 1-B6207-25TL   | 481,05 €       | 1-B6207-3TL    | 515,58 €       |
| <b>UNC 5/16 x 18</b>        | 1.000      | 1-B6208-1TL    | 382,29 €       | 1-B6208-15TL   | 430,95 €       | 1-B6208-2TL    | 477,38 €       | 1-B6208-25TL   | 523,92 €       | 1-B6208-3TL    | 568,70 €       |
| <b>UNC 3/8 x 16</b>         | 1.000      | 1-B6209-1TL    | 421,02 €       | 1-B6209-15TL   | 490,82 €       | 1-B6209-2TL    | 559,67 €       | 1-B6209-25TL   | 634,31 €       | 1-B6209-3TL    | 700,19 €       |

**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 |                | 1,5 x Diameter |                | 2,0 x Diameter |                | 2,5 x Diameter |                | 3,0 x Diameter |                |
|                             |            | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit | Item-No.:      | Price per unit |
| <b>UNF 10 x 32</b>          | 1.000      | 1-B6293-1TL    | 380,27 €       | 1-B6293-15TL   | 395,94 €       | 1-B6293-2TL    | 410,34 €       | 1-B6293-25TL   | 425,96 €       | 1-B6293-3TL    | 440,41 €       |
| <b>UNF 1/4 x 28</b>         | 1.000      | 1-B6225-1TL    | 408,64 €       | 1-B6225-15TL   | 439,13 €       | 1-B6225-2TL    | 464,68 €       | 1-B6225-25TL   | 492,79 €       | 1-B6225-3TL    | 520,84 €       |
| <b>UNF 5/16 x 24</b>        | 1.000      | 1-B6226-1TL    | 418,09 €       | 1-B6226-15TL   | 458,47 €       | 1-B6226-2TL    | 492,89 €       | 1-B6226-25TL   | 539,54 €       | 1-B6226-3TL    | 562,38 €       |
| <b>UNF 3/8 x 24</b>         | 1.000      | 1-B6227-1TL    | 462,03 €       | 1-B6227-15TL   | 515,58 €       | 1-B6227-2TL    | 568,49 €       | 1-B6227-25TL   | 633,99 €       | 1-B6227-3TL    | 690,94 €       |

**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

|             |       |       |         |  |  |  | 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 |



## BaerCoil® Thread Repair Kits for spark plug

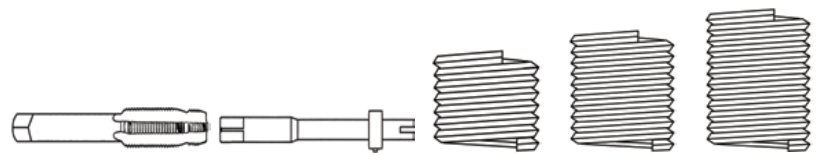
STI Tap HSSG with pilot nose for spark plug

Inserting Tool

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

**different lengths for all applications**

Instruction for use



|                    |       |              |              |              | No.    | €     |
|--------------------|-------|--------------|--------------|--------------|--------|-------|
| <b>M 10 x 1,0</b>  | EBW10 | 10 mm<br>5   | 15 mm<br>5   | 20 mm<br>5   | ZKG010 | 38,60 |
| <b>M 12 x 1,25</b> | EBW12 | 12 mm<br>5   | 18 mm<br>5   | 24 mm<br>5   | ZKG012 | 41,10 |
| <b>M 14 x 1,25</b> | EBW14 | 8,4 mm<br>5  | 12,4 mm<br>5 | 16,4 mm<br>5 | ZKG014 | 42,00 |
| <b>M 18 x 1,5</b>  | EBW18 | 12,7 mm<br>5 | 15,9 mm<br>5 | 16,7 mm<br>5 | ZKG018 | 66,00 |



## BaerCoil® Thread Repair Kits for oil drain plug

Drill HSS

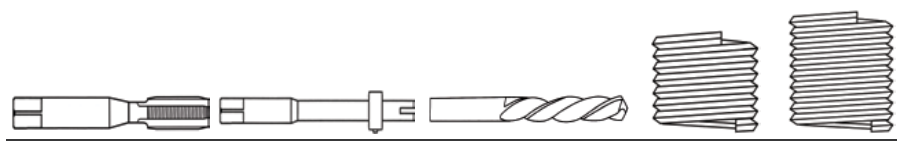
STI Bottoming Tap HSSG

Inserting Tool

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

**different lengths for all applications**

Instruction for use



|                   |       |         |            |            | No.    | €     |
|-------------------|-------|---------|------------|------------|--------|-------|
| <b>M 12 x 1,5</b> | EBW12 | 12,4 mm | 12 mm<br>5 | 18 mm<br>5 | B40223 | 34,90 |
| <b>M 14 x 1,5</b> | EBW14 | 14,4 mm | 14 mm<br>5 | 21 mm<br>5 | B40293 | 39,80 |
| <b>M 16 x 1,5</b> | EBW16 |         | 16 mm<br>5 | 24 mm<br>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

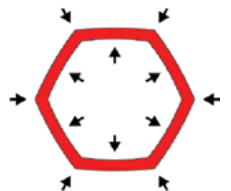


**M** ISO metric thread

|             |       |       |         |    | 1,5 D  | No.    | € |
|-------------|-------|-------|---------|----|--------|--------|---|
| M 3 x 0,5   | EBW03 | BZ003 | 3,2 mm  | 10 | BS4005 | 20,90  |   |
| M 4 x 0,7   | EBW04 | BZ004 | 4,2 mm  | 10 | BS4007 | 20,90  |   |
| M 5 x 0,8   | EBW05 | BZ005 | 5,2 mm  | 10 | BS4009 | 20,90  |   |
| M 6 x 1,0   | EBW06 | BZ006 | 6,3 mm  | 10 | BS4010 | 20,90  |   |
| M 8 x 1,25  | EBW08 | BZ008 | 8,3 mm  | 10 | BS4012 | 29,60  |   |
| M 10 x 1,5  | EBW10 | BZ010 | 10,4 mm | 10 | BS4016 | 31,45  |   |
| M 12 x 1,75 | EBW12 | BZ012 | 12,4 mm | 10 | BS4021 | 35,60  |   |
| M 14 x 2,0  | EBW14 |       | 14,5 mm | 5  | BS4028 | 71,40  |   |
| M 16 x 2,0  | EBW14 |       |         | 5  | BS4032 | 83,50  |   |
| M 18 x 2,5  | EBW18 |       |         | 5  | BS4034 | 102,60 |   |
| M 20 x 2,5  | EBW20 |       |         | 5  | BS4037 | 156,50 |   |
| M 24 x 3,0  | EBW24 |       |         | 5  | BS4043 | 209,50 |   |
| M 30 x 3,5  | EBW30 |       |         | 5  | BS4054 | 417,90 |   |

## 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.





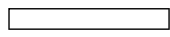

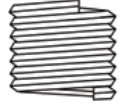
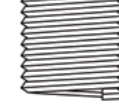

**i** see locking torque on page 7

## 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



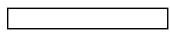



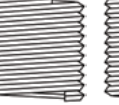
|  |   |   |   | 1,5 D   | 2,0 D  | 2,5 D   | No.    | €     |
|--|---|---|---|---|--|---|--------|-------|
|  |  |  |  |  |  |  |        |       |
| <b>M 3 x 0,5</b>   | KEBW03  | BZ003   | 3,2 mm  | 10  | 5  | 5   | B40054 | 23,40 |
| <b>M 4 x 0,7</b>   | KEBW04  | BZ004   | 4,2 mm  | 10  | 5  | 5   | B40074 | 23,40 |
| <b>M 5 x 0,8</b>   | KEBW05  | BZ005   | 5,2 mm  | 10  | 5  | 5   | B40094 | 23,40 |
| <b>M 6 x 1,0</b>   | KEBW06  | BZ006   | 6,3 mm  | 10  | 5  | 5   | B40104 | 25,50 |
| <b>M 8 x 1,25</b>  | KEBW08  | BZ008   | 8,3 mm  | 10  | 5  | 5   | B40124 | 31,40 |
| <b>M 10 x 1,5</b>  | KEBW10  | BZ010   | 10,4 mm   | 5   | 5  | 5   | B40164 | 35,20 |
| <b>M 12 x 1,75</b>   | KEBW12  | BZ012   | 12,4 mm   | 5   | 5  | 5   | B40214 | 39,90 |

## 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 | 36,60 |
| <b>M 4 x 0,7</b>   | EBW04   | BZ004   | 10,4 mm   | 4,2 mm  | 10   | 5   | 5   | B40075 | 36,60 |
| <b>M 5 x 0,8</b>   | EBW05   | BZ005   | 10,4 mm   | 5,2 mm  | 10   | 5   | 5   | B40095 | 36,60 |
| <b>M 6 x 1,0</b>   | EBW06   | BZ006   | 10,4 mm   | 6,3 mm  | 10   | 5   | 5   | B40105 | 36,60 |
| <b>M 7 x 1,0</b>   | EBW07   | BZ006   | 10,4 mm   | 7,3 mm  | 10   | 5   | 5   | B40115 | 54,30 |
| <b>M 8 x 1,25</b>  | EBW08   | BZ008   | 10,4 mm   | 8,3 mm  | 10   | 5   | 5   | B40125 | 54,80 |
| <b>M 10 x 1,5</b>  | EBW10   | BZ010   | 16,5 mm   | 10,4 mm   | 10   | 5   | 5   | B40165 | 56,70 |
| <b>M 12 x 1,5</b>  | EBW12   | BZ012   | 16,5 mm   | 12,4 mm   | 5  | 5   | 5   | B40225 | 72,20 |
| <b>M 12 x 1,75</b>   | EBW12   | BZ012   | 16,5 mm   | 12,4 mm   | 5  | 5   | 5   | B40215 | 72,20 |
| <b>M 14 x 1,5</b>  | EBW14   |   | 16,5 mm   | 14,4 mm   | 5  | 5   |     | B40295 | 75,80 |
| <b>M 16 x 2,0</b>  | EBW14   |   | 16,5 mm   |   | 10   |   |     | B40325 | 94,40 |



## BaerCoil® Thread Repair Kits

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



**M** ISO metric thread

|              |       |       |          | 1,5 D | No.   | €      |
|--------------|-------|-------|----------|-------|-------|--------|
| M 2 x 0,4    | EBW01 | BZ001 | 2,1 mm   | 20    | B4001 | 21,00  |
| M 2,2 x 0,45 | EBW01 | BZ001 | 2,3 mm   | 20    | B4002 | 45,80  |
| M 2,5 x 0,45 | EBW02 | BZ002 | 2,6 mm   | 20    | B4003 | 20,30  |
| M 3 x 0,5    | EBW03 | BZ003 | 3,2 mm   | 20    | B4005 | 20,30  |
| M 3,5 x 0,6  | EBW03 | BZ003 | 3,7 mm   | 20    | B4006 | 20,30  |
| M 4 x 0,7    | EBW04 | BZ004 | 4,2 mm   | 20    | B4007 | 20,30  |
| M 5 x 0,8    | EBW05 | BZ005 | 5,2 mm   | 20    | B4009 | 20,80  |
| M 6 x 0,75   | EBW06 | BZ006 | 6,3 mm   | 10    | B0675 | 69,00  |
| M 6 x 1,0    | EBW06 | BZ006 | 6,3 mm   | 20    | B4010 | 20,90  |
| M 7 x 1,0    | EBW07 | BZ006 | 7,3 mm   | 20    | B4011 | 29,00  |
| M 8 x 0,75   | EBW08 | BZ008 | 8,3 mm   | 10    | B0875 | 69,00  |
| M 8 x 1,0    | EBW08 | BZ008 | 8,3 mm   | 20    | B4013 | 29,00  |
| M 8 x 1,25   | EBW08 | BZ008 | 8,3 mm   | 20    | B4012 | 27,80  |
| M 9 x 1,0    | EBW08 | BZ008 | 9,3 mm   | 10    | B0091 | 69,00  |
| M 9 x 1,25   | EBW08 | BZ008 | 9,3 mm   | 15    | B4014 | 32,20  |
| M 10 x 1,0   | EBW10 | BZ010 | 10,3 mm  | 15    | B4018 | 30,80  |
| M 10 x 1,25  | EBW10 | BZ010 | 10,3 mm  | 15    | B4017 | 30,80  |
| M 10 x 1,5   | EBW10 | BZ010 | 10,4 mm  | 15    | B4016 | 29,50  |
| M 11 x 1,0   | EBW10 | BZ010 | 11,4 mm  | 5     | B0111 | 75,80  |
| M 11 x 1,25  | EBW10 | BZ010 | 11,4 mm  | 5     | B1125 | 75,80  |
| M 11 x 1,5   | EBW10 | BZ010 | 11,4 mm  | 10    | B4019 | 35,00  |
| M 12 x 1,0   | EBW12 | BZ012 | 12,3 mm  | 10    | B4024 | 35,00  |
| M 12 x 1,25  | EBW12 | BZ012 | 12,3 mm  | 10    | B4023 | 35,00  |
| M 12 x 1,5   | EBW12 | BZ012 | 12,4 mm  | 10    | B4022 | 34,50  |
| M 12 x 1,75  | EBW12 | BZ012 | 12,4 mm  | 10    | B4021 | 34,80  |
| M 13 x 1,25  | EBW12 |       | 13,25 mm | 5     | B1315 | 99,00  |
| M 13 x 1,5   | EBW12 |       | 13,25 mm | 5     | B1325 | 89,00  |
| M 14 x 1,0   | EBW14 |       | 14,4 mm  | 10    | B4031 | 39,20  |
| M 14 x 1,25  | EBW14 |       | 14,4 mm  | 10    | B4030 | 39,20  |
| M 14 x 1,5   | EBW14 |       | 14,4 mm  | 10    | B4029 | 38,50  |
| M 14 x 2,0   | EBW14 |       | 14,5 mm  | 10    | B4028 | 38,70  |
| M 15 x 1,5   | EBW14 |       |          | 5     | B1515 | 126,00 |
| M 15 x 2,0   | EBW14 |       |          | 5     | B1520 | 126,00 |
| M 16 x 1,5   | EBW14 |       |          | 10    | B4033 | 47,20  |
| M 16 x 2,0   | EBW14 |       |          | 10    | B4032 | 47,20  |

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

## BaerCoil® Thread Repair Kits

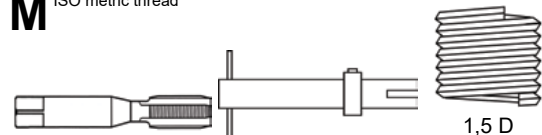
STI Bottoming Tap HSSG

Inserting Tool

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

Instruction for use

**M** ISO metric thread



|            |       | 1,5 D | No.   | €      |
|------------|-------|-------|-------|--------|
| M 18 x 1,5 | EBW18 | 5     | B4036 | 58,00  |
| M 18 x 2,0 | EBW18 | 5     | B4035 | 58,00  |
| M 18 x 2,5 | EBW18 | 5     | B4034 | 58,00  |
| M 20 x 1,5 | EBW20 | 5     | B4039 | 63,00  |
| M 20 x 2,0 | EBW20 | 5     | B4038 | 63,00  |
| M 20 x 2,5 | EBW20 | 5     | B4037 | 63,00  |
| M 22 x 1,5 | EBW22 | 5     | B4042 | 73,00  |
| M 22 x 2,0 | EBW22 | 5     | B4041 | 73,00  |
| M 22 x 2,5 | EBW22 | 5     | B4040 | 73,00  |
| M 24 x 1,5 | EBW24 | 5     | B4045 | 84,00  |
| M 24 x 2,0 | EBW24 | 5     | B4044 | 84,00  |
| M 24 x 3,0 | EBW24 | 5     | B4043 | 84,00  |
| M 26 x 1,5 | EBW26 | 5     | B4049 | 262,00 |
| M 27 x 1,5 | EBW27 | 5     | B4052 | 262,00 |
| M 27 x 2,0 | EBW27 | 5     | B4051 | 262,00 |
| M 27 x 3,0 | EBW27 | 5     | B4050 | 262,00 |
| M 28 x 1,5 | EBW28 | 5     | B4053 | 262,00 |
| M 30 x 1,5 | EBW30 | 5     | B4056 | 330,00 |
| M 30 x 2,0 | EBW30 | 5     | B4055 | 330,00 |
| M 30 x 3,5 | EBW30 | 5     | B4054 | 330,00 |
| M 33 x 2,0 | EBW33 | 5     | B4058 | 344,00 |
| M 33 x 3,5 | EBW33 | 5     | B4057 | 344,00 |
| M 36 x 1,5 | EBW36 | 5     | B4063 | 366,00 |
| M 36 x 2,0 | EBW36 | 5     | B4062 | 366,00 |
| M 36 x 3,0 | EBW36 | 5     | B4061 | 366,00 |
| M 36 x 4,0 | EBW36 | 5     | B0364 | 366,00 |
| M 39 x 2,0 | EBW39 | 5     | B0392 | 998,00 |
| M 39 x 4,0 | EBW39 | 5     | B0394 | 530,00 |
| M 42 x 2,0 | EBW42 | 5     | B0422 | 998,00 |
| M 42 x 3,0 | EBW42 | 5     | B0423 | 530,00 |
| M 42 x 4,0 | EBW42 | 5     | B0424 | 998,00 |



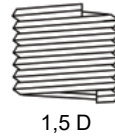


## BaerCoil® Thread Repair Kits

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

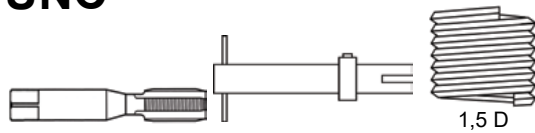


| UNC |           |       |       | 1,5 D   | No. | €            |
|-----|-----------|-------|-------|---------|-----|--------------|
| UNC | 2 x 56    | EBW01 | BZ001 | 2,3 mm  | 20  | B4100 66,00  |
| UNC | 3 x 48    | EBW02 | BZ002 | 2,6 mm  | 10  | B4348 66,00  |
| UNC | 4 x 40    | EBW03 | BZ003 | 3,0 mm  | 20  | B4101 28,00  |
| UNC | 5 x 40    | EBW03 | BZ003 | 3,4 mm  | 20  | B4106 28,00  |
| UNC | 6 x 32    | EBW03 | BZ003 | 3,7 mm  | 20  | B4102 28,00  |
| UNC | 8 x 32    | EBW04 | BZ004 | 4,5 mm  | 20  | B4103 28,00  |
| UNC | 10 x 24   | EBW04 | BZ004 | 5,2 mm  | 20  | B4104 28,00  |
| UNC | 12 x 24   | EBW05 | BZ005 | 5,8 mm  | 10  | B4105 28,00  |
| UNC | 1/4 x 20  | EBW06 | BZ006 | 6,7 mm  | 20  | B4107 24,00  |
| UNC | 5/16 x 18 | EBW07 | BZ006 | 8,3 mm  | 20  | B4108 28,40  |
| UNC | 3/8 x 16  | EBW08 | BZ008 | 9,9 mm  | 15  | B4109 31,40  |
| UNC | 7/16 x 14 | EBW10 | BZ010 | 11,6 mm | 10  | B4110 36,80  |
| UNC | 1/2 x 13  | EBW12 | BZ012 | 13,0 mm | 10  | B4111 39,80  |
| UNC | 9/16 x 12 | EBW14 |       |         | 10  | B4112 53,00  |
| UNC | 5/8 x 11  | EBW14 |       |         | 10  | B4113 156,00 |

## BaerCoil® Thread Repair Kits

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

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



| UNC |           |       |  | 1,5 D | No. | €             |
|-----|-----------|-------|--|-------|-----|---------------|
| UNC | 11/16x11  | EBW16 |  |       | 5   | B41116 280,00 |
| UNC | 3/4 x 10  | EBW18 |  |       | 5   | B4114 147,00  |
| UNC | 7/8 x 9   | EBW22 |  |       | 5   | B4115 179,00  |
| UNC | 1"x 8     | EBW24 |  |       | 5   | B4116 170,00  |
| UNC | 1.1/8 x 7 | EBW26 |  |       | 10  | B4117 399,00  |
| UNC | 1.1/4 x 7 | EBW30 |  |       | 10  | B4118 453,20  |
| UNC | 1.3/8 x 6 | EBW31 |  |       | 10  | B4119 543,40  |
| UNC | 1.1/2 x 6 | EBW36 |  |       | 10  | B4120 633,60  |

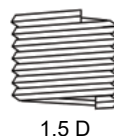


## BaerCoil® Thread Repair Kits

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



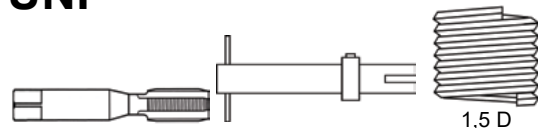
|     |           |       |       |         | No. | €             |
|-----|-----------|-------|-------|---------|-----|---------------|
| UNF | 2 x 64    | EBW01 | BZ001 | 2,3 mm  | 10  | B41201 115,80 |
| UNF | 3 x 56    | EBW02 | BZ002 | 2,6 mm  | 10  | B4356 115,80  |
| UNF | 4 x 48    | EBW03 | BZ003 | 3,0 mm  | 20  | B41202 27,10  |
| UNF | 6 x 40    | EBW03 | BZ003 | 3,7 mm  | 20  | B4121 27,10   |
| UNF | 8 x 36    | EBW04 | BZ004 | 4,4 mm  | 20  | B4122 27,10   |
| UNF | 10 x 32   | EBW05 | BZ005 | 5,1 mm  | 20  | B4123 27,10   |
| UNF | 1/4 x 28  | EBW06 | BZ006 | 6,6 mm  | 20  | B4125 32,30   |
| UNF | 5/16 x 24 | EBW07 | BZ006 | 8,2 mm  | 20  | B4126 39,30   |
| UNF | 3/8 x 24  | EBW08 | BZ008 | 9,8 mm  | 15  | B4127 31,50   |
| UNF | 7/16 x 20 | EBW10 | BZ010 | 11,5 mm | 10  | B4128 35,50   |
| UNF | 1/2 x 20  | EBW12 | BZ012 | 13,0 mm | 10  | B4129 39,00   |
| UNF | 9/16 x 18 | EBW14 |       |         | 10  | B4130 78,30   |
| UNF | 5/8 x 18  | EBW14 |       |         | 10  | B4131 103,50  |

\* prices on request

## BaerCoil® Thread Repair Kits

STI Bottoming Tap 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



|     |            |       |   | No.    | €      |
|-----|------------|-------|---|--------|--------|
| UNF | 3/4 x 16   | EBW20 | 5 | B4132  | 117,00 |
| UNF | 7/8 x 14   | EBW22 | 5 | B4133  | 137,00 |
| UNF | 1" x 12    | EBW24 | 5 | B4134  | 137,00 |
| UNF | 1" x 14    | EBW24 | 5 | B41351 | *      |
| UNF | 1.1/8 x 12 | EBW30 | 5 | B4137  | 392,90 |
| UNF | 1.1/4 x 12 | EBW31 | 5 | B4138  | 449,00 |
| UNF | 1.3/8 x 12 | EBW36 | 5 | B4139  | 534,40 |
| UNF | 1.1/2 x 12 | EBW39 | 5 | B4140  | 633,60 |



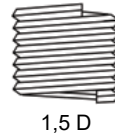


## BaerCoil® Thread Repair Kits

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



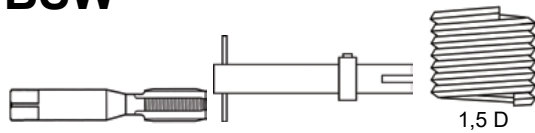
|               |       |       |         | 1,5 D | No.   | €      |
|---------------|-------|-------|---------|-------|-------|--------|
| BSW 1/8 x 40  | EBW03 | BZ003 | 3,4 mm  | 20    | B4141 | 55,90  |
| BSW 3/16 x 24 | EBW05 | BZ005 | 5,0 mm  | 20    | B4142 | 55,90  |
| BSW 1/4 x 20  | EBW06 | BZ006 | 6,7 mm  | 20    | B4143 | 49,90  |
| BSW 5/16 x 18 | EBW07 | BZ006 | 8,3 mm  | 20    | B4144 | 52,90  |
| BSW 3/8 x 16  | EBW08 | BZ008 | 9,9 mm  | 15    | B4145 | 57,70  |
| BSW 7/16 x 14 | EBW10 | BZ010 | 11,6 mm | 10    | B4146 | 63,40  |
| BSW 1/2 x 12  | EBW12 | BZ012 | 13,0 mm | 10    | B4147 | 68,00  |
| BSW 9/16 x 12 | EBW14 |       |         | 5     | B4148 | 114,00 |
| BSW 5/8 x 11  | EBW14 |       |         | 5     | B4149 | 114,90 |

\* prices on request

## BaerCoil® Thread Repair Kits

STI Bottoming Tap 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



|               |       |   |       | No.    | € |
|---------------|-------|---|-------|--------|---|
| BSW 11/16x11  | EBW16 | 5 | B4153 | *      |   |
| BSW 3/4 x10   | EBW18 | 5 | B4150 | 147,40 |   |
| BSW 7/8 x 9   | EBW22 | 5 | B4151 | 179,10 |   |
| BSW 1" x 8    | EBW24 | 4 | B4152 | 170,80 |   |
| BSW 1.1/8 x 7 | EBW26 | 5 | B4154 | *      |   |
| BSW 1.1/4 x 7 | EBW30 | 5 | B4155 | *      |   |
| BSW 1.3/8 x 6 | EBW31 | 5 | B4156 | *      |   |
| BSW 1.1/2 x 6 | EBW36 | 5 | B4157 | *      |   |

\* 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



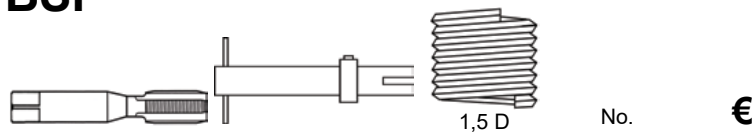
|               |       |       |         | 1,5 D | No.   | €      |
|---------------|-------|-------|---------|-------|-------|--------|
| BSF 3/16 x 32 | EBW04 | BZ004 | 5,0 mm  | 20    | B4162 | 55,90  |
| BSF 7/32 x 28 | EBW05 | BZ005 | 5,8 mm  | 10    | B4177 | *      |
| BSF 1/4 x 26  | EBW06 | BZ006 | 6,6 mm  | 20    | B4163 | 49,90  |
| BSF 9/32 x 26 | EBW06 | BZ006 | 7,3 mm  | 10    | B4178 | *      |
| BSF 5/16 x 22 | EBW07 | BZ008 | 8,3 mm  | 20    | B4165 | 52,90  |
| BSF 3/8 x 20  | EBW08 | BZ008 | 9,9 mm  | 15    | B4166 | 57,70  |
| BSF 7/16 x 18 | EBW10 | BZ010 | 11,5 mm | 10    | B4167 | 63,40  |
| BSF 1/2 x 16  | EBW12 | BZ012 | 13,0 mm | 10    | B4168 | 68,00  |
| BSF 9/16 x 16 | EBW14 |       |         | 5     | B4169 | 114,00 |
| BSF 5/8 x 14  | EBW14 |       |         | 5     | B4170 | 114,90 |

\* prices on request

## BaerCoil® Thread Repair Kits

STI Bottoming Tap 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



|               |       |  |  | No. | €     |        |
|---------------|-------|--|--|-----|-------|--------|
| BSF 11/16x 14 | EBW16 |  |  | 5   | B4171 | *      |
| BSF 3/4 x 12  | EBW18 |  |  | 5   | B4172 | 147,40 |
| BSF 13/16x 12 | EBW18 |  |  | 5   | B4173 | *      |
| BSF 7/8 x 11  | EBW22 |  |  | 5   | B4174 | 179,10 |
| BSF 1" x 10   | EBW24 |  |  | 4   | B4176 | 179,10 |
| BSF 1.1/8 x 9 | EBW30 |  |  | 5   | B4179 | *      |
| BSF 1.1/4 x 9 | EBW31 |  |  | 5   | B4180 | *      |
| BSF 1.3/8 x 8 | EBW36 |  |  | 5   | B4181 | *      |
| BSF 1.1/2 x 8 | EBW39 |  |  | 5   | B4182 | *      |

\* 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



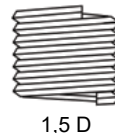
|   |            |       |       | 2,0 D   | No. | €            |
|---|------------|-------|-------|---------|-----|--------------|
| G | 1/8 x 28   | EBW10 | BZ010 | 9,9 mm  | 5   | B4190 51,40  |
| G | 1/4 x 19   | EBW12 | BZ012 | 13,5 mm | 5   | B4191 51,40  |
| G | 3/8 x 19   | EBW14 |       | 17,0 mm | 5   | B4192 58,90  |
| G | 1/2 x 14   | EBW22 |       |         | 5   | B4193 73,80  |
| G | 5/8 x 14   | EBW24 |       |         | 5   | B4194 159,00 |
| G | 3/4 x 14   | EBW26 |       |         | 5   | B4195 159,00 |
| G | 7/8 x 14   | EBW30 |       |         | 5   | B4196 235,00 |
| G | 1" x 11    | EBW36 |       |         | 5   | B4197 235,00 |
| G | 1.1/4 x 11 | EBW42 |       |         | 5   | B4198 *      |
| G | 1.1/2 x 11 | EBW50 |       |         | 5   | B4199 *      |

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

But the length of the thread insert is calculated with the value 25.4 mm:

e.g.: Length  $\geq$  D at G 1/4 x 19:  
 1/4 x 25.4 mm x 2 = **12.70 mm**

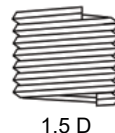
### BA British Association Standard Thread BS 93



|      |  |       |       | 1,5 D  | No. | €            |
|------|--|-------|-------|--------|-----|--------------|
| BA 0 |  | EBW06 | BZ006 | 6,2 mm | 10  | B4201 128,30 |
| BA 1 |  | EBW05 | BZ005 | 5,5 mm | 10  | B4202 128,30 |
| BA 2 |  | EBW05 | BZ005 | 4,9 mm | 10  | B4203 128,30 |
| BA 3 |  | EBW04 | BZ004 | 4,3 mm | 5   | B4204 *      |
| BA 4 |  | EBW03 | BZ003 | 3,8 mm | 5   | B4205 139,00 |
| BA 5 |  | EBW03 | BZ003 | 3,2 mm | 5   | B4206 *      |
| BA 6 |  | EBW02 | BZ002 | 2,9 mm | 5   | B4207 149,60 |

leading time: 1 - 3 weeks

### BSB British Standard Brass Thread



|     |           |       |       | 1,5 D   | No. | €            |
|-----|-----------|-------|-------|---------|-----|--------------|
| BSB | 1/4 x 26  | EBW06 | BZ006 | 6,6 mm  | 5   | B4208 222,40 |
| BSB | 5/16 x 26 | EBW07 | BZ006 | 8,2 mm  | 5   | B4209 222,40 |
| BSB | 3/8 x 26  | EBW08 | BZ008 | 9,8 mm  | 5   | B4210 222,40 |
| BSB | 7/16 x 26 | EBW10 | BZ010 | 11,5 mm | 5   | B4211 230,90 |
| BSB | 1/2 x 26  | EBW12 | BZ012 | 13,0 mm | 5   | B4212 258,80 |

leading time: 1 - 3 weeks

\* prices on request



A close-up photograph of a BaerCoil thread repair workshop kit. The kit is housed in a black plastic case with multiple compartments. The tools, which are made of metal, include various sizes of thread repair inserts, taps, and drill bits. The inserts are cylindrical with a threaded section. The taps are long, thin rods with a threaded end. The drill bits have a double-flute design. The tools are arranged in a neat, organized manner within the case. The lighting is bright, highlighting the metallic surfaces and the precision of the tools.


**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



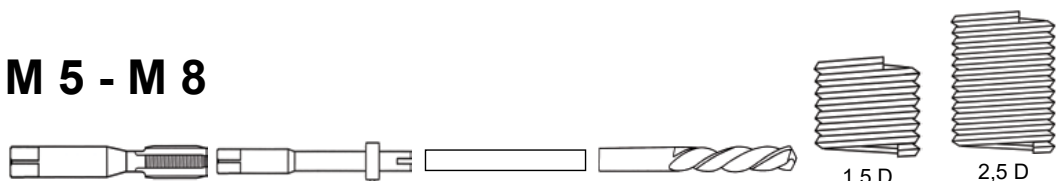
|             |       |       |         | 1,5 D | 2,5 D | No.   | €      |
|-------------|-------|-------|---------|-------|-------|-------|--------|
| M 3 x 0,5   | EBW03 | BZ003 | 3,2 mm  | 10    | 5     | B5101 | 154,20 |
| M 4 x 0,7   | EBW04 | BZ004 | 4,2 mm  | 10    | 5     |       |        |
| M 5 x 0,8   | EBW05 | BZ005 | 5,2 mm  | 10    | 5     |       |        |
| M 6 x 1,0   | EBW06 | BZ006 | 6,3 mm  | 10    | 5     |       |        |
| M 8 x 1,25  | EBW08 | BZ008 | 8,3 mm  | 10    | 5     |       |        |
| M 10 x 1,5  | EBW10 | BZ010 | 10,4 mm | 5     | 5     |       |        |
| M 12 x 1,75 | EBW12 | BZ012 | 12,4 mm | 5     | 5     |       |        |

### M 5 - M 12



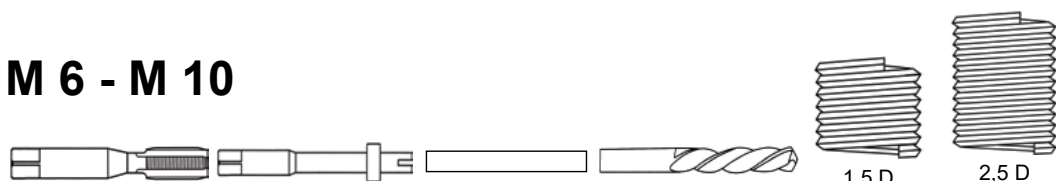
|             |       |       |         | 1,5 D | 2,5 D | No.   | €      |
|-------------|-------|-------|---------|-------|-------|-------|--------|
| M 5 x 0,8   | EBW05 | BZ005 | 5,2 mm  | 10    | 5     | B5104 | 117,50 |
| M 6 x 1,0   | EBW06 | BZ006 | 6,3 mm  | 10    | 5     |       |        |
| M 8 x 1,25  | EBW08 | BZ008 | 8,3 mm  | 10    | 5     |       |        |
| M 10 x 1,5  | EBW10 | BZ010 | 10,4 mm | 5     | 5     |       |        |
| M 12 x 1,75 | EBW12 | BZ012 | 12,4 mm | 5     | 5     |       |        |

### M 5 - M 8



|            |       |       |        | 1,5 D | 2,5 D | No.   | €     |
|------------|-------|-------|--------|-------|-------|-------|-------|
| M 5 x 0,8  | EBW05 | BZ005 | 5,2 mm | 10    | 5     | B5131 | 82,70 |
| M 6 x 1,0  | EBW06 | BZ006 | 6,3 mm | 10    | 5     |       |       |
| M 8 x 1,25 | EBW08 | BZ008 | 8,3 mm | 10    | 5     |       |       |

### M 6 - M 10

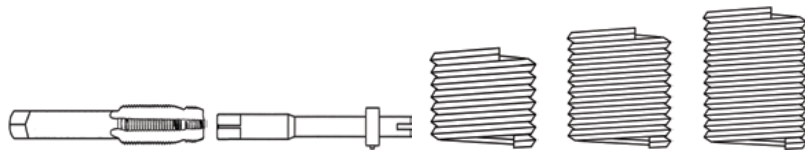


|            |       |       |         | 1,5 D | 2,5 D | No.   | €     |
|------------|-------|-------|---------|-------|-------|-------|-------|
| M 6 x 1,0  | EBW06 | BZ006 | 6,3 mm  | 10    | 5     | B5130 | 93,10 |
| M 8 x 1,25 | EBW08 | BZ008 | 8,3 mm  | 10    | 5     |       |       |
| M 10 x 1,5 | 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

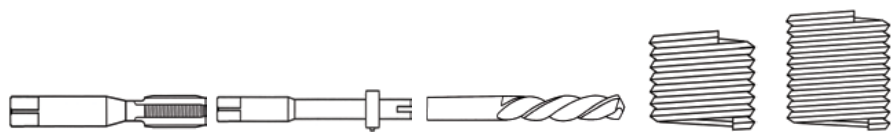


|             |       |        |         |         | No.   | €      |
|-------------|-------|--------|---------|---------|-------|--------|
| M 10 x 1,0  | EBW10 | 10 mm  | 15 mm   | 20 mm   | B5113 | 135,00 |
| M 12 x 1,25 | EBW12 | 5      | 5       | 5       |       |        |
| M 14 x 1,25 | EBW14 | 12 mm  | 18 mm   | 24 mm   |       |        |
|             |       | 8,4 mm | 12,4 mm | 16,4 mm |       |        |
|             |       | 5      | 5       | 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



|            |       |         |       |       | No.   | €      |
|------------|-------|---------|-------|-------|-------|--------|
| M 12 x 1,5 | EBW12 | 12,4 mm | 12 mm | 18 mm | B5157 | 124,50 |
| M 14 x 1,5 | EBW14 | 14,4 mm | 5     | 5     |       |        |
| M 16 x 1,5 | EBW14 |         | 14 mm | 21 mm |       |        |
|            |       |         | 5     | 5     |       |        |
|            |       |         | 16 mm | 24 mm |       |        |
|            |       |         | 5     | 5     |       |        |


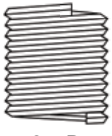


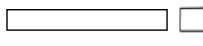



## BaerCoil® Thread Repair Workshop Kits

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






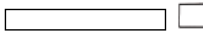



### M 6 - M 14 x 1,5<sup>2</sup>

|  |       |       |         |  |  | No.   | €      |
|--|-------|-------|---------|---|--|-------|--------|
|  <b>M 6 x 1,0</b>    | EBW06 | BZ006 | 6,3 mm  | 10  | 5  | B5116 | 145,00 |
|  <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 | 14 mm<br>5  | 21 mm<br>5   |       |        |






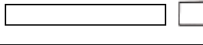

<sup>2</sup> for oil drain plug thread

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

|  |       |       |         |  |  |  | No.    | €            |
|--|-------|-------|---------|---|--|---|--------|--------------|
|  <b>M 6 x 1,0</b>    | EBW06 | BZ006 | 6,3 mm  | 10  | 5  | B5108   | 145,00 |              |
|  <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<br>5   | 12,4 mm<br>5   |   |        | 16,4 mm<br>5 |

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

### automotive - special

|  |       |       |         |  |  |  | No.    | €            |
|--|-------|-------|---------|---|--|---|--------|--------------|
|  <b>M 6 x 1,0</b>                | EBW06 | BZ006 | 6,3 mm  | 10  | 5  | B5109   | 197,10 |              |
|  <b>M 10 x 1,0<sup>1</sup></b>  | EBW10 |       |         | 10 mm<br>5  | 15 mm<br>5   |   |        | 20 mm<br>5   |
|  <b>M 12 x 1,25<sup>1</sup></b> | EBW12 | BZ012 | 12,4 mm | 12 mm<br>5  | 18 mm<br>5   |   |        | 24 mm<br>5   |
|  <b>M 12 x 1,5<sup>2</sup></b>  |       |       |         | 12 mm<br>5  | 18 mm<br>5   |   |        |              |
| <b>M 14 x 1,25<sup>1</sup></b>   | EBW14 |       | 14,4 mm | 8,4 mm<br>5   | 12,4 mm<br>5   |   |        | 16,4 mm<br>5 |
| <b>M 14 x 1,5<sup>2</sup></b>  |       |       |         | 14 mm<br>5  | 21 mm<br>5   |   |        |              |

<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

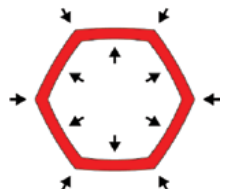
|             |       |       |         |    |       | No.    | € |
|-------------|-------|-------|---------|----|-------|--------|---|
| M 3 x 0,5   | EBW03 | BZ003 | 3,2 mm  | 20 | B5153 | 165,90 |   |
| M 4 x 0,7   | EBW04 | BZ004 | 4,2 mm  | 20 |       |        |   |
| M 5 x 0,8   | EBW05 | BZ005 | 5,2 mm  | 20 |       |        |   |
| M 6 x 1,0   | EBW06 | BZ006 | 6,3 mm  | 20 |       |        |   |
| M 8 x 1,25  | EBW08 | BZ008 | 8,3 mm  | 20 |       |        |   |
| M 10 x 1,5  | EBW10 | BZ010 | 10,4 mm | 10 |       |        |   |
| M 12 x 1,75 | EBW12 | BZ012 | 12,4 mm | 10 |       |        |   |

### M 5 - M 12

|             |       |       |         |    |       | No.    | € |
|-------------|-------|-------|---------|----|-------|--------|---|
| M 5 x 0,8   | EBW05 | BZ005 | 5,2 mm  | 20 | B5154 | 145,10 |   |
| M 6 x 1,0   | EBW06 | BZ006 | 6,3 mm  | 20 |       |        |   |
| M 8 x 1,25  | EBW08 | BZ008 | 8,3 mm  | 20 |       |        |   |
| M 10 x 1,5  | EBW10 | BZ010 | 10,4 mm | 10 |       |        |   |
| M 12 x 1,75 | 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

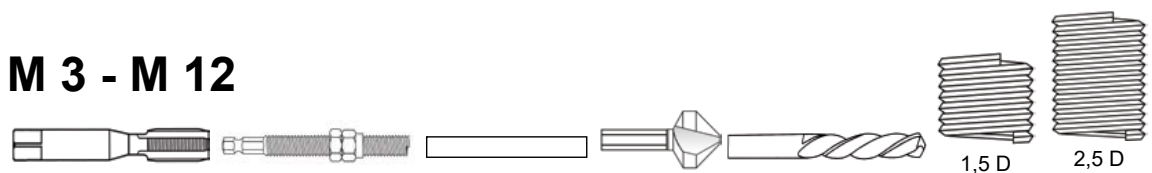


## BaerCoil® Thread Repair Workshop Kits - PRO

- 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

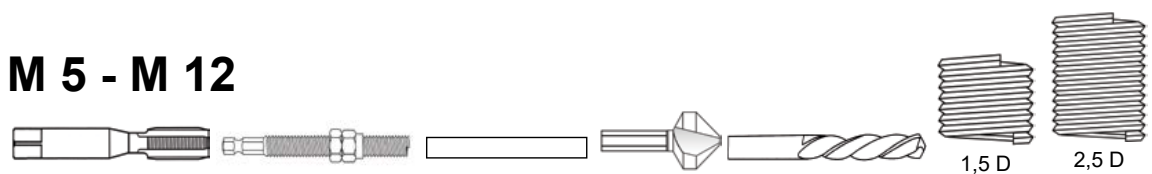


### M 3 - M 12



|             |        |       |         |         | 1,5 D | 2,5 D | No.   | €      |
|-------------|--------|-------|---------|---------|-------|-------|-------|--------|
| M 3 x 0,5   | KEBW03 | BZ003 |         | 3,2 mm  | 10    | 5     |       |        |
| M 4 x 0,7   | KEBW04 | BZ004 |         | 4,2 mm  | 10    | 5     |       |        |
| M 5 x 0,8   | KEBW05 | BZ005 | 10,4 mm | 5,2 mm  | 10    | 5     |       |        |
| M 6 x 1,0   | KEBW06 | BZ006 |         | 6,3 mm  | 10    | 5     | B5103 | 169,50 |
| M 8 x 1,25  | KEBW08 | BZ008 |         | 8,3 mm  | 10    | 5     |       |        |
| M 10 x 1,5  | KEBW10 | BZ010 | 16,5 mm | 10,4 mm | 5     | 5     |       |        |
| M 12 x 1,75 | KEBW12 | BZ012 |         | 12,4 mm | 5     | 5     |       |        |

### M 5 - M 12



|             |        |       |         |         | 1,5 D | 2,5 D | No.   | €      |
|-------------|--------|-------|---------|---------|-------|-------|-------|--------|
| M 5 x 0,8   | KEBW05 | BZ005 |         | 5,2 mm  | 10    | 5     |       |        |
| M 6 x 1,0   | KEBW06 | BZ006 | 10,4 mm | 6,3 mm  | 10    | 5     |       |        |
| M 8 x 1,25  | KEBW08 | BZ008 |         | 8,3 mm  | 10    | 5     | B5106 | 155,50 |
| M 10 x 1,5  | KEBW10 | BZ010 | 16,5 mm | 10,4 mm | 5     | 5     |       |        |
| M 12 x 1,75 | KEBW12 | BZ012 |         | 12,4 mm | 5     | 5     |       |        |


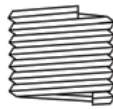


## BaerCoil® Thread Repair Workshop Kits

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


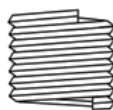


### UNC 1/4 - 1/2"


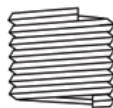
|               |       |       |         | 1,5 D | No.   | €      |
|---------------|-------|-------|---------|-------|-------|--------|
| UNC 1/4 x 20  | EBW06 | BZ006 | 6,7 mm  | 25    | B5120 | 157,00 |
| UNC 5/16 x 18 | EBW07 | BZ008 | 8,3 mm  | 25    |       |        |
| UNC 3/8 x 16  | EBW08 | 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    |       |        |

### UNF 1/4 - 1/2"


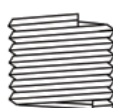
|               |       |       |         | 1,5 D | No.   | €      |
|---------------|-------|-------|---------|-------|-------|--------|
| UNF 1/4 x 28  | EBW06 | BZ006 | 6,6 mm  | 25    | B5121 | 157,00 |
| UNF 5/16 x 24 | EBW07 | BZ008 | 8,3 mm  | 25    |       |        |
| UNF 3/8 x 24  | EBW08 | 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    |       |        |

### BSW 1/4 - 1/2"

|               |       |       |         | 1,5 D | No.   | €      |
|---------------|-------|-------|---------|-------|-------|--------|
| BSW 1/4 x 20  | EBW06 | BZ006 | 6,7 mm  | 25    | B5122 | 157,00 |
| 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    |       |        |

### BSF 1/4 - 1/2"

|               |       |       |         | 1,5 D | No.   | €      |
|---------------|-------|-------|---------|-------|-------|--------|
| BSF 1/4 x 26  | EBW06 | BZ006 | 6,6 mm  | 25    | B5123 | 157,00 |
| 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    |       |        |

## 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

|                  |       |       |         |   | No.   | €      |
|------------------|-------|-------|---------|---|-------|--------|
| G (BSP) 1/8 x 28 | EBW10 | BZ010 | 10,0 mm | 5 | B5124 | 240,00 |
| G (BSP) 1/4 x 19 | EBW12 | BZ012 | 13,5 mm | 5 |       |        |
| G (BSP) 3/8 x 19 | EBW14 |       | 17,0 mm | 5 |       |        |
| G (BSP) 1/2 x 14 | EBW22 |       |         | 5 |       |        |

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

However, the length of the thread insert is calculated with the value 25.4 mm:

e.g.: length  $1.5 D$  at G 1/4 x 19:  
 $1/4 \times 25,4 \text{ mm} \times 1.5 = 9,525 \text{ mm}$

### BA British Association Standard Thread BS 93

|      |       |       |        |   | No.   | €      |
|------|-------|-------|--------|---|-------|--------|
| BA 0 | EBW06 | BZ006 | 6,2 mm | 5 | B5125 | 253,00 |
| BA 2 | EBW05 | BZ005 | 4,9 mm | 5 |       |        |
| BA 4 | EBW03 | BZ003 | 3,8 mm | 5 |       |        |
| BA 6 | EBW02 | BZ002 | 2,9 mm | 5 |       |        |

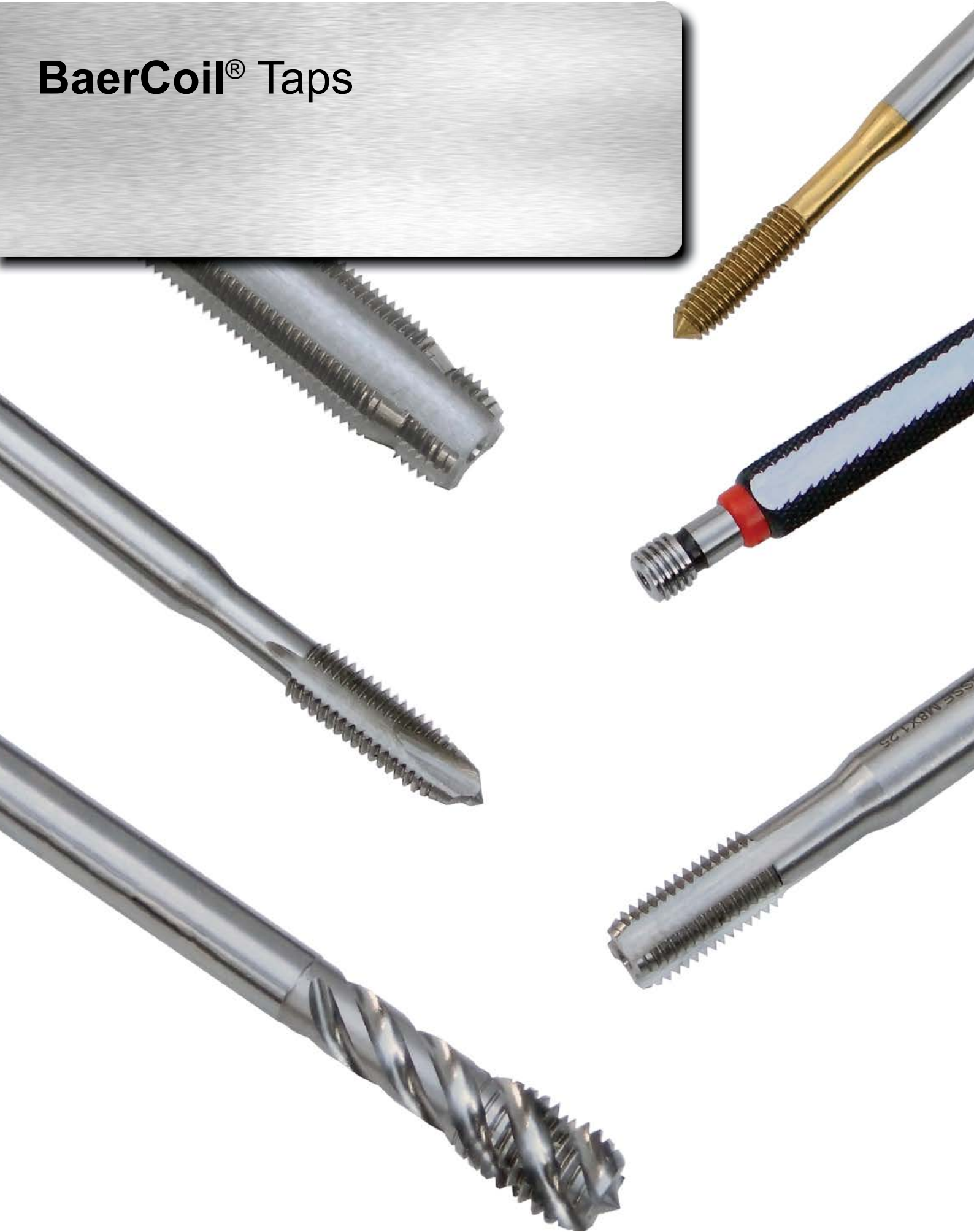
leading time: 1 - 3 weeks

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

|              |       |   |       |        | No. | € |
|--------------|-------|---|-------|--------|-----|---|
| NPT 1/8 x 27 | EBW10 | 5 | B5126 | 418,00 |     |   |
| NPT 1/4 x 19 | EBW14 | 5 |       |        |     |   |
| NPT 3/8 x 18 | EBW14 | 5 |       |        |     |   |
| NPT 1/2 x 14 | EBW22 | 5 |       |        |     |   |

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 Pine 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                 |

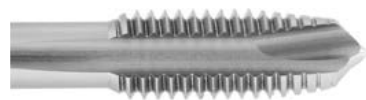
## Compatibility

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



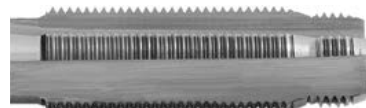
Bottoming tap  
chamfer: Form D (3-4 pitches)  
for through hole and blind hole



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

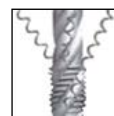


Machine tap  
chamfer: Form C (2-3 pitches)  
for blind hole



Tap with pilot nose  
for thread repair

### chip removal



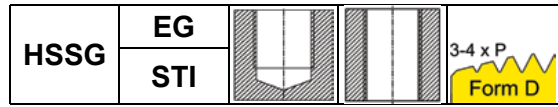
### hole type





## BaerCoil® Bottoming Taps for Wire Thread Inserts

Bottoming Taps can be used by hand or machine



works standard



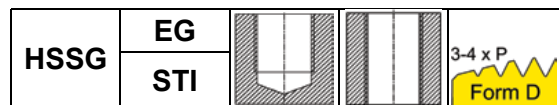
| M            | D1    | D2    | L1    | L2   | □    |      | No.   | €      |
|--------------|-------|-------|-------|------|------|------|-------|--------|
| M 2 x 0,4    | 2,52  | 2,80  | 44,5  | 9,5  | 2,24 | 2,1  | B3001 | 6,60   |
| M 2,2 x 0,45 | 2,79  | 3,15  | 48,0  | 11,0 | 2,50 | 2,3  | B3002 | 19,90  |
| M 2,5 x 0,45 | 3,09  | 3,15  | 48,0  | 11,0 | 2,50 | 2,6  | B3003 | 6,60   |
| M 3 x 0,5    | 3,65  | 4,00  | 53,0  | 13,0 | 3,15 | 3,2  | B3005 | 5,80   |
| M 3,5 x 0,6  | 4,28  | 4,50  | 53,0  | 13,0 | 3,55 | 3,7  | B3006 | 16,30  |
| M 4 x 0,7    | 4,91  | 5,00  | 58,0  | 16,0 | 4,00 | 4,2  | B3007 | 5,80   |
| M 5 x 0,8    | 6,04  | 6,3   | 66,0  | 19,0 | 5,00 | 5,3  | B3008 | 5,80   |
| M 6 x 0,75   | 6,98  | 8,00  | 72,0  | 22,0 | 6,30 | 6,2  | B3071 | 34,70  |
| M 6 x 1,0    | 7,30  | 8,00  | 72,0  | 22,0 | 6,30 | 6,3  | B3009 | 5,80   |
| M 7 x 1,0    | 8,30  | 9,00  | 72,0  | 22,0 | 7,10 | 7,3  | B3010 | 7,20   |
| M 8 x 0,75   | 8,90  | 9,60  | 77,0  | 33,0 | 7,20 | 8,2  | B3072 | 34,80  |
| M 8 x 1,0    | 9,30  | 10,00 | 80,0  | 24,0 | 8,00 | 8,3  | B3012 | 7,20   |
| M 8 x 1,25   | 9,62  | 10,00 | 80,0  | 24,0 | 8,00 | 8,3  | B3011 | 7,20   |
| M 9 x 1,0    | 10,30 | 8,20  | 90,0  | 35,0 | 6,10 | 9,3  | B3073 | 35,30  |
| M 9 x 1,25   | 10,62 | 8,00  | 85,0  | 25,0 | 6,30 | 9,3  | B3013 | 8,90   |
| M 10 x 1,0   | 11,30 | 8,00  | 85,0  | 25,0 | 6,30 | 10,3 | B3017 | 8,90   |
| M 10 x 1,25  | 11,62 | 8,00  | 85,0  | 25,0 | 6,30 | 10,3 | B3016 | 8,90   |
| M 10 x 1,5   | 11,95 | 9,00  | 89,0  | 29,0 | 7,10 | 10,4 | B3015 | 8,90   |
| M 11 x 1,0   | 12,25 | 9,30  | 86,0  | 42,0 | 6,90 | 11,3 | B3074 | 54,90  |
| M 11 x 1,25  | 12,62 | 9,00  | 89,0  | 29,0 | 7,10 | 11,3 | B3075 | 12,30  |
| M 11 x 1,5   | 12,95 | 9,00  | 89,0  | 29,0 | 7,10 | 11,4 | B3018 | 10,00  |
| M 12 x 1,0   | 13,30 | 10,90 | 91,0  | 42,0 | 8,10 | 12,3 | B3023 | 30,10  |
| M 12 x 1,25  | 13,62 | 11,20 | 95,0  | 30,0 | 9,00 | 12,3 | B3022 | 12,20  |
| M 12 x 1,5   | 13,95 | 11,20 | 95,0  | 30,0 | 9,00 | 12,4 | B3021 | 12,20  |
| M 12 x 1,75  | 14,27 | 11,20 | 95,0  | 30,0 | 9,00 | 12,4 | B3020 | 10,00  |
| M 13 x 1,25  | 14,62 | 11,30 | 95,0  | 32,0 | 8,90 | 13,4 | B3076 | 88,00  |
| M 13 x 1,5   | 14,95 | 12,50 | 102,0 | 32,0 | 11,2 | 13,4 | B3077 | 88,00  |
| M 13 x 1,75  | 15,25 | 12,50 | 102,0 | 32,0 | 11,2 | 13,4 | B3078 | 88,00  |
| M 14 x 1,0   | 15,30 | 12,50 | 102,0 | 32,0 | 10,0 | 14,4 | B3030 | 13,90  |
| M 14 x 1,25  | 15,57 | 12,5  | 102   | 32   | 10,0 | 14,4 | B3029 | 13,90  |
| M 14 x 1,5   | 15,95 | 12,5  | 102   | 32   | 10,0 | 14,5 | B3028 | 13,90  |
| M 14 x 2,0   | 16,60 | 12,5  | 102   | 32   | 10,0 | 14,5 | B3027 | 13,90  |
| M 15 x 1,5   | 16,95 | 12,5  | 102   | 32   | 10,0 | 15,5 | B3079 | 120,00 |
| M 15 x 2,0   | 17,60 | 14,0  | 112   | 37   | 11,2 | 15,5 | B3080 | 120,00 |
| M 16 x 1,5   | 17,95 | 14,0  | 104   | 29   | 11,2 | 16,5 | B3034 | 17,00  |
| M 16 x 2,0   | 18,60 | 14,0  | 112   | 37   | 11,2 | 16,5 | B3033 | 17,00  |

| M          | D1    | D2   | L1  | L2 | □    |      | No.   | €      |
|------------|-------|------|-----|----|------|------|-------|--------|
| M 18 x 1,5 | 19,95 | 14,0 | 104 | 29 | 11,2 | 18,5 | B3037 | 25,40  |
| M 18 x 2,0 | 20,60 | 16,6 | 113 | 51 | 12,4 | 18,5 | B3036 | 25,40  |
| M 18 x 2,5 | 21,25 | 16,0 | 118 | 38 | 12,5 | 18,5 | B3035 | 25,40  |
| M 20 x 1,5 | 21,95 | 16,0 | 113 | 33 | 12,5 | 20,5 | B3040 | 28,20  |
| M 20 x 2,0 | 22,60 | 16,0 | 113 | 33 | 12,5 | 20,5 | B3039 | 28,20  |
| M 20 x 2,5 | 23,25 | 16,0 | 118 | 38 | 12,5 | 20,5 | B3038 | 28,20  |
| M 22 x 1,5 | 23,95 | 19,3 | 124 | 58 | 14,4 | 22,5 | B3043 | 32,50  |
| M 22 x 2,0 | 24,60 | 20,3 | 130 | 64 | 15,2 | 22,5 | B3042 | 32,50  |
| M 22 x 2,5 | 25,25 | 20,3 | 130 | 64 | 15,2 | 22,5 | B3041 | 32,50  |
| M 24 x 1,5 | 26,02 | 18,0 | 120 | 35 | 14,0 | 24,5 | B3046 | 50,00  |
| M 24 x 2,0 | 26,60 | 20,0 | 127 | 37 | 16,0 | 24,5 | B3045 | 50,00  |
| M 24 x 3,0 | 27,90 | 23,0 | 138 | 66 | 17,0 | 24,5 | B3044 | 50,00  |
| M 26 x 1,5 | 27,95 | 20,0 | 127 | 37 | 16,0 | 26,5 | B3049 | 134,70 |
| M 27 x 1,5 | 28,95 | 20,0 | 127 | 37 | 16,0 | 27,5 | B3052 | 134,70 |
| M 27 x 2,0 | 29,60 | 20,0 | 127 | 37 | 16,0 | 27,5 | B3051 | 134,70 |
| M 27 x 3,0 | 30,90 | 22,4 | 151 | 51 | 18,0 | 27,5 | B3050 | 134,70 |
| M 28 x 1,5 | 29,95 | 20,0 | 127 | 37 | 16,0 | 28,5 | B3053 | 134,70 |
| M 30 x 1,5 | 31,95 | 22,4 | 137 | 37 | 18,0 | 30,5 | B3056 | 176,50 |
| M 30 x 2,0 | 32,60 | 22,4 | 137 | 37 | 18,0 | 30,5 | B3055 | 176,50 |
| M 30 x 3,0 | 33,90 | 22,4 | 137 | 37 | 18,0 | 30,5 | B3081 | 600,00 |
| M 30 x 3,5 | 34,55 | 25,0 | 162 | 57 | 20,0 | 30,5 | B3054 | 176,50 |
| M 33 x 2,0 | 35,60 | 25,0 | 144 | 37 | 20,0 | 33,5 | B3058 | 183,20 |
| M 33 x 3,5 | 37,55 | 25,0 | 162 | 57 | 20,0 | 33,5 | B3057 | 183,20 |
| M 36 x 1,5 | 37,95 | 28,0 | 150 | 39 | 22,4 | 36,5 | B3063 | 204,20 |
| M 36 x 2,0 | 38,60 | 28,0 | 150 | 39 | 22,4 | 36,5 | B3062 | 204,20 |
| M 36 x 3,0 | 39,90 | 28,0 | 170 | 60 | 22,4 | 36,5 | B3061 | 204,20 |
| M 36 x 4,0 | 41,20 | 28,0 | 170 | 60 | 22,4 | 36,5 | B3060 | 204,20 |
| M 39 x 2,0 | 41,60 | 31,5 | 187 | 67 | 25,0 | 39,5 | B3066 | 950,00 |
| M 39 x 3,0 | 42,90 | 31,5 | 187 | 67 | 25,0 | 39,5 | B3065 | 300,00 |
| M 39 x 4,0 | 44,20 | 31,5 | 187 | 67 | 25,0 | 39,5 | B3064 | 330,00 |
| M 42 x 2,0 | 44,60 | 35,5 | 200 | 70 | 28,0 | 42,5 | B3070 | 450,00 |
| M 42 x 3,0 | 45,90 | 35,5 | 200 | 70 | 28,0 | 42,8 | B3069 | 450,00 |
| M 42 x 4,0 | 47,20 | 35,5 | 200 | 70 | 28,0 | 43,0 | B3068 | 450,00 |
| M 42 x 4,5 | 47,85 | 35,5 | 200 | 70 | 28,0 | 43,0 | B3067 | 450,00 |
| M 52 x 5,0 | 58,50 | 40,0 | 221 | 76 | 34,0 | 53,5 | B3082 | 730,00 |



# BaerCoil® Bottoming Taps for Wire Thread Inserts

Bottoming Taps can be used by hand or machine



works standard



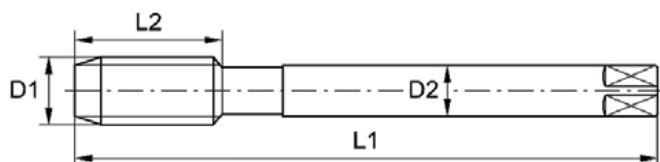
| UNC           | D1    | D2   | L1  | L2 | □     |       | No.   | €      |
|---------------|-------|------|-----|----|-------|-------|-------|--------|
| UNC 2 x 56    | 2,77  | 3,2  | 48  | 10 | 2,50  | 2,30  | B3100 | 9,20   |
| UNC 3 x 48    | 3,20  | 4,0  | 53  | 13 | 3,15  | 2,60  | B3121 | 56,00  |
| UNC 4 x 40    | 3,67  | 4,0  | 53  | 13 | 3,15  | 3,00  | B3101 | 9,00   |
| UNC 5 x 40    | 4,00  | 4,0  | 53  | 13 | 3,15  | 3,40  | B3102 | 9,00   |
| UNC 6 x 32    | 4,54  | 5,0  | 58  | 16 | 4,00  | 3,70  | B3103 | 9,00   |
| UNC 8 x 32    | 5,20  | 5,6  | 62  | 17 | 4,50  | 4,40  | B3104 | 9,00   |
| UNC 10 x 24   | 6,20  | 6,3  | 66  | 19 | 5,00  | 5,10  | B3105 | 9,00   |
| UNC 12 x 24   | 6,86  | 7,1  | 66  | 19 | 5,60  | 5,70  | B3106 | 9,00   |
| UNC 1/4 x 20  | 8,00  | 8,0  | 73  | 30 | 6,00  | 6,70  | B3107 | 5,90   |
| UNC 5/16 x 18 | 9,77  | 9,6  | 77  | 33 | 7,20  | 8,30  | B3108 | 6,50   |
| UNC 3/8 x 16  | 11,59 | 9,3  | 85  | 42 | 6,90  | 9,90  | B3109 | 6,80   |
| UNC 7/16 x 14 | 13,47 | 10,8 | 91  | 43 | 8,10  | 11,60 | B3110 | 9,10   |
| UNC 1/2 x 13  | 15,24 | 12,1 | 96  | 46 | 9,00  | 13,00 | B3111 | 10,40  |
| UNC 9/16 x 12 | 17,03 | 14,0 | 112 | 37 | 11,20 | 14,80 | B3112 | 17,40  |
| UNC 5/8 x 11  | 18,87 | 14,0 | 112 | 37 | 11,20 | 16,50 | B3113 | 21,40  |
| UNC 11/16x11  | 20,50 | 14,0 | 112 | 37 | 11,20 | 18,50 | B3122 | 266,90 |
| UNC 3/4 x 10  | 22,35 | 16,0 | 118 | 38 | 12,50 | 19,75 | B3114 | 26,00  |
| UNC 7/8 x 9   | 25,89 | 18,0 | 130 | 45 | 14,00 | 23,00 | B3115 | 37,50  |
| UNC 1" x 8    | 29,52 | 20,0 | 138 | 48 | 16,00 | 26,25 | B3116 | 37,50  |
| UNC 1.1/8 x 7 | 33,29 | 22,4 | 151 | 51 | 18,0  | 29,5  | B3117 | 127,00 |
| UNC 1.1/4 x 7 | 36,46 | 25,0 | 162 | 57 | 20,0  | 33,0  | B3118 | 152,50 |
| UNC 1.3/8 x 6 | 40,42 | 28,0 | 170 | 60 | 22,4  | 36,0  | B3119 | 182,00 |
| UNC 1.1/2 x 6 | 43,60 | 31,5 | 187 | 67 | 25,0  | 39,0  | B3120 | 244,00 |

| UNF            | D1    | D2    | L1  | L2 | □     |      | No.   | €      |
|----------------|-------|-------|-----|----|-------|------|-------|--------|
| UNF 3 x 56     | 3,10  | 4,00  | 53  | 13 | 3,15  | 2,6  | B3150 | 55,30  |
| UNF 4 x 48     | 3,53  | 4,00  | 53  | 13 | 3,15  | 3,0  | B3151 | 9,00   |
| UNF 6 x 40     | 4,33  | 4,50  | 53  | 13 | 3,55  | 3,7  | B3152 | 9,00   |
| UNF 8 x 36     | 5,08  | 5,60  | 62  | 17 | 4,50  | 4,4  | B3153 | 9,00   |
| UNF 10 x 32    | 5,86  | 6,30  | 66  | 19 | 5,00  | 5,1  | B3154 | 9,00   |
| UNF 1/4 x 28   | 7,53  | 8,00  | 73  | 30 | 6,00  | 6,6  | B3155 | 5,90   |
| UNF 5/16 x 24  | 9,31  | 9,60  | 78  | 33 | 7,20  | 8,2  | B3156 | 6,50   |
| UNF 3/8 x 24   | 10,90 | 8,10  | 80  | 36 | 6,10  | 9,8  | B3157 | 6,70   |
| UNF 7/16 x 20  | 12,76 | 9,25  | 84  | 43 | 6,90  | 11,5 | B3158 | 9,00   |
| UNF 1/2 x 20   | 14,35 | 10,80 | 91  | 43 | 8,10  | 13,0 | B3159 | 10,20  |
| UNF 9/16 x 18  | 16,12 | 12,50 | 104 | 29 | 10,00 | 14,8 | B3160 | 17,20  |
| UNF 5/8 x 18   | 17,71 | 14,00 | 104 | 29 | 11,20 | 16,3 | B3161 | 21,20  |
| UNF 3/4 x 16   | 21,11 | 14,00 | 104 | 29 | 11,20 | 19,5 | B3162 | 26,00  |
| UNF 7/8 x 14   | 24,58 | 18,00 | 120 | 35 | 14,00 | 22,8 | B3163 | 37,50  |
| UNF 1" x 12    | 28,15 | 20,00 | 127 | 37 | 16,00 | 26,0 | B3164 | 37,50  |
| UNF 1" x 14    | 27,80 | 20,00 | 127 | 37 | 16,00 | 26,0 | B3165 | 38,00  |
| UNF 1.1/8 x 12 | 31,32 | 22,4  | 137 | 37 | 18,0  | 29,0 | B3166 | 234,20 |
| UNF 1.1/4 x 12 | 34,50 | 25,0  | 144 | 39 | 20,0  | 32,5 | B3167 | 281,10 |
| UNF 1.3/8 x 12 | 37,68 | 28,0  | 150 | 39 | 22,4  | 35,5 | B3168 | 351,50 |
| UNF 1.1/2 x 12 | 40,85 | 28,0  | 150 | 39 | 22,4  | 38,5 | B3169 | 390,00 |

| BA   | D1   | D2  | L1 | L2 | □   |     | No.   | €     |
|------|------|-----|----|----|-----|-----|-------|-------|
| BA 0 | 7,12 | 7,1 | 66 | 19 | 5,6 | 6,2 | B3321 | 14,00 |
| BA 1 | 6,33 | 6,3 | 66 | 19 | 5,0 | 5,5 | B3322 | 73,00 |
| BA 2 | 5,61 | 6,3 | 66 | 19 | 5,0 | 4,9 | B3323 | 14,00 |
| BA 3 | 4,92 | 5,0 | 58 | 16 | 4,0 | 4,2 | B3324 | 90,00 |
| BA 4 | 4,35 | 4,5 | 53 | 13 | 3,6 | 3,8 | B3325 | 14,00 |
| BA 5 | 3,87 | 4,0 | 53 | 13 | 3,2 | 3,3 | B3326 | 90,00 |
| BA 6 | 3,40 | 3,6 | 50 | 13 | 2,8 | 2,9 | B3327 | 14,00 |

| G (BSP)      | D1    | D2   | L1  | L2 | □    |      | No.   | €      |
|--------------|-------|------|-----|----|------|------|-------|--------|
| G 1/8 x 28   | 10,82 | 8,0  | 59  | 15 | 6,3  | 10,0 | B3311 | 8,70   |
| G 1/4 x 19   | 14,74 | 11,2 | 67  | 19 | 9,0  | 13,5 | B3312 | 11,00  |
| G 3/8 x 19   | 18,25 | 14,0 | 75  | 21 | 11,2 | 17,0 | B3313 | 14,30  |
| G 1/2 x 14   | 23,09 | 16,0 | 87  | 26 | 12,5 | 21,5 | B3314 | 23,30  |
| G 5/8 x 14   | 25,05 | 18,0 | 91  | 26 | 14,0 | 23,5 | B3315 | 34,30  |
| G 3/4 x 14   | 28,59 | 20,0 | 96  | 28 | 16,0 | 27,0 | B3316 | 34,30  |
| G 7/8 x 14   | 32,35 | 22,4 | 102 | 29 | 18,0 | 30,5 | B3318 | 198,00 |
| G 1" x 11    | 35,96 | 25,0 | 109 | 33 | 20,0 | 33,5 | B3317 | 54,60  |
| G 1.1/4 x 11 | 44,63 | 36,0 | 125 | 40 | 29,0 | 42,5 | B3319 | *      |
| G 1.1/2 x 11 | 50,53 | 36,0 | 140 | 40 | 29,0 | 48,5 | B3320 | *      |

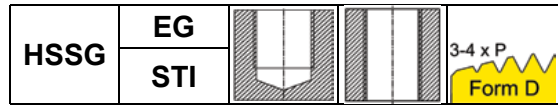
\* prices on request





# BaerCoil® Bottoming Taps for Wire Thread Inserts

Bottoming Taps can be used by hand or machine



works standard



| BSW           | D1    | D2   | L1  | L2 | □     |       | No.   | €      |
|---------------|-------|------|-----|----|-------|-------|-------|--------|
| BSW 1/8 x 40  | 3,93  | 4,0  | 53  | 13 | 3,15  | 3,40  | B3201 | 13,70  |
| BSW 3/16 x 24 | 6,01  | 6,3  | 56  | 19 | 6,00  | 5,10  | B3202 | 13,70  |
| BSW 1/4 x 20  | 7,84  | 8,0  | 72  | 22 | 7,20  | 6,70  | B3203 | 13,70  |
| BSW 5/16 x 18 | 9,59  | 10,0 | 80  | 24 | 6,90  | 8,30  | B3204 | 13,70  |
| BSW 3/8 x 16  | 11,39 | 8,0  | 85  | 25 | 8,10  | 9,90  | B3205 | 13,70  |
| BSW 7/16 x 14 | 13,24 | 11,2 | 95  | 30 | 9,00  | 11,60 | B3206 | 13,70  |
| BSW 1/2 x 12  | 15,17 | 12,5 | 102 | 32 | 10,00 | 13,00 | B3207 | 13,70  |
| BSW 9/16 x 12 | 16,76 | 12,5 | 102 | 32 | 10,00 | 14,80 | B3208 | 39,10  |
| BSW 5/8 x 11  | 18,57 | 14,0 | 112 | 37 | 11,20 | 16,70 | B3209 | 48,30  |
| BSW 11/16x11  | 20,20 | 14,0 | 112 | 37 | 11,20 | 18,50 | B3210 | 58,60  |
| BSW 3/4 x 10  | 22,02 | 16,0 | 118 | 38 | 12,50 | 20,00 | B3211 | 58,60  |
| BSW 7/8 x 9   | 25,52 | 18,0 | 130 | 45 | 14,00 | 23,00 | B3212 | 68,30  |
| BSW 1" x 8    | 29,10 | 20,0 | 138 | 48 | 16,00 | 26,50 | B3213 | 68,30  |
| BSW 1.1/8 x 7 | 32,80 | 22,4 | 151 | 51 | 18,00 | 29,50 | B3214 | 448,00 |
| BSW 1.1/4 x 7 | 35,97 | 25,0 | 162 | 57 | 20,00 | 33,00 | B3215 | 572,00 |
| BSW 1.3/8 x 6 | 39,88 | 28,0 | 170 | 60 | 22,40 | 36,00 | B3216 | 725,00 |
| BSW 1.1/2 x 6 | 43,02 | 31,5 | 187 | 67 | 25,00 | 39,00 | B3217 | 743,50 |

| BSF           | D1    | D2   | L1  | L2 | □    |      | No.   | €      |
|---------------|-------|------|-----|----|------|------|-------|--------|
| BSF 3/16 x 32 | 5,71  | 6,3  | 66  | 19 | 5,0  | 5,0  | B3251 | 13,70  |
| BSF 7/32 x 28 | 6,63  | 7,1  | 66  | 19 | 5,6  | 5,8  | B3269 | *      |
| BSF 1/4 x 26  | 7,51  | 8,0  | 72  | 22 | 6,3  | 6,6  | B3253 | 13,70  |
| BSF 9/32 x 26 | 8,31  | 9,0  | 72  | 22 | 7,1  | 7,3  | B3270 | *      |
| BSF 5/16 x 22 | 9,30  | 10,0 | 80  | 24 | 8,0  | 8,3  | B3255 | 13,70  |
| BSF 3/8 x 20  | 11,02 | 8,0  | 85  | 25 | 6,3  | 9,9  | B3256 | 13,70  |
| BSF 7/16 x 18 | 12,78 | 9,0  | 89  | 29 | 7,1  | 11,6 | B3257 | 13,70  |
| BSF 1/2 x 16  | 14,57 | 11,2 | 95  | 30 | 9,0  | 13,0 | B3258 | 13,70  |
| BSF 9/16 x 16 | 16,16 | 12,5 | 102 | 32 | 10,0 | 14,8 | B3259 | 39,10  |
| BSF 5/8 x 14  | 18,01 | 14,0 | 112 | 37 | 11,2 | 16,4 | B3260 | 48,30  |
| BSF 11/16x 14 | 19,60 | 14,0 | 112 | 37 | 11,2 | 18,0 | B3261 | 58,60  |
| BSF 3/4 x 12  | 21,53 | 16,0 | 118 | 38 | 12,5 | 19,5 | B3262 | 58,60  |
| BSF 13/16x 12 | 23,12 | 16,0 | 118 | 38 | 12,5 | 21,0 | B3271 | *      |
| BSF 7/8 x 11  | 24,94 | 18,0 | 130 | 45 | 14,0 | 22,7 | B3264 | 68,30  |
| BSF 1" x 10   | 28,38 | 20,0 | 138 | 48 | 16,0 | 26,5 | B3265 | 68,30  |
| BSF 1.1/8 x 9 | 31,88 | 22,4 | 137 | 37 | 18,0 | 29,5 | B3265 | 68,30  |
| BSF 1.1/4 x 9 | 35,06 | 25,0 | 144 | 39 | 20,0 | 32,5 | B3266 | 686,30 |
| BSF 1.3/8 x 8 | 38,64 | 28,0 | 150 | 39 | 22,4 | 36,0 | B3267 | *      |
| BSF 1.1/2 x 8 | 41,82 | 28,0 | 150 | 39 | 22,4 | 39,0 | B3268 | *      |

| BSB           | D1   | D2   | L1 | L2 | □   |      | No.   | €     |
|---------------|------|------|----|----|-----|------|-------|-------|
| BSB 1/4 x 26  | 7,5  | 8,0  | 69 | 19 | 6,3 | 6,5  | B3341 | 13,70 |
| BSB 5/16 x 26 | 9,1  | 10,0 | 76 | 20 | 8,0 | 8,2  | B3342 | 14,80 |
| BSB 3/8 x 26  | 10,7 | 8,0  | 82 | 22 | 6,3 | 9,8  | B3343 | 15,50 |
| BSB 7/16 x 26 | 12,3 | 9,0  | 84 | 24 | 7,1 | 11,5 | B3344 | 20,70 |
| BSB 1/2 x 26  | 13,9 | 11,2 | 90 | 25 | 9,0 | 12,8 | B3345 | 23,50 |

| BSC           | D1   | D2   | L1 | L2 | □   |      | No.   | €      |
|---------------|------|------|----|----|-----|------|-------|--------|
| BSC 5/16 x 26 | 9,1  | 10,0 | 76 | 20 | 8,0 | 8,2  | B3331 | 72,50  |
| BSC 3/8 x 26  | 10,7 | 8,0  | 82 | 22 | 6,3 | 9,8  | B3332 | 103,00 |
| BSC 7/16 x 26 | 12,3 | 9,0  | 84 | 24 | 7,1 | 11,5 | B3333 | 125,90 |
| BSC 1/2 x 26  | 13,9 | 11,2 | 90 | 25 | 9,0 | 12,8 | B3334 | 162,00 |

| special sizes       | D1   | D2   | L1  | L2 | □    |      | No.   | €      |
|---------------------|------|------|-----|----|------|------|-------|--------|
| UNEF 1/4 x 32       | 7,3  | 8,0  | 69  | 19 | 6,3  | 6,5  | B3350 | 74,00  |
| Harley 1/4 x 24     | 7,8  | 8,0  | 69  | 29 | 6,3  | 6,5  | B3351 | 41,50  |
| Harley 7/16 x 16    | 13,2 | 10,8 | 91  | 42 | 8,2  | 11,5 | B3352 | 41,50  |
| Cummins 11/16x16    |      | 14,0 | 112 | 37 | 14,0 | 18,0 | B3353 | 276,40 |
| Carburetor 7/8 x 20 |      | 18,0 | 120 | 35 | 14,0 | 22,5 | B3354 | 362,20 |
| Carburetor 1" x 20  |      | 20,0 | 127 | 37 | 16,0 | 26,0 | B3355 | 457,50 |

| NPT           | D1 | D2 | L1  | L2 | □    |      | No.   | €      |
|---------------|----|----|-----|----|------|------|-------|--------|
| NPT 1/8 x 27  |    | 7  | 65  | 19 | 5,5  | 9,9  | B3370 | 219,20 |
| NPT 1/4 x 19  |    | 11 | 70  | 25 | 9,0  | 13,5 | B3371 | 244,00 |
| NPT 3/8 x 18  |    | 12 | 75  | 26 | 9,0  | 17,0 | B3372 | 335,50 |
| NPT 1/2 x 14  |    | 16 | 80  | 31 | 12,0 | 21,5 | B3373 | 448,00 |
| NPT 3/4 x 14  |    | 20 | 100 | 33 | 16,0 | 27,0 | B3374 | 528,10 |
| NPT 1" x 11,5 |    | 25 | 110 | 38 | 20,0 | 33,5 | B3375 | 735,90 |

| 8 - UN    | D1 | D2   | L1  | L2 | □    |      | No.   | €       |
|-----------|----|------|-----|----|------|------|-------|---------|
| 1.1/8 x 8 |    | 20,0 | 138 | 59 | 16,0 | 28,5 | B3360 | 531,90  |
| 1.1/4 x 8 |    | 22,4 | 151 | 51 | 18,0 | 32,0 | B3361 | 655,80  |
| 1.3/8 x 8 |    | 25,0 | 162 | 57 | 20,0 | 35,0 | B3362 | 783,90  |
| 1.1/2 x 8 |    | 28,0 | 170 | 60 | 22,4 | 38,0 | B3363 | 817,90  |
| 1.5/8 x 8 |    | 28,0 | 170 | 60 | 22,4 | 41,0 | B3364 | 972,50  |
| 1.3/4 x 8 |    | 31,5 | 187 | 67 | 25,0 | 44,5 | B3365 | 1130,50 |
| 1.7/8 x 8 |    | 31,5 | 187 | 67 | 25,0 | 47,5 | B3366 | 1229,90 |
| 2" x 8    |    | 35,5 | 200 | 70 | 28,0 | 51,0 | B3367 | 1344,00 |




\* prices on request



## BaerCoil® Taps with pilot nose

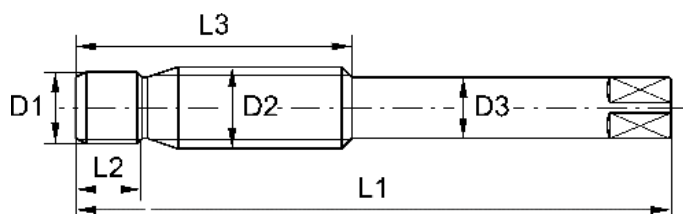
|      |     |                |
|------|-----|----------------|
| HSSG | EG  | works standard |
|      | STI |                |



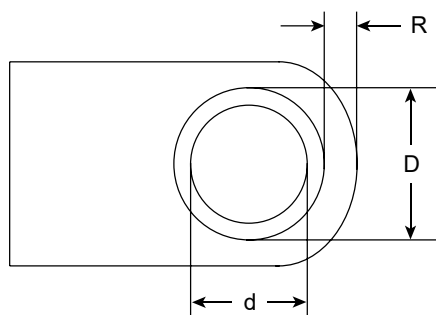
| M            | D1   | D2    | D3   | L1  | L2 | □  |  | No.   | €     |
|--------------|------|-------|------|-----|----|----|---|-------|-------|
| M 6 x 1,0    | 6,0  | 7,30  | 8,0  | 70  | 8  | 28 | 6,3   | B3630 | 12,00 |
| M 8 x 1,25   | 8,0  | 9,62  | 8,0  | 75  | 8  | 32 | 6,3   | B3631 | 13,00 |
| M 10 x 1,0*  | 10,0 | 11,30 | 8,0  | 73  | 8  | 32 | 6,3   | B3632 | 16,20 |
| M 10 x 1,5   | 10,0 | 11,95 | 9,0  | 80  | 9  | 37 | 7,1   | B3633 | 16,20 |
| M 12 x 1,25* | 12,0 | 13,62 | 11,0 | 81  | 8  | 33 | 9,0   | B3634 | 21,00 |
| M 14 x 1,25* | 14,0 | 15,57 | 12,5 | 90  | 8  | 48 | 10,0  | B3635 | 24,50 |
| M 18 x 1,5*  | 18,0 | 19,95 | 16,0 | 116 | 10 | 47 | 12,5  | B3636 | 37,00 |

\* 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

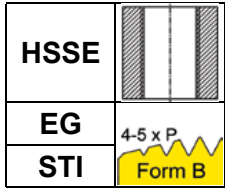
$$R (\text{min}) = 0,375 \times D$$

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 aluminium, cast and wrought alloys and the length of thread engagement of BaerCoil Wire Thread Insert of 1.5 D.

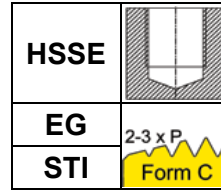


## BaerCoil® Machine taps - ECO for Wire Thread Inserts



through hole

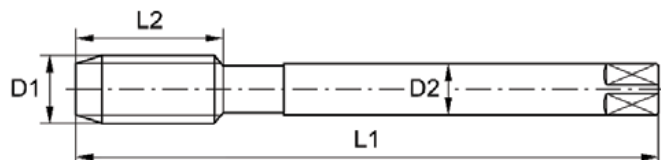
| M           | D1    | D2   | L1  | L2   |       |      | No.   | €     |
|-------------|-------|------|-----|------|-------|------|-------|-------|
| M 3 x 0,5   | 3,65  | 4,0  | 53  | 13,0 | 3,15  | 3,2  | B3505 | 10,80 |
| M 3,5 x 0,6 | 4,28  | 4,5  | 53  | 13,0 | 3,55  | 3,7  | B3506 | 10,80 |
| 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 |



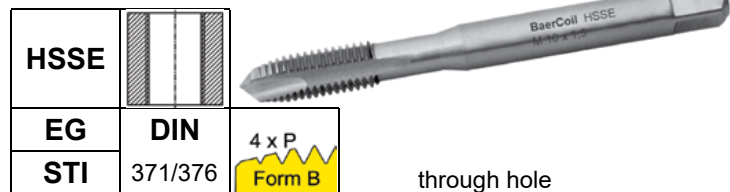
blind hole

| M           | D1    | D2   | L1   | L2   |       |      | 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 |     |      | No.   | €     |
|-----------|------|------|----|----|-----|------|-------|-------|
| 1/4 x 24  | 7,8  | 8,0  | 69 | 29 | 6,3 | 6,5  | B3351 | 41,50 |
| 7/16 x 16 | 13,2 | 10,8 | 91 | 42 | 8,2 | 11,5 | B3352 | 41,50 |

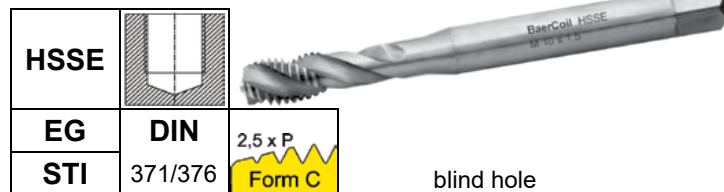


# BaerCoil® Machine taps - PRO for Wire Thread Inserts



through hole

| M            | D1    | D2   | L1  | L2   | □    |      | No.    | €      |
|--------------|-------|------|-----|------|------|------|--------|--------|
| M 2,5 x 0,45 | 3,09  | 3,5  | 56  | 11,0 | 2,7  | 2,6  | B3505P | 58,70  |
| M 3 x 0,5    | 3,65  | 4,5  | 63  | 10,0 | 3,4  | 3,2  | B3506P | 33,50  |
| M 4 x 0,7    | 4,91  | 6,0  | 70  | 13,0 | 4,9  | 4,2  | B3507P | 34,50  |
| M 5 x 0,8    | 6,04  | 6,0  | 80  | 13,0 | 4,9  | 5,3  | B3508P | 37,70  |
| M 6 x 1,0    | 7,30  | 8,0  | 90  | 17,0 | 6,2  | 6,3  | B3509P | 38,00  |
| M 8 x 1,25   | 9,62  | 10,0 | 100 | 18,0 | 8,0  | 8,3  | B3511P | 44,90  |
| M 10 x 1,5   | 11,95 | 9,0  | 110 | 22,0 | 7,0  | 10,4 | B3515P | 54,00  |
| M 12 x 1,75  | 14,27 | 11,0 | 110 | 26,0 | 9,0  | 12,4 | B3520P | 72,90  |
| M 16 x 2,0   | 18,60 | 14,0 | 125 | 27,0 | 11,0 | 16,5 | B3527P | 140,00 |
| M 20 x 2,5   | 23,25 | 18,0 | 160 | 34,0 | 14,5 | 20,5 | B3533P | 215,00 |



blind hole

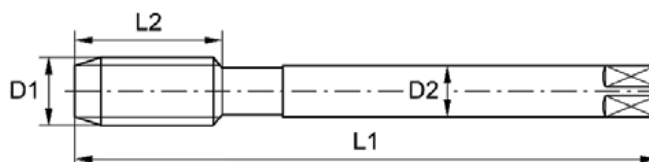
| M            | D1    | D2   | L1  | L2   | □    |      | No.    | €      |
|--------------|-------|------|-----|------|------|------|--------|--------|
| M 2,5 x 0,45 | 3,09  | 3,5  | 56  | 6,0  | 2,7  | 2,6  | B3703P | 61,95  |
| M 3 x 0,5    | 3,65  | 4,5  | 63  | 6,0  | 3,4  | 3,2  | B3705P | 44,10  |
| M 4 x 0,7    | 4,91  | 6,0  | 70  | 8,0  | 4,9  | 4,2  | B3707P | 36,40  |
| M 5 x 0,8    | 6,04  | 6,0  | 80  | 8,0  | 4,9  | 5,3  | B3708P | 37,60  |
| M 6 x 1,0    | 7,30  | 8,0  | 90  | 10,0 | 6,2  | 6,3  | B3709P | 37,60  |
| M 8 x 1,25   | 9,62  | 10,0 | 100 | 16,0 | 8,0  | 8,3  | B3711P | 47,25  |
| M 10 x 1,5   | 11,95 | 9,0  | 110 | 15,0 | 7,0  | 10,4 | B3715P | 56,60  |
| M 12 x 1,75  | 14,27 | 11,0 | 110 | 20,0 | 9,0  | 12,4 | B3720P | 76,40  |
| M 16 x 2,0   | 18,60 | 14,0 | 125 | 22,0 | 11,0 | 16,5 | B3733P | 145,10 |
| M 20 x 2,5   | 23,25 | 18,0 | 160 | 30,0 | 14,5 | 20,5 | B3738P | 225,99 |

| UNC           | D1    | D2   | L1  | L2   | □    |       | No.    | €      |
|---------------|-------|------|-----|------|------|-------|--------|--------|
| UNC 4 x 40    | 3,67  | 4,5  | 63  | 13,0 | 3,4  | 3,0   | B3901P | 78,60  |
| UNC 6 x 32    | 4,54  | 6,0  | 70  | 14,0 | 4,9  | 3,7   | B3902P | 73,60  |
| UNC 10 x 24   | 6,20  | 7,0  | 80  | 17,0 | 5,5  | 5,1   | B3903P | 78,60  |
| UNC 1/4 x 20  | 8,00  | 8,0  | 90  | 20,0 | 6,2  | 6,7   | B3904P | 75,10  |
| UNC 5/16 x 18 | 9,77  | 10,0 | 100 | 22,0 | 8,0  | 8,3   | B3905P | 90,10  |
| UNC 3/8 x 16  | 11,59 | 12,0 | 110 | 21,0 | 9,0  | 9,9   | B3906P | 103,00 |
| UNC 7/16 x 14 | 13,47 | 11,0 | 110 | 26,0 | 9,0  | 11,6  | B3907P | 128,70 |
| UNC 1/2 x 13  | 15,24 | 12,0 | 110 | 27,0 | 9,0  | 13,0  | B3908P | 135,90 |
| UNC 9/16 x 12 | 17,03 | 14,0 | 125 | 26,0 | 11,0 | 14,8  | B3909P | 200,20 |
| UNC 5/8 x 11  | 18,87 | 14,0 | 125 | 30,0 | 11,0 | 16,5  | B3910P | 180,20 |
| UNC 3/4 x 10  | 22,35 | 18,0 | 140 | 32,0 | 14,5 | 19,75 | B3911P | 238,80 |

| UNC           | D1    | D2   | L1  | L2   | □    |       | No.    | €      |
|---------------|-------|------|-----|------|------|-------|--------|--------|
| UNC 4 x 40    | 3,67  | 4,5  | 63  | 7,0  | 3,4  | 3,0   | B3921P | 80,10  |
| UNC 6 x 32    | 4,54  | 6,0  | 70  | 8,0  | 4,9  | 3,7   | B3922P | 77,20  |
| UNC 8 x 32    | 5,20  | 6,0  | 80  | 8,0  | 4,9  | 4,4   | B3923P | 78,60  |
| UNC 10 x 24   | 6,20  | 7,0  | 80  | 10,0 | 5,5  | 5,1   | B3924P | 81,50  |
| UNC 1/4 x 20  | 8,00  | 8,0  | 90  | 14,0 | 6,2  | 6,7   | B3925P | 90,10  |
| UNC 5/16 x 18 | 9,77  | 10,0 | 100 | 16,0 | 8,0  | 8,3   | B3926P | 94,40  |
| UNC 3/8 x 16  | 11,59 | 12,0 | 110 | 16,0 | 9,0  | 9,9   | B3927P | 105,80 |
| UNC 7/16 x 14 | 13,47 | 11,0 | 110 | 20,0 | 9,0  | 11,6  | B3928P | 145,90 |
| UNC 1/2 x 13  | 15,24 | 12,0 | 110 | 22,0 | 9,0  | 13,0  | B3929P | 148,70 |
| UNC 9/16 x 12 | 17,03 | 14,0 | 125 | 22,0 | 11,0 | 14,8  | B3930P | 204,50 |
| UNC 5/8 x 11  | 18,87 | 14,0 | 125 | 25,0 | 11,0 | 16,5  | B3931P | 197,30 |
| UNC 3/4 x 10  | 22,35 | 18,0 | 140 | 27,0 | 14,5 | 19,75 | B3932P | 246,00 |

| UNF           | D1    | D2   | L1  | L2   | □   |      | No.    | €      |
|---------------|-------|------|-----|------|-----|------|--------|--------|
| UNF 4 x 48    | 3,53  | 4,0  | 56  | 12,0 | 3,0 | 3,0  | B3950P | 81,50  |
| UNF 6 x 40    | 4,33  | 6,0  | 70  | 14,0 | 4,9 | 3,7  | B3951P | 80,10  |
| UNF 8 x 36    | 5,08  | 6,0  | 70  | 13,0 | 4,9 | 4,4  | B3952P | 80,10  |
| UNF 10 x 32   | 5,86  | 6,0  | 80  | 13,0 | 4,9 | 5,1  | B3953P | 85,80  |
| UNF 1/4 x 28  | 7,53  | 8,0  | 90  | 17,0 | 6,2 | 6,6  | B3954P | 90,10  |
| UNF 5/16 x 24 | 9,31  | 10,0 | 100 | 18,0 | 8,0 | 8,2  | B3955P | 94,40  |
| UNF 3/8 x 24  | 10,90 | 12,0 | 110 | 18,0 | 9,0 | 9,8  | B3956P | 101,50 |
| UNF 7/16 x 20 | 12,76 |      | 100 | 22,0 |     | 11,5 | B3957P | 138,70 |
| UNF 1/2 x 20  | 14,35 |      | 100 | 22,0 |     | 13,0 | B3958P | 128,70 |
| UNF 9/16 x 18 | 16,12 |      | 100 | 22,0 |     | 14,8 | B3959P | 213,10 |
| UNF 5/8 x 18  | 17,71 |      | 110 | 25,0 |     | 16,3 | B3960P | 191,60 |
| UNF 3/4 x 16  | 21,11 |      | 125 | 25,0 |     | 19,5 | B3961P | 253,10 |

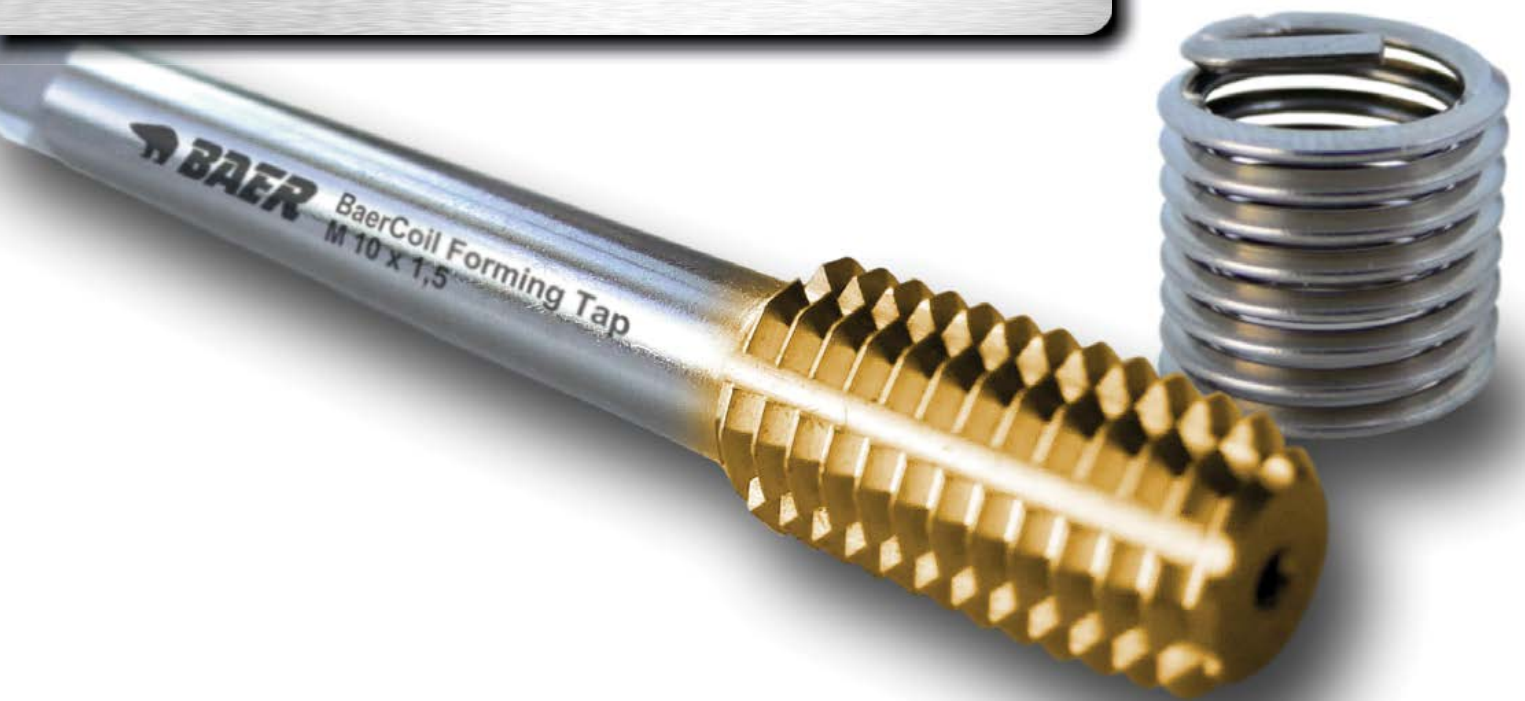
| UNF           | D1    | D2   | L1  | L2   | □   |      | No.    | €      |
|---------------|-------|------|-----|------|-----|------|--------|--------|
| UNF 4 x 48    | 3,53  | 4,0  | 56  | 7,0  | 3,0 | 3,0  | B3970P | 95,80  |
| UNF 6 x 40    | 4,33  | 6,0  | 70  | 8,0  | 4,9 | 3,7  | B3971P | 94,40  |
| UNF 8 x 36    | 5,08  | 6,0  | 70  | 8,0  | 4,9 | 4,4  | B3972P | 94,40  |
| UNF 10 x 32   | 5,86  | 6,0  | 80  | 8,0  | 4,9 | 5,1  | B3973P | 103,00 |
| UNF 1/4 x 28  | 7,53  | 8,0  | 90  | 10,0 | 6,2 | 6,6  | B3974P | 113,00 |
| UNF 5/16 x 24 | 9,31  | 10,0 | 100 | 10,0 | 8,0 | 8,2  | B3975P | 125,80 |
| UNF 3/8 x 24  | 10,90 | 12,0 | 110 | 11,0 | 9,0 | 9,8  | B3976P | 128,70 |
| UNF 7/16 x 20 | 12,76 |      | 100 | 13,0 |     | 11,5 | B3977P | 161,60 |
| UNF 1/2 x 20  | 14,35 |      | 100 | 15,0 |     | 13,0 | B3978P | 157,30 |
| UNF 9/16 x 18 | 16,12 |      | 100 | 15,0 |     | 14,8 | B3979P | 254,50 |
| UNF 5/8 x 18  | 17,71 |      | 110 | 17,0 |     | 16,3 | B3980P | 233,10 |



### PRO - professional:

Case hardening steels,  
 heat treatable steels up to 1000 N/mm<sup>2</sup>,  
 structural steels, carbon tool steels,  
 cast steel up to 1000 N/mm<sup>2</sup>,  
 wrought alloy of aluminium,  
 soft brass (Ms63 long chipping),  
 red brass, copper

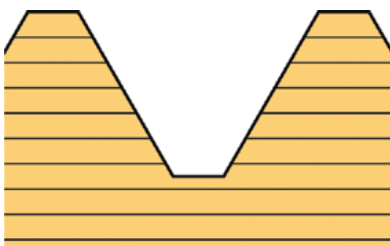
# BaerCoil® Forming Taps



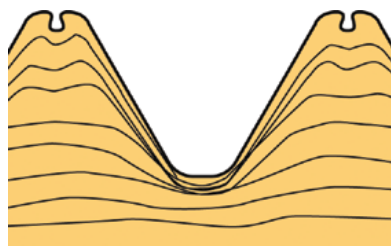
## BaerCoil® Forming Taps

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.

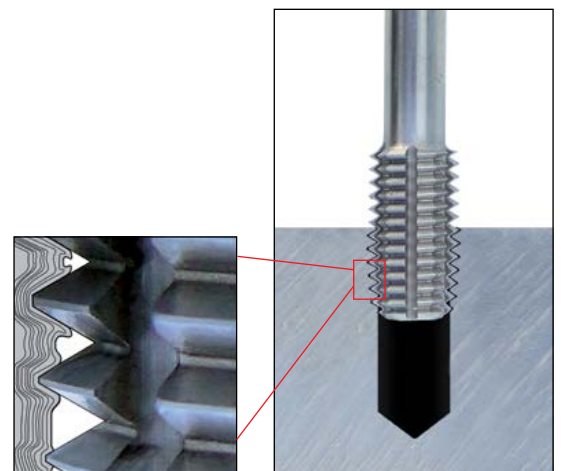
Result: The thread into which the BaerCoil® wire thread insert is turned has a significantly **higher load capacity**. The process of thread forming is **faster** and produces a **better surface** than thread cutting. Additionally there are **no chips**, and the thread forming tap has a **longer life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

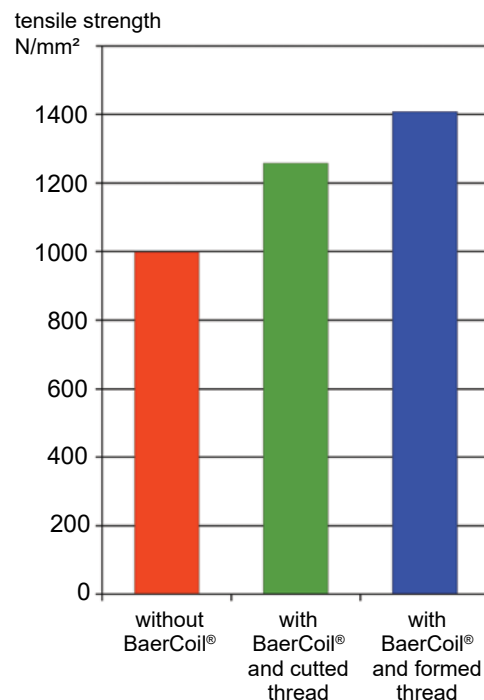
Cryogenic Materialtests - CryoMaK within the Institute for Technical Physics at the Institute of Technology in Karlsruhe – KIT – have conducted pull-out strength tests. And customers, after performing internal tests, are already taking advantage of the system and have integrated it into their production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

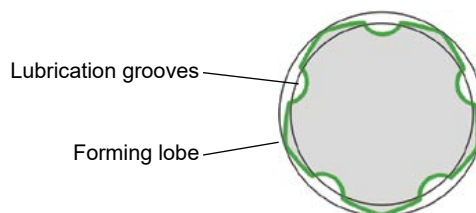
- stainless steel materials up to 950 N/mm<sup>2</sup>
- construction steels up to 800 N/mm<sup>2</sup>
- heat-treatable steels up to 1000 N/mm<sup>2</sup>
- aluminium alloys
- zinc alloys
- copper alloys



## BaerCoil® Forming Taps

|      |     |  |                |
|------|-----|--|----------------|
| HSSE | EG  |  | works standard |
| TIN  | STI |  |                |

2-3 x P  
Form C

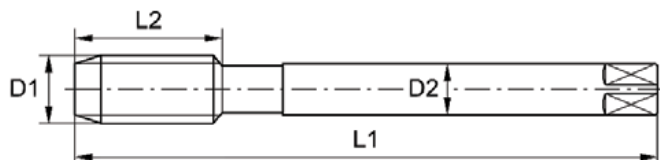


| M            | D1    | D2   | L1  | L2   | □    |       | No.   | €     |
|--------------|-------|------|-----|------|------|-------|-------|-------|
| M 2 x 0,4    | 2,54  | 2,8  | 50  | 9,0  | 2,10 | 2,35  | B3601 | 45,10 |
| M 2,5 x 0,45 | 3,11  | 3,5  | 56  | 10,0 | 2,70 | 2,90  | B3603 | 45,10 |
| M 3 x 0,5    | 3,68  | 4,5  | 63  | 12,0 | 3,40 | 3,40  | B3605 | 38,00 |
| M 4 x 0,7    | 4,94  | 6,0  | 70  | 14,0 | 4,90 | 4,60  | B3607 | 39,00 |
| M 5 x 0,8    | 6,07  | 6,0  | 80  | 16,0 | 4,90 | 5,65  | B3608 | 40,50 |
| M 6 x 1,0    | 7,34  | 8,0  | 90  | 18,0 | 6,20 | 6,85  | B3609 | 43,00 |
| M 8 x 1,25   | 9,67  | 10,0 | 99  | 20,0 | 8,00 | 9,05  | B3611 | 50,00 |
| M 10 x 1,5   | 11,99 | 9,0  | 100 | 22,0 | 7,00 | 11,30 | B3615 | 53,00 |
| 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.

Find forming speeds on page 63



# BaerCoil® Inserting Tools



## BaerCoil® Inserting Tools

with locking ring for depth stop



| M   | M  | UNC<br>UNF   | BSW<br>BSF   | BA<br>G (BSP)<br>NPT       | UNEF<br>Harley<br>BSC<br>BSB                       | length | <input type="checkbox"/> | No.   | €    |
|---|--|--|--|----------------------------|--|--------|--------------------------|-------|------|
| M 3 x 0,5   | M 3,5 x 0,6  | UNC 4 x 40<br>UNC 5 x 40<br>UNC 6 x 32<br>UNF 4 x 48<br>UNF 6 x 40 | BSW 1/8 x 40   | 5 BA                       |  | 100    | 5                        | EBW03 | 5,90 |
| M 4 x 0,7   |  | UNC 8 x 32<br>UNC 10 x 24<br>UNF 8 x 36                            | BSF 3/16 x 32  | 4 BA<br>3 BA               |  | 100    | 5                        | EBW04 | 5,90 |
| M 5 x 0,8   |  | UNC 12 x 24<br>UNF 10 x 32   | BSW 3/16 x 24<br>BSF 7/32 x 28                                 | 2 BA<br>1 BA               |  | 100    | 5                        | EBW05 | 5,90 |
| M 6 x 1,0<br>M 6 x 0,75                               |  | UNC 1/4 x 20<br>UNF 1/4 x 28                                       | BSW 1/4 x 20<br>BSF 1/4 x 26<br>BSF 9/32 x 26                  | 0 BA                       | UNEF 1/4 x 32<br>Harley 1/4 x 24<br>BSB 1/4 x 26   | 100    | 5                        | EBW06 | 5,90 |
| M 7 x 1,0   |  | UNC 5/16 x 18<br>UNF 5/16 x 24                                     | BSW 5/16 x 18<br>BSF 5/16 x 22                                 |                            | BSC 5/16 x 26<br>BSB 5/16 x 26                     | 100    | 7                        | EBW07 | 6,70 |
| M 8 x 1,25<br>M 8 x 1,0<br>M 8 x 0,75                 | M 9 x 1,25<br>M 9 x 1,0                              | UNC 3/8 x 16<br>UNF 3/8 x 24                                       | BSW 3/8 x 16<br>BSF 3/8 x 20                                   |                            | BSC 3/8 x 26<br>BSB 3/8 x 26                       | 100    | 7                        | EBW08 | 6,70 |
| M 10 x 1,5<br>M 10 x 1,25<br>M 10 x 1,0               | M 11 x 1,5<br>M 11 x 1,25<br>M 11 x 1,0              | UNC 7/16 x 14<br>UNF 7/16 x 20                                     | BSW 7/16 x 14<br>BSF 7/16 x 18                                 | G 1/8 x 28<br>NPT 1/8 x 27 | Harley 7/16 x 16<br>BSC 7/16 x 26<br>BSB 7/16 x 26 | 100    | 7                        | EBW10 | 7,30 |
| M 12 x 1,75<br>M 12 x 1,5<br>M 12 x 1,25              | M 12 x 1,0<br>M 13 x 1,5<br>M 13 x 1,25              | UNC 1/2 x 13<br>UNF 1/2 x 20                                       | BSW 1/2 x 12<br>BSF 1/2 x 16                                   | G 1/4 x 19                 | BSC 1/2 x 26<br>BSB 1/2 x 26                       | 100    | 7                        | EBW12 | 8,30 |
| M 14 x 2,0<br>M 14 x 1,5<br>M 14 x 1,25<br>M 14 x 1,0 | M 15 x 2,0<br>M 15 x 1,5<br>M 16 x 2,0<br>M 16 x 1,5 | UNC 9/16 x 12<br>UNC 5/8 x 11<br>UNF 9/16 x 18<br>UNF 5/8 x 18     | BSW 9/16 x 12<br>BSW 5/8 x 11<br>BSF 9/16 x 16<br>BSF 5/8 x 14 | G 3/8 x 19<br>NPT 1/4 x 19 | 11/16 x 16   | 100    | 7                        | EBW14 | 9,70 |

### 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

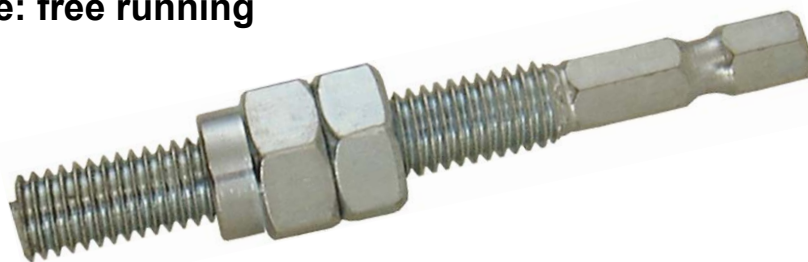




| M  | UNC<br>UNF                               | BSW<br>BSF                                     | G (BSP)<br>NPT             | 8-UN  | No.   | €     |
|--|--|--|----------------------------|---|-------|-------|
| M 2 x 0,4<br>M 2,2 x 0,45                            | UNC 2 x 56<br>UNF 2 x 64       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



## BaerCoil® Machine Inserting Tool - type: free running

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



|                      | Length   |  |  | No.      | €     |
|----------------------|----------|---|---|----------|-------|
| <b>M 3 x 0,5</b>     | 46,00 mm | 5,50 mm   | 1/4"  | KEBW03   | 8,60  |
| <b>M 4 x 0,7</b>     | 48,00 mm | 7,00 mm   | 1/4"  | KEBW04   | 8,60  |
| <b>M 5 x 0,8</b>     | 57,00 mm | 8,00 mm   | 1/4"  | KEBW05   | 8,60  |
| <b>M 6 x 1,0</b>     | 62,00 mm | 10,00 mm  | 1/4"  | KEBW06   | 8,60  |
| <b>M 7 x 1,0</b>     | 72,00 mm | 11,00 mm  | 1/4"  | KEBW07   | 9,00  |
| <b>M 8 x 1,25</b>    | 72,00 mm | 13,00 mm  | 1/4"  | KEBW08   | 10,50 |
| <b>M 10 x 1,0</b>    | 77,00 mm | 17,00 mm  | 1/4"  | KEBW1010 | 12,30 |
| <b>M 10 x 1,5</b>    | 82,00 mm | 17,00 mm  | 1/4"  | KEBW10   | 11,70 |
| <b>M 12 x 1,25</b>   | 79,00 mm | 19,00 mm  | 1/4"  | KEBW1212 | 13,50 |
| <b>M 12 x 1,5</b>    | 79,00 mm | 19,00 mm  | 1/4"  | KEBW1215 | 13,50 |
| <b>M 12 x 1,75</b>   | 92,00 mm | 19,00 mm  | 1/4"  | KEBW12   | 12,90 |
| <b>M 14 x 1,5</b>    | 94,00 mm | 21,00 mm  | 1/4"  | KEBW1415 | 13,50 |
| <b>M 14 x 2,0</b>    | 94,00 mm | 21,00 mm  | 1/4"  | KEBW1420 | 13,50 |
|                      |          |   |   |          |       |
| <b>UNC 1/4 x 20</b>  | 62,00 mm | 7/16 "  | 1/4"  | KEBW21   | 9,50  |
| <b>UNC 5/16 x 18</b> | 67,00 mm | 1/2 "   | 1/4"  | KEBW22   | 9,50  |
| <b>UNC 3/8 x 16</b>  | 77,00 mm | 9/16 "  | 1/4"  | KEBW23   | 11,60 |
| <b>UNC 7/16 x 14</b> | 87,00 mm | 11/16 "   | 1/4"  | KEBW24   | 12,90 |
| <b>UNC 1/2 x 13</b>  | 97,00 mm | 3/4 "   | 1/4"  | KEBW25   | 13,50 |
|                      |          |   |   |          |       |
| <b>UNF 1/4 x 28</b>  | 62,00 mm | 7/16 "  | 1/4"  | KEBW31   | 9,50  |
| <b>UNF 5/16 x 24</b> | 67,00 mm | 1/2 "   | 1/4"  | KEBW32   | 9,50  |
| <b>UNF 3/8 x 24</b>  | 77,00 mm | 9/16 "  | 1/4"  | KEBW33   | 11,60 |
| <b>UNF 7/16 x 20</b> | 87,00 mm | 11/16 "   | 1/4"  | KEBW34   | 12,90 |
| <b>UNF 1/2 x 20</b>  | 97,00 mm | 3/4 "   | 1/4"  | KEBW35   | 13,50 |

## BaerCoil® Extracting Tools



| M           | UNC<br>UNF  | BSW<br>BSF   |  | No.   | €     |        |
|-------------|---|--|--|---|-------|--------|
| M 2 – M 4   | UNC 2 x 56 – UNC 8 x 32<br>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<br>UNF 4 x 48 – UNF 3/8        | BSW 3/16 – BSW 3/8<br>BSF 3/16 – BSF 3/8           | BA 0 – BA 2<br>G 1/8<br>BSB 1/4 x 26 – BSB 3/8 x 26<br>BSC 5/16 x 26 – BSC 3/8 x 26                                  | NPT 1/8 x 27<br>UNEF 1/4 x 32<br>Harley 1/4 x 24                                    | B7052 | 26,90  |
| M 11 – M 24 | UNC 3/8 – UNC 1"<br>UNF 3/8 – UNF 1"<br>UNF 1" x 14 | BSW 3/8 – BSW 1"<br>BSF 3/8 – BSF 1"               | G 1/4 x 19 – G 5/8 x 14<br>BSB 3/8 x 26 – BSB 1/2 x 26<br>BSC 3/8 x 26 – BSC 1/2 x 26<br>NPT 1/4 x 19 – NPT 1/2 x 14 | Harley 7/16 x 16<br>Cummins 11/16 x 16<br>Carburetor 7/8 x 20<br>Carburetor 1" x 20 | B7053 | 32,20  |
| M 20 – M 39 | UNC 1.1/8" – UNC 1.1/2"<br>UNF 1.1/8" – UNF 1.1/8"  | BSW 1.1/8" – BSW 1.1/2"<br>BSF 1.1/8" – BSF 1.1/2" | G 1/2 – G 1"<br>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<br>UNF   | BSW<br>BSF  | BA<br>G (BSP)<br>NPT       | UNEF<br>Harley<br>BSC<br>BSB   | Länge | No.   | €    |
|--|---|--|---|----------------------------|--|-------|-------|------|
| M 2 x 0,4                                | M 2,2 x 0,45                            | UNC 2 x 56<br>UNF 2 x 64   |   |                            |  |       | BZ001 | 5,30 |
| M 2,5 x 0,45                             |   | UNC 3 x 48<br>UNF 3 x 56   |   | 6 BA                       |  |       | BZ002 | 2,65 |
| M 3 x 0,5                                | M 3,5 x 0,6                             | UNC 4 x 40<br>UNC 5 x 40<br>UNC 6 x 32<br>UNF 4 x 48<br>UNF 6 x 40 | BSW 1/8 x 40  | 5 BA                       |  | 100   | BZ003 | 2,35 |
| M 4 x 0,7                                |   | UNC 8 x 32<br>UNC 10 x 24<br>UNF 8 x 36                            | BSF 3/16 x 32   | 4 BA<br>3 BA               |  | 100   | BZ004 | 2,35 |
| M 5 x 0,8                                |   | UNC 12 x 24<br>UNF 10 x 32   | BSW 3/16 x 24<br>BSF 7/32 x 28  | 2 BA<br>1 BA               |  | 100   | BZ005 | 2,35 |
| M 6 x 1,0<br>M 6 x 0,75                  | M 7 x 1,0                               | UNC 1/4 x 20<br>UNF 1/4 x 28<br>UNC 5/16 x 18<br>UNF 5/16 x 24     | BSW 1/4 x 20<br>BSF 1/4 x 26<br>BSW 9/32 x 26<br>BSW 5/16 x 18<br>BSF 5/16 x 22 | 0 BA                       | UNEF 1/4 x 32<br>Harley 1/4 x 24<br>BSB 1/4 x 26<br>BSC 5/16 x 26<br>BSB 5/16 x 26 | 100   | BZ006 | 2,50 |
| M 8 x 1,25<br>M 8 x 1,0<br>M 8 x 0,75    | M 9 x 1,25<br>M 9 x 1,0                 | UNC 3/8 x 16<br>UNF 3/8 x 24                                       | BSW 3/8 x 16<br>BSF 3/8 x 20  |                            | BSC 3/8 x 26<br>BSB 3/8 x 26   | 100   | BZ008 | 2,50 |
| M 10 x 1,5<br>M 10 x 1,25<br>M 10 x 1,0  | M 11 x 1,5<br>M 11 x 1,25<br>M 11 x 1,0 | UNC 7/16 x 14<br>UNF 7/16 x 20                                     | BSW 7/16 x 14<br>BSF 7/16 x 18  | G 1/8 x 28<br>NPT 1/8 x 27 | Harley 7/16 x 16<br>BSC 7/16 x 26<br>BSB 7/16 x 26                                 | 100   | BZ010 | 2,50 |
| M 12 x 1,75<br>M 12 x 1,5<br>M 12 x 1,25 | M 12 x 1,0                              | UNC 1/2 x 13<br>UNF 1/2 x 20                                       | BSW 1/2 x 12<br>BSF 1/2 x 16  | G 1/4 x 19                 | BSC 1/2 x 26<br>BSB 1/2 x 26   | 100   | BZ012 | 3,20 |

## BaerCoil® Countersink HSSG

with 1/4" hexagonal drive  
to countersink a borehole



| Ø    | M          | UNC<br>UNF                                     | BSW<br>BSF                                 |  | Hexagon  | No.  | €           |
|------|------------|--|--|--|--|------|-------------|
| 10,4 | M 3 – M 8  | UNC 4 x 40 – UNC 5/16<br>UNF 4 x 48 – UNF 5/16 | BSW 3/16 – BSW 5/16<br>BSF 3/16 – BSF 5/16 | BA 0 – BA 6<br>G 1/8<br>BSB 1/4 x 26 – BSB 5/16 x 26<br>BSC 5/16 x 26    | NPT 1/8 x 27<br>UNEF 1/4 x 32<br>Harley 1/4 x 24 | 1/4" | B9402 9,35  |
| 16,5 | M 8 – M 15 | UNC 5/16 – UNC 9/16<br>UNF 5/16 – UNF 9/16     | BSW 5/16 – BSW 9/16<br>BSF 5/16 – BSF 9/16 | G 1/4 x 19<br>BSB 3/8 x 26 – BSB 1/2 x 26<br>BSC 3/8 x 26 – BSC 1/2 x 26 | NPT 1/4 x 19<br>Harley 7/16 x 16                 | 1/4" | B9403 10,40 |

## 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.    | €     |
|----------|--------------|--------------------------|---------------|----------------|---------------|---------------|-------|--------|-------|
| 2,10 mm  | M 2 x 0,4    |                          |               |                |               |               | 338   | 16121  | 0,80  |
| 2,30 mm  | M 2,2 x 0,45 |                          | UNC 2 x 56    | UNF 2 x 64     |               |               | 338   | 16123  | 0,80  |
| 2,60 mm  | M 2,5 x 0,45 |                          | UNC 3 x 48    | UNF 3 x 56     |               |               | 338   | 16126  | 0,80  |
| 3,00 mm  |              |                          | UNC 4 x 40    | UNF 4 x 48     |               |               | 338   | 16130  | 0,80  |
| 3,20 mm  | M 3 x 0,5    |                          |               |                |               |               | 338   | 16132  | 0,80  |
| 3,30 mm  |              |                          |               | UNF 5 x 44     |               |               | 338   | 16133  | 0,80  |
| 3,40 mm  |              |                          | UNC 5 x 40    |                | BSW 1/8 x 40  |               | 338   | 16134  | 0,90  |
| 3,70 mm  | M 3,5 x 0,6  |                          | UNC 6 x 32    | UNF 6 x 40     |               |               | 338   | 16137  | 1,00  |
| 4,20 mm  | M 4 x 0,7    |                          |               |                |               |               | 338   | 16142  | 1,20  |
| 4,40 mm  |              |                          |               | UNF 8 x 36     |               |               | 338   | 16144  | 1,40  |
| 4,50 mm  |              |                          | UNC 8 x 32    |                |               |               | 338   | 16145  | 1,40  |
| 5,00 mm  |              |                          |               |                | BSW 3/16 x 24 | BSF 3/16 x 32 | 338   | 16150  | 1,50  |
| 5,10 mm  |              |                          |               | UNF 10 x 32    |               |               | 338   | 16151  | 1,70  |
| 5,20 mm  | M 5 x 0,8    |                          | UNC 10 x 24   |                |               |               | 338   | 16152  | 1,70  |
| 5,80 mm  |              |                          | UNC 12 x 24   |                |               | BSF 7/32 x 28 | 338   | 16158  | 1,90  |
| 6,30 mm  | M 6 x 1,0    | M 6 x 0,75               |               |                |               |               | 338   | 16163  | 2,10  |
| 6,60 mm  |              |                          |               | UNF 1/4 x 28   |               | BSF 1/4 x 26  | 338   | 16166  | 2,40  |
| 6,70 mm  |              |                          | UNC 1/4 x 20  |                | BSW 1/4 x 20  |               | 338   | 16167  | 2,40  |
| 7,30 mm  | M 7 x 1,0    |                          |               |                |               | BSF 9/32 x 26 | 338   | 16173  | 2,80  |
| 8,20 mm  | M 8 x 0,75   |                          |               | UNF 5/16 x 24  |               |               | 338   | 16182  | 4,00  |
| 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  | 4,00  |
| 9,30 mm  | M 9 x 1,25   | M 9 x 1,0                |               |                |               |               | 338   | 16193  | 4,00  |
| 9,80 mm  |              |                          |               | UNF 3/8 x 24   |               |               | 338   | 16198  | 4,60  |
| 9,90 mm  |              |                          | UNC 3/8 x 16  |                | BSW 3/8 x 16  | BSF 3/8 x 20  | 338   | 16199  | 4,60  |
| 10,30 mm | M 10 x 1,0   | M 10 x 1,25              |               |                |               |               | 338   | 161103 | 6,00  |
| 10,40 mm | M 10 x 1,5   |                          |               |                |               |               | 338   | 161104 | 6,00  |
| 11,30 mm | M 11 x 1,0   |                          |               |                |               |               | 338   | 161113 | 7,30  |
| 11,40 mm | M 11 x 1,5   | M 11 x 1,25              |               |                |               |               | 338   | 161114 | 7,30  |
| 11,50 mm |              |                          |               | UNF 7/16 x 20  |               | BSF 7/16 x 18 | 338   | 161115 | 7,30  |
| 11,60 mm |              |                          | UNC 7/16 x 14 |                | BSW 7/16 x 14 |               | 338   | 161116 | 7,30  |
| 12,30 mm | M 12 x 1,0   | M 12 x 1,25              |               |                |               |               | 338   | 161123 | 9,40  |
| 12,40 mm | M 12 x 1,75  | M 12 x 1,5               |               |                |               |               | 338   | 161124 | 9,40  |
| 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 | 9,40  |
| 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<br>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<br>M 20 x 1,5 |               |                |               |               | 338-A | 111205 | 48,00 |
| 22,50 mm | M 22 x 2,5   | M 22 x 2,0<br>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<br>M 24 x 1,5 |               |                |               |               | 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<br>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<br>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<br>M 42 x 4,0 | M 42 x 3,0<br>M 42 x 2,0 |                |                 |                |                | 345 | 130430 | 296,00 |

| Ø        | G (BSP)       | BSB           | BSC           | NPT           | BA   | DIN                               | No.   | €      |        |
|----------|---------------|---------------|---------------|---------------|------|-----------------------------------|-------|--------|--------|
| 2,90 mm  |               |               |               |               | BA 6 | 338                               | 16129 | 0,80   |        |
| 3,20 mm  |               |               |               |               | BA 5 | 338                               | 16132 | 0,80   |        |
| 3,80 mm  |               |               |               |               | BA 4 | 338                               | 16138 | 1,00   |        |
| 4,30 mm  |               |               |               |               | BA 3 | 338                               | 16143 | 1,40   |        |
| 4,90 mm  |               |               |               |               | BA 2 | 338                               | 16149 | 1,50   |        |
| 5,50 mm  |               |               |               |               | BA 1 | 338                               | 16155 | 1,90   |        |
| 6,20 mm  |               |               |               |               | BA 0 | 338                               | 16162 | 2,10   |        |
| 6,60 mm  |               | BSB 1/4 x 26  |               |               |      | UNEUF 1/4 x 32<br>Harley 1/4 x 24 | 338   | 16166  | 2,40   |
| 8,20 mm  |               | BSB 5/16 x 26 | BSC 5/16 x 26 |               |      |                                   | 338   | 16182  | 4,00   |
| 9,80 mm  |               | BSB 3/8 x 26  | BSC 3/8 x 26  |               |      |                                   | 338   | 16198  | 4,60   |
| 9,90 mm  | G 1/8 x 28    |               |               | NPT 1/8 x 27  |      |                                   | 338   | 16199  | 4,60   |
| 11,50 mm |               | BSB 7/16 x 26 | BSC 7/16 x 26 |               |      | Harley 7/16 x 16                  | 338   | 161115 | 7,30   |
| 13,00 mm |               | BSB 1/2 x 26  | BSC 1/2 x 26  |               |      |                                   | 338   | 161130 | 9,40   |
| 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 | 55,50  |
| 23,50 mm | G 5/8 x 14    |               |               |               |      |                                   | 345   | 130235 | 58,00  |
| 26,00 mm |               |               |               |               |      | Carburetor 1" x 20                | 338-A | 111260 | 79,00  |
| 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 | 97,00  |
| 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 | 296,00 |
| 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 6H modified class 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.



### 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



| Spring No. | Material | Wire Dia. | Coil Dia. | Length | Weight | Force |
|------------|----------|-----------|-----------|--------|--------|-------|
| 1          | St 304   | 0.5       | 1.0       | 10     | 0.15   | 10    |
| 2          | St 304   | 0.5       | 1.0       | 20     | 0.30   | 20    |
| 3          | St 304   | 0.5       | 1.0       | 30     | 0.45   | 30    |
| 4          | St 304   | 0.5       | 1.0       | 40     | 0.60   | 40    |
| 5          | St 304   | 0.5       | 1.0       | 50     | 0.75   | 50    |



| Spring No. | Material | Wire Dia. | Coil Dia. | Length | Weight | Force |
|------------|----------|-----------|-----------|--------|--------|-------|
| 1          | St 304   | 0.5       | 1.0       | 10     | 0.15   | 10    |
| 2          | St 304   | 0.5       | 1.0       | 20     | 0.30   | 20    |
| 3          | St 304   | 0.5       | 1.0       | 30     | 0.45   | 30    |
| 4          | St 304   | 0.5       | 1.0       | 40     | 0.60   | 40    |
| 5          | St 304   | 0.5       | 1.0       | 50     | 0.75   | 50    |

| Automatenstahl, un |          |
|--------------------|----------|
| Spring No.         | Material |
| 1                  | St 304   |
| 2                  | St 304   |
| 3                  | St 304   |
| 4                  | St 304   |
| 5                  | St 304   |

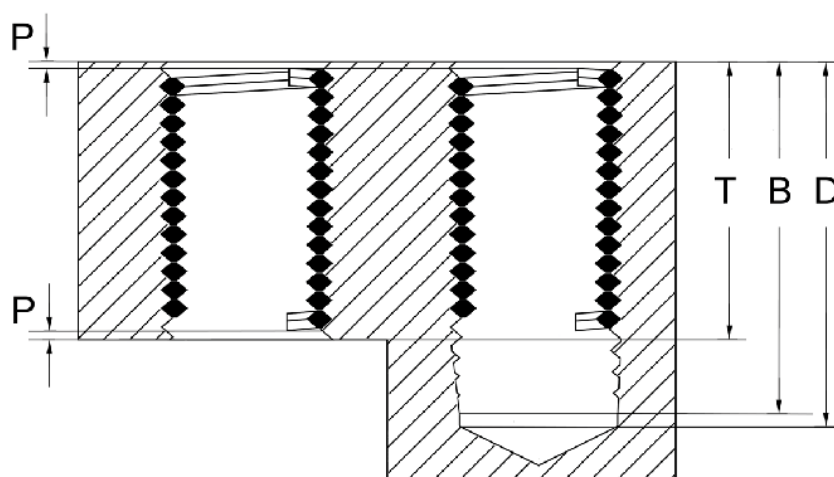
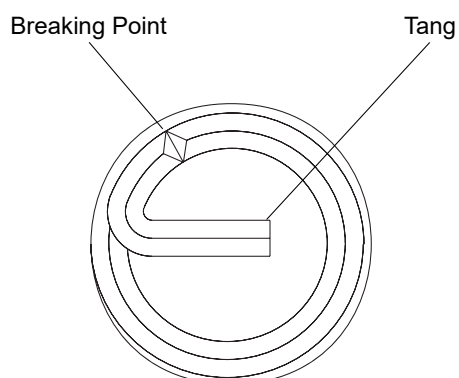
  

| Feinwerk-Kalibras |          |
|-------------------|----------|
| Spring No.        | Material |
| 1                 | St 304   |
| 2                 | St 304   |
| 3                 | St 304   |
| 4                 | St 304   |
| 5                 | St 304   |

# 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



## Technical Data for BaerCoil® Wire Thread Inserts

| 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 20 x 1.5 | 20.00 | 26.75 | 25.25 | 30.00 | 36.75 | 35.25 | 40.00 | 46.75  | 45.25 | 50.00  | 56.75  | 55.25  | 60.00  | 66.75  | 65.25  | 21.75  | 24.00 |
| M 20 x 2.0 | 20.00 | 29.00 | 27.00 | 30.00 | 39.00 | 37.00 | 40.00 | 49.00  | 47.00 | 50.00  | 59.00  | 57.00  | 60.00  | 69.00  | 67.00  | 22.31  | 24.05 |
| M 20 x 2.5 | 20.00 | 31.25 | 28.75 | 30.00 | 41.25 | 38.75 | 40.00 | 51.25  | 48.75 | 50.00  | 61.25  | 58.75  | 60.00  | 71.25  | 68.75  | 22.86  | 24.40 |
| M 22 x 1.5 | 22.00 | 28.75 | 27.25 | 33.00 | 39.75 | 38.25 | 44.00 | 50.75  | 49.25 | 55.00  | 61.75  | 60.25  | 66.00  | 72.75  | 71.25  | 23.75  | 26.45 |
| M 22 x 2.0 | 22.00 | 31.00 | 29.00 | 33.00 | 42.00 | 40.00 | 44.00 | 53.00  | 51.00 | 55.00  | 64.00  | 62.00  | 66.00  | 75.00  | 73.00  | 24.31  | 26.50 |
| M 22 x 2.5 | 22.00 | 33.25 | 30.75 | 33.00 | 44.25 | 41.75 | 44.00 | 55.25  | 52.75 | 55.00  | 66.25  | 63.75  | 66.00  | 77.25  | 74.75  | 24.86  | 26.90 |
| M 24 x 2.0 | 24.00 | 33.00 | 31.00 | 36.00 | 45.00 | 43.00 | 48.00 | 57.00  | 55.00 | 60.00  | 69.00  | 67.00  | 72.00  | 81.00  | 79.00  | 26.32  | 29.10 |
| M 24 x 3.0 | 24.00 | 37.50 | 34.50 | 36.00 | 49.50 | 46.50 | 48.00 | 61.50  | 58.50 | 60.00  | 73.50  | 70.50  | 72.00  | 85.50  | 82.50  | 27.43  | 29.00 |
| M 27 x 2.0 | 27.00 | 36.00 | 34.00 | 40.50 | 49.50 | 47.50 | 54.00 | 63.00  | 61.00 | 67.50  | 76.50  | 74.50  | 81.00  | 90.00  | 88.00  | 29.32  | 32.30 |
| M 27 x 3.0 | 27.00 | 40.50 | 37.50 | 40.50 | 54.00 | 51.00 | 54.00 | 67.50  | 64.50 | 67.50  | 81.00  | 78.00  | 81.00  | 94.50  | 91.50  | 30.43  | 32.40 |
| M 30 x 3.0 | 30.00 | 43.50 | 40.50 | 45.00 | 58.50 | 55.50 | 60.00 | 73.50  | 70.50 | 75.00  | 88.50  | 85.50  | 90.00  | 103.50 | 100.50 | 33.43  | 36.10 |
| M 30 x 3.5 | 30.00 | 45.75 | 42.25 | 45.00 | 60.75 | 57.25 | 60.00 | 75.75  | 72.25 | 75.00  | 90.75  | 87.25  | 90.00  | 105.75 | 102.25 | 33.99  | 35.81 |
| M 33 x 3.5 | 33.00 | 48.75 | 45.25 | 49.50 | 65.25 | 61.75 | 66.00 | 81.75  | 78.25 | 82.50  | 98.25  | 94.75  | 99.00  | 114.75 | 111.25 | 36.99  | 38.80 |
| M 36 x 3.0 | 36.00 | 49.50 | 46.50 | 54.00 | 67.50 | 64.50 | 72.00 | 85.50  | 82.50 | 90.00  | 103.50 | 100.50 | 108.00 | 121.50 | 118.50 | 39.43  | 42.70 |
| M 36 x 4.0 | 36.00 | 54.00 | 50.00 | 54.00 | 72.00 | 68.00 | 72.00 | 90.00  | 86.00 | 90.00  | 108.00 | 104.00 | 108.00 | 126.00 | 122.00 | 40.54  | 42.67 |
| M 39 x 4.0 | 39.00 | 57.00 | 53.00 | 58.50 | 76.50 | 72.50 | 78.00 | 96.00  | 92.00 | 97.50  | 115.50 | 111.50 | 117.00 | 135.00 | 131.00 | 43.54  | 45.75 |
| M 42 x 3.0 | 42.00 | 55.50 | 52.50 | 63.00 | 76.50 | 73.50 | 84.00 | 97.50  | 94.50 | 105.00 | 118.50 | 115.50 | 126.00 | 139.50 | 136.50 | 45.43  | 49.00 |
| M 42 x 4.5 | 42.00 | 62.25 | 57.75 | 63.00 | 83.25 | 78.75 | 84.00 | 104.25 | 99.75 | 105.00 | 125.25 | 120.75 | 126.00 | 146.25 | 141.75 | 47.10  | 49.00 |

| G (BSP)     | 1,0 D |       |       | 1,5 D |       |       | 2,0 D |       |       | 2,5 D |       |       | 3,0 D |       |       | F (inch) |       |
|-------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|----------|-------|
|             | T     | D     | B     | T     | D     | B     | T     | D     | B     | T     | D     | B     | T     | D     | B     | min.     | max.  |
| 1/8 x 28    | 0.125 | 0.287 | 0.251 | 0.187 | 0.349 | 0.313 | 0.250 | 0.412 | 0.376 | 0.312 | 0.474 | 0.438 | 0.375 | 0.537 | 0.501 | 0.426    | 0.472 |
| 1/4 x 19    | 0.250 | 0.488 | 0.435 | 0.375 | 0.613 | 0.560 | 0.500 | 0.738 | 0.685 | 0.625 | 0.863 | 0.810 | 0.750 | 0.988 | 0.935 | 0.582    | 0.637 |
| 3/8 x 19    | 0.375 | 0.613 | 0.560 | 0.562 | 0.800 | 0.747 | 0.750 | 0.988 | 0.935 | 0.937 | 1.175 | 1.122 | 1.125 | 1.363 | 1.310 | 0.720    | 0.787 |
| 1/2 x 14    | 0.500 | 0.820 | 0.749 | 0.750 | 1.070 | 0.999 | 1.000 | 1.320 | 1.249 | 1.250 | 1.570 | 1.499 | 1.500 | 1.821 | 1.749 | 0.911    | 0.992 |
| 5/8 x 14    | 0.625 | 0.945 | 0.874 | 0.937 | 1.257 | 1.186 | 1.250 | 1.570 | 1.499 | 1.562 | 1.882 | 1.811 | 1.875 | 2.195 | 2.124 | 0.988    | 1.078 |
| 3/4 x 14    | 0.750 | 1.070 | 0.999 | 1.125 | 1.445 | 1.374 | 1.500 | 1.820 | 1.749 | 1.875 | 2.195 | 2.124 | 2.250 | 2.570 | 2.499 | 1.127    | 1.228 |
| 7/8 x 14    | 0.875 | 1.195 | 1.124 | 1.312 | 1.632 | 1.561 | 1.750 | 2.070 | 1.999 | 2.187 | 2.507 | 2.436 | 2.625 | 2.945 | 2.874 | 1.275    | 1.389 |
| 1" x 11     | 1.000 | 1.410 | 1.319 | 1.500 | 1.910 | 1.819 | 2.000 | 2.410 | 2.319 | 2.500 | 2.910 | 2.819 | 3.000 | 3.410 | 3.319 | 1.416    | 1.543 |
| 1.1/4" x 11 | 1.250 | 1.660 | 1.569 | 1.875 | 2.285 | 2.194 | 2.500 | 2.910 | 2.819 | 3.125 | 3.535 | 3.440 | 3.750 | 4.160 | 4.069 | 1.759    | 1.909 |
| 1.1/2" x 11 | 1.506 | 1.910 | 1.819 | 2.250 | 2.660 | 2.569 | 3.000 | 3.410 | 3.319 | 3.750 | 4.160 | 4.069 | 4.500 | 4.910 | 4.819 | 1.991    | 2.161 |

| BA   | 1,0 D |       |       | 1,5 D |       |       | 2,0 D |       |       | 2,5 D |       |       | 3,0 D |       |       | F (inch) |       |
|------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|----------|-------|
|      | T     | D     | B     | T     | D     | B     | T     | D     | B     | T     | D     | B     | T     | D     | B     | min.     | max.  |
| BA 0 | 0.236 | 0.413 | 0.374 | 0.354 | 0.531 | 0.492 | 0.472 | 0.649 | 0.610 | 0.591 | 0.768 | 0.729 | 0.709 | 0.886 | 0.847 | 0.280    | 0.309 |
| BA 1 | 0.209 | 0.368 | 0.333 | 0.313 | 0.472 | 0.437 | 0.417 | 0.567 | 0.541 | 0.522 | 0.681 | 0.646 | 0.626 | 0.785 | 0.750 | 0.248    | 0.273 |
| BA 2 | 0.185 | 0.329 | 0.297 | 0.278 | 0.422 | 0.390 | 0.370 | 0.514 | 0.482 | 0.463 | 0.607 | 0.575 | 0.555 | 0.699 | 0.667 | 0.220    | 0.243 |
| BA 3 | 0.616 | 0.132 | 0.262 | 0.242 | 0.372 | 0.343 | 0.323 | 0.453 | 0.424 | 0.404 | 0.543 | 0.505 | 0.484 | 0.614 | 0.585 | 0.193    | 0.213 |
| BA 4 | 0.142 | 0.259 | 0.233 | 0.213 | 0.330 | 0.304 | 0.283 | 0.400 | 0.374 | 0.354 | 0.471 | 0.455 | 0.425 | 0.542 | 0.516 | 0.170    | 0.188 |
| BA 5 | 0.126 | 0.230 | 0.207 | 0.189 | 0.293 | 0.270 | 0.252 | 0.356 | 0.333 | 0.315 | 0.419 | 0.396 | 0.378 | 0.482 | 0.459 | 0.152    | 0.167 |
| BA 6 | 0.110 | 0.204 | 0.183 | 0.165 | 0.259 | 0.238 | 0.220 | 0.314 | 0.293 | 0.276 | 0.370 | 0.349 | 0.331 | 0.425 | 0.404 | 0.133    | 0.147 |



## Technical Data for BaerCoil® Wire Thread Inserts

| UNC        | 1,0 D |       |       | 1,5 D |       |       | 2,0 D |       |       | 2,5 D |       |       | 3,0 D |       |       | F (inch) |       |
|------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|----------|-------|
|            | T     | D     | B     | T     | D     | B     | T     | D     | B     | T     | D     | B     | T     | D     | B     | min.     | max.  |
| 2 x 56     | 0.086 | 0.166 | 0.148 | 0.129 | 0.209 | 0.191 | 0.172 | 0.252 | 0.234 | 0.215 | 0.295 | 0.277 | 0.258 | 0.338 | 0.320 | 0.107    | 0.119 |
| 3 x 48     | 0.099 | 0.193 | 0.172 | 0.148 | 0.242 | 0.221 | 0.198 | 0.292 | 0.271 | 0.248 | 0.342 | 0.321 | 0.297 | 0.391 | 0.370 | 0.124    | 0.139 |
| 4 x 40     | 0.112 | 0.224 | 0.199 | 0.168 | 0.280 | 0.255 | 0.224 | 0.336 | 0.311 | 0.280 | 0.392 | 0.367 | 0.336 | 0.448 | 0.423 | 0.142    | 0.159 |
| 5 x 40     | 0.125 | 0.237 | 0.212 | 0.187 | 0.300 | 0.275 | 0.250 | 0.362 | 0.337 | 0.312 | 0.425 | 0.400 | 0.375 | 0.487 | 0.462 | 0.155    | 0.173 |
| 6 x 32     | 0.138 | 0.279 | 0.247 | 0.207 | 0.348 | 0.316 | 0.276 | 0.417 | 0.385 | 0.345 | 0.486 | 0.454 | 0.414 | 0.555 | 0.523 | 0.175    | 0.193 |
| 8 x 32     | 0.164 | 0.305 | 0.273 | 0.246 | 0.387 | 0.355 | 0.328 | 0.469 | 0.437 | 0.410 | 0.551 | 0.519 | 0.492 | 0.633 | 0.601 | 0.201    | 0.220 |
| 10 x 24    | 0.190 | 0.377 | 0.336 | 0.285 | 0.472 | 0.431 | 0.380 | 0.567 | 0.526 | 0.475 | 0.662 | 0.621 | 0.570 | 0.757 | 0.716 | 0.238    | 0.259 |
| 12 x 24    | 0.216 | 0.404 | 0.362 | 0.324 | 0.512 | 0.470 | 0.432 | 0.620 | 0.578 | 0.540 | 0.727 | 0.686 | 0.648 | 0.836 | 0.794 | 0.265    | 0.283 |
| 1/4 x 20   | 0.250 | 0.475 | 0.425 | 0.375 | 0.600 | 0.550 | 0.500 | 0.725 | 0.675 | 0.625 | 0.850 | 0.800 | 0.750 | 0.975 | 0.925 | 0.308    | 0.330 |
| 5/16 x 18  | 0.312 | 0.562 | 0.507 | 0.469 | 0.719 | 0.663 | 0.625 | 0.875 | 0.819 | 0.781 | 1.031 | 0.976 | 0.937 | 1.187 | 1.132 | 0.377    | 0.400 |
| 3/8 x 16   | 0.375 | 0.656 | 0.594 | 0.562 | 0.844 | 0.781 | 0.750 | 1.031 | 0.969 | 0.937 | 1.219 | 1.156 | 1.125 | 1.406 | 1.344 | 0.447    | 0.472 |
| 7/16 x 14  | 0.437 | 0.759 | 0.687 | 0.656 | 0.978 | 0.906 | 0.875 | 1.196 | 1.125 | 1.094 | 1.415 | 1.343 | 1.312 | 1.634 | 1.562 | 0.520    | 0.551 |
| 1/2 x 13   | 0.500 | 0.846 | 0.769 | 0.750 | 1.096 | 1.019 | 1.000 | 1.346 | 1.269 | 1.250 | 1.596 | 1.519 | 1.500 | 1.846 | 1.769 | 0.588    | 0.622 |
| 9/16 x 12  | 0.562 | 0.937 | 0.854 | 0.844 | 1.219 | 1.135 | 1.125 | 1.500 | 1.417 | 1.406 | 1.781 | 1.698 | 1.687 | 2.062 | 1.979 | 0.659    | 0.694 |
| 5/8 x 11   | 0.625 | 1.034 | 0.943 | 0.937 | 1.347 | 1.256 | 1.250 | 1.659 | 1.568 | 1.562 | 1.972 | 1.881 | 1.875 | 2.284 | 2.193 | 0.730    | 0.767 |
| 3/4 x 10   | 0.750 | 1.200 | 1.100 | 1.125 | 1.575 | 1.475 | 1.500 | 1.950 | 1.850 | 1.875 | 2.325 | 2.225 | 2.250 | 2.700 | 2.600 | 0.865    | 0.906 |
| 7/8 x 9    | 0.875 | 1.375 | 1.264 | 1.312 | 1.812 | 1.701 | 1.750 | 2.250 | 2.139 | 2.187 | 2.687 | 2.576 | 2.625 | 3.125 | 3.014 | 1.002    | 1.052 |
| 1" x 8     | 1.000 | 1.563 | 1.437 | 1.500 | 2.062 | 1.937 | 2.000 | 2.562 | 2.437 | 2.500 | 3.062 | 2.937 | 3.000 | 3.562 | 3.437 | 1.143    | 1.196 |
| 1.1/8" x 7 | 1.125 | 1.768 | 1.625 | 1.687 | 2.330 | 2.187 | 2.250 | 2.893 | 2.750 | 2.812 | 3.455 | 3.312 | 3.375 | 4.018 | 3.875 | 1.288    | 1.355 |
| 1.1/4" x 7 | 1.250 | 1.893 | 1.750 | 1.875 | 2.518 | 2.375 | 2.500 | 3.143 | 3.000 | 3.125 | 3.768 | 3.625 | 3.750 | 4.393 | 4.250 | 1.413    | 1.483 |
| 1.3/8" x 6 | 1.375 | 2.125 | 1.958 | 2.062 | 2.812 | 2.646 | 2.750 | 3.500 | 3.333 | 3.437 | 4.187 | 4.021 | 4.125 | 4.875 | 4.708 | 1.565    | 1.643 |
| 1.1/2" x 6 | 1.500 | 2.250 | 2.083 | 2.250 | 3.000 | 2.833 | 3.000 | 3.750 | 3.583 | 3.750 | 4.500 | 4.333 | 4.500 | 5.250 | 5.083 | 1.690    | 1.772 |

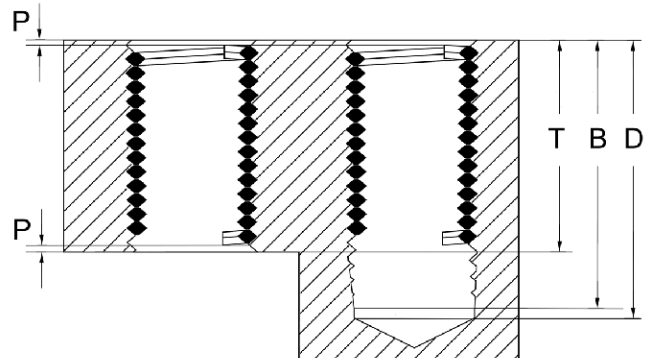
| UNF         | 1,0 D |       |       | 1,5 D |       |       | 2,0 D |       |       | 2,5 D |       |       | 3,0 D |       |       | F (inch) |       |
|-------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|----------|-------|
|             | T     | D     | B     | T     | D     | B     | T     | D     | B     | T     | D     | B     | T     | D     | B     | min.     | max.  |
| 2 x 64      | 0.086 | 0.156 | 0.141 | 0.129 | 0.199 | 0.184 | 0.172 | 0.242 | 0.227 | 0.215 | 0.285 | 0.270 | 0.258 | 0.328 | 0.313 | 0.105    | 0.116 |
| 3 x 56      | 0.099 | 0.179 | 0.161 | 0.148 | 0.228 | 0.210 | 0.198 | 0.278 | 0.260 | 0.248 | 0.328 | 0.310 | 0.297 | 0.377 | 0.359 | 0.120    | 0.146 |
| 4 x 48      | 0.112 | 0.206 | 0.185 | 0.168 | 0.262 | 0.241 | 0.224 | 0.318 | 0.297 | 0.280 | 0.374 | 0.353 | 0.336 | 0.430 | 0.409 | 0.137    | 0.162 |
| 5 x 44      | 0.125 | 0.227 | 0.205 | 0.188 | 0.290 | 0.268 | 0.250 | 0.352 | 0.330 | 0.312 | 0.414 | 0.392 | 0.375 | 0.477 | 0.455 | 0.152    | 0.168 |
| 6 x 40      | 0.138 | 0.250 | 0.225 | 0.207 | 0.319 | 0.294 | 0.276 | 0.388 | 0.363 | 0.345 | 0.457 | 0.432 | 0.414 | 0.526 | 0.501 | 0.168    | 0.193 |
| 8 x 36      | 0.164 | 0.289 | 0.261 | 0.246 | 0.371 | 0.343 | 0.328 | 0.453 | 0.425 | 0.410 | 0.535 | 0.507 | 0.492 | 0.617 | 0.589 | 0.197    | 0.224 |
| 10 x 32     | 0.190 | 0.331 | 0.299 | 0.285 | 0.426 | 0.394 | 0.380 | 0.521 | 0.489 | 0.475 | 0.616 | 0.584 | 0.570 | 0.711 | 0.679 | 0.227    | 0.256 |
| 1/4 x 28    | 0.250 | 0.411 | 0.375 | 0.375 | 0.536 | 0.500 | 0.500 | 0.661 | 0.625 | 0.625 | 0.786 | 0.750 | 0.750 | 0.911 | 0.875 | 0.292    | 0.326 |
| 5/16 x 24   | 0.312 | 0.500 | 0.458 | 0.469 | 0.656 | 0.615 | 0.625 | 0.812 | 0.771 | 0.781 | 0.969 | 0.927 | 0.937 | 1.125 | 1.083 | 0.361    | 0.400 |
| 3/8 x 24    | 0.375 | 0.562 | 0.521 | 0.562 | 0.750 | 0.708 | 0.750 | 0.937 | 0.896 | 0.937 | 1.125 | 1.083 | 1.125 | 1.312 | 1.271 | 0.424    | 0.468 |
| 7/16 x 20   | 0.437 | 0.662 | 0.612 | 0.656 | 0.881 | 0.831 | 0.875 | 1.100 | 1.050 | 1.094 | 1.319 | 1.269 | 1.312 | 1.537 | 1.488 | 0.496    | 0.549 |
| 1/2 x 20    | 0.500 | 0.725 | 0.675 | 0.750 | 0.975 | 0.925 | 1.000 | 1.225 | 1.175 | 1.250 | 1.475 | 1.425 | 1.500 | 1.725 | 1.675 | 0.559    | 0.617 |
| 9/16 x 18   | 0.562 | 0.812 | 0.757 | 0.844 | 1.094 | 1.038 | 1.125 | 1.375 | 1.319 | 1.406 | 1.656 | 1.601 | 1.687 | 1.937 | 1.882 | 0.628    | 0.691 |
| 5/8 x 18    | 0.625 | 0.875 | 0.819 | 0.937 | 1.187 | 1.132 | 1.250 | 1.500 | 1.444 | 1.562 | 1.812 | 1.757 | 1.875 | 2.125 | 2.069 | 0.690    | 0.758 |
| 3/4 x 16    | 0.750 | 1.031 | 0.969 | 1.125 | 1.406 | 1.344 | 1.500 | 1.781 | 1.719 | 1.875 | 2.156 | 2.094 | 2.250 | 2.531 | 2.469 | 0.823    | 0.901 |
| 7/8 x 14    | 0.875 | 1.196 | 1.125 | 1.312 | 1.634 | 1.562 | 1.750 | 2.071 | 2.000 | 2.187 | 2.509 | 2.437 | 2.625 | 2.946 | 2.875 | 0.958    | 1.051 |
| 1" x 12     | 1.000 | 1.375 | 1.292 | 1.500 | 1.875 | 1.792 | 2.000 | 2.375 | 2.292 | 2.500 | 2.875 | 2.792 | 3.000 | 3.375 | 3.292 | 1.097    | 1.199 |
| 1.1/8" x 12 | 1.125 | 1.500 | 1.417 | 1.687 | 2.062 | 1.979 | 2.250 | 2.625 | 2.542 | 2.812 | 3.187 | 3.104 | 3.375 | 3.750 | 3.667 | 1.222    | 1.334 |
| 1.1/4" x 12 | 1.250 | 1.625 | 1.542 | 1.875 | 2.250 | 2.167 | 2.500 | 2.875 | 2.792 | 3.125 | 3.500 | 3.417 | 3.750 | 4.125 | 4.042 | 1.347    | 1.469 |
| 1.3/8" x 12 | 1.375 | 1.750 | 1.667 | 2.062 | 2.437 | 2.354 | 2.750 | 3.125 | 3.042 | 3.437 | 3.812 | 3.729 | 4.125 | 4.500 | 4.417 | 1.472    | 1.610 |
| 1.1/2" x 12 | 1.500 | 1.875 | 1.792 | 2.250 | 2.625 | 2.542 | 3.000 | 3.375 | 3.292 | 3.750 | 4.125 | 4.042 | 4.500 | 4.875 | 4.792 | 1.598    | 1.745 |



## Technical Data for BaerCoil® Wire Thread Inserts

| BSW        | 1,0 D |       |       | 1,5 D |       |       | 2,0 D |       |       | 2,5 D |       |       | 3,0 D |       |       | F (inch) |       |
|------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|----------|-------|
|            | T     | D     | B     | T     | D     | B     | T     | D     | B     | T     | D     | B     | T     | D     | B     | min.     | max.  |
| 1/8 x 40   | 0.125 | 0.237 | 0.212 | 0.187 | 0.299 | 0.274 | 0.250 | 0.362 | 0.337 | 0.312 | 0.425 | 0.400 | 0.375 | 0.487 | 0.462 | 0.155    | 0.173 |
| 3/16 x 24  | 0.187 | 0.375 | 0.332 | 0.281 | 0.468 | 0.426 | 0.375 | 0.562 | 0.520 | 0.468 | 0.656 | 0.612 | 0.562 | 0.750 | 0.708 | 0.237    | 0.256 |
| 1/4 x 20   | 0.125 | 0.475 | 0.425 | 0.375 | 0.600 | 0.550 | 0.500 | 0.725 | 0.675 | 0.625 | 0.850 | 0.800 | 0.750 | 0.975 | 0.925 | 0.309    | 0.331 |
| 5/16 x 18  | 0.312 | 0.562 | 0.507 | 0.469 | 0.719 | 0.663 | 0.625 | 0.875 | 0.819 | 0.781 | 1.031 | 0.976 | 0.937 | 1.187 | 1.132 | 0.378    | 0.401 |
| 3/8 x 16   | 0.375 | 0.656 | 0.594 | 0.562 | 0.844 | 0.781 | 0.750 | 1.031 | 0.969 | 0.937 | 1.219 | 1.156 | 1.125 | 1.406 | 1.344 | 0.449    | 0.472 |
| 7/16 x 14  | 0.437 | 0.759 | 0.687 | 0.656 | 0.978 | 0.906 | 0.875 | 1.196 | 1.125 | 1.093 | 1.415 | 1.343 | 1.312 | 1.634 | 1.562 | 0.522    | 0.551 |
| 1/2 x 12   | 0.500 | 0.875 | 0.792 | 0.750 | 1.125 | 1.042 | 1.050 | 1.375 | 1.292 | 1.250 | 1.625 | 1.542 | 1.500 | 1.875 | 1.792 | 0.598    | 0.630 |
| 9/16 x 12  | 0.562 | 0.937 | 0.854 | 0.844 | 1.219 | 1.135 | 1.125 | 1.500 | 1.417 | 1.406 | 1.781 | 1.698 | 1.687 | 2.062 | 1.979 | 0.661    | 0.694 |
| 5/8 x 11   | 0.625 | 1.034 | 0.943 | 0.937 | 1.347 | 1.256 | 1.250 | 1.659 | 1.568 | 1.562 | 1.972 | 1.881 | 1.875 | 2.234 | 2.193 | 0.732    | 0.767 |
| 11/16 x 11 | 0.687 | 1.097 | 1.006 | 1.031 | 1.441 | 1.350 | 1.375 | 1.696 | 1.694 | 1.718 | 2.128 | 2.037 | 2.062 | 2.472 | 2.381 |          |       |
| 3/4 x 10   | 0.750 | 1.200 | 1.100 | 1.125 | 1.575 | 1.475 | 1.500 | 1.950 | 1.850 | 1.875 | 2.325 | 2.225 | 2.250 | 2.700 | 2.606 | 0.868    | 0.905 |
| 7/8 x 9    | 0.875 | 1.375 | 1.264 | 1.312 | 1.812 | 1.701 | 1.750 | 2.250 | 2.139 | 2.187 | 2.687 | 2.576 | 2.625 | 3.125 | 3.014 | 1.006    | 1.051 |
| 1" x 8     | 1.000 | 1.563 | 1.437 | 1.500 | 2.062 | 1.937 | 2.000 | 2.562 | 2.437 | 2.500 | 3.062 | 2.937 | 3.000 | 3.562 | 3.437 | 1.147    | 1.197 |
| 1.1/8" x 7 | 1.125 | 1.768 | 1.625 | 1.687 | 2.330 | 2.187 | 2.250 | 2.893 | 2.750 | 2.812 | 3.455 | 3.312 | 3.375 | 4.018 | 3.875 | 1.293    | 1.354 |
| 1.1/4" x 7 | 1.250 | 1.893 | 1.750 | 1.875 | 2.518 | 2.375 | 2.500 | 3.143 | 3.000 | 3.125 | 3.768 | 3.625 | 3.750 | 4.393 | 4.250 | 1.418    | 1.484 |
| 1.1/2" x 6 | 1.500 | 2.250 | 2.083 | 2.250 | 3.000 | 2.833 | 3.000 | 3.750 | 3.583 | 3.750 | 4.500 | 4.333 | 4.500 | 5.250 | 5.083 | 1.696    | 1.776 |

| BSF        | 1,0 D |       |       | 1,5 D |       |       | 2,0 D |       |       | 2,5 D |       |       | 3,0 D |       |       | F (inch) |       |
|------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|----------|-------|
|            | T     | D     | B     | T     | D     | B     | T     | D     | B     | T     | D     | B     | T     | D     | B     | min.     | max.  |
| 3/16 x 32  | 0.187 | 0.327 | 0.296 | 0.281 | 0.421 | 0.390 | 0.375 | 0.515 | 0.484 | 0.468 | 0.608 | 0.577 | 0.562 | 0.702 | 0.671 | 0.225    | 0.247 |
| 7/32 x 28  | 0.218 | 0.379 | 0.343 | 0.328 | 0.489 | 0.453 | 0.437 | 0.598 | 0.562 | 0.546 | 0.707 | 0.671 | 0.656 | 0.817 | 0.781 |          |       |
| 1/4 x 26   | 0.250 | 0.423 | 0.385 | 0.375 | 0.548 | 0.510 | 0.500 | 0.673 | 0.635 | 0.625 | 0.798 | 0.760 | 0.750 | 0.923 | 0.885 | 0.296    | 0.331 |
| 9/32 x 26  | 0.281 | 0.454 | 0.416 | 0.421 | 0.594 | 0.566 | 0.562 | 0.735 | 0.697 | 0.703 | 0.876 | 0.838 | 0.843 | 1.016 | 0.978 |          |       |
| 5/16 x 22  | 0.312 | 0.516 | 0.471 | 0.469 | 0.673 | 0.628 | 0.625 | 0.829 | 0.784 | 0.781 | 0.985 | 0.940 | 0.937 | 1.141 | 1.096 | 0.367    | 0.405 |
| 3/8 x 20   | 0.375 | 0.325 | 0.550 | 0.562 | 0.787 | 0.737 | 0.750 | 0.975 | 0.925 | 0.937 | 1.162 | 1.112 | 1.125 | 1.350 | 1.300 | 0.435    | 0.476 |
| 7/16 x 18  | 0.437 | 0.687 | 0.631 | 0.656 | 0.906 | 0.850 | 0.875 | 1.125 | 1.069 | 1.093 | 1.343 | 1.287 | 1.312 | 1.562 | 1.506 | 0.504    | 0.555 |
| 1/2 x 16   | 0.500 | 0.781 | 0.719 | 0.750 | 1.031 | 0.969 | 1.000 | 1.281 | 1.219 | 1.250 | 1.531 | 1.469 | 1.500 | 1.781 | 1.719 | 0.575    | 0.630 |
| 9/16 x 16  | 0.562 | 0.843 | 0.781 | 0.844 | 1.125 | 1.063 | 1.125 | 1.406 | 1.344 | 1.406 | 1.687 | 1.625 | 1.687 | 1.968 | 1.906 | 0.637    | 0.700 |
| 5/8 x 14   | 0.625 | 0.946 | 0.875 | 0.937 | 1.258 | 1.187 | 1.250 | 1.571 | 1.500 | 1.562 | 1.883 | 1.812 | 1.875 | 2.196 | 2.125 | 0.710    | 0.775 |
| 11/16 x 14 | 0.687 | 1.008 | 0.937 | 1.031 | 1.352 | 1.281 | 1.375 | 1.696 | 1.625 | 1.718 | 2.039 | 1.968 | 2.062 | 2.383 | 2.312 |          |       |
| 3/4 x 12   | 0.750 | 1.125 | 1.042 | 1.125 | 1.500 | 1.417 | 1.500 | 1.875 | 1.792 | 1.875 | 2.250 | 2.167 | 2.250 | 2.625 | 2.542 | 0.849    | 0.925 |
| 13/16 x 12 | 0.812 | 1.187 | 1.104 | 1.218 | 1.593 | 1.510 | 1.625 | 2.000 | 1.917 | 2.031 | 2.406 | 2.323 | 2.437 | 2.812 | 2.729 |          |       |
| 7/8 x 11   | 0.875 | 1.284 | 1.193 | 1.312 | 1.721 | 1.630 | 1.750 | 2.159 | 2.068 | 2.187 | 2.596 | 2.505 | 2.625 | 3.034 | 2.943 | 0.983    | 1.074 |
| 1" x 10    | 1.000 | 1.450 | 1.350 | 1.500 | 1.950 | 1.850 | 2.000 | 2.450 | 2.350 | 2.500 | 2.950 | 2.850 | 3.000 | 3.450 | 3.350 | 1.119    | 1.220 |
| 1.1/8" x 9 | 1.125 | 1.625 | 1.514 | 1.687 | 2.187 | 2.076 | 2.250 | 2.750 | 2.639 | 2.812 | 3.312 | 3.201 | 3.375 | 3.875 | 3.764 | 1.257    | 1.366 |
| 1.1/4" x 9 | 1.250 | 1.750 | 1.639 | 1.875 | 2.375 | 2.264 | 2.500 | 3.000 | 2.889 | 3.125 | 3.625 | 3.514 | 3.750 | 4.250 | 4.139 | 1.382    | 1.500 |
| 1.3/8" x 8 | 1.375 | 1.938 | 1.813 | 2.062 | 2.625 | 2.500 | 2.750 | 3.312 | 3.188 | 3.437 | 4.000 | 3.875 | 4.125 | 4.688 | 4.563 | 1.523    | 1.657 |
| 1.1/2" x 8 | 1.500 | 2.063 | 1.938 | 2.250 | 2.813 | 2.688 | 3.000 | 3.563 | 3.438 | 3.750 | 4.313 | 4.188 | 4.500 | 5.063 | 4.938 | 1.648    | 1.811 |



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

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



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