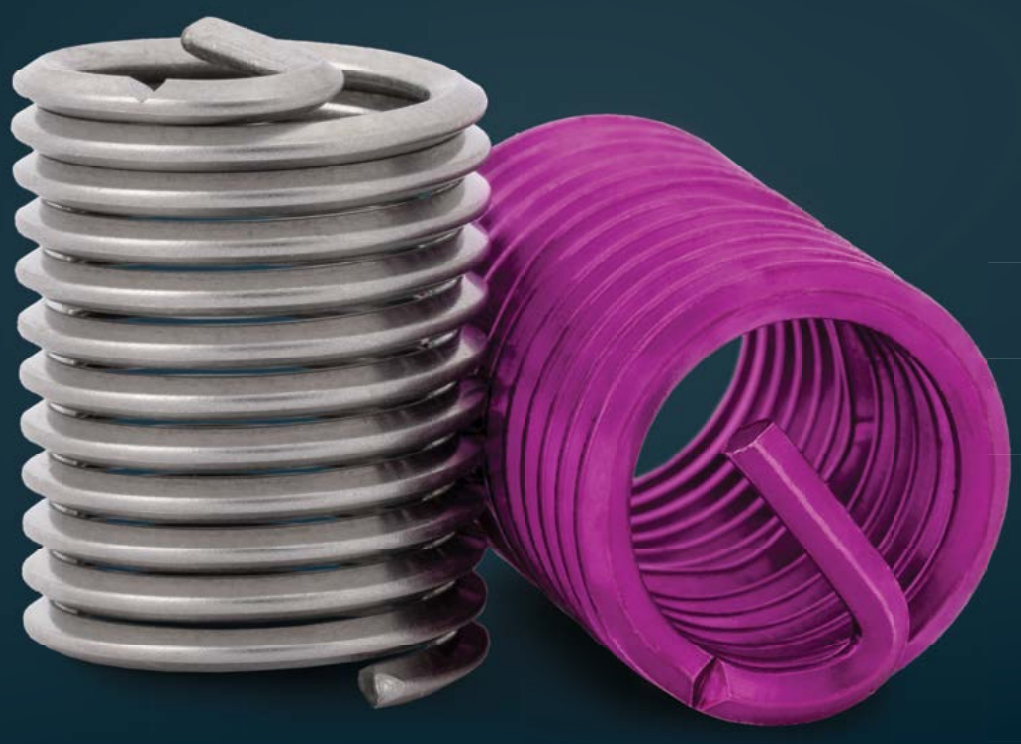
BAER GERMANY

BaerCoil®

WIRE THREAD INSERTS



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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 distributer 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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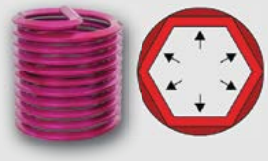

BaerCoil® Wire Thread Inserts
Special materials: Bronze, Stainless Steel AISI 316 (V4A)
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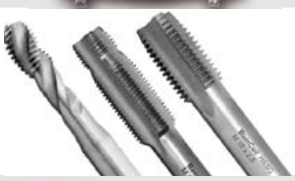

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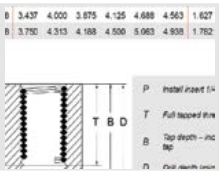

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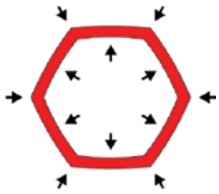
BaerCoil® Thread Reinforcement & Thread Repair

BaerCoil® Wire Thread Inserts - typee: “free running“

BaerCoil® thread inserts are made from austenitic chromium-nickel steel (stainless steel AISI 304 with a material tensile strength of at least 1400 N/mm²). In production the wire is swaged in cold-form to a rhombic cross-section, which ensures performance and maximum space utilization. With BaerCoil® thread inserts you achieve a better thread connection in regard to wear resistance, thread abrasion, surface finish, corrosion- and heat resistance than with any other single screw connection.

BaerCoil® Wire Thread Inserts - typee: “screw grip“

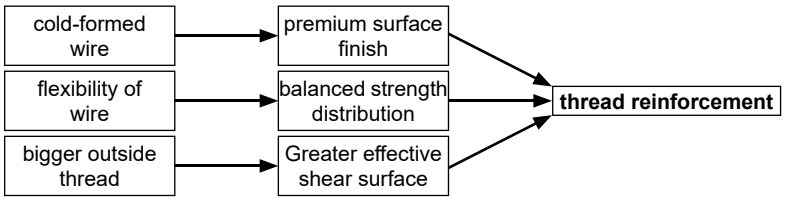


In addition to “free-running” insert characteristics, BaerCoil® “screw grip” thread inserts have one or more polygon-formed windings, which have a clamping effect on the flanks of the inserted screw. We only recommend using screws with a higher screw property class (from 8.8 on) because of this screw locking or screw clamping effect. An elastic and flexible frictional connection is formed. The clamping torque is comparable to the indications in DIN 267 Part 15 and ISO 2320. BaerCoil® “screw grip” thread inserts are predominantly used in areas where screw connections must remain tight while exposed to impacts, constant vibrations and movements.

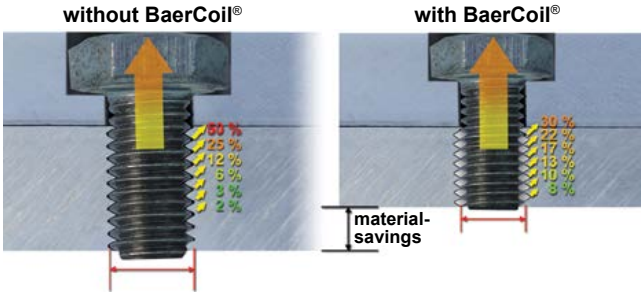
i see locking torque values on page 7

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.

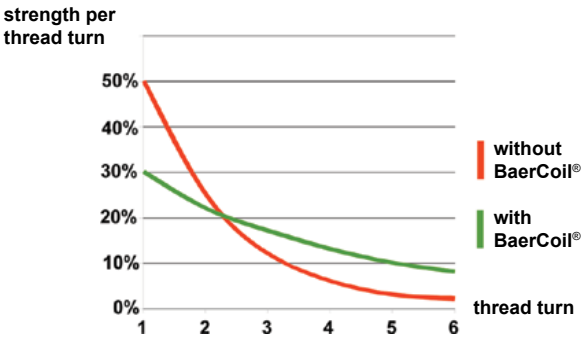


example from test results	
material	Magnesium
thread - length	M 10 x 1,5 - 10 mm
pull-out strength without BaerCoil	3540 kg/mm²
pull-out strength with BaerCoil	4570 kg/mm²
relative increase	about 29 %



Premium surface finish

BaerCoil® thread inserts have a premium surface finish (about 2,5 µm) and are made predominantly from stainless steel (AISI 304) or other materials with a hardness (min. 425 HV 0,2) that far exceeds normal screw connections. For repetitive screw connections these properties ensure, among other things, a higher and consistent tension force at the same torque strength. This leads to a better utilization of yield strength. The torsion tension is up to 90% less than for threads without BaerCoil® thread inserts.



Balanced strength distribution

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

Greater effective shear surface

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

Protection against wear of a thread

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

Corrosion-resistance

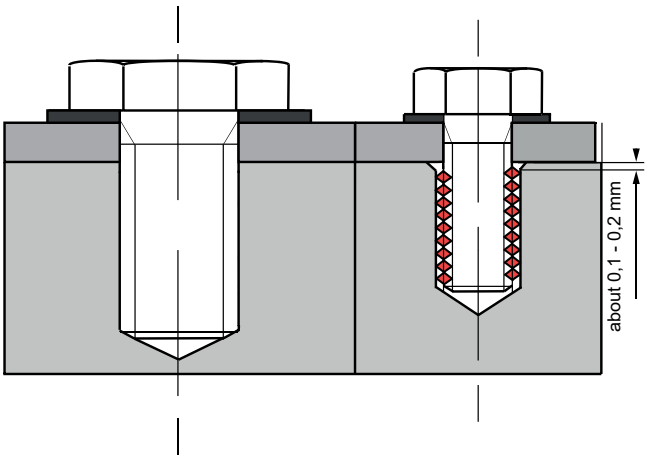
BaerCoil® thread inserts also have excellent corrosion-resistance properties. This ensures applicability in almost all materials and under most conditions.

Flexibility

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

Reductions of weight and space

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



Minimize total costs

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

Thread Repair

Besides thread reinforcement, the BaerCoil® thread insert also facilitates the repair of damaged threads. Rejected parts can be salvaged while maintaining the original thread size. Additionally, the thread is strengthened in its pull-out- and corrosion resistance. In maintenance the use of these thread inserts saves procurement- and processing costs for spare parts.

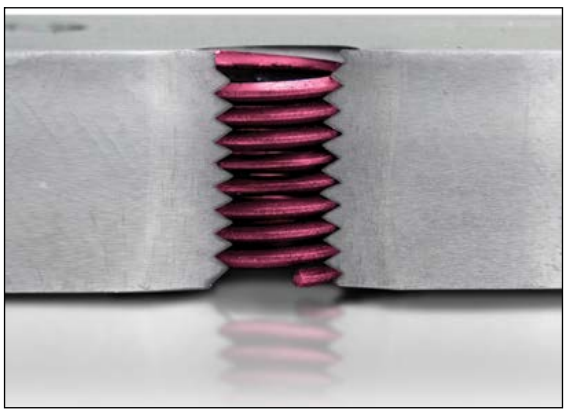
Applications

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

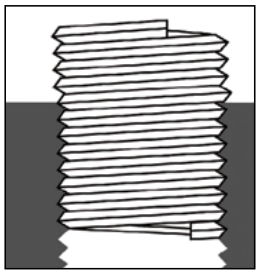
- Aluminum and aluminum alloys
- Brass, bronze, cast-iron
- Magnesium alloys
- Steels etc.

Application examples:

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



Design



The outer diameter of non-installed BaerCoil® thread inserts is larger by a fixed measure than the receiving thread. This is necessary in order to apply radial pressure during installation to the inner thread of the receiving thread. This radial pressure safely and firmly seats the thread insert in the receiving thread. Additional securing elements are, therefore, not required. The thread insert adjusts to the thread turns and slightly expands in length. This is why the length of the thread insert can only be measured when installed since it lengthens while being pressed together as it adjusts to the cut thread.
Each thread insert size is available in 5 lengths. Lengths range from 1 x, 1.5 x, 2 x, 2.5 x and 3 times the size of the thread diameter. Other lengths are available upon request.

Materials

	Material	Tensile Strength	Temperature resistance	Examples of use	
	Stainless Steel V2A AISI 304 X5CrNi18-10 Material-No.: 1.4301	>1400 N/mm²	315°C long-term 425°C short-term	standard applications for all property classes and materials for Thread Repair and Thread Reinforcement	
	Stainless Steel V4A AISI 316 X5CrNiMo17-12-2 Material-No.: 1.4401	>1400 N/mm²	315°C long-term 425°C short-term	- increased corrosion protection - low thread friction - for high alloyed CrNi steel screws	general lightweight construction sea water and chlorine-containing water
	Inconel X750 NiCr15Fe7TiAl Material-No.: 2.4669	>1150 N/mm²	550°C long-term 750°C short-term	- high thermal load - high corrosion protection	- aerospace technology - turbocharger - aeroplane engines - turbines - thermal power plants
	Bronze CuSn6 CW452K Material-No.: 2.1020	> 900 N/mm²	250°C long-term 300°C short-term	- translation threads - CrNi screws - Cu workpieces - non-magnetic	applications in sea water best electric conductivity

Surface treatments

surface treatments	color	applications
cadmium plating	iridescent yellow	provides high corrosion resistance and lubrication to prevent galling - suitable up to 250°C
zinc plating	white	provides corrosion resistance as an alternative to cadmium
silver plating	silver white	to reduce galling of threads at high temperatures
cadmium plate & olive drab	olive drab	as specified on US military specs such as NASM21209.
Dry Film Lubricated	grey	additional lubrication in high friction applications - recommended for use with screw grip inserts

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/mm²	1,5 D	1,5 D	2,0 D	2,5 D	3,0 D			
100 - 150 N/mm²	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/mm²	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/mm²	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/mm²	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/mm²	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/mm²	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/mm²	1,0 D	1,0 D	1,0 D	1,0 D	1,0 D	1,5 D	1,5 D	1,5 D

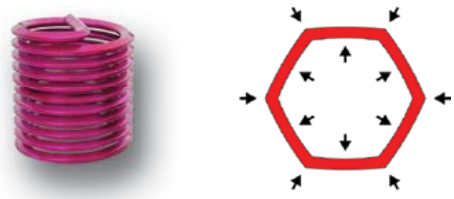
Temperature limits for validity: aluminium alloys max. 300°C, magnesium alloys max. 100°C. For design of screwed connections under thermal stress, the changes of temperature-department material parameters must be taken into account. Intermediate lengths are available, too. For these guide values, the 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 15th cycle [Nm]
M 2 x 0.4	0.12	0,003
M 2.2 x 0.45	0.14	0.02
M 2.5 x 0.45	0.22	0.06
M 3 x 0.5	0.44	0.1
M 3.5 x 0.6	0.68	0.12
M 4 x 0.7	0.9	0.16
M 5 x 0.8	1.6	0.3
M 6 x 1.0	3	0.4
M 7 x 1.0	4.4	0.6
M 8 x 1.25	6	0.8
M 10 x 1.5	10	1.4
M 12 x 1.75	15	2.2
M 14 x 2.0	23	3
M 16 x 2.0	32	4.2
M 18 x 2.5	42	5.5
M 20 x 2.5	54	7
M 22 x 2.5	70	9
M 24 x 3.0	80	11
M 27 x 3.0	95	12
M 30 x 3.5	110	14
M 33 x 3.5	125	16
M 36 x 4.0	140	18

thread dimension	max. locking torque [Nm]	min. locking torque 15th cycle
UNC 2 x 56	20 oz-in	3 oz-in
UNC 3 x 48	32 oz-in	7 oz-in
UNC 4 x 40	48 oz-in	10 oz-in
UNC 5 x 40	75 oz-in	13 oz-in
UNC 6 x 32	6 lb-in	1 lb-in
UNC 8 x 32	9 lb-in	1.5 lb-in
UNC 10 x 24	13 lb-in	2 lb-in
UNC 12 x 24	24 lb-in	3 lb-in
UNC 1/4 x 20	30 lb-in	4.5 lb-in
UNC 5/16 x 18	60 lb-in	7.5 lb-in
UNC 3/8 x 16	80 lb-in	12 lb-in
UNC 7/16 x 14	100 lb-in	16.5 lb-in
UNC 1/2 x 13	150 lb-in	24 lb-in
UNC 9/16 x 12	200 lb-in	30 lb-in
UNC 5/8 x 11	300 lb-in	40 lb-in
UNC 3/4 x 10	400 lb-in	60 lb-in
UNC 7/8 x 9	600 lb-in	82 lb-in
UNC 1“ x 8	800 lb-in	110 lb-in
UNC 1.1/8“ x 7	900 lb-in	137 lb-in
UNC 1.1/4“ x 7	1000 lb-in	165 lb-in
UNC 1.3/8“ x 6	1150 lb-in	185 lb-in
UNC 1.1/2“ x 6	1350 lb-in	210 lb-in

BaerCoil® Thread Inserts - typee: „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

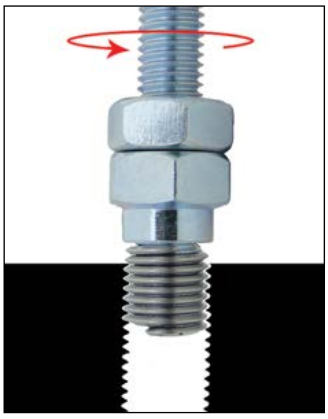
Clear the damaged thread with a standard drill bit. Optionally you can countersink the borehole.

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.

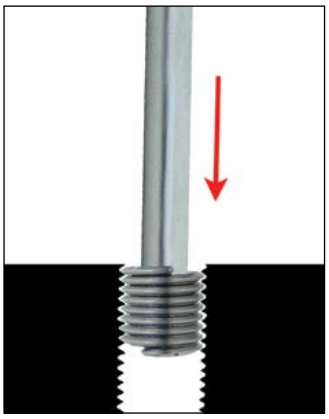
3. Installing thread inserts

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.

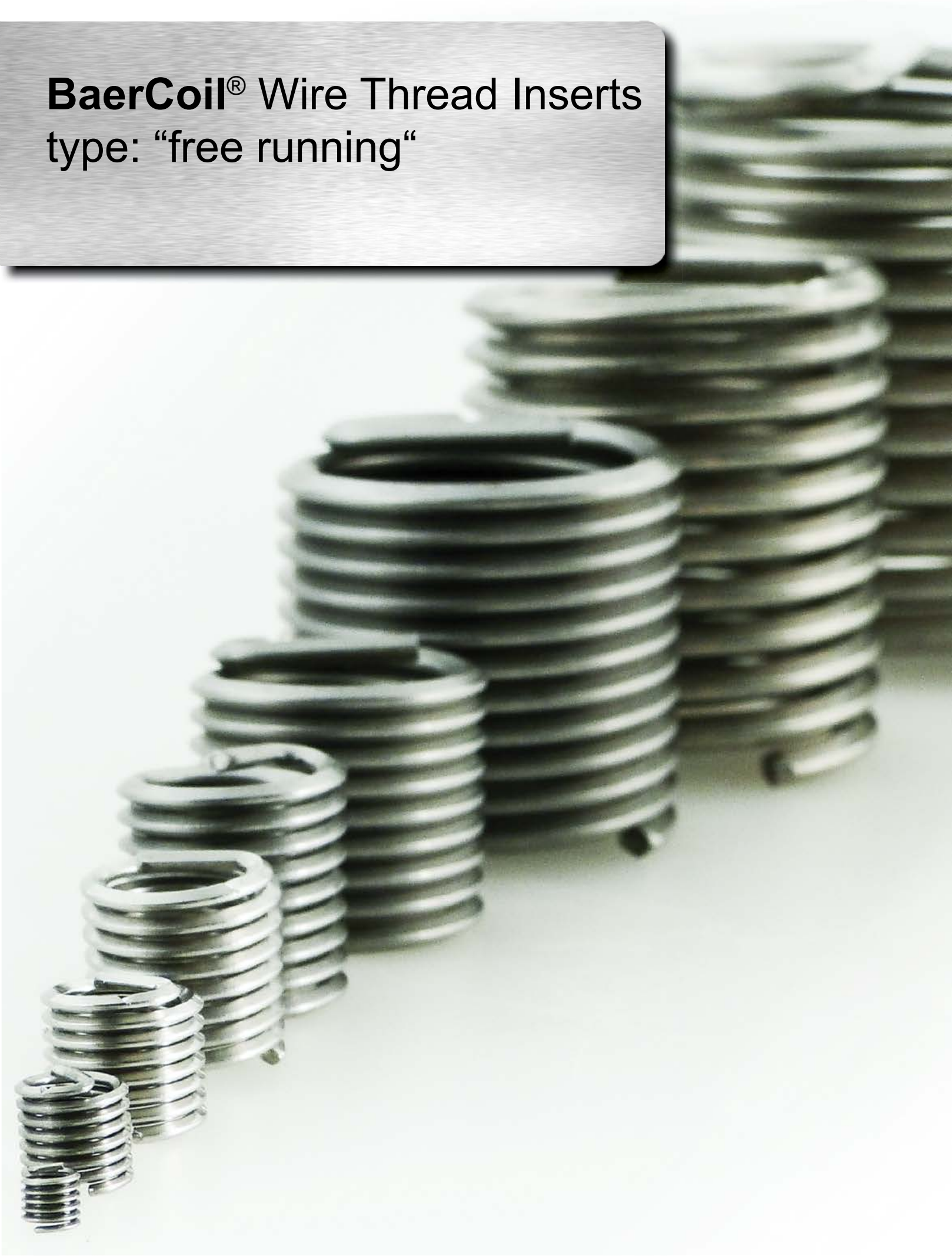


4. Tang removal

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 1,0 x Diameter Item-No.:	Price per unit	1,5 D 1,5 x Diameter Item-No.:	Price per unit	2,0 D 2,0 x Diameter Item-No.:	Price per unit	2,5 D 2,5 x Diameter Item-No.:	Price per unit	3,0 D 3,0 x Diameter 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 €
M 2,5 x 0,45	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 €
	10	2-B7204-1	8,59 €	2-B7204-15	8,65 €	2-B7204-2	6,34 €				
M 3 x 0,5	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 €
	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 €
M 3,5 x 0,6	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 4 x 0,7	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	*
M 5 x 0,8	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 €
	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 €
M 6 x 0,75	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	*				
M 8 x 1,0	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 €
	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 €
M 8 x 1,25	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 €
	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 €
M 9 x 1,0	100	1-BE91-1	*	1-BE91-15	32,74 €	1-BE91-2	*				
	10			2-BE91-15	9,40 €						
M 9 x 1,25	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 €
	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 €
M 10 x 1,0	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 €
	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 €
M 10 x 1,25	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 €
	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 €
M 10 x 1,5	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 €
	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 €
M 11 x 1,0	100	1-BE111-1	*	1-BE111-15	*	1-BE111-2	*				
M 11 x 1,25	100			1-BE1125-15	68,77 €	1-BE1125-2	*				
	10			2-BE1125-15	10,79 €						
M 11 x 1,5	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	*				
M 13 x 1,5	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	*				
M 16 x 1,5	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 €
	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 €
M 16 x 2,0	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 €
	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 €
M 18 x 1,5	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 €
M 18 x 2,5	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 €
M 20 x 2,0	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 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit	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 €
		12,7 mm		**16,7 mm**			
M 18 x 1,5	10	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 1,0 x Diameter	1,5 D 1,5 x Diameter	2,0 D 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 Threads per inch	pack. unit	1,0 D 1,0 x Diameter Item-No.:	Price per unit	1,5 D 1,5 x Diameter Item-No.:	Price per unit	2,0 D 2,0 x Diameter Item-No.:	Price per unit	2,5 D 2,5 x Diameter Item-No.:	Price per unit	3,0 D 3,0 x Diameter 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 €
	10							2-B8200-25	12,84 €		
UNC 3 x 48	100	1-B8213-1	27,56 €	1-B8213-15	29,80 €	1-B8213-2	30,89 €			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 €
	10			2-B8201-15	12,80 €						
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 €
	10			2-B8202-15	9,88 €			2-B8202-25	16,67 €		
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 €
	10			2-B8203-15	6,28 €	2-B8203-2	6,44 €	2-B8203-25	7,80 €		
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 €
	10			2-B8204-15	5,73 €	2-B8204-2	6,39 €	2-B8204-25	7,46 €		
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 €
	10			2-B8205-15	6,53 €	2-B8205-2	7,73 €	2-B8205-25	8,24 €		
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 €
	10			2-B8206-15	7,46 €			2-B8206-25	12,50 €		
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 €
	10			2-B8207-15	7,46 €	2-B8207-2	7,45 €	2-B8207-25	8,21 €		
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 €
	10			2-B8208-15	8,40 €	2-B8208-2	9,58 €	2-B8208-25	12,06 €		
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 €
	10			2-B8209-15	11,43 €	2-B8209-2	12,13 €	2-B8209-25	15,52 €		
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 €
	10			2-B8210-15	15,14 €	2-B8210-2	19,58 €	2-B8210-25	25,66 €		
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 €
	10			2-B8211-15	16,90 €			2-B8211-25	29,25 €		
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 €
	10			2-B8212-15	17,61 €			2-B8212-25	30,97 €		
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 €
	10	2-B8214-1	14,24 €	2-B8214-15	20,51 €			2-B8214-25	59,74 €		
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 €
	10	2-B8215-1	9,38 €	2-B8215-15	13,08 €						
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 Threads per inch	pack. unit	1,0 D 1,0 x Diameter Item-No.:	Price per unit	1,5 D 1,5 x Diameter Item-No.:	Price per unit	2,0 D 2,0 x Diameter Item-No.:	Price per unit	2,5 D 2,5 x Diameter Item-No.:	Price per unit	3,0 D 3,0 x Diameter 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-B8288-3	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 €
	10			2-B8290-15	10,62 €	2-B8290-2	11,04 €	2-B8290-25	13,19 €		
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 €
	10			2-B8289-15	10,62 €						
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 €
	10			2-B8291-15	9,91 €	2-B8291-2	10,29 €	2-B8291-25	12,32 €		
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 €
	10			2-B8292-15	9,91 €	2-B8292-2	10,29 €	2-B8292-25	12,32 €		
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 €
	10	2-B8293-1	6,23 €	2-B8293-15	6,51 €	2-B8293-2	7,05 €	2-B8293-25	8,92 €		
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 €
	10			2-B8225-15	7,46 €	2-B8225-2	8,43 €	2-B8225-25	13,46 €		
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 €
	10			2-B8226-15	10,24 €	2-B8226-2	11,86 €	2-B8226-25	17,78 €		
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 €
	10			2-B8227-15	14,05 €	2-B8227-2	15,51 €	2-B8227-25	20,69 €		
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 €
	10			2-B8228-15	11,25 €	2-B8228-2	13,96 €	2-B8228-25	16,59 €		
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 €
	10			2-B8229-15	17,36 €	2-B8229-2	14,63 €	2-B8229-25	17,54 €		
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 €
	10			2-B8230-15	18,43 €			2-B8230-25	37,44 €		
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 €
	10			2-B8231-15	21,93 €			2-B8231-25	34,82 €		
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 €
	10			2-B8233-15	28,97 €			2-B8233-25	43,26 €		
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 Threads per inch	pack. unit	1,0 D 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit	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 Threads per inch	pack. unit	1,0 D 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit	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 Threads per inch	pack. unit	1,0 D 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit	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. unit	1,0 D 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit	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)

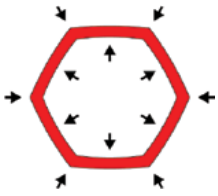
M

Diameter x Pitch	pack. unit	1,0 D 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit	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 €[1]	1-B6125-15	22,61 €[1]	1-B6125-2	27,58 €[1]	1-B6125-25	28,94 €[1]	1-B6125-3	32,81 €[1]
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 €[1]	1-B6135-15	14,50 €[1]	1-B6135-2	17,21 €[1]	1-B6135-25	20,34 €[1]	1-B6135-3	23,54 €[1]
M 4 x 0,7	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 €
	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 €
M 5 x 0,8	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 €
	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 €
M 6 x 1,0	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 €
	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 €
M 7 x 1,0	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 €
	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 €
M 8 x 1,0	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 €
	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 €
M 8 x 1,25	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 €
	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 €
M 10 x 1,25	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 €
	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 €
M 10 x 1,5	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 €
	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 €
M 12 x 1,25	100			1-B6112-15	58,49 €	1-B6112-2	78,06 €	1-B6112-25	97,14 €		
M 12 x 1,5	100			1-B6115-15	60,82 €	1-B6115-2	80,53 €				
M 12 x 1,75	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 €
	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 €
M 14 x 2,0	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 €
	10	2-B6114-1	13,86 €	2-B6114-15	20,80 €	2-B6114-2	27,06 €	2-B6114-25	39,48 €		
M 16 x 2,0	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 €
	10	2-B6116-1	16,97 €	2-B6116-15	25,21 €			2-B6116-25	50,43 €		
M 18 x 2,5	25	1-B6119-1	39,57 €	1-B6119-15	60,05 €						
	10	2-B6119-1	30,70 €	2-B6119-15	45,48 €						
M 20 x 1,5	25	1-B6120-1	185,75 €	1-B6120-15	191,21 €	1-B6120-2	344,17 €				
M 20 x 2,5	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
[1] prices only available for remainder of stock

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

In addition to “free-running” insert characteristics, BaerCoil® “screw grip” thread inserts have one or more polygon-formed windings, which have a clamping effect on the flanks of the inserted screw. We only recommend using screws with a higher screw property class (from 8.8 on), because of this screw locking or screw clamping effect. An elastic and flexible frictional connection is formed. The clamping torque is comparable to the indications in DIN 267 Part 15 and ISO 2320. BaerCoil® “screw grip” thread inserts are predominantly used in areas where screw connections must remain tight while exposed to tremors, constant vibrations and movements. Screw grip inserts are red-colored.



see locking torque on page 7

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

UNC

Diameter x Threads per inch	pack. unit	1,0 D 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit	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 Threads per inch	pack. unit	1,0 D 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit	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 Threads per inch	pack. unit	1,0 D 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit	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. unit	1,0 D 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit	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 Threads per inch	pack. unit	1,0 D 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit
BSW 3/16 x 24	100			1-B6242-15	36,77 €	1-B6242-2	47,28 €	1-B6242-25	52,53 €	1-B6242-3	57,78 €
BSW 1/4 x 20	100			1-B6243-15	44,55 €	1-B6243-2	57,31 €	1-B6243-25	67,40 €	1-B6243-3	79,06 €
BSW 5/16 x 18	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 €
BSW 3/8 x 16	100	1-B6245-1	60,20 €	1-B6245-15	86,78 €	1-B6245-2	113,46 €				
BSW 7/16 x 14	100			1-B6246-15	97,13 €	1-B6246-2	146,98 €	1-B6246-25	195,62 €		
BSW 1/2 x 12	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 €
BSW 5/8 x 11	50	1-B6249-1	182,80 €								

BSF

Diameter x Threads per inch	pack. unit	1,0 D 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit
BSF 1/4 x 26	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 €
BSF 5/16 x 22	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 €
BSF 3/8 x 20	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 €
BSF 7/16 x 18	100	1-B6267-1	168,10 €	1-B6267-15	193,05 €	1-B6267-2	253,77 €	1-B6267-25	325,69 €		
BSF 1/2 x 16	100	1-B6268-1	145,46 €	1-B6268-15	217,16 €	1-B6268-2	287,39 €	1-B6268-25	358,20 €		
BSF 9/16 x 16	50	1-B6269-1	106,01 €	1-B6269-15	157,91 €						
BSF 5/8 x 14	50	1-B6270-1	151,08 €	1-B6270-15	226,30 €	1-B6270-2	302,31 €				
BSF 3/4 x 12	25	1-B6272-1	219,10 €	1-B6272-15	267,54 €	1-B6272-3	518,52 €				
BSF 7/8 x 11	10			1-B6274-15	131,33 €						
BSF 1“ x 10	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 pitch	1,0 D 1,0 x Diameter	1,5 D 1,5 x Diameter	2,0 D 1,5 x Diameter
	Item-No.:	Item-No.:	Item-No.:
M 3 x 0,5	B6103-1MAG	B6103-15MAG	B6103-25MAG
M 4 x 0,7	B6104-1MAG	B6104-15MAG	B6104-25MAG
M 5 x 0,8	B6105-1MAG	B6105-15MAG	B6105-25MAG
M 6 x 1,0	B6106-1MAG	B6106-15MAG	B6106-25MAG
M 8 x 1,25	B6108-1MAG	B6108-15MAG	B6108-25MAG
M 10 x 1,5	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 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 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 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 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 & 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 & 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 & prices on request

Non-magnetic bronze inserts with best electic 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 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit	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	1.000	1-B7202-1TL	508,41 €	1-B7202-15TL	519,62 €	1-B7202-2TL	530,83 €				
M 2,5 x 0,45	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 €
M 3 x 0,5	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 €
M 4 x 0,7	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 €
M 5 x 0,8	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 €
M 6 x 1,0	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 €
M 8 x 1,25	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 €
M 10 x 1,5	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 €
M 12 x 1,75	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 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit
UNC 2 x 56	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 €
UNC 4 x 40	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 €
UNC 6 x 32	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 €
UNC 8 x 32	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 €
UNC 10 x 24	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 €
UNC 1/4 x 20	1.000	1-B8207-1TL	347,60 €	1-B8207-15TL	383,62 €	1-B8207-2TL	416,66 €	1-B8207-25TL	451,19 €	1-B8207-3TL	485,72 €
UNC 5/16 x 18	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 €
UNC 3/8 x 16	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 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit
UNF 10 x 32	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 €
UNF 1/4 x 28	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 €
UNF 5/16 x 24	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 €
UNF 3/8 x 24	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 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit
M 2,5 x 0,45	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 €
M 3 x 0,5	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 €
M 4 x 0,7	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 €
M 5 x 0,8	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 €
M 6 x 1,0	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 €
M 8 x 1,25	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 €
M 10 x 1,5	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 €
M 12 x 1,75	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 €

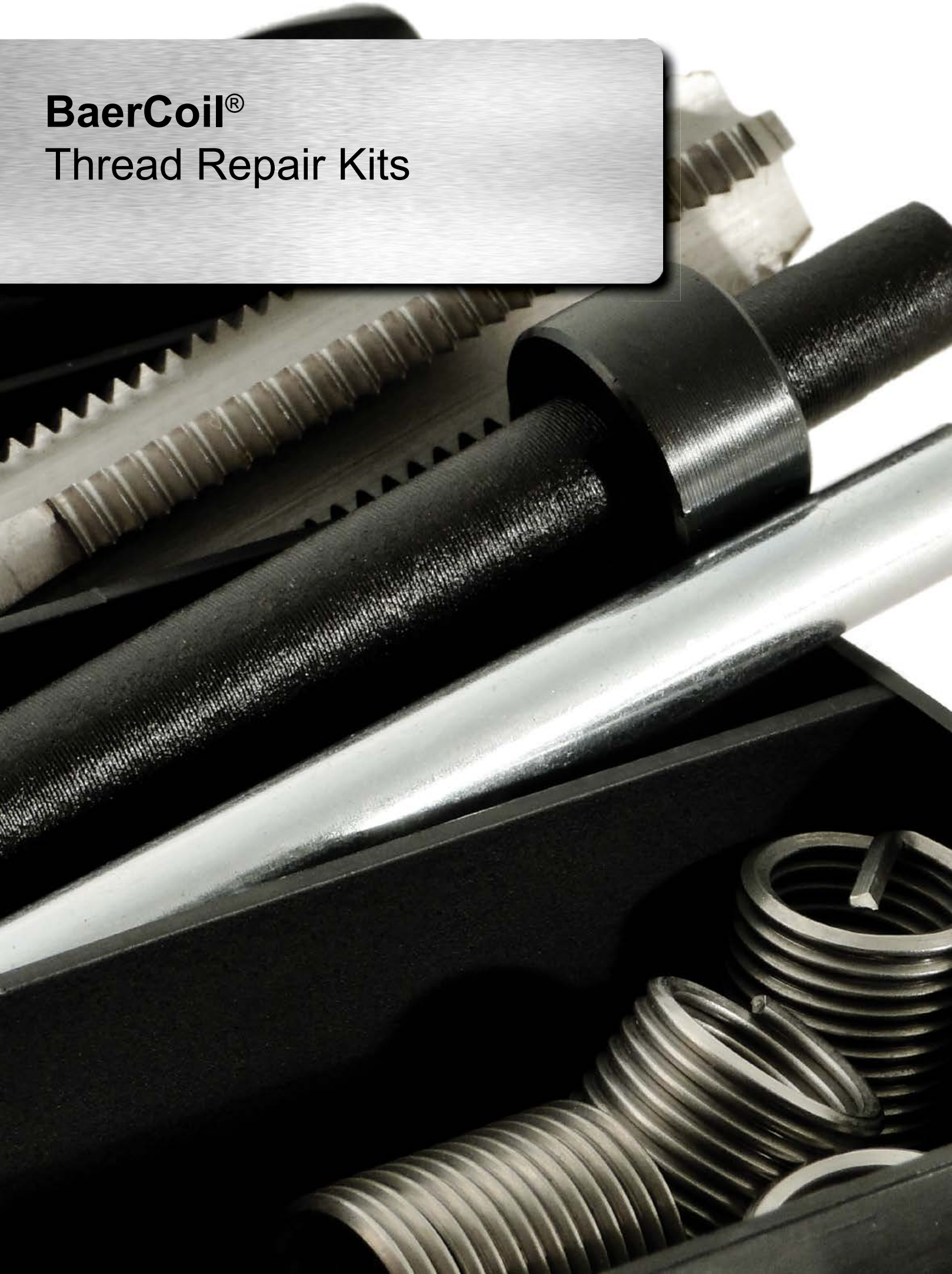
UNC

Diameter x Threads per inch	pack. unit	1,0 D 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit
UNC 2 x 56	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 €
UNC 4 x 40	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 €
UNC 6 x 32	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 €
UNC 8 x 32	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 €
UNC 10 x 24	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 €
UNC 1/4 x 20	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 €
UNC 5/16 x 18	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 €
UNC 3/8 x 16	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 1,0 x Diameter		1,5 D 1,5 x Diameter		2,0 D 2,0 x Diameter		2,5 D 2,5 x Diameter		3,0 D 3,0 x Diameter	
		Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit	Item-No.:	Price per unit
UNF 10 x 32	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 €
UNF 1/4 x 28	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 €
UNF 5/16 x 24	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 €
UNF 3/8 x 24	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



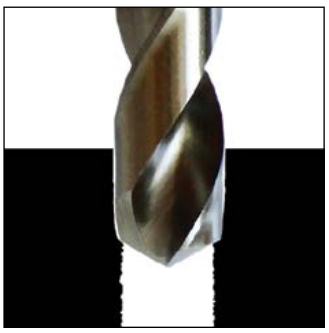
Thread repair

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.

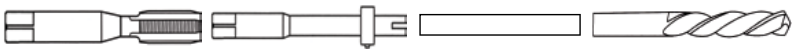
Compatibility

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

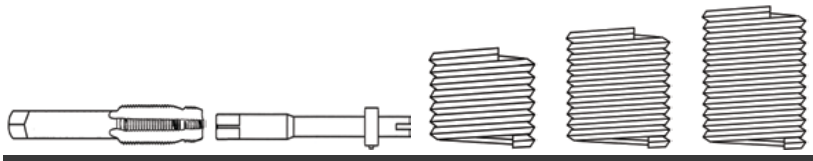
M ISO metric thread



				1,5 D	2,0 D	2,5 D	No.	€
M 3 x 0,5	EBW03	BZ003	3,2 mm	10	5	5	B40052	20,40
M 4 x 0,7	EBW04	BZ004	4,2 mm	10	5	5	B40072	20,30
M 5 x 0,8	EBW05	BZ005	5,2 mm	10	5	5	B40092	20,80
M 6 x 1,0	EBW06	BZ006	6,3 mm	10	5	5	B40102	20,90
M 7 x 1,0	EBW07	BZ006	7,3 mm	10	5	5	B40112	29,00
M 8 x 1,0	EBW08	BZ008	8,3 mm	10	5	5	B40132	29,00
M 8 x 1,25	EBW08	BZ008	8,3 mm	10	5	5	B40122	28,80
M 10 x 1,0	EBW10	BZ010	10,3 mm	10	5	5	B40182	31,00
M 10 x 1,25	EBW10	BZ010	10,3 mm	10	5	5	B40172	31,00
M 10 x 1,5	EBW10	BZ010	10,4 mm	10	5	5	B40162	30,80
M 12 x 1,25	EBW12	BZ012	12,3 mm	10	5	5	B40232	34,80
M 12 x 1,5	EBW12	BZ012	12,4 mm	5	5	5	B40222	34,90
M 12 x 1,75	EBW12	BZ012	12,4 mm	5	5	5	B40212	35,00
M 14 x 1,5	EBW14		14,4 mm	3	3	3	B40292	39,20
M 14 x 2,0	EBW14		14,4 mm	3	3	3	B40282	39,20

BaerCoil® Thread Repair Kits for spark plug

STI Tap HSSG with pilot nose for spark plug
Inserting Tool
Wire Thread Inserts - type: “free running“ - different lengths
different lengths for all applications
Instruction for use



					No.	€
M 10 x 1,0	EBW10	10 mm 5	15 mm 5	20 mm 5	ZKG010	38,60
M 12 x 1,25	EBW12	12 mm 5	18 mm 5	24 mm 5	ZKG012	41,10
M 14 x 1,25	EBW14	8,4 mm 5	12,4 mm 5	16,4 mm 5	ZKG014	42,00
M 18 x 1,5	EBW18	12,7 mm 5	15,9 mm 5	16,7 mm 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.	€
M 12 x 1,5	EBW12	12,4 mm	12 mm 5	18 mm 5	B40223	34,90
M 14 x 1,5	EBW14	14,4 mm	14 mm 5	21 mm 5	B40293	39,80
M 16 x 1,5	EBW16		16 mm 5	24 mm 5	B40333	49,90

BaerCoil® Thread Repair Kits - type: “screw grip“

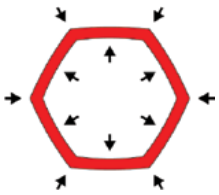
Drill HSS
STI Bottoming Tap HSSG
Inserting Tool
Tang Break Tool
Wire Thread Inserts - **type: “screw grip“ (screw locking)** - length: 1,5 D
for impact resistant and vibration resistant bolted connections
(more information on page 4 - 7)
Instruction for use

M ISO metric thread

				1,5 D	No.	€
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.

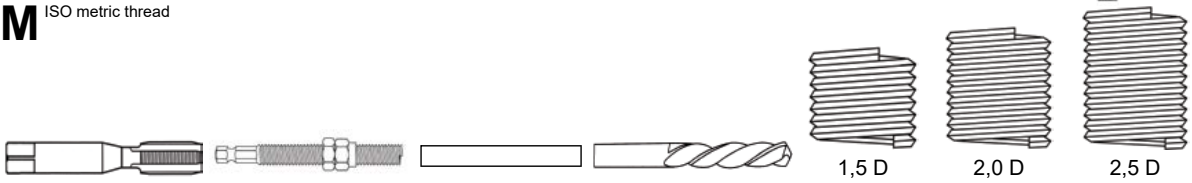


i see locking torque on page 7

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

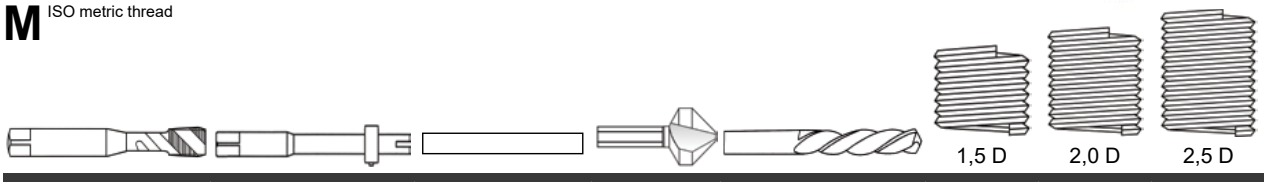


				1,5 D	2,0 D	2,5 D	No.	€
M 3 x 0,5	KEBW03	BZ003	3,2 mm	10	5	5	B40054	23,40
M 4 x 0,7	KEBW04	BZ004	4,2 mm	10	5	5	B40074	23,40
M 5 x 0,8	KEBW05	BZ005	5,2 mm	10	5	5	B40094	23,40
M 6 x 1,0	KEBW06	BZ006	6,3 mm	10	5	5	B40104	25,50
M 8 x 1,25	KEBW08	BZ008	8,3 mm	10	5	5	B40124	31,40
M 10 x 1,5	KEBW10	BZ010	10,4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

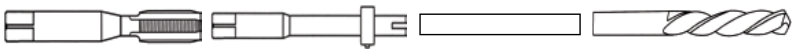


					1,5 D	2,0 D	2,5 D	No.	€
M 3 x 0,5	EBW03	BZ003	10,4 mm	3,2 mm	10	5	5	B40055	36,60
M 4 x 0,7	EBW04	BZ004	10,4 mm	4,2 mm	10	5	5	B40075	36,60
M 5 x 0,8	EBW05	BZ005	10,4 mm	5,2 mm	10	5	5	B40095	36,60
M 6 x 1,0	EBW06	BZ006	10,4 mm	6,3 mm	10	5	5	B40105	36,60
M 7 x 1,0	EBW07	BZ006	10,4 mm	7,3 mm	10	5	5	B40115	54,30
M 8 x 1,25	EBW08	BZ008	10,4 mm	8,3 mm	10	5	5	B40125	54,80
M 10 x 1,5	EBW10	BZ010	16,5 mm	10,4 mm	10	5	5	B40165	56,70
M 12 x 1,5	EBW12	BZ012	16,5 mm	12,4 mm	5	5	5	B40225	72,20
M 12 x 1,75	EBW12	BZ012	16,5 mm	12,4 mm	5	5	5	B40215	72,20
M 14 x 1,5	EBW14		16,5 mm	14,4 mm	5	5		B40295	75,80
M 16 x 2,0	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



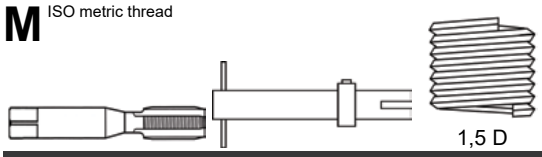
				1,5 D	No.	€
M 2 x 0,4	EBW01	BZ001	2,1 mm	20	B4001	21,00
M 2,2 x 0,45	EBW01	BZ001	2,3 mm	20	B4002	45,80
M 2,5 x 0,45	EBW02	BZ002	2,6 mm	20	B4003	20,30
M 3 x 0,5	EBW03	BZ003	3,2 mm	20	B4005	20,30
M 3,5 x 0,6	EBW03	BZ003	3,7 mm	20	B4006	20,30
M 4 x 0,7	EBW04	BZ004	4,2 mm	20	B4007	20,30
M 5 x 0,8	EBW05	BZ005	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

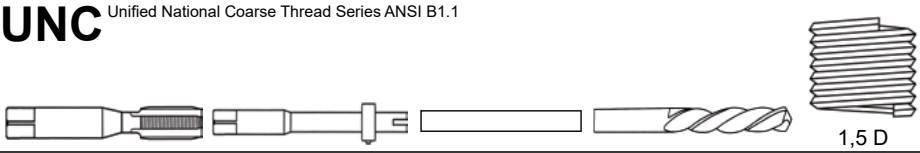


		1,5 D	No.	€
M 18 x 1,5	EBW18	5	B4036	58,00
M 18 x 2,0	EBW18	5	B4035	58,00
M 18 x 2,5	EBW18	5	B4034	58,00
M 20 x 1,5	EBW20	5	B4039	63,00
M 20 x 2,0	EBW20	5	B4038	63,00
M 20 x 2,5	EBW20	5	B4037	63,00
M 22 x 1,5	EBW22	5	B4042	73,00
M 22 x 2,0	EBW22	5	B4041	73,00
M 22 x 2,5	EBW22	5	B4040	73,00
M 24 x 1,5	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

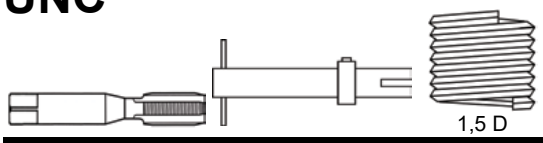


				1,5 D	No.	€
UNC 2 x 56	EBW01	BZ001	2,3 mm	20	B4100	66,00
UNC 3 x 48	EBW02	BZ002	2,6 mm	10	B4348	66,00
UNC 4 x 40	EBW03	BZ003	3,0 mm	20	B4101	28,00
UNC 5 x 40	EBW03	BZ003	3,4 mm	20	B4106	28,00
UNC 6 x 32	EBW03	BZ003	3,7 mm	20	B4102	28,00
UNC 8 x 32	EBW04	BZ004	4,5 mm	20	B4103	28,00
UNC 10 x 24	EBW04	BZ004	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

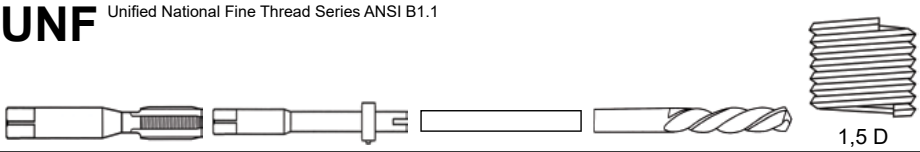


		1,5 D	No.	€
UNC 11/16x11	EBW16	5	B41116	280,00
UNC 3/4 x 10	EBW18	5	B4114	147,00
UNC 7/8 x 9	EBW22	5	B4115	179,00
UNC 1“x 8	EBW24	5	B4116	170,00
UNC 1.1/8 x 7	EBW26	10	B4117	399,00
UNC 1.1/4 x 7	EBW30	10	B4118	453,20
UNC 1.3/8 x 6	EBW31	10	B4119	543,40
UNC 1.1/2 x 6	EBW36	10	B4120	633,60

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



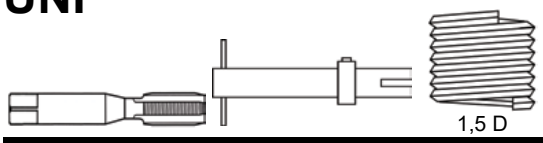
				1,5 D	No.	€
UNF 2 x 64	EBW01	BZ001	2,3 mm	10	B41201	115,80
UNF 3 x 56	EBW02	BZ002	2,6 mm	10	B4356	115,80
UNF 4 x 48	EBW03	BZ003	3,0 mm	20	B41202	27,10
UNF 6 x 40	EBW03	BZ003	3,7 mm	20	B4121	27,10
UNF 8 x 36	EBW04	BZ004	4,4 mm	20	B4122	27,10
UNF 10 x 32	EBW05	BZ005	5,1 mm	20	B4123	27,10
UNF 1/4 x 28	EBW06	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

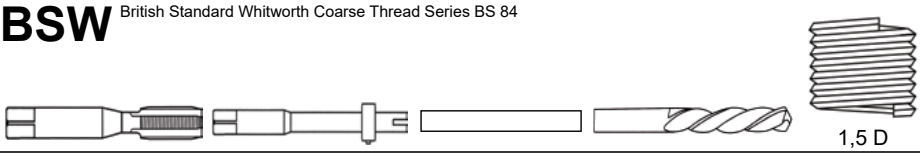


		1,5 D	No.	€
UNF 3/4 x 16	EBW20	5	B4132	117,00
UNF 7/8 x 14	EBW22	5	B4133	137,00
UNF 1“ x 12	EBW24	5	B4134	137,00
UNF 1“ x 14	EBW24	5	B41351	*
UNF 1.1/8 x 12	EBW30	5	B4137	392,90
UNF 1.1/4 x 12	EBW31	5	B4138	449,00
UNF 1.3/8 x 12	EBW36	5	B4139	534,40
UNF 1.1/2 x 12	EBW39	5	B4140	633,60

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



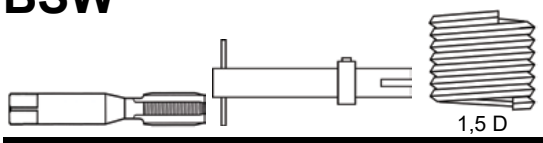
				1,5 D	No.	€
BSW 1/8 x 40	EBW03	BZ003	3,4 mm	20	B4141	55,90
BSW 3/16 x 24	EBW05	BZ005	5,0 mm	20	B4142	55,90
BSW 1/4 x 20	EBW06	BZ006	6,7 mm	20	B4143	49,90
BSW 5/16 x 18	EBW07	BZ006	8,3 mm	20	B4144	52,90
BSW 3/8 x 16	EBW08	BZ008	9,9 mm	15	B4145	57,70
BSW 7/16 x 14	EBW10	BZ010	11,6 mm	10	B4146	63,40
BSW 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



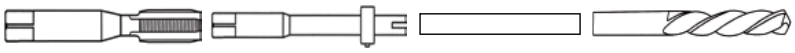
		1,5 D	No.	€
BSW 11/16x11	EBW16	5	B4153	*
BSW 3/4 x10	EBW18	5	B4150	147,40
BSW 7/8 x 9	EBW22	5	B4151	179,10
BSW 1“ x 8	EBW24	4	B4152	170,80
BSW 1.1/8 x 7	EBW26	5	B4154	*
BSW 1.1/4 x 7	EBW30	5	B4155	*
BSW 1.3/8 x 6	EBW31	5	B4156	*
BSW 1.1/2 x 6	EBW36	5	B4157	*

* 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



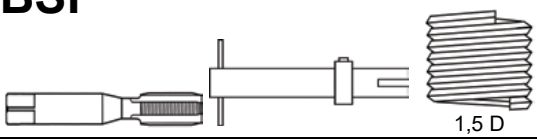
				1,5 D	No.	€
BSF 3/16 x 32	EBW04	BZ004	5,0 mm	20	B4162	55,90
BSF 7/32 x 28	EBW05	BZ005	5,8 mm	10	B4177	*
BSF 1/4 x 26	EBW06	BZ006	6,6 mm	20	B4163	49,90
BSF 9/32 x 26	EBW06	BZ006	7,3 mm	10	B4178	*
BSF 5/16 x 22	EBW07	BZ008	8,3 mm	20	B4165	52,90
BSF 3/8 x 20	EBW08	BZ008	9,9 mm	15	B4166	57,70
BSF 7/16 x 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



		1,5 D	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 2 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

BaerCoil® Thread Repair Kits

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

special sizes

				1,5 D	No.	€
UNEF 1/4 x 32	EBW06	BZ006	6,6 mm	10	B4225	171,10
Harley 1/4 x 24	EBW06	BZ006	6,6 mm	10	B4226	58,10
Harley 7/16 x16	EBW10	BZ010	11,5 mm	10	B4227	66,10
Cummins 11/16x16	EBW14			10	B4228	568,00
Carburetor 7/8 x 20	EBW22			10	B4229	640,50
Carburetor 1“ x 20	EBW24			10	B4230	396,50

BSC British Standard Cycle Thread RS 811

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

leading time: 1 - 3 weeks

NPT American Taper Pipe Thread ANSI B1.20.1

		1,5 D	No.	€
NPT 1/8 x 27	EBW10	10	B4231	247,80
NPT 1/4 x 19	EBW14	10	B4232	247,80
NPT 3/8 x 18	EBW14	10	B4233	247,80
NPT 1/2 x 14	EBW22	5	B4234	247,00
NPT 3/4 x 14	EBW26	5	B4235	376,00
NPT 1“ x 11,5	EBW36	5	B4236	399,00

leading time: 1 - 3 weeks

8 - UN Unified Thread Series 8 TPI ANSI B1.1

		1,5 D	No.	€
1.1/8 x 8	EBW26	5	B4240	707,80
1.1/4 x 8	EBW30	5	B4241	768,40
1.3/8 x 8	EBW31	5	B4242	875,00
1.1/2 x 8	EBW36	4	B4243	982,20
1.5/8 x 8	EBW39	4	B4244	1142,50
1.3/4 x 8	EBW42	4	B4245	1267,00
1.7/8 x 8	EBW42	4	B4246	1445,40
2“ x 8	EBW42	4	B4247	1623,60

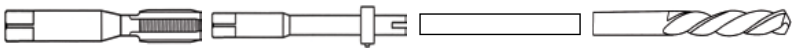
leading time: 1 - 3 weeks

BaerCoil® Thread Repair Workshop Kits

BaerCoil® Thread Repair Workshop Kits

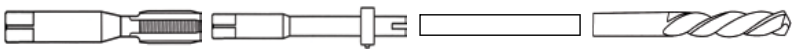
Drill HSS
STI Bottoming Tap HSSG
Inserting Tool
Tang Break Tool
Wire Thread Inserts - type: “free running“ - lengths: **1,5 D - 2,5 D**
different lengths for most applications
Instruction for use

M 3 - M 12



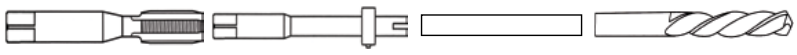
				1,5 D	2,5 D	No.	€
M 3 x 0,5	EBW03	BZ003	3,2 mm	10	5		
M 4 x 0,7	EBW04	BZ004	4,2 mm	10	5		
M 5 x 0,8	EBW05	BZ005	5,2 mm	10	5		
M 6 x 1,0	EBW06	BZ006	6,3 mm	10	5	B5101	154,20
M 8 x 1,25	EBW08	BZ008	8,3 mm	10	5		
M 10 x 1,5	EBW10	BZ010	10,4 mm	5	5		
M 12 x 1,75	EBW12	BZ012	12,4 mm	5	5		

M 5 - M 12



				1,5 D	2,5 D	No.	€
M 5 x 0,8	EBW05	BZ005	5,2 mm	10	5		
M 6 x 1,0	EBW06	BZ006	6,3 mm	10	5		
M 8 x 1,25	EBW08	BZ008	8,3 mm	10	5	B5104	117,50
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



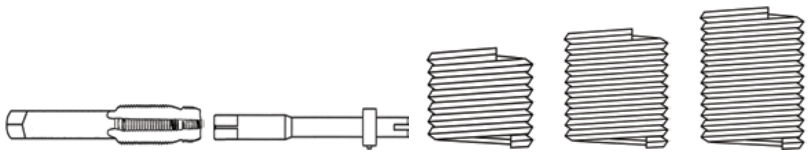
				1,5 D	2,5 D	No.	€
M 5 x 0,8	EBW05	BZ005	5,2 mm	10	5		
M 6 x 1,0	EBW06	BZ006	6,3 mm	10	5	B5131	82,70
M 8 x 1,25	EBW08	BZ008	8,3 mm	10	5		

M 6 - M 10

				1,5 D	2,5 D	No.	€
M 6 x 1,0	EBW06	BZ006	6,3 mm	10	5		
M 8 x 1,25	EBW08	BZ008	8,3 mm	10	5	B5130	93,10
M 10 x 1,5	EBW10	BZ010	10,4 mm	5	5		

BaerCoil® Thread Repair Workshop Kit for spark plug

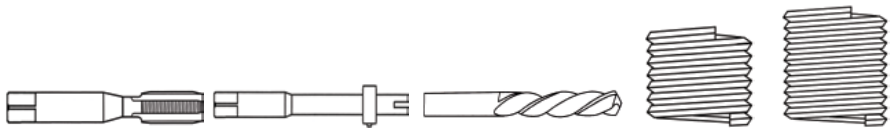
STI Tap HSSG with pilot nose, for spark plug
Inserting Tool
Wire Thread Inserts - type: “free running“
different lengths for most applications
Instruction for use



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

BaerCoil® Thread Repair Workshop Kit for oil drain plug

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



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

BaerCoil® Thread Repair Workshop Kits

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

M 6 - M 14 x 1,5 [2]

				1,5 D	2,5 D	No.	€
M 6 x 1,0	EBW06	BZ006	6,3 mm	10	5	B5116	145,00
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 14 x 1,5[2]	EBW14		14,4 mm	14 mm 5	21 mm 5		

[2] for oil drain plug thread

M 6 - M 14 x 1,25 [1]

				1,5 D	2,5 D		No.	€
M 6 x 1,0	EBW06	BZ006	6,3 mm	10	5		B5108	145,00
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 14 x 1,25[1]	EBW14			8,4 mm 5	12,4 mm 5	16,4 mm 5		

[1] for spark plug thread

automotive - special

				1,5 D	2,5 D		No.	€
M 6 x 1,0	EBW06	BZ006	6,3 mm	10	5		B5109	197,10
M 10 x 1,0[1]	EBW10			10 mm 5	15 mm 5	20 mm 5		
M 12 x 1,25[1]	EBW12			12 mm 5	18 mm 5	24 mm 5		
M 12 x 1,5[2]		BZ012	12,4 mm	12 mm 5	18 mm 5			
M 14 x 1,25[1]	EBW14			8,4 mm 5	12,4 mm 5	16,4 mm 5		
M 14 x 1,5[2]			14,4 mm	14 mm 5	21 mm 5			

[1] for spark plug thread [2] for oil drain plug thread

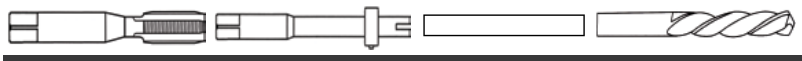
BaerCoil® Thread Repair Workshop Kits - “screw grip“

Drill HSS
STI Bottoming Tap HSSG
Inserting Tool
Tang Break Tool
Wire Thread Inserts - **type: “screw grip“ (screw locking)** - length: 1,5 D
for impact resistant and vibration resistant bolted connections
(more information on page 4 - 7)
Instruction for use

M 3 - M 12

				1,5 D	No.	€
M 3 x 0,5	EBW03	BZ003	3,2 mm	20		
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	B5153	165,90
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		

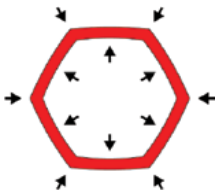
M 5 - M 12



				1,5 D	No.	€
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	B5154	145,10
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.

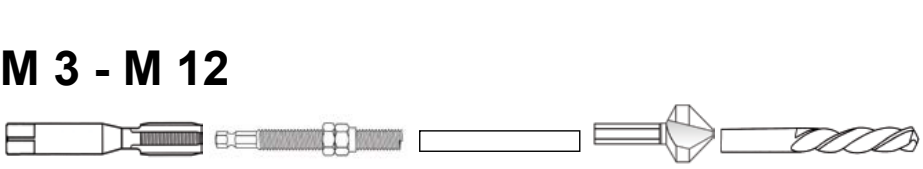


i see locking torque on page 7

BaerCoil® Thread Repair Workshop Kits - PRO

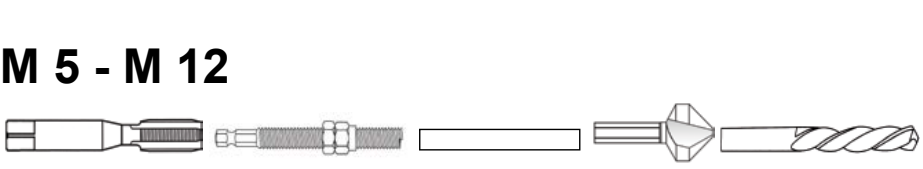
Drill HSS
STI Machine Tap HSSG
Countersink HSS with 1/4“ hexagon drive (bit shank)
Machine Inserting Tool with 1/4“ hexagon drive (bit shank)
Tang Break Tool
Wire Thread Inserts - type: “free running“ - lengths **1,5 D - 2,5 D**
different lengths for most applications

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		

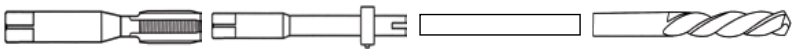
BSF 1/4 - 1/2“

				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



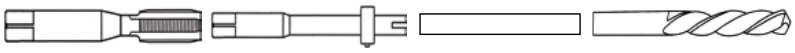
				1,5 D	No.	€
G (BSP) 1/8 x 28	EBW10	BZ010	10,0 mm	5	B5124	240,00
G (BSP) 1/4 x 19	EBW12	BZ012	13,5 mm	5		
G (BSP) 3/8 x 19	EBW14		17,0 mm	5		
G (BSP) 1/2 x 14	EBW22			5		

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 x 25,4 mm x 1,5 = **9,525 mm**

BA Britisch Association Standard Thread BS 93



				1,5 D	No.	€
BA 0	EBW06	BZ006	6,2 mm	5	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

		1,5 D	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

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

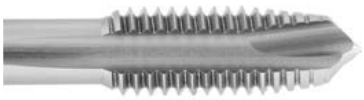
Compatibility

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

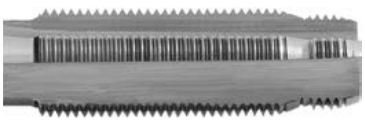
chip removal **hole type**

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

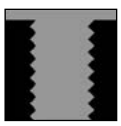


Machine tap
chamfer: Form B (about 4 pitches)
for through hole

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

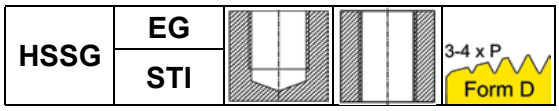


Tap with pilot nose
for thread repair



BaerCoil® Bottoming Taps for Wire Thread Inserts

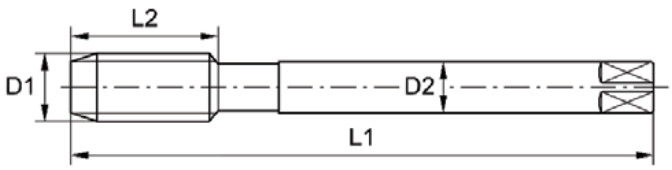
Bottoming Taps can be used by hand or machine



works standard

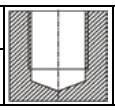
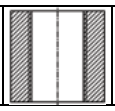
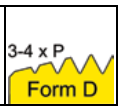
M	D1	D2	L1	L2	□		No.	€
M 2 x 0,4	2,52	2,80	44,5	9,5	2,24	2,1	B3001	6,60
M 2,2 x 0,45	2,79	3,15	48,0	11,0	2,50	2,3	B3002	19,90
M 2,5 x 0,45	3,09	3,15	48,0	11,0	2,50	2,6	B3003	6,60
M 3 x 0,5	3,65	4,00	53,0	13,0	3,15	3,2	B3005	5,80
M 3,5 x 0,6	4,28	4,50	53,0	13,0	3,55	3,7	B3006	16,30
M 4 x 0,7	4,91	5,00	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

HSSG	EG			
	STI			

works standard

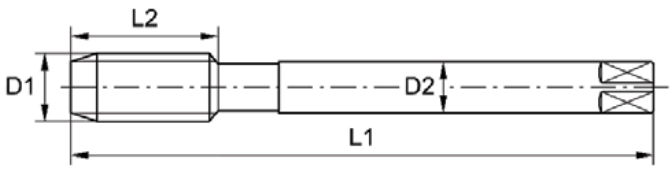
UNC	D1	D2	L1	L2	□		No.	€
UNC 2 x 56	2,77	3,2	48	10	2,50	2,30	B3100	9,20
UNC 3 x 48	3,20	4,0	53	13	3,15	2,60	B3121	56,00
UNC 4 x 40	3,67	4,0	53	13	3,15	3,00	B3101	9,00
UNC 5 x 40	4,00	4,0	53	13	3,15	3,40	B3102	9,00
UNC 6 x 32	4,54	5,0	58	16	4,00	3,70	B3103	9,00
UNC 8 x 32	5,20	5,6	62	17	4,50	4,40	B3104	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

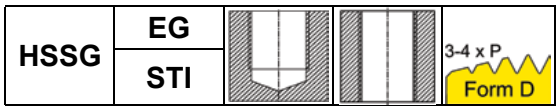
G (BSP)	D1	D2	L1	L2	□		No.	€
G 1/8 x 28	10,82	8,0	59	15	6,3	10,0	B3311	8,70
G 1/4 x 19	14,74	11,2	67	19	9,0	13,5	B3312	11,00
G 3/8 x 19	18,25	14,0	75	21	11,2	17,0	B3313	14,30
G 1/2 x 14	23,09	16,0	87	26	12,5	21,5	B3314	23,30
G 5/8 x 14	25,05	18,0	91	26	14,0	23,5	B3315	34,30
G 3/4 x 14	28,59	20,0	96	28	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 x10	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

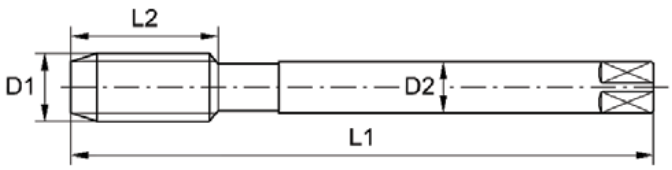
	D1	D2	L1	L2	□		No.	€
UNEF 1/4 x 32	7,3	8,0	69	19	6,3	6,5	B3350	74,00
Harley 1/4 x 24	7,8	8,0	69	29	6,3	6,5	B3351	41,50
Harley 7/16 x 16	13,2	10,8	91	42	8,2	11,5	B3352	41,50
Cummins 11/16x16		14,0	112	37	14,0	18,0	B3353	276,40
Carburetor 7/8 x 20		18,0	120	35	14,0	22,5	B3354	362,20
Carburetor 1“ x 20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

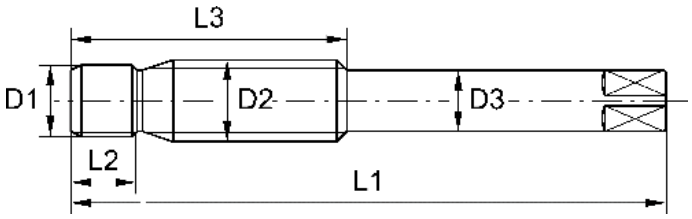
HSSG	EG
	STI

works standard

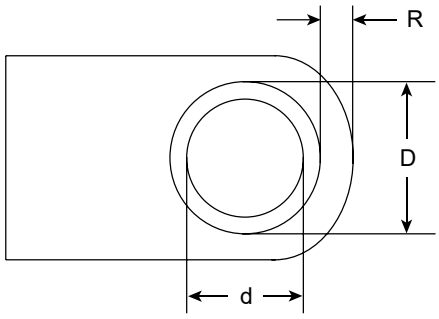
M	D1	D2	D3	L1	L2	□		No.	€
M 6 x 1,0	6,0	7,30	8,0	70	8	28	6,3	B3630	12,00
M 8 x 1,25	8,0	9,62	8,0	75	8	32	6,3	B3631	13,00
M 10 x 1,0*	10,0	11,30	8,0	73	8	32	6,3	B3632	16,20
M 10 x 1,5	10,0	11,95	9,0	80	9	37	7,1	B3633	16,20
M 12 x 1,25*	12,0	13,62	11,0	81	8	33	9,0	B3634	21,00
M 14 x 1,25*	14,0	15,57	12,5	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 (min) = 0,375 x D

The minimum wall thickness mainly depends on individual operating data.
These definde material strength and length of thread engagement. The indicated guide value formulas apply to allumnium, 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

HSSE	
EG	4-5 x P
STI	Form B

through hole

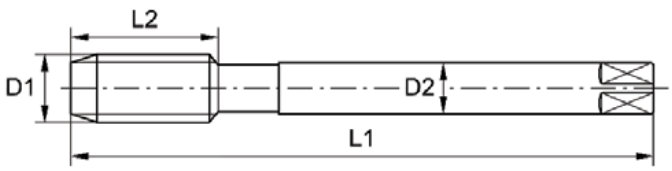
M	D1	D2	L1	L2	□		No.	€
M 3 x 0,5	3,65	4,0	53	13,0	3,15	3,2	B3505	10,80
M 3,5 x 0,6	4,28	4,5	53	13,0	3,55	3,7	B3506	10,80
M 4 x 0,7	4,91	5,0	58	16,0	4,00	4,2	B3507	11,50
M 5 x 0,8	6,04	6,3	66	19,0	5,00	5,3	B3508	11,50
M 6 x 1,0	7,30	8,0	72	22,0	6,30	6,3	B3509	11,50
M 7 x 1,0	8,30	9,0	72	22,0	7,10	7,3	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

HSSE	
EG	2-3 x P
STI	Form C

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

HSSE		
EG	DIN	4 x P
STI	371/376	Form B

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

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

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

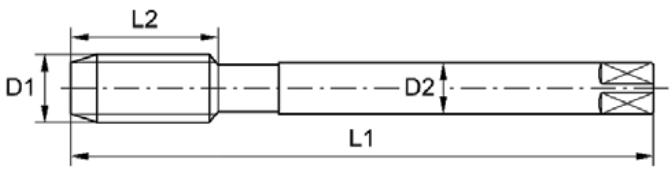
HSSE		
EG	DIN	2,5 x P
STI	371/376	Form C

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	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	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



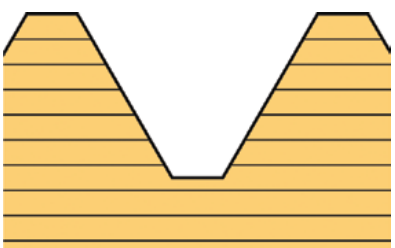
PRO - professional:
Case hardening steels,
heat treatable steels up to 1000 N/mm²,
structural steels, carbon tool steels,
cast steel up to 1000 N/mm²,
wrought alloy of aluminium,
soft brass (Ms63 long chipping),
red brass, copper

BaerCoil® Forming Taps

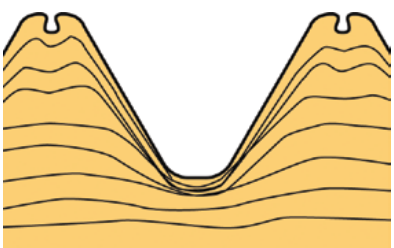
BaerCoil® Forming Taps

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.

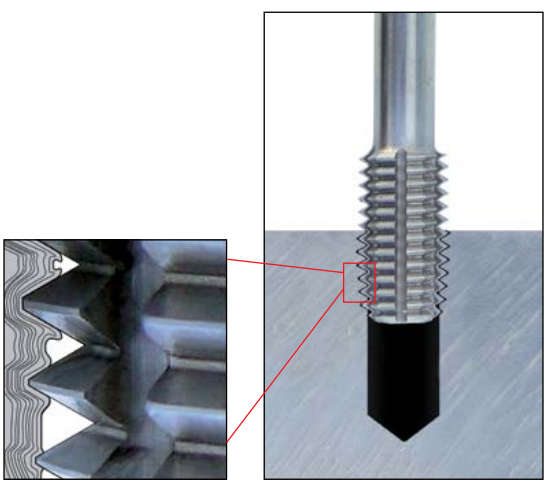
Result: The thread into which the BaerCoil® wire thread insert is turned has a significantly **higher load capacity**. The process of thread forming is **faster** and produces a **better surfac**e than thread cutting. Additionally there are **no chips**, and the thread forming tap has a **longer life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



Grain structure of a cutted thread



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

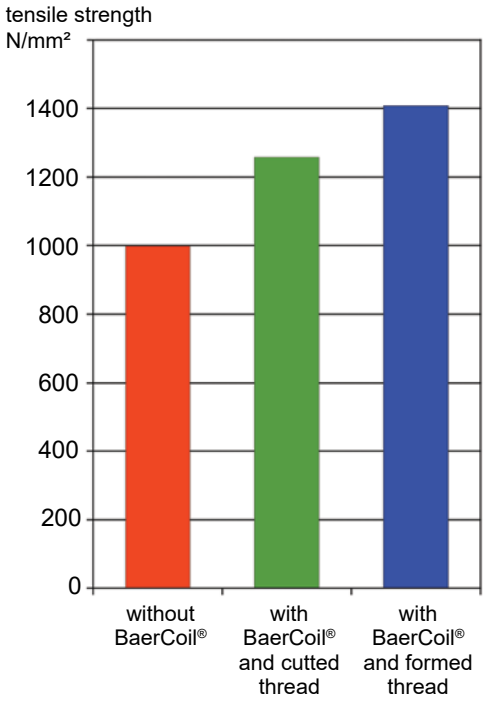


BaerCoil® System for strongest bolted connection

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.

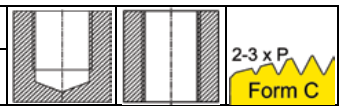
Advantages:
- increased pull out strength and torque of the formed threads
- creates a better surface quality
- no problems with chip
- longer tool lifetime

Materials:
- stainless steel materials up to 950 N/mm²
- construction steels up to 800 N/mm²
- heat-treatable steels up to 1000 N/mm²
- aluminium alloys
- zinc alloys
- copper alloys

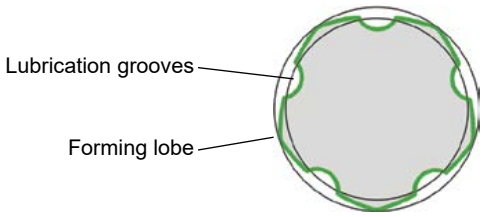


BaerCoil® Forming Taps

HSSE	EG
TIN	STI



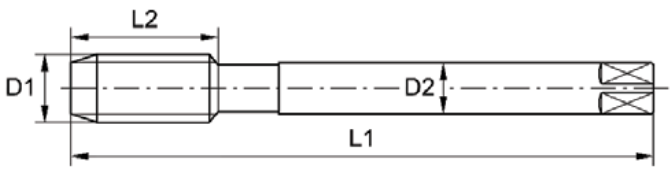
works standard



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

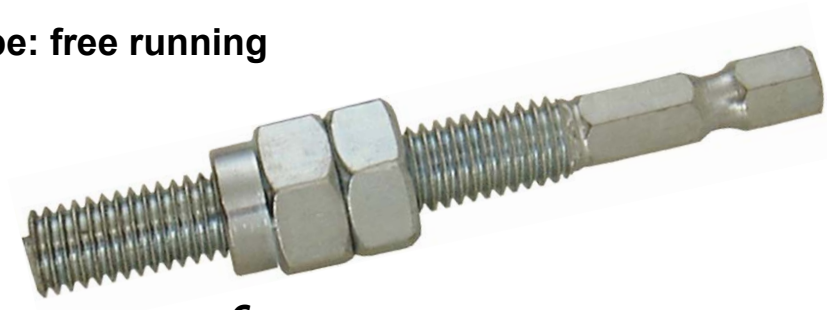
BaerCoil® Inserting Tools

with locking ring for depth stop

M	UNC UNF	BSW BSF	G (BSP) NPT	8-UN	No.	€
M 2 x 0,4 M 2,2 x 0,45	UNC 2 x 56 UNF 2 x 64				EBW01	12,50
M 2,5 x 0,45	UNC 3 x 48 UNF 3 x 56		BA 6		EBW02	12,50
M 18 x 2,5 M 18 x 2,0 M 18 x 1,5	UNC 3/4 x 10	BSW 3/4 x 10 BSF 3/4 x 12 BSF 13/16 x 12			EBW18	23,90
M 20 x 2,5 M 20 x 2,0 M 20 x 1,5	UNF 3/4 x 16				EBW20	23,90
M 22 x 2,5 M 22 x 2,0 M 22 x 1,5	UNC 7/8 x 9 UNF 7/8 x 14	BSW 7/8 x 9 BSF 7/8 x 11	G 1/2 x 14 NPT 1/2 x 14		EBW22	29,90
M 24 x 3,0 M 24 x 2,0 M 24 x 1,5	UNC 1“ x 8 UNF 1“ x 12 UNF 1“ x 14	BSW 1“ x 8 BSF 1“ x 10		1“ x 20	EBW24	29,90
M 26 x 1,5 M 27 x 2,0 M 27 x 1,5	UNC 1.1/8“ x 7	BSW 1.1/8“ x 7	G 3/4 x 14 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 M 30 x 3,0	UNC 1.1/4“ x 7 UNF 1.1/8“ x 12	BSW 1.1/4“ x 7 BSF 1.1/8“ x 9		UN 1.1/4“ x 8	EBW30	62,90
M 30 x 2,0 M 30 x 1,5	UNC 1.3/8“ x 6 UNF 1.1/4“ x 12	BSW 1.3/8“ x 6 BSF 1.1/4“ x 9	G 7/8 x 14	UN 1.3/8“ x 8	EBW31	62,90
M 33 x 3,5 M 33 x 2,0					EBW33	47,80
M 36 x 4,0 M 36 x 3,0	UNC 1.1/2“ x 6 UNF 1.3/8“ x 12	BSW 1.1/2“ x 6 BSF 1.3/8“ x 8	G 1“ x 11 NPT 1“ x 11,5	UN 1.1/2“ x 8	EBW36	62,90
M 36 x 1,5 M 39 x 4,0 M 39 x 3,0 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 M 42 x 4,0 M 42 x 3,0 M 42 x 2,0			G 1.1/4 x 11	UN 1.3/4“ x 8 UN 1.7/8“ x 8 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.	€
M 3 x 0,5	46,00 mm	5,50 mm	1/4“	KEBW03	8,60
M 4 x 0,7	48,00 mm	7,00 mm	1/4“	KEBW04	8,60
M 5 x 0,8	57,00 mm	8,00 mm	1/4“	KEBW05	8,60
M 6 x 1,0	62,00 mm	10,00 mm	1/4“	KEBW06	8,60
M 7 x 1,0	72,00 mm	11,00 mm	1/4“	KEBW07	9,00
M 8 x 1,25	72,00 mm	13,00 mm	1/4“	KEBW08	10,50
M 10 x 1,0	77,00 mm	17,00 mm	1/4“	KEBW1010	12,30
M 10 x 1,5	82,00 mm	17,00 mm	1/4“	KEBW10	11,70
M 12 x 1,25	79,00 mm	19,00 mm	1/4“	KEBW1212	13,50
M 12 x 1,5	79,00 mm	19,00 mm	1/4“	KEBW1215	13,50
M 12 x 1,75	92,00 mm	19,00 mm	1/4“	KEBW12	12,90
M 14 x 1,5	94,00 mm	21,00 mm	1/4“	KEBW1415	13,50
M 14 x 2,0	94,00 mm	21,00 mm	1/4“	KEBW1420	13,50
UNC 1/4 x 20	62,00 mm	7/16 "	1/4“	KEBW21	9,50
UNC 5/16 x 18	67,00 mm	1/2 "	1/4“	KEBW22	9,50
UNC 3/8 x 16	77,00 mm	9/16 "	1/4“	KEBW23	11,60
UNC 7/16 x 14	87,00 mm	11/16 "	1/4“	KEBW24	12,90
UNC 1/2 x 13	97,00 mm	3/4 "	1/4“	KEBW25	13,50
UNF 1/4 x 28	62,00 mm	7/16 "	1/4“	KEBW31	9,50
UNF 5/16 x 24	67,00 mm	1/2 "	1/4“	KEBW32	9,50
UNF 3/8 x 24	77,00 mm	9/16 "	1/4“	KEBW33	11,60
UNF 7/16 x 20	87,00 mm	11/16 "	1/4“	KEBW34	12,90
UNF 1/2 x 20	97,00 mm	3/4 "	1/4“	KEBW35	13,50

BaerCoil® Extracting Tools

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

BaerCoil® Tang Break Tool

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

BaerCoil® Countersink HSSG

with 1/4“ hexagonal drive
to countersink a borehole

Ø	M	UNC UNF	BSW BSF			⬡	No.	€
10,4	M 3 – M 8	UNC 4 x 40 – UNC 5/16 UNF 4 x 48 – UNF 5/16	BSW 3/16 – BSW 5/16 BSF 3/16 – BSF 5/16	BA 0 – BA 6 G 1/8 BSB 1/4 x 26 – BSB 5/16 x 26 BSC 5/16 x 26	NPT 1/8 x 27 UNEF 1/4 x 32 Harley 1/4 x 24	1/4“	B9402	9,35
16,5	M 8 – M 15	UNC 5/16 – UNC 9/16 UNF 5/16 – UNF 9/16	BSW 5/16 – BSW 9/16 BSF 5/16 – BSF 9/16	G 1/4 x 19 BSB 3/8 x 26 – BSB 1/2 x 26 BSC 3/8 x 26 – BSC 1/2 x 26	NPT 1/4 x 19 Harley 7/16 x 16	1/4“	B9403	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 M 18 x 1,5					338-A	111185	29,80
19,50 mm				UNF 3/4 x 16		BSF 3/4 x 12	338-A	111195	33,00
19,75 mm			UNC 3/4 x 10		BSW 3/4 x 10		345	130197	49,00
20,50 mm	M 20 x 2,5	M 20 x 2,0 M 20 x 1,5					338-A	111205	48,00
22,50 mm	M 22 x 2,5	M 22 x 2,0 M 22 x 1,5		UNF 7/8 x 14		BSF 7/8 x 11	345	130225	55,50
23,00 mm			UNC 7/8 x 9		BSW 7/8 x 9		338-A	111230	58,00
24,50 mm	M 24 x 3,0	M 24 x 2,0 M 24 x 1,5					345	130245	55,50
26,00 mm			UNC 1“ x 8	UNF 1“ x 12/14	BSW 1“ x 8	BSF 1“ x 10	338-A	111260	79,00

BaerCoil® Drill Bits

DIN 338 - HSS straight shank drill bit

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

DIN 345 - HSS morse taper shank drill bit

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

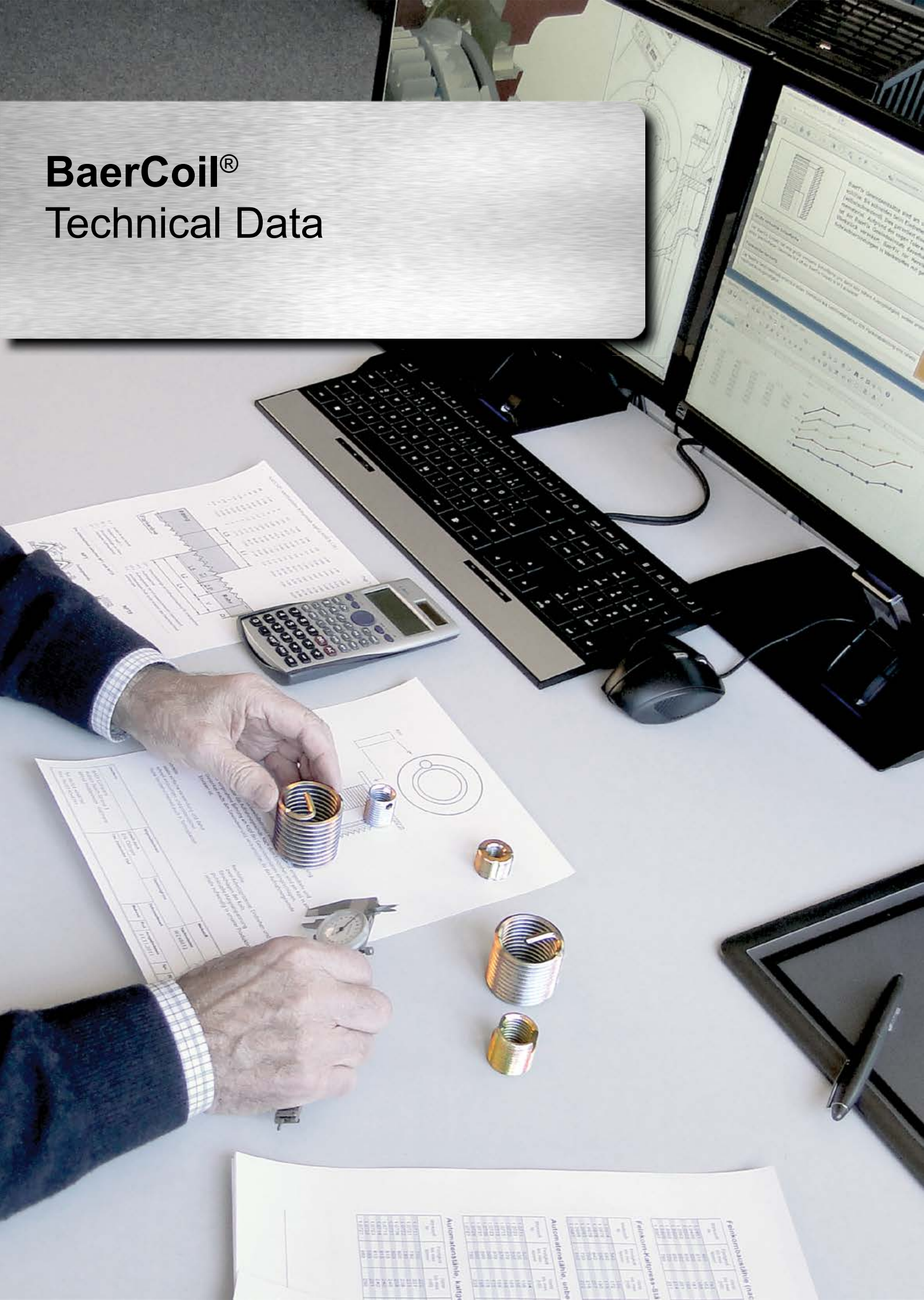
BaerCoil® wire thread inserts and custom-made products

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.

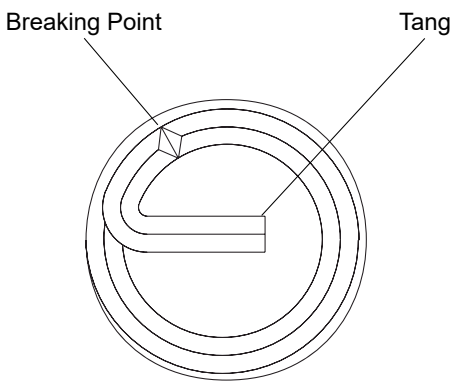
BaerCoil®
Technical Data

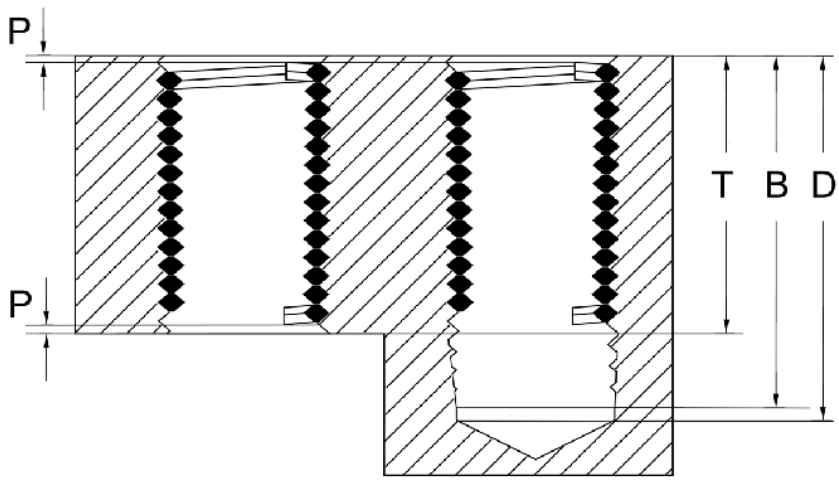


Technical Data for BaerCoil® Wire Thread Inserts

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

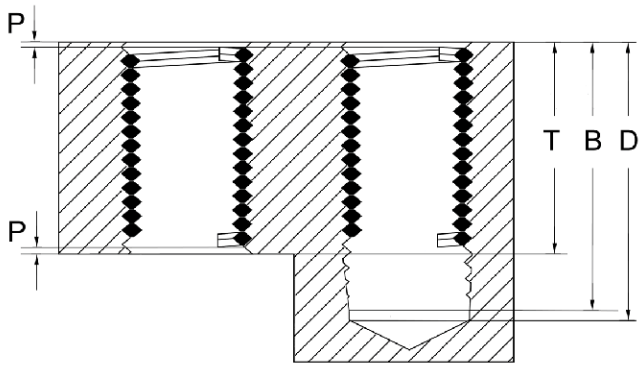
UNC	1,0 D			1,5 D			2,0 D			2,5 D			3,0 D			F (inch)	
	T	D	B	T	D	B	T	D	B	T	D	B	T	D	B	min.	max.
2 x 56	0.086	0.166	0.148	0.129	0.209	0.191	0.172	0.252	0.234	0.215	0.295	0.277	0.258	0.338	0.320	0.107	0.119
3 x 48	0.099	0.193	0.172	0.148	0.242	0.221	0.198	0.292	0.271	0.248	0.342	0.321	0.297	0.391	0.370	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, free-macining steels, cold-extrusion steels etc.	< 600 N/mm²	20 - 80	Cutting oil/ Emulsion
construction steels, heat-treatable steels, cast steels etc.	< 800 N/mm²	20 - 60	Cutting oil/ Emulsion
heat-treatable steels, cold-extrusion steels, nitriding steels etc.	< 1000 N/mm²	10 - 40	Cutting oil
corrosion and acid proof steels ferritic, martensitic	< 950 N/mm²	10 - 25 (with emulsion just limitedly applicable)	Cutting oil
corrosion and acid proof steels austenitic	< 950 N/mm²	10 - 25 (with emulsion just limitedly applicable)	Cutting oil
aluminium wrought alloys	< 550 N/mm²	15 - 40	Cutting oil/ Emulsion
aluminium cast alloys	Si < 12%	15 - 40	Cutting oil/ Emulsion
pure copper	< 400 N/mm²	20 - 40	Cutting oil/ Emulsion
copper-zinc alloys (brass long-chipping)	< 550 N/mm²	40 - 80	Emulsion

forming (cutting) speed [m/min] = (diameter * π * number of rotation) / 1000
number of rotation n [1/min] = (cutting speed in m/min * 1000) / (diameter * π)
feed programming [mm/min] = number of rotation * pitch
Please notice that the mentioned cutting speeds are only for orientation.
The right cutting speed is depend on lubrication and application.

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