BAER GERMANY

BaerCoil®

WIRE THREAD INSERTS

www.baercoil.com

2022

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.

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.

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.

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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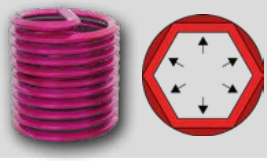
BaerCoil® Wire Thread Inserts - type: “screw grip“	14 - 17	
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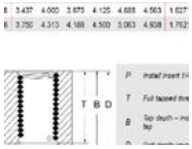
Technical Data	60 - 66	

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BaerCoil®
Catalog 2022

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

BaerCoil® thread inserts are made from austenitic chromium-nickel steel (stainless steel AISI 304 with a material tensile strength of at least 1400 N/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 - type: “screw grip“

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

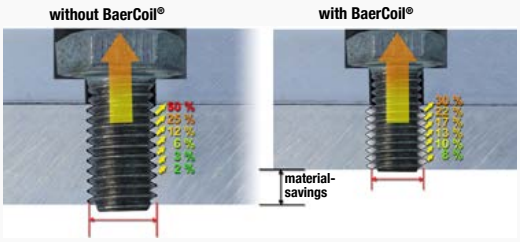
i see locking torque values on page 7

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.

cold-formed wire	→ premium surface finish	→ thread reinforcement
flexibility of wire	→ balanced strength distribution	→ thread reinforcement
bigger outside thread	→ Greater effective shear surface	→ thread reinforcement

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

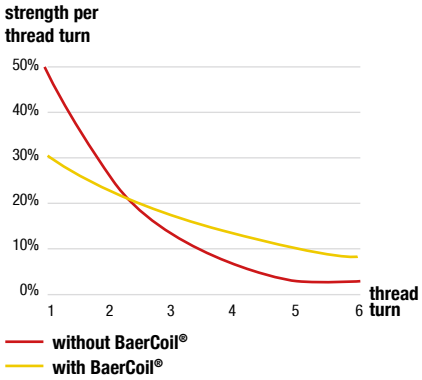
BaerCoil® thread inserts have a premium surface finish (about 2,5 µm) and are made predominantly from stainless steel (AISI 304) or other materials with a hardness (min. 425 HV 0,2) that far exceeds normal screw connections. For repetitive screw connections these properties ensure, among other things, 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.

Premium surface finish

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

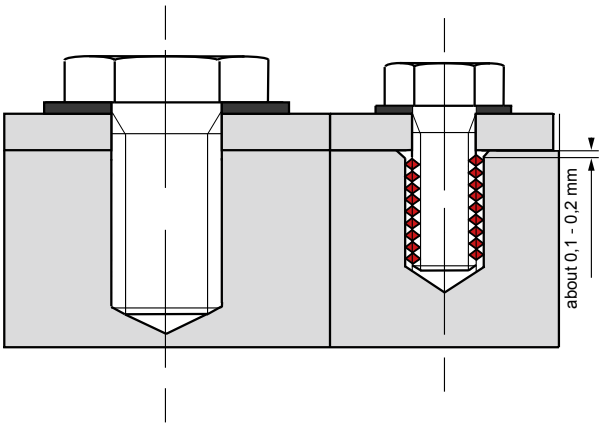
BaerCoil® thread inserts also have excellent corrosion-resistance properties. This ensures applicability in almost all materials and under most conditions.

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.

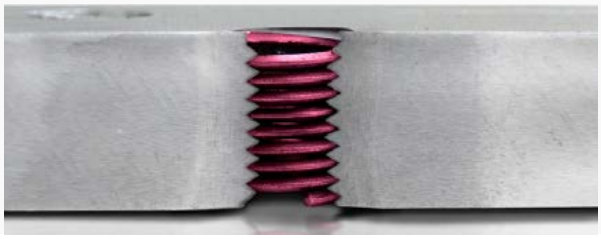
Thread Repair

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

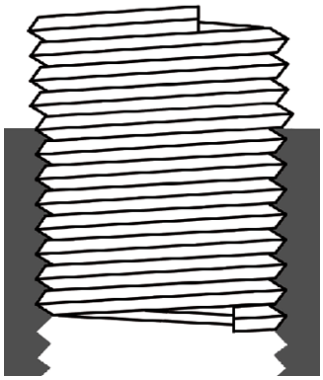
BaerCoil® thread inserts are especially well suited for the following materials:

- 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.

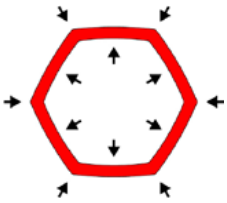
Locking Torque for BaerCoil® Wire Thread Inserts - type: „screw grip“

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 - type: „screw grip“ (screw locking) are red colored

Please find them on page 15



Installation by hand

1

Drilling

Clear the damaged thread with a standard drill bit. To repair a spark plug thread no pre-drilling is necessary if using the special spark plug tap with pilot nose. Optionally you can countersink the borehole.

2

Tapping

Use the special BaerCoil® tap for cutting the holding thread into the cleared hole. BaerCoil® taps are suitable for blind- and through holes. It's recommended to use a suitable cutting oil.

3

Installing thread inserts

Place insert on installing tool and position the adjustable ring that the insert tang is centred in the tang slot. Wind insert in with light downward pressure until 1/4 to 1/2 turn below the surface. Do not turn against direction of rotation, because the tang can break.

4

Tang removal

Lift the inserting tool from tang and place the tang break tool over the tang and tap down sharply. For bigger sizes and spark plug use a long nose pliers to remove the tang.

Installation by machine or electronic screwdriver

1

Drilling

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

2

Tapping

Use the special BaerCoil® tap for cutting the holding thread into the cleared hole. BaerCoil® taps and forming taps are suitable for blindand 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.

BAER GERMANY

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	18,10 €	1-B7202-2	18,90 €	1-B7202-25	20,05 €	1-B7202-3	22,43 €
	10	2-B7202-1	12,55 €	2-B7202-15	6,58 €	2-B7202-2	6,88 €	2-B7202-25	7,25 €	2-B7202-3	8,12 €
M 2,2 x 0,45	100	1-B7203-1	15,72 €	1-B7203-15	16,07 €	1-B7203-2	19,81 €	1-B7203-25	20,85 €	1-B7203-3	23,69 €
M 2,5 x 0,45	100	1-B7204-1	23,74 €	1-B7204-15	23,90 €	1-B7204-2	19,04 €	1-B7204-25	20,98 €	1-B7204-3	23,34 €
	10	2-B7204-1	9,02 €	2-B7204-15	9,08 €	2-B7204-2	6,66 €				
M 3 x 0,5	100	1-B7205-1	13,42 €	1-B7205-15	15,12 €	1-B7205-2	16,07 €	1-B7205-25	16,48 €	1-B7205-3	18,35 €
	10	2-B7205-1	5,16 €	2-B7205-15	5,26 €	2-B7205-2	5,12 €	2-B7205-25	5,27 €	2-B7205-3	5,67 €
M 3,5 x 0,6	100	1-B7206-1	12,02 €	1-B7206-15	13,14 €	1-B7206-2	15,64 €	1-B7206-25	16,65 €	1-B7206-3	21,92 €
M 4 x 0,7	100	1-B7207-1	13,09 €	1-B7207-15	13,28 €	1-B7207-2	15,13 €	1-B7207-25	17,82 €	1-B7207-3	20,74 €
	10	2-B7207-1	4,55 €	2-B7207-15	4,67 €	2-B7207-2	4,97 €	2-B7207-25	5,50 €	2-B7207-3	6,08 €
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	14,49 €	1-B7208-15	14,01 €	1-B7208-2	16,12 €	1-B7208-25	18,42 €	1-B7208-3	20,89 €
	10	2-B7208-1	4,87 €	2-B7208-15	4,98 €	2-B7208-2	5,17 €	2-B7208-25	5,67 €	2-B7208-3	6,05 €
M 6 x 0,75	100	1-BE675-1	*	1-BE675-15	*	1-BE675-2	*				
M 6 x 1,0	100	1-B7209-1	12,43 €	1-B7209-15	15,38 €	1-B7209-2	19,72 €	1-B7209-25	25,23 €	1-B7209-3	27,71 €
	10	2-B7209-1	4,47 €	2-B7209-15	5,20 €	2-B7209-2	5,89 €	2-B7209-25	6,81 €	2-B7209-3	7,37 €
M 7 x 1,0	100	1-B7210-1	15,56 €	1-B7210-15	19,05 €	1-B7210-2	25,14 €	1-B7210-25	31,21 €	1-B7210-3	36,68 €
	10	2-B7210-1	5,08 €	2-B7210-15	5,80 €	2-B7210-2	6,80 €	2-B7210-25	8,02 €	2-B7210-3	8,97 €
M 8 x 0,75	100	1-BE875-1	*	1-BE875-15	*	1-BE875-2	*				
M 8 x 1,0	100	1-B7212-1	17,81 €	1-B7212-15	23,21 €	1-B7212-2	29,41 €	1-B7212-25	34,65 €	1-B7212-3	41,60 €
	10	2-B7212-1	5,53 €	2-B7212-15	6,73 €	2-B7212-2	7,62 €	2-B7212-25	8,69 €	2-B7212-3	9,93 €
M 8 x 1,25	100	1-B7211-1	19,86 €	1-B7211-15	24,91 €	1-B7211-2	32,15 €	1-B7211-25	39,98 €	1-B7211-3	47,16 €
	10	2-B7211-1	5,87 €	2-B7211-15	7,07 €	2-B7211-2	8,46 €	2-B7211-25	10,01 €	2-B7211-3	11,41 €
M 9 x 1,0	100	1-BE91-1	*	1-BE91-15	32,74 €	1-BE91-2	*				
	10			2-BE91-15	9,87 €						
M 9 x 1,25	100	1-B7213-1	25,08 €	1-B7213-15	31,80 €	1-B7213-2	39,18 €	1-B7213-25	53,59 €	1-B7213-3	60,75 €
	10	2-B7213-1	6,96 €	2-B7213-15	8,36 €	2-B7213-2	10,01 €	2-B7213-25	11,95 €	2-B7213-3	14,48 €
M 10 x 1,0	100	1-B7217-1	23,19 €	1-B7217-15	32,00 €	1-B7217-2	40,51 €	1-B7217-25	46,86 €	1-B7217-3	55,21 €
	10	2-B7217-1	6,63 €	2-B7217-15	8,51 €	2-B7217-2	10,10 €	2-B7217-25	11,34 €	2-B7217-3	12,98 €
M 10 x 1,25	100	1-B7216-1	24,32 €	1-B7216-15	37,11 €	1-B7216-2	44,34 €	1-B7216-25	55,87 €	1-B7216-3	65,18 €
	10	2-B7216-1	6,95 €	2-B7216-15	9,44 €	2-B7216-2	10,86 €	2-B7216-25	13,10 €	2-B7216-3	14,91 €
M 10 x 1,5	100	1-B7215-1	28,47 €	1-B7215-15	39,44 €	1-B7215-2	49,36 €	1-B7215-25	60,40 €	1-B7215-3	77,33 €
	10	2-B7215-1	7,67 €	2-B7215-15	10,03 €	2-B7215-2	12,35 €	2-B7215-25	14,64 €	2-B7215-3	17,34 €
M 11 x 1,0	100	1-BE111-1	*	1-BE111-15	*	1-BE111-2	*				
M 11 x 1,25	100			1-BE1125-15	72,21 €	1-BE1125-2	*				
	10			2-BE1125-15	11,33 €						
M 11 x 1,5	100	1-B7219-1	36,19 €	1-B7219-15	54,84 €	1-B7219-2	65,92 €	1-B7219-25	81,80 €	1-B7219-3	106,33 €
	10	2-B7219-1	9,07 €	2-B7219-15	13,06 €	2-B7219-2	15,18 €	2-B7219-25	18,27 €		
M 12 x 1,0	100	1-B7224-1	32,03 €	1-B7224-15	44,05 €	1-B7224-2	57,29 €	1-B7224-25	71,33 €	1-B7224-3	89,36 €
	10	2-B7224-1	8,41 €	2-B7224-15	10,83 €	2-B7224-2	13,53 €	2-B7224-25	16,25 €		
M 12 x 1,25	100	1-B7223-1	32,79 €	1-B7223-15	45,08 €	1-B7223-2	58,52 €	1-B7223-25	73,00 €	1-B7223-3	81,53 €
	10	2-B7223-1	8,62 €	2-B7223-15	11,33 €	2-B7223-2	14,07 €	2-B7223-25	16,98 €	2-B7223-3	18,77 €
M 12 x 1,5	100	1-B7222-1	38,36 €	1-B7222-15	53,59 €	1-B7222-2	71,17 €	1-B7222-25	87,21 €	1-B7222-3	99,18 €
	10	2-B7222-1	10,04 €	2-B7222-15	12,81 €	2-B7222-2	16,23 €	2-B7222-25	17,31 €	2-B7222-3	21,68 €
M 12 x 1,75	100	1-B7221-1	37,70 €	1-B7221-15	53,88 €	1-B7221-2	67,05 €	1-B7221-25	93,31 €	1-B7221-3	113,81 €
	10	2-B7221-1	9,70 €	2-B7221-15	14,19 €	2-B7221-2	18,19 €	2-B7221-25	22,06 €	2-B7221-3	26,18 €
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	20,08 €	1-B7228-15	29,23 €	1-B7228-2	36,92 €	1-B7228-25	47,38 €	1-B7228-3	56,40 €
	10	2-B7228-1	9,83 €	2-B7228-15	14,45 €	2-B7228-2	16,77 €	2-B7228-25	20,85 €	2-B7228-3	24,34 €
M 14 x 1,25	50	1-B7227-1	19,39 €	1-B7227-15	35,48 €	1-B7227-2	35,66 €	1-B7227-25	45,79 €	1-B7227-3	67,92 €
	10	2-B7227-1	9,40 €	2-B7227-15	15,00 €	2-B7227-2	16,12 €	2-B7227-25	20,07 €	2-B7227-3	30,49 €
M 14 x 1,5	50	1-B7226-1	25,91 €	1-B7226-15	33,21 €	1-B7226-2	43,87 €	1-B7226-25	55,87 €	1-B7226-3	71,55 €
	10	2-B7226-1	11,97 €	2-B7226-15	15,18 €	2-B7226-2	19,85 €	2-B7226-25	24,06 €	2-B7226-3	30,86 €
M 14 x 2,0	50	1-B7225-1	28,19 €	1-B7225-15	41,09 €	1-B7225-2	56,21 €	1-B7225-25	76,68 €	1-B7225-3	95,24 €
	10	2-B7225-1	13,21 €	2-B7225-15	18,63 €	2-B7225-2	24,13 €	2-B7225-25	32,52 €	2-B7225-3	39,87 €
M 15 x 1,5	50	1-BE1515-1	*	1-BE1515-15	*	1-BE1515-2	*				
M 16 x 1,5	50	1-B7235-1	32,63 €	1-B7235-15	45,53 €	1-B7235-2	60,90 €	1-B7235-25	81,30 €	1-B7235-3	96,09 €
	10	2-B7235-1	14,43 €	2-B7235-15	20,28 €	2-B7235-2	26,09 €	2-B7235-25	34,03 €	2-B7235-3	38,26 €
M 16 x 2,0	50	1-B7234-1	33,06 €	1-B7234-15	45,33 €	1-B7234-2	56,84 €	1-B7234-25	86,94 €	1-B7234-3	140,87 €
	10	2-B7234-1	14,78 €	2-B7234-15	20,10 €	2-B7234-2	27,74 €	2-B7234-25	36,26 €	2-B7234-3	57,38 €
M 18 x 1,5	25	1-B7238-1	20,19 €	1-B7238-15	41,93 €	1-B7238-2	49,90 €	1-B7238-25	52,51 €	1-B7238-3	56,70 €
M 18 x 2,0	25	1-B7237-1	26,85 €	1-B7237-15	36,33 €	1-B7237-2	48,97 €	1-B7237-25	73,89 €	1-B7237-3	89,10 €
M 18 x 2,5	25	1-B7236-1	28,15 €	1-B7236-15	43,51 €	1-B7236-2	58,67 €	1-B7236-25	73,91 €	1-B7236-3	88,91 €
M 20 x 1,5	25	1-B7241-1	28,79 €	1-B7241-15	36,65 €	1-B7241-2	47,11 €	1-B7241-25	57,71 €	1-B7241-3	81,50 €
M 20 x 2,0	25	1-B7240-1	29,64 €	1-B7240-15	41,81 €	1-B7240-2	57,36 €	1-B7240-25	91,25 €	1-B7240-3	110,00 €
M 20 x 2,5	25	1-B7239-1	35,27 €	1-B7239-15	45,93 €	1-B7239-2	71,39 €	1-B7239-25	95,99 €	1-B7239-3	113,83 €

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

DIN 8140 with reduced diameter for better installation / Tolerance ISO 2 (6H)

M		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	
Diameter x Pitch	pack. unit	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	43,96 €	1-B7243-15	72,48 €	1-B7243-2	100,32 €	1-B7243-25	124,99 €	1-B7243-3	152,88 €
M 22 x 1,5	25	1-B7244-1	40,69 €	1-B7244-15	54,95 €	1-B7244-2	60,75 €	1-B7244-25	82,13 €	1-B7244-3	98,91 €
M 22 x 2,5	25	1-B7242-1	52,46 €	1-B7242-15	76,95 €	1-B7242-2	94,84 €	1-B7242-25	119,86 €	1-B7242-3	172,18 €
M 24 x 1,5	25	1-B7247-1	46,90 €	1-B7247-15	81,35 €	1-B7247-2	97,07 €	1-B7247-25	127,20 €	1-B7247-3	142,08 €
M 24 x 2,0	25	1-B7246-1	46,56 €	1-B7246-15	82,83 €	1-B7246-2	90,42 €	1-B7246-25	143,08 €	1-B7246-3	165,28 €
M 24 x 3,0	25	1-B7245-1	72,37 €	1-B7245-15	106,47 €	1-B7245-2	128,55 €	1-B7245-25	179,72 €	1-B7245-3	265,72 €
M 26 x 1,5	5			1-B7349-15	18,70 €						
M 27 x 1,5	5			1-B7352-15	18,70 €						
M 27 x 2,0	5			1-B7351-15	18,70 €						
M 27 x 3,0	5	1-BE273-1	15,79 €	1-BE273-15	26,08 €	1-BE273-2	31,03 €				
M 28 x 1,5	5	1-B7353-1		1-B7353-15	55,07 €						
M 30 x 1,5	5	1-B7356-1	56,31 €	1-B7356-15	66,52 €						
M 30 x 2,0	5	1-B7355-1	50,33 €	1-B7355-15	24,92 €						
M 30 x 3,5	5	1-B7354-1	40,25 €	1-B7354-15	48,67 €	1-B7354-2	63,94 €				
M 33 x 2,0	5	1-B7358-1	52,00 €	1-B7358-15	66,19 €						
M 33 x 3,5	5	1-B7357-1	59,83 €	1-B7357-15	73,54 €	1-B7357-2	83,06 €				
M 36 x 1,5	5			1-B7363-15	85,00 €						
M 36 x 2,0	5			1-B7362-15	77,61 €						
M 36 x 3,0	5			1-B7361-15	92,39 €						
M 36 x 4,0	5	1-BE364-1	31,92 €	1-BE364-15	52,06 €	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	116,78 €						
M 42 x 2,0	5			1-BE422-15	315,33 €						
M 42 x 3,0	5			1-BE423-15	331,10 €						
M 42 x 4,0	5			1-BE424-15	315,33 €						

For Spark Plug

Diameter x Pitch	pack. unit	8,4 mm Item-No.:	Price per unit	12,4 mm Item-No.:	Price per unit	16,4 mm Item-No.:	Price per unit
M 14 x 1,25	50	1-B7128	22,79 €	1-B7228	29,15 €	1-B7328	35,18 €
	10	2-B7128	10,57 €	2-B7228	12,86 €	2-B7328	15,79 €
		12,7 mm		15,9 mm		16,7 mm	
M 18 x 1,5	10	1-B7238-127	8,07 €	1-B7238-159	13,23 €	1-B7238-167	16,52 €

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	1,0 D 1,0 x Diameter	1,5 D 1,5 x Diameter	2,0 D 2,0 x Diameter
Diameter x Pitch	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	32,44 €	1-B8200-15	27,80 €	1-B8200-2	28,34 €	1-B8200-25	40,38 €	1-B8200-3	55,96 €
	10							2-B8200-25	13,48 €		
UNC 3 x 48	100	1-B8213-1	30,32 €	1-B8213-15	32,78 €	1-B8213-2	33,97 €			1-B8213-3	101,28 €
UNC 4 x 40	100	1-B8201-1	31,72 €	1-B8201-15	32,52 €	1-B8201-2	34,68 €	1-B8201-25	45,78 €	1-B8201-3	52,95 €
	10			2-B8201-15	13,44 €						
UNC 5 x 40	100	1-B8202-1	36,32 €	1-B8202-15	40,09 €	1-B8202-2	46,24 €	1-B8202-25	55,94 €	1-B8202-3	91,00 €
	10			2-B8202-15	10,37 €			2-B8202-25	17,50 €		
UNC 6 x 32	100	1-B8203-1	20,91 €	1-B8203-15	22,45 €	1-B8203-2	23,48 €	1-B8203-25	28,13 €	1-B8203-3	51,85 €
	10			2-B8203-15	6,59 €	2-B8203-2	6,76 €	2-B8203-25	8,19 €		
UNC 8 x 32	100	1-B8204-1	17,52 €	1-B8204-15	18,75 €	1-B8204-2	19,44 €	1-B8204-25	23,49 €	1-B8204-3	55,16 €
	10			2-B8204-15	6,02 €	2-B8204-2	6,71 €	2-B8204-25	7,83 €		
UNC 10 x 24	100	1-B8205-1	19,61 €	1-B8205-15	20,56 €	1-B8205-2	24,35 €	1-B8205-25	25,96 €	1-B8205-3	71,70 €
	10			2-B8205-15	6,86 €	2-B8205-2	8,12 €	2-B8205-25	8,65 €		
UNC 12 x 24	100	1-B8206-1	27,62 €	1-B8206-15	23,49 €	1-B8206-2	32,82 €	1-B8206-25	39,38 €	1-B8206-3	103,14 €
	10			2-B8206-15	7,83 €			2-B8206-25	13,13 €		
UNC 1/4 x 20	100	1-B8207-1	20,18 €	1-B8207-15	23,48 €	1-B8207-2	27,25 €	1-B8207-25	31,72 €	1-B8207-3	71,70 €
	10			2-B8207-15	7,83 €	2-B8207-2	7,82 €	2-B8207-25	8,62 €		
UNC 5/16 x 18	100	1-B8208-1	26,55 €	1-B8208-15	32,34 €	1-B8208-2	39,99 €	1-B8208-25	52,17 €	1-B8208-3	104,80 €
	10			2-B8208-15	8,82 €	2-B8208-2	10,06 €	2-B8208-25	12,66 €		
UNC 3/8 x 16	100	1-B8209-1	40,55 €	1-B8209-15	42,84 €	1-B8209-2	55,35 €	1-B8209-25	70,52 €	1-B8209-3	155,21 €
	10			2-B8209-15	12,00 €	2-B8209-2	12,74 €	2-B8209-25	16,30 €		
UNC 7/16 x 14	100	1-B8210-1	52,16 €	1-B8210-15	57,41 €	1-B8210-2	71,79 €	1-B8210-25	123,95 €	1-B8210-3	165,47 €
	10			2-B8210-15	15,90 €	2-B8210-2	20,56 €	2-B8210-25	26,94 €		
UNC 1/2 x 13	100	1-B8211-1	64,33 €	1-B8211-15	71,39 €	1-B8211-2	103,38 €	1-B8211-25	142,88 €	1-B8211-3	193,05 €
	10			2-B8211-15	17,75 €			2-B8211-25	30,71 €		
UNC 9/16 x 12	50	1-B8212-1	44,50 €	1-B8212-15	50,17 €	1-B8212-2	89,66 €	1-B8212-25	159,03 €	1-B8212-3	191,50 €
	10			2-B8212-15	18,49 €			2-B8212-25	32,52 €		
UNC 5/8 x 11	50	1-B8214-1	44,11 €	1-B8214-15	63,51 €	1-B8214-2	115,64 €	1-B8214-25	158,03 €	1-B8214-3	187,81 €
	10	2-B8214-1	14,95 €	2-B8214-15	21,54 €			2-B8214-25	62,73 €		
UNC 3/4 x 10	25	1-B8215-1	39,92 €	1-B8215-15	57,57 €	1-B8215-2	77,87 €	1-B8215-25	97,56 €	1-B8215-3	121,35 €
	10	2-B8215-1	9,85 €	2-B8215-15	13,73 €						
UNC 7/8 x 9	10	1-B8218-1	29,24 €	1-B8218-15	42,70 €	1-B8218-2	68,94 €	1-B8218-25	73,27 €	1-B8218-3	90,51 €
UNC 1“ x 8	10	1-B8219-1	63,91 €	1-B8219-15	66,58 €	1-B8219-2	92,63 €	1-B8219-25	110,87 €	1-B8219-3	125,20 €
UNC 1.1/8“ x 7	5			1-B8320-15	53,78 €						
UNC 1.1/4“ x 7	5			1-B8321-15	56,54 €						
UNC 1.3/8“ x 6	5			1-B8322-15	91,00 €						
UNC 1.1/2“ x 6	5			1-B8323-15	114,18 €						

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	107,51 €	1-B8287-15	116,83 €	1-B8287-2	122,48 €	1-B8287-25	270,42 €	1-B8287-3	298,15 €
UNF 3 x 56	100	1-B8288-1	35,81 €	1-B8288-15	38,94 €	1-B8288-2	41,93 €			1-B8288-3	149,09 €
UNF 4 x 48	100	1-B8290-1	32,11 €	1-B8290-15	35,19 €	1-B8290-2	36,19 €	1-B8290-25	43,48 €	1-B8290-3	99,28 €
	10			2-B8290-15	11,15 €	2-B8290-2	11,59 €	2-B8290-25	13,85 €		
UNF 5 x 44	100	1-B8289-1	64,50 €	1-B8289-15	35,04 €	1-B8289-2	162,50 €	1-B8289-25	270,42 €	1-B8289-3	298,15 €
	10			2-B8289-15	11,15 €						
UNF 6 x 40	100	1-B8291-1	29,98 €	1-B8291-15	32,84 €	1-B8291-2	33,77 €	1-B8291-25	40,61 €	1-B8291-3	63,56 €
	10			2-B8291-15	10,41 €	2-B8291-2	10,80 €	2-B8291-25	12,94 €		
UNF 8 x 36	100	1-B8292-1	29,98 €	1-B8292-15	32,84 €	1-B8292-2	33,77 €	1-B8292-25	40,61 €	1-B8292-3	105,90 €
	10			2-B8292-15	10,41 €	2-B8292-2	10,80 €	2-B8292-25	12,94 €		
UNF 10 x 32	100	1-B8293-1	19,61 €	1-B8293-15	20,50 €	1-B8293-2	22,99 €	1-B8293-25	29,62 €	1-B8293-3	49,64 €
	10	2-B8293-1	6,54 €	2-B8293-15	6,84 €	2-B8293-2	7,40 €	2-B8293-25	9,37 €		
UNF 1/4 x 28	100	1-B8225-1	26,58 €	1-B8225-15	23,48 €	1-B8225-2	26,53 €	1-B8225-25	42,41 €	1-B8225-3	71,70 €
	10			2-B8225-15	7,83 €	2-B8225-2	8,85 €	2-B8225-25	14,13 €		
UNF 5/16 x 24	100	1-B8226-1	28,13 €	1-B8226-15	32,26 €	1-B8226-2	37,35 €	1-B8226-25	56,00 €	1-B8226-3	74,18 €
	10			2-B8226-15	10,75 €	2-B8226-2	12,45 €	2-B8226-25	18,67 €		
UNF 3/8 x 24	100	1-B8227-1	39,03 €	1-B8227-15	44,26 €	1-B8227-2	51,52 €	1-B8227-25	65,18 €	1-B8227-3	137,90 €
	10			2-B8227-15	14,75 €	2-B8227-2	16,29 €	2-B8227-25	21,72 €		
UNF 7/16 x 20	100	1-B8228-1	44,25 €	1-B8228-15	50,48 €	1-B8228-2	62,87 €	1-B8228-25	77,14 €	1-B8228-3	148,92 €
	10			2-B8228-15	11,81 €	2-B8228-2	14,66 €	2-B8228-25	17,42 €		
UNF 1/2 x 20	100	1-B8229-1	46,13 €	1-B8229-15	54,65 €	1-B8229-2	62,87 €	1-B8229-25	77,15 €	1-B8229-3	154,43 €
	10			2-B8229-15	18,23 €	2-B8229-2	15,36 €	2-B8229-25	18,42 €		
UNF 9/16 x 18	50	1-B8230-1	49,15 €	1-B8230-15	45,63 €	1-B8230-2	69,38 €	1-B8230-25	79,47 €	1-B8230-3	165,47 €
	10			2-B8230-15	19,35 €			2-B8230-25	39,31 €		
UNF 5/8 x 18	50	1-B8231-1	57,83 €	1-B8231-15	55,52 €	1-B8231-2	74,47 €	1-B8231-25	87,63 €	1-B8231-3	165,47 €
	10			2-B8231-15	23,03 €			2-B8231-25	36,56 €		
UNF 3/4 x 16	25	1-B8233-1	43,43 €	1-B8233-15	59,85 €	1-B8233-2	63,98 €	1-B8233-25	99,90 €	1-B8233-3	124,10 €
	10			2-B8233-15	30,42 €			2-B8233-25	45,42 €		
UNF 7/8 x 14	10	1-B8235-1	30,27 €	1-B8235-15	37,22 €	1-B8235-2	63,98 €	1-B8235-25	68,51 €	1-B8235-3	95,97 €
UNF 1“ x 12	10	1-B8237-1	47,44 €	1-B8237-15	56,10 €	1-B8237-2	76,20 €	1-B8237-25	101,25 €	1-B8237-3	110,31 €
UNF 1.1/8“ x 12	5			1-B8238-15	79,98 €						
UNF 1.1/4“ x 12	5			1-B8239-15	81,08 €						
UNF 1.3/8“ x 12	5			1-B8240-15	196,91 €						
UNF 1.1/2“ x 12	5			1-B8236-15	204,08 €						

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	58,26 €	1-B8241-15	57,46 €	1-B8241-2	69,34 €	1-B8241-25	92,23 €	1-B8241-3	103,93 €
BSW 3/16 x 24	100	1-B8242-1	46,60 €	1-B8242-15	57,46 €	1-B8242-2	57,79 €	1-B8242-25	63,41 €	1-B8242-3	69,29 €
BSW 1/4 x 20	100	1-B8243-1	55,16 €	1-B8243-15	55,16 €	1-B8243-2	60,67 €	1-B8243-25	71,70 €	1-B8243-3	88,25 €
BSW 5/16 x 18	100	1-B8244-1	60,67 €	1-B8244-15	71,70 €	1-B8244-2	77,22 €	1-B8244-25	104,80 €	1-B8244-3	126,86 €
BSW 3/8 x 16	100	1-B8245-1	60,67 €	1-B8245-15	71,70 €	1-B8245-2	77,22 €	1-B8245-25	104,80 €	1-B8245-3	126,86 €
BSW 7/16 x 14	100	1-B8246-1	132,37 €	1-B8246-15	137,90 €	1-B8246-2	137,90 €	1-B8246-25	170,98 €	1-B8246-3	198,57 €
BSW 1/2 x 12	100	1-B8247-1	176,51 €	1-B8247-15	187,53 €	1-B8247-2	198,57 €	1-B8247-25	220,63 €	1-B8247-3	226,14 €
BSW 9/16 x 12	50	1-B8248-1	92,45 €	1-B8248-15	101,13 €	1-B8248-2	107,02 €	1-B8248-25	121,20 €	1-B8248-3	132,90 €
BSW 5/8 x 11	50	1-B8249-1	93,77 €	1-B8249-15	104,01 €	1-B8249-2	127,27 €	1-B8249-25	158,71 €	1-B8249-3	196,46 €
BSW 3/4 x 10	25	1-B8251-1	55,16 €	1-B8251-15	71,70 €	1-B8251-2	85,49 €	1-B8251-25	107,55 €	1-B8251-3	133,76 €
BSW 7/8 x 9	10	1-B8253-1	45,78 €	1-B8253-15	46,88 €	1-B8253-2	76,11 €	1-B8253-25	80,52 €	1-B8253-3	86,05 €
BSW 1“ x 8	10	1-B8255-1	65,09 €	1-B8255-15	83,29 €	1-B8255-2	112,52 €	1-B8255-25	119,13 €	1-B8255-3	130,17 €
BSW 1.1/8“ x 7	10	1-B8256-1	86,68 €	1-B8256-15	104,58 €	1-B8256-2	142,14 €				
BSW 1.1/4“ x 7	10	1-B8257-1	97,66 €	1-B8257-15	128,28 €	1-B8257-2	171,03 €				
BSW 1.3/8“ x 6	10			1-B8258-15	346,70 €						
BSW 1.1/2“ x 6	10	1-B8259-1	187,80 €	1-B8259-15	264,06 €	1-B8259-2	320,12 €				

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	76,11 €	1-B8262-15	79,42 €	1-B8262-2	90,15 €	1-B8262-25	103,76 €	1-B8262-3	114,32 €
BSF 1/4 x 26	100	1-B8263-1	93,77 €	1-B8263-15	104,80 €	1-B8263-2	110,31 €	1-B8263-25	121,35 €	1-B8263-3	132,37 €
BSF 5/16 x 22	100	1-B8265-1	104,80 €	1-B8265-15	115,83 €	1-B8265-2	121,35 €	1-B8265-25	132,37 €	1-B8265-3	193,05 €
BSF 3/8 x 20	100	1-B8266-1	137,90 €	1-B8266-15	154,43 €	1-B8266-2	159,96 €	1-B8266-25	176,51 €	1-B8266-3	251,52 €
BSF 7/16 x 18	100	1-B8267-1	237,17 €	1-B8267-15	264,75 €	1-B8267-2	275,78 €	1-B8267-25	251,52 €	1-B8267-3	301,15 €
BSF 1/2 x 16	100	1-B8268-1	275,78 €	1-B8268-15	303,37 €	1-B8268-2	314,39 €	1-B8268-25	364,04 €	1-B8268-3	450,07 €
BSF 9/16 x 16	100	1-B8269-1	314,39 €	1-B8269-15	358,52 €	1-B8269-2	375,06 €	1-B8269-25	526,20 €	1-B8269-3	612,23 €
BSF 5/8 x 14	50	1-B8270-1	182,02 €	1-B8270-15	209,59 €	1-B8270-2	217,86 €	1-B8270-25	395,47 €	1-B8270-3	458,35 €
BSF 3/4 x 12	50	1-B8272-1	237,17 €	1-B8272-15	262,00 €	1-B8272-2	339,21 €	1-B8272-25	676,77 €	1-B8272-3	777,70 €
BSF 7/8 x 11	25	1-B8274-1	122,72 €	1-B8274-15	131,00 €	1-B8274-2	169,61 €	1-B8274-25	456,70 €	1-B8274-3	531,98 €
BSF 1“ x 10	10	1-B8276-1	60,67 €	1-B8276-15	72,25 €	1-B8276-2	78,32 €	1-B8276-25	237,28 €	1-B8276-3	273,02 €
BSF 1.1/8“ x 9	10	1-B8277-1	91,30 €	1-B8277-15	109,79 €						
BSF 1.1/4“ x 9	10	1-B8278-1	109,20 €	1-B8278-15	131,75 €						
BSF 1.1/2“ x 8	10			1-B8279-15	157,75 €	1-B8279-2	165,84 €				

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	86,68 €	1-B8380-15	38,52 €	1-B8380-2	43,06 €	1-B8380-25	104,01 €	1-B8380-3	109,79 €
G 1/4 x 19	100	1-B8381-1	115,56 €	1-B8381-15	48,89 €	1-B8381-2	64,58 €	1-B8381-25	138,67 €	1-B8381-3	150,24 €
G 3/8 x 19	50	1-B8382-1	117,39 €	1-B8382-15	42,18 €	1-B8382-2	52,85 €	1-B8382-25	121,35 €	1-B8382-3	127,13 €
G 1/2 x 14	25	1-B8383-1	114,33 €	1-B8383-15	36,79 €	1-B8383-2	52,30 €	1-B8383-25	117,02 €	1-B8383-3	121,35 €
G 5/8 x 14	10	1-B8384-1	34,68 €	1-B8384-15	24,63 €	1-B8384-2	32,34 €	1-B8384-25	46,81 €		
G 3/4 x 14	5	1-B8385-1	18,49 €	1-B8385-15	14,45 €	1-B8385-2	20,48 €	1-B8385-25	26,58 €		
G 7/8 x 14	5	1-B8386-1	18,78 €	1-B8386-15	18,28 €	1-B8386-2	25,53 €				
G 1“ x 11	5	1-B8387-1	26,58 €	1-B8387-15	34,16 €	1-B8387-2	45,34 €				

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
BA 0	100	1-B6370-1	145,62 €	1-B6370-15	176,82 €	1-B6370-2	242,69 €	1-B6370-25	350,17 €	1-B6370-3	416,04 €
BA 1	100	1-B6371-1	100,54 €	1-B6371-15	107,49 €	1-B6371-2	114,41 €	1-B6371-25	135,22 €	1-B6371-3	152,54 €
BA 2	100	1-B6372-1	100,54 €	1-B6372-15	107,49 €	1-B6372-2	114,41 €	1-B6372-25	135,22 €	1-B6372-3	152,54 €
BA 3	100			1-B6373-15	260,03 €						
BA 4	100	1-B6374-1	100,54 €	1-B6374-15	107,49 €	1-B6374-2	114,41 €	1-B6374-25	142,14 €	1-B6374-3	162,95 €
BA 6	100	1-B6376-1	114,41 €	1-B6376-15	131,75 €	1-B6376-2	159,48 €	1-B6376-25	225,35 €	1-B6376-3	266,95 €

BAER GERMANY

BaerCoil®

Wire Thread Inserts

type: “screw grip“

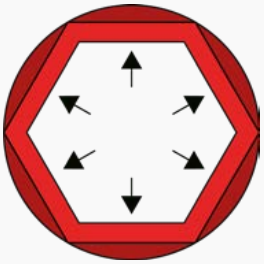
BaerCoil® Wire Thread Inserts - type: “screw grip“ - material: 304 stainless steel

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	22,83 €[1]	1-B6125-15	24,87 €[1]	1-B6125-2	30,34 €[1]	1-B6125-25	31,84 €[1]	1-B6125-3	36,09 €[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	21,19 €	1-B6103-15	16,62 €	1-B6103-2	18,62 €	1-B6103-25	21,05 €	1-B6103-3	*
	10	2-B6103-1	7,42 €	2-B6103-15	5,97 €	2-B6103-2	6,73 €	2-B6103-25	*	2-B6103-3	*
M 3,5 x 0,6	100	1-B6135-1	13,03 €[1]	1-B6135-15	15,96 €[1]	1-B6135-2	18,93 €[1]	1-B6135-25	22,38 €[1]	1-B6135-3	25,90 €[1]
M 4 x 0,7	100	1-B6104-1	16,66 €	1-B6104-15	22,56 €	1-B6104-2	30,06 €	1-B6104-25	24,41 €	1-B6104-3	24,92 €
	10	2-B6104-1	5,95 €	2-B6104-15	7,90 €	2-B6104-2	10,52 €	2-B6104-25	8,16 €	2-B6104-3	8,33 €
M 5 x 0,8	100	1-B6105-1	14,64 €	1-B6105-15	20,71 €	1-B6105-2	18,89 €	1-B6105-25	22,56 €	1-B6105-3	26,80 €
	10	2-B6105-1	5,51 €	2-B6105-15	6,92 €	2-B6105-2	6,54 €	2-B6105-25	8,00 €	2-B6105-3	8,87 €
M 6 x 1,0	100	1-B6106-1	24,34 €	1-B6106-15	18,82 €	1-B6106-2	29,20 €	1-B6106-25	28,50 €	1-B6106-3	30,28 €
	10	2-B6106-1	8,43 €	2-B6106-15	5,95 €	2-B6106-2	9,51 €	2-B6106-25	8,30 €	2-B6106-3	8,55 €
M 7 x 1,0	100	1-B6107-1	23,26 €	1-B6107-15	30,85 €	1-B6107-2	39,89 €	1-B6107-25	49,58 €	1-B6107-3	58,46 €
	10	2-B6107-1	6,71 €	2-B6107-15	8,14 €	2-B6107-2	9,81 €	2-B6107-25	11,61 €	2-B6107-3	13,26 €
M 8 x 1,0	100	1-B6181-1	23,31 €	1-B6181-15	30,88 €	1-B6181-2	39,90 €	1-B6181-25	48,82 €	1-B6181-3	53,66 €
	10	2-B6181-1	6,71 €	2-B6181-15	8,14 €	2-B6181-2	9,81 €	2-B6181-25	11,61 €	2-B6181-3	13,26 €
M 8 x 1,25	100	1-B6108-1	23,12 €	1-B6108-15	29,48 €	1-B6108-2	38,09 €	1-B6108-25	53,66 €	1-B6108-3	52,60 €
	10	2-B6108-1	6,71 €	2-B6108-15	8,14 €	2-B6108-2	9,81 €	2-B6108-25	11,61 €	2-B6108-3	13,26 €
M 10 x 1,25	100	1-B6101-1	31,89 €	1-B6101-15	46,15 €	1-B6101-2	59,85 €	1-B6101-25	73,19 €	1-B6101-3	86,72 €
	10	2-B6101-1	8,15 €	2-B6101-15	10,80 €	2-B6101-2	13,35 €	2-B6101-25	15,83 €	2-B6101-3	18,34 €
M 10 x 1,5	100	1-B6110-1	30,44 €	1-B6110-15	44,05 €	1-B6110-2	57,13 €	1-B6110-25	79,14 €	1-B6110-3	86,72 €
	10	2-B6110-1	8,15 €	2-B6110-15	10,80 €	2-B6110-2	13,35 €	2-B6110-25	17,09 €	2-B6110-3	18,34 €
M 12 x 1,25	100			1-B6112-15	64,33 €	1-B6112-2	85,86 €	1-B6112-25	106,86 €		
M 12 x 1,5	100			1-B6115-15	66,90 €	1-B6115-2	88,59 €				
M 12 x 1,75	100	1-B6127-1	45,15 €	1-B6127-15	61,20 €	1-B6127-2	88,54 €	1-B6127-25	115,20 €	1-B6127-3	127,14 €
	10	2-B6127-1	11,18 €	2-B6127-15	14,19 €	2-B6127-2	19,66 €	2-B6127-25	23,81 €	2-B6127-3	26,18 €
M 14 x 2,0	50	1-B6114-1	33,38 €	1-B6114-15	49,83 €	1-B6114-2	66,70 €	1-B6114-25	109,43 €	1-B6114-3	125,68 €
	10	2-B6114-1	14,55 €	2-B6114-15	21,84 €	2-B6114-2	28,41 €	2-B6114-25	41,45 €		
M 16 x 2,0	50	1-B6116-1	42,07 €	1-B6116-15	64,39 €	1-B6116-2	125,80 €	1-B6116-25	135,83 €	1-B6116-3	169,36 €
	10	2-B6116-1	17,82 €	2-B6116-15	26,47 €			2-B6116-25	52,95 €		
M 18 x 2,5	25	1-B6119-1	43,53 €	1-B6119-15	66,05 €						
	10	2-B6119-1	32,24 €	2-B6119-15	47,75 €						
M 20 x 1,5	25	1-B6120-1	204,33 €	1-B6120-15	210,33 €	1-B6120-2	378,59 €				
M 20 x 2,5	25	1-BS7240-1	48,16 €	1-BS7240-15	82,30 €	1-BS7240-2	105,31 €	1-BS7240-25	133,03 €		
	10	2-BS7240-1	38,07 €	2-BS7240-15	63,48 €	2-BS7240-2	80,61 €	2-BS7240-25	101,25 €		
M 24 x 2,0	25					1-BS7246-2	85,17 €				
	10					2-BS7246-2	65,63 €				
M 24 x 3,0	25	1-BS7245-1	92,78 €	1-BS7245-15	138,98 €	1-BS7245-2	183,66 €	1-BS7245-25	450,71 €		
	10	2-BS7245-1	71,27 €	2-BS7245-15	49,64 €	2-BS7245-2	138,95 €				
M 30 x 3,5	5	1-BS7354-1	33,66 €	1-BS7354-15	51,16 €	1-BS7354-2	78,19 €				
M 36 x 4,0	5			1-BES364-15	92,48 €	1-BES364-2	123,63 €				

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



i see locking torque on page 7

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

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 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-B6200-15	57,79 €	1-B6200-2	57,79 €	1-B6200-25	72,22 €		
UNC 4 x 40	100	1-B6201-1	12,27 €	1-B6201-15	52,00 €	1-B6201-2	53,17 €	1-B6201-25	57,79 €	1-B6201-3	63,56 €
UNC 6 x 32	100	1-B6203-1	14,47 €	1-B6203-15	15,53 €	1-B6203-2	19,04 €	1-B6203-25	52,00 €	1-B6203-3	57,79 €
UNC 8 x 32	100	1-B6204-1	40,45 €	1-B6204-15	40,45 €	1-B6204-2	40,45 €	1-B6204-25	46,22 €	1-B6204-3	52,00 €
UNC 10 x 24	100			1-B6205-15	63,56 €	1-B6205-2	63,56 €	1-B6205-25	69,34 €	1-B6205-3	75,11 €
UNC 1/4 x 20	100	1-B6207-1	52,00 €	1-B6207-15	24,80 €	1-B6207-2	63,56 €	1-B6207-25	36,55 €	1-B6207-3	92,45 €
UNC 5/16 x 18	100	1-B6208-1	63,56 €	1-B6208-15	37,96 €	1-B6208-2	86,68 €	1-B6208-25	60,11 €	1-B6208-3	138,67 €
UNC 3/8 x 16	100	1-B6209-1	63,56 €	1-B6209-15	50,76 €	1-B6209-2	86,68 €	1-B6209-25	115,56 €	1-B6209-3	138,67 €
UNC 7/16 x 14	100	1-B6210-1	144,47 €	1-B6210-15	150,24 €	1-B6210-2	150,24 €	1-B6210-25	190,69 €	1-B6210-3	213,80 €
UNC 1/2 x 13	100	1-B6211-1	144,47 €	1-B6211-15	150,24 €	1-B6211-2	156,01 €	1-B6211-25	208,03 €	1-B6211-3	248,46 €
UNC 5/8 x 11	50	1-B6214-1	109,79 €	1-B6214-15	115,56 €	1-B6214-2	127,13 €	1-B6214-25	150,24 €	1-B6214-3	231,14 €
UNC 3/4 x 10	25	1-B6216-1	59,22 €	1-B6216-15	78,02 €	1-B6216-2	93,90 €				
UNC 7/8 x 9	10	1-B6218-1	51,43 €	1-B6218-15	66,45 €	1-B6218-2	82,64 €				
UNC 1“ x 8	10	1-B6219-1	68,19 €	1-B6219-15	90,71 €	1-B6219-2	123,07 €	1-B6219-25	153,12 €		

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 6 x 40	100	1-B6291-1	52,00 €	1-B6291-15	55,47 €	1-B6291-2	61,24 €			1-B6291-3	75,11 €
UNF 8 x 36	100	1-B6292-1	100,54 €	1-B6292-15	107,49 €	1-B6292-2	110,94 €	1-B6292-25	124,80 €		
UNF 10 x 32	100	1-B6293-1	40,45 €	1-B6293-15	46,22 €	1-B6293-2	52,00 €	1-B6293-25	55,47 €	1-B6293-3	63,56 €
UNF 1/4 x 28	100	1-B6225-1	52,00 €	1-B6225-15	22,16 €	1-B6225-2	27,53 €	1-B6225-25	32,48 €	1-B6225-3	86,68 €
UNF 5/16 x 24	100	1-B6226-1	46,22 €	1-B6226-15	29,46 €	1-B6226-2	63,56 €	1-B6226-25	80,90 €	1-B6226-3	144,47 €
UNF 3/8 x 24	100	1-B6227-1	57,79 €	1-B6227-15	32,75 €	1-B6227-2	75,11 €	1-B6227-25	56,85 €		
UNF 7/16 x 20	100	1-B6228-1	69,34 €	1-B6228-15	51,60 €	1-B6228-2	86,68 €	1-B6228-25	82,31 €	1-B6228-3	161,78 €
UNF 1/2 x 20	100			1-B6229-15	59,53 €	1-B6229-2	109,79 €	1-B6229-25	144,47 €	1-B6229-3	173,35 €
UNF 9/16 x 18	50	1-B6230-1	63,56 €	1-B6230-15	69,34 €	1-B6230-2	78,02 €				
UNF 5/8 x 18	50	1-B6231-1	72,22 €	1-B6231-15	80,90 €	1-B6231-2	98,24 €	1-B6231-25	144,47 €	1-B6231-3	190,69 €
UNF 3/4 x 16	25	1-B6233-1	65,02 €	1-B6233-15	67,90 €	1-B6233-2	75,11 €	1-B6233-25	125,67 €	1-B6233-3	140,13 €
UNF 7/8 x 14	10	1-B6235-1	54,90 €	1-B6235-15	57,20 €	1-B6235-2	82,64 €				
UNF 1“ x 12	10	1-B6237-1	61,83 €	1-B6237-15	70,49 €	1-B6237-2	81,47 €				

Harley-Davidson

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
1/4 x 24	10			2-B6305-15	6,46 €						
7/16 x 16	10			2-B6308-15	9,71 €						

BA

Diameter	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
BA 0	100	1-B6470-1	38,41 €	1-B6470-15	49,95 €	1-B6470-2	59,92 €	1-B6470-25	73,25 €	1-B6470-3	84,71 €
BA 2	100	1-B6471-1	39,41 €	1-B6471-15	46,38 €	1-B6471-2	56,99 €	1-B6471-25	63,96 €	1-B6471-3	73,64 €
BA 3	100			1-B6472-15	39,25 €						
BA 4	100	1-B6473-1	36,94 €	1-B6473-15	39,73 €	1-B6473-2	48,23 €	1-B6473-25	51,49 €	1-B6473-3	58,07 €
BA 6	100	1-B6474-1	31,05 €	1-B6474-15	33,61 €	1-B6474-2	40,26 €	1-B6474-25	41,97 €	1-B6474-3	47,14 €

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 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
BSW 3/16 x 24	100			1-B6242-15	40,45 €	1-B6242-2	52,00 €	1-B6242-25	57,79 €	1-B6242-3	63,56 €
BSW 1/4 x 20	100			1-B6243-15	49,01 €	1-B6243-2	63,05 €	1-B6243-25	74,14 €	1-B6243-3	86,96 €
BSW 5/16 x 18	100	1-B6244-1	53,63 €	1-B6244-15	77,15 €	1-B6244-2	100,19 €	1-B6244-25	122,38 €	1-B6244-3	146,31 €
BSW 3/8 x 16	100	1-B6245-1	66,22 €	1-B6245-15	95,46 €	1-B6245-2	124,80 €				
BSW 7/16 x 14	100			1-B6246-15	106,85 €	1-B6246-2	161,68 €	1-B6246-25	215,18 €		
BSW 1/2 x 12	100	1-B6247-1	235,46 €	1-B6247-15	358,96 €	1-B6247-2	478,86 €	1-B6247-25	602,16 €	1-B6247-3	760,90 €
BSW 5/8 x 11	50	1-B6249-1	201,08 €								

BSF

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
BSF 1/4 x 26	100	1-B6263-1	52,48 €	1-B6263-15	68,29 €	1-B6263-2	82,92 €	1-B6263-25	98,24 €	1-B6263-3	113,67 €
BSF 5/16 x 22	100	1-B6265-1	73,73 €	1-B6265-15	103,89 €	1-B6265-2	132,31 €	1-B6265-25	163,01 €	1-B6265-3	202,24 €
BSF 3/8 x 20	100	1-B6266-1	99,44 €	1-B6266-15	143,14 €	1-B6266-2	185,20 €	1-B6266-25	231,14 €	1-B6266-3	274,87 €
BSF 7/16 x 18	100	1-B6267-1	184,92 €	1-B6267-15	212,35 €	1-B6267-2	279,15 €	1-B6267-25	358,25 €		
BSF 1/2 x 16	100	1-B6268-1	160,00 €	1-B6268-15	238,88 €	1-B6268-2	316,13 €	1-B6268-25	394,02 €		
BSF 9/16 x 16	50	1-B6269-1	116,61 €	1-B6269-15	173,71 €						
BSF 5/8 x 14	50	1-B6270-1	166,18 €	1-B6270-15	248,94 €	1-B6270-2	332,55 €				
BSF 3/4 x 12	25	1-B6272-1	241,02 €	1-B6272-15	294,30 €	1-B6272-3	570,38 €				
BSF 7/8 x 11	10			1-B6274-15	144,47 €						
BSF 1“ x 10	10			1-B6276-15	193,98 €	1-B6276-2	257,83 €				

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 Item-No.:	1,5 D 1,5 x Diameter Item-No.:	2,0 D 1,5 x Diameter 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 and 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	39,83 €	1-B7205-15B	41,64 €	1-B7205-2B	48,85 €
M 4 x 0,7	100	1-B7207-1B	37,12 €	1-B7207-15B	38,49 €	1-B7207-2B	43,49 €
M 5 x 0,8	100	1-B7208-1B	41,64 €	1-B7208-15B	43,06 €	1-B7208-2B	44,38 €
M 6 x 1,0	100	1-B7209-1B	45,45 €	1-B7209-15B	48,70 €	1-B7209-2B	51,50 €
M 8 x 1,25	100	1-B7211-1B	45,32 €	1-B7211-15B	48,90 €	1-B7211-2B	54,39 €
M 10 x 1,5	100	1-B7215-1B	49,09 €	1-B7215-15B	52,36 €	1-B7215-2B	72,45 €
M 12 x 1,75	100	1-B7221-1B	91,10 €	1-B7221-15B	96,60 €	1-B7221-2B	103,35 €
M 16 x 2,0	100	1-B7234-1B	174,32 €	1-B7234-15B	180,11 €	1-B7234-2B	225,92 €
M 20 x 2,5	100	1-B7239-1B	559,20 €	1-B7239-15B	653,10 €	1-B7239-2B	818,13 €

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	33,60 €	1-B7205-15V4A	36,52 €	1-B7205-2V4A	37,99 €
M 4 x 0,7	100	1-B7207-1V4A	29,23 €	1-B7207-15V4A	31,55 €	1-B7207-2V4A	32,91 €
M 5 x 0,8	100	1-B7208-1V4A	36,52 €	1-B7208-15V4A	38,74 €	1-B7208-2V4A	40,91 €
M 6 x 1,0	100	1-B7209-1V4A	38,74 €	1-B7209-15V4A	43,83 €	1-B7209-2V4A	49,68 €
M 8 x 1,25	100	1-B7211-1V4A	42,37 €	1-B7211-15V4A	48,21 €	1-B7211-2V4A	56,98 €
M 10 x 1,5	100	1-B7215-1V4A	52,60 €	1-B7215-15V4A	58,45 €	1-B7215-2V4A	65,75 €
M 12 x 1,75	100	1-B7221-1V4A	80,35 €	1-B7221-15V4A	89,89 €	1-B7221-2V4A	99,35 €

BaerCoil® Wire Thread Inserts - type: “free running“ - material: Inconel X750

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-B7205-1X750	118,40 €	1-B7205-15X750	120,50 €	1-B7205-2X750	146,70 €
M 4 x 0,7	100	1-B7207-1X750	75,00 €	1-B7207-15X750	100,00 €	1-B7207-2X750	143,75 €
M 5 x 0,8	100	1-B7208-1X750	123,59 €	1-B7208-15X750	179,16 €	1-B7208-2X750	235,46 €
M 6 x 1,0	100	1-B7209-1X750	137,59 €	1-B7209-15X750	198,67 €	1-B7209-2X750	261,15 €
M 8 x 1,25	100	1-B7211-1X750	190,94 €	1-B7211-15X750	280,10 €	1-B7211-2X750	373,46 €
M 10 x 1,5	100	1-B7215-1X750	276,50 €	1-B7215-15X750	409,03 €	1-B7215-2X750	542,91 €
M 12 x 1,75	100	1-B7221-1X750	354,97 €	1-B7221-15X750	527,07 €	1-B7221-2X750	697,97 €
M 16 x 2,0	100	1-B7234-1X750	468,00 €	1-B7234-15X750	562,00 €	1-B7234-2X750	572,00 €

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®

BAER GERMANY

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.

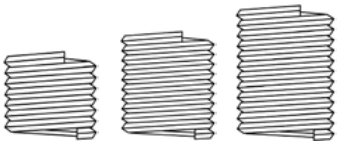
Compatibility

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

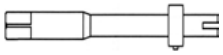
M ISO metric thread



				1,5 D	2,0 D	2,5 D	No.	€
M 3 x 0,5	EBW03	BZ003	3,2 mm	10	5	5	B40052	21,42
M 4 x 0,7	EBW04	BZ004	4,2 mm	10	5	5	B40072	21,32
M 5 x 0,8	EBW05	BZ005	5,2 mm	10	5	5	B40092	21,84
M 6 x 1,0	EBW06	BZ006	6,3 mm	10	5	5	B40102	21,95
M 7 x 1,0	EBW07	BZ006	7,3 mm	10	5	5	B40112	30,45
M 8 x 1,0	EBW08	BZ008	8,3 mm	10	5	5	B40132	30,45
M 8 x 1,25	EBW08	BZ008	8,3 mm	10	5	5	B40122	30,24
M 10 x 1,0	EBW10	BZ010	10,3 mm	10	5	5	B40182	32,55
M 10 x 1,25	EBW10	BZ010	10,3 mm	10	5	5	B40172	32,55
M 10 x 1,5	EBW10	BZ010	10,4 mm	10	5	5	B40162	32,34
M 12 x 1,25	EBW12	BZ012	12,3 mm	10	5	5	B40232	36,54
M 12 x 1,5	EBW12	BZ012	12,4 mm	5	5	5	B40222	36,65
M 12 x 1,75	EBW12	BZ012	12,4 mm	5	5	5	B40212	36,75
M 14 x 1,5	EBW14		14,4 mm	3	3	3	B40292	41,16
M 14 x 2,0	EBW14		14,4 mm	3	3	3	B40282	41,16

BaerCoil® Thread Repair Kits for spark plug

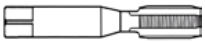
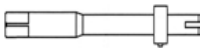
- STI Tap HSSG with pilot nose for spark plug
- Inserting Tool
- Wire Thread Inserts - type: “free running“ - different lengths
- **different lengths for most applications**
- Instruction for use

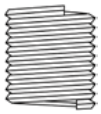


					No.	€
M 10 x 1,0	EBW10	10 mm 5	15 mm 5	20 mm 5	ZKG010	40,53
M 12 x 1,25	EBW12	12 mm 5	18 mm 5	24 mm 5	ZKG012	43,16
M 14 x 1,25	EBW14	8,4 mm 5	12,4 mm 5	16,4 mm 5	ZKG014	44,10
M 18 x 1,5	EBW18	12,7 mm 5	15,9 mm 5	16,7 mm 5	ZKG018	69,30

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 most applications**
- Instruction for use



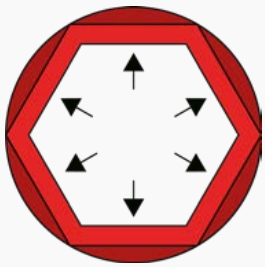
					No.	€
M 12 x 1,5	EBW12	12,4 mm	12 mm 5	18 mm 5	B40223	36,65
M 14 x 1,5	EBW14	14,4 mm	14 mm 5	21 mm 5	B40293	41,79
M 16 x 1,5	EBW16		16 mm 5	24 mm 5	B40333	52,40

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	21,95
M 4 x 0,7	EBW04	BZ004	4,2 mm	10	BS4007	21,95
M 5 x 0,8	EBW05	BZ005	5,2 mm	10	BS4009	21,95
M 6 x 1,0	EBW06	BZ006	6,3 mm	10	BS4010	21,95
M 8 x 1,25	EBW08	BZ008	8,3 mm	10	BS4012	31,08
M 10 x 1,25	EBW10	BZ010	10,3 mm	10	BS4015	33,02
M 10 x 1,5	EBW10	BZ010	10,4 mm	10	BS4016	33,02
M 12 x 1,75	EBW12	BZ012	12,4 mm	10	BS4021	37,38
M 14 x 2,0	EBW14		14,5 mm	5	BS4028	74,97
M 16 x 2,0	EBW14			5	BS4032	87,68
M 18 x 2,5	EBW18			5	BS4034	107,73
M 20 x 2,5	EBW20			5	BS4037	164,33
M 24 x 3,0	EBW24			5	BS4043	219,98
M 30 x 3,5	EBW30			5	BS4054	438,8



i see locking torque on page 7

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

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

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	24,57
M 4 x 0,7	KEBW04	BZ004	4,2 mm	10	5	5	B40074	24,57
M 5 x 0,8	KEBW05	BZ005	5,2 mm	10	5	5	B40094	24,57
M 6 x 1,0	KEBW06	BZ006	6,3 mm	10	5	5	B40104	26,78
M 8 x 1,25	KEBW08	BZ008	8,3 mm	10	5	5	B40124	32,97
M 10 x 1,5	KEBW10	BZ010	10,4 mm	5	5	5	B40164	36,96
M 12 x 1,75	KEBW12	BZ012	12,4 mm	5	5	5	B40214	41,90

BaerCoil® Thread Repair Kits for blind holes

- 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	EBW03	BZ003	10,4 mm	3,2 mm	10	5	5	B40055	38,43
M 4 x 0,7	EBW04	BZ004	10,4 mm	4,2 mm	10	5	5	B40075	38,43
M 5 x 0,8	EBW05	BZ005	10,4 mm	5,2 mm	10	5	5	B40095	38,43
M 6 x 1,0	EBW06	BZ006	10,4 mm	6,3 mm	10	5	5	B40105	38,43
M 7 x 1,0	EBW07	BZ006	10,4 mm	7,3 mm	10	5	5	B40115	57,02
M 8 x 1,25	EBW08	BZ008	10,4 mm	8,3 mm	10	5	5	B40125	57,54
M 10 x 1,5	EBW10	BZ010	16,5 mm	10,4 mm	10	5	5	B40165	59,54
M 12 x 1,5	EBW12	BZ012	16,5 mm	12,4 mm	5	5	5	B40225	75,81
M 12 x 1,75	EBW12	BZ012	16,5 mm	12,4 mm	5	5	5	B40215	75,81
M 14 x 1,5	EBW14		16,5 mm	14,4 mm	5	5		B40295	79,59
M 16 x 1,5	EBW14		16,5 mm		10			B40335	99,12
M 16 x 2,0	EBW14		16,5 mm		10			B40325	99,12

BaerCoil® Thread Repair Kits

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

M ISO metric thread

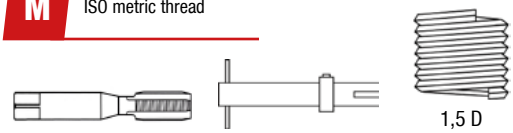
				1,5 D	No.	€
M 2 x 0,4	EBW01	BZ001	2,1 mm	20	B4001	22,05
M 2,2 x 0,45	EBW01	BZ001	2,3 mm	20	B4002	48,09
M 2,5 x 0,45	EBW02	BZ002	2,6 mm	20	B4003	21,32
M 3 x 0,5	EBW03	BZ003	3,2 mm	20	B4005	21,32
M 3,5 x 0,6	EBW03	BZ003	3,7 mm	20	B4006	21,32
M 4 x 0,7	EBW04	BZ004	4,2 mm	20	B4007	21,32
M 5 x 0,8	EBW05	BZ005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

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

BaerCoil® Thread Repair Kits

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

M ISO metric thread



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

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	31,00
UNC 3 x 48	EBW02	BZ002	2,6 mm	10	B4348	69,30
UNC 4 x 40	EBW03	BZ003	3,0 mm	20	B4101	28,46
UNC 5 x 40	EBW03	BZ003	3,4 mm	20	B4106	28,46
UNC 6 x 32	EBW03	BZ003	3,7 mm	20	B4102	28,46
UNC 8 x 32	EBW04	BZ004	4,5 mm	20	B4103	28,46
UNC 10 x 24	EBW04	BZ004	5,2 mm	20	B4104	28,46
UNC 12 x 24	EBW05	BZ005	5,8 mm	10	B4105	28,46
UNC 1/4 x 20	EBW06	BZ006	6,7 mm	20	B4107	25,20
UNC 5/16 x 18	EBW07	BZ006	8,3 mm	20	B4108	29,82
UNC 3/8 x 16	EBW08	BZ008	9,9 mm	15	B4109	32,97
UNC 7/16 x 14	EBW10	BZ010	11,6 mm	10	B4110	37,50
UNC 1/2 x 13	EBW12	BZ012	13,0 mm	10	B4111	41,20
UNC 9/16 x 12	EBW14			10	B4112	55,00
UNC 5/8 x 11	EBW14			10	B4113	55,00

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 Coarse Thread Series ANSI B1.1

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

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 Coarse Thread Series ANSI B1.1

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

* prices on request

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 Coarse Thread Series ANSI B1.1

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

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	31,00
BSW 3/16 x 24	EBW05	BZ005	5,0 mm	20	B4142	31,00
BSW 1/4 x 20	EBW06	BZ006	6,7 mm	20	B4143	28,00
BSW 5/16 x 18	EBW07	BZ006	8,3 mm	20	B4144	35,00
BSW 3/8 x 16	EBW08	BZ008	9,9 mm	15	B4145	38,00
BSW 7/16 x 14	EBW10	BZ010	11,6 mm	10	B4146	41,00
BSW 1/2 x 12	EBW12	BZ012	13,0 mm	10	B4147	44,00
BSW 9/16 x 12	EBW14			5	B4148	58,10
BSW 5/8 x 11	EBW14			5	B4149	58,10

* 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 Unified National Coarse Thread Series ANSI B1.1

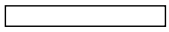
		1,5 D	No.	€
BSW 11/16x11	EBW16	5	B4153	*
BSW 3/4 x10	EBW18	5	B4150	75,60
BSW 7/8 x 9	EBW22	5	B4151	89,90
BSW 1“ x 8	EBW24	4	B4152	86,80
BSW 1.1/8 x 7	EBW26	5	B4154	*
BSW 1.1/4 x 7	EBW30	5	B4155	*
BSW 1.3/8 x 6	EBW31	5	B4156	*
BSW 1.1/2 x 6	EBW36	5	B4157	*

* 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



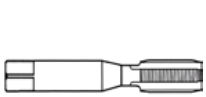
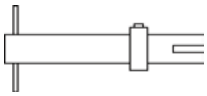
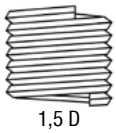
				1,5 D	No.	€
BSF 3/16 x 32	EBW04	BZ004	5,0 mm	20	B4162	31,00
BSF 7/32 x 28	EBW05	BZ005	5,8 mm	10	B4177	*
BSF 1/4 x 26	EBW06	BZ006	6,6 mm	20	B4163	28,00
BSF 9/32 x 26	EBW06	BZ006	7,3 mm	10	B4178	*
BSF 5/16 x 22	EBW07	BZ008	8,3 mm	20	B4165	35,00
BSF 3/8 x 20	EBW08	BZ008	9,9 mm	15	B4166	38,00
BSF 7/16 x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

* 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	75,60
BSF 13/16x 12	EBW18	5	B4173	*
BSF 7/8 x 11	EBW22	5	B4174	89,90
BSF 1“ x 10	EBW24	4	B4176	86,80
BSF 1.1/8 x 9	EBW30	5	B4179	*
BSF 1.1/4 x 9	EBW31	5	B4180	*
BSF 1.3/8 x 8	EBW36	5	B4181	*
BSF 1.1/2 x 8	EBW39	5	B4182	*

* 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	56,54
G 1/4 x 19	EBW12	BZ012	13,5 mm	5	B4191	56,54
G 3/8 x 19	EBW14		17,0 mm	5	B4192	64,79
G 1/2 x 14	EBW22			5	B4193	81,18
G 5/8 x 14	EBW24			5	B4194	174,90
G 3/4 x 14	EBW26			5	B4195	174,90
G 7/8 x 14	EBW30			5	B4196	258,50
G 1“ x 11	EBW36			5	B4197	258,50
G 1.1/4 x 11	EBW42			5	B4198	*
G 1.1/2 x 11	EBW50			5	B4199	*

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

BA British Association Standard Thread BS 931,5

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

leading time: 1 - 3 weeks

BSB British Standard Brass Thread

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

leading time: 1 - 3 weeks

* 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	179,66
Harley 1/4 x 24	EBW06	BZ006	6,6 mm	10	B4226	61,01
Harley 7/16 x16	EBW10	BZ010	11,5 mm	10	B4227	69,41
Cummins 11/16x16	EBW14			10	B4228	596,40
Carburetor 7/8 x 20	EBW22			10	B4229	672,53
Carburetor 1“ x 20	EBW24			10	B4230	416,33

BSC British Standard Cycle Thread RS 811

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

leading time: 1 - 3 weeks

NPT American Taper Pipe Thread ANSI B1.20.1

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

leading time: 1 - 3 weeks

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

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

leading time: 1 - 3 weeks

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	161,91
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	123,38
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	86,84
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	97,76
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		
M 12 x 1,25	EBW12	12 mm 5	18 mm 5	24 mm 5	B5113	141,75
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		
M 14 x 1,5	EBW14	14,4 mm	14 mm 5	21 mm 5	B5157	130,73
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	152,25
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 1,5[2]

				1,5 D	2,5 D		No.	€
M 6 x 1,0	EBW06	BZ006	6,3 mm	10	5		B5108	152,25
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		

automotive - special

				1,5 D	2,5 D		No.	€
M 6 x 1,0	EBW06	BZ006	6,3 mm	10	5		B5109	206,96
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			

BaerCoil® Thread Repair Workshop Kits - “screw grip“

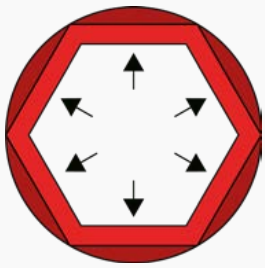
- Drill HSS
- STI Bottoming Tap HSSG
- Inserting Tool
- Tang Break Tool
- Wire Thread Inserts - type: **“screw grip“ (screw locking)** - length: 1,5 D
- for impact resistant and vibration resistant bolted connections (more information on page 4 - 7)
- Instruction for use

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	174,20
M 8 x 1,25	EBW08	BZ008	8,3 mm	20		
M 10 x 1,5	EBW10	BZ010	10,4 mm	10		
M 12 x 1,75	EBW12	BZ012	12,4 mm	10		

M 5 - M 12

				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	152,36
M 10 x 1,5	EBW10	BZ010	10,4 mm	10		
M 12 x 1,75	EBW12	BZ012	12,4 mm	10		



see locking torque on page 7

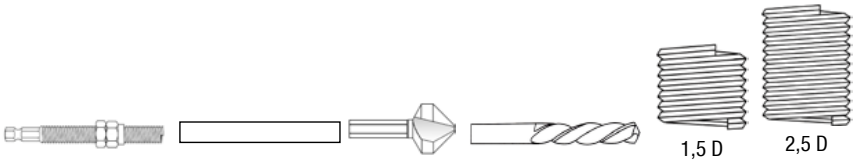
BaerCoil® Wire Thread Inserts - type: “screw grip“

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

BaerCoil® Thread Repair Workshop Kits - PRO

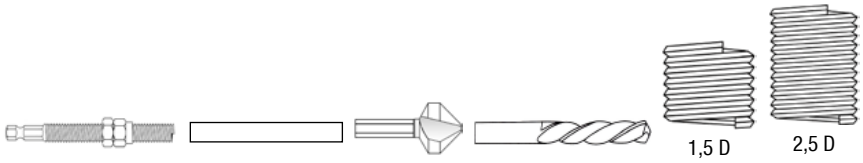
- Drill HSS
- STI Machine Tap HSSG
- Countersink HSS with 1/4“ hexagon drive (bit shank)
- Machine Inserting Tool with 1/4“ hexagon drive (bit shank)
- Tang Break Tool
- Wire Thread Inserts - type: “free running“ - lengths **1,5 D - 2,5 D**
- **different lengths for most applications**

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	177,98
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	163,28
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

UNF 1/4 - 1/2“

				1,5 D	No.	€
UNF 1/4 x 28	EBW06	BZ006	6,6 mm	25		
UNF 5/16 x 24	EBW07	BZ008	8,3 mm	25		
UNF 3/8 x 24	EBW08	BZ008	9,9 mm	25	B5121	164,85
UNF 7/16 x 20	EBW10	BZ010	11,5 mm	10		
UNF 1/2 x 20	EBW12	BZ012	13,0 mm	10		

UNC 1/4 - 1/2“

				1,5 D	No.	€
UNC 1/4 x 20	EBW06	BZ006	6,7 mm	25		
UNC 5/16 x 18	EBW07	BZ008	8,3 mm	25		
UNC 3/8 x 16	EBW08	BZ008	9,9 mm	25	B5120	164,85
UNC 7/16 x 14	EBW10	BZ010	11,6 mm	10		
UNC 1/2 x 13	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		
BSW 5/16 x 18	EBW07	BZ008	8,3 mm	25		
BSW 3/8 x 16	EBW08	BZ008	9,9 mm	25	B5122	164,85
BSW 7/16 x 14	EBW10	BZ010	11,6 mm	10		
BSW 1/2 x 12	EBW12	BZ012	13,0 mm	10		

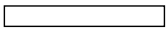
BSF 1/4 - 1/2“

				1,5 D	No.	€
BSF 1/4 x 26	EBW06	BZ006	6,6 mm	25		
BSF 5/16 x 22	EBW07	BZ008	8,3 mm	25		
BSF 3/8 x 20	EBW08	BZ008	9,9 mm	25	B5123	164,85
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

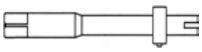
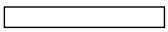
G (BSP) British Standard Pipe Thread DIN ISO 228



				1,5 D	No.	€
G (BSP) 1/8 x 28	EBW10	BZ010	10,0 mm	5	B5124	252,00
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**

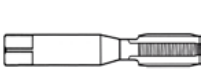
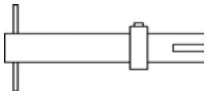
BA Britisch Association Standard Thread BS 93

				1,5 D	No.	€
BA 0	EBW06	BZ006	6,2 mm	5	B5125	265,65
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	438,90
NPT 1/4 x 19	EBW14	5		
NPT 3/8 x 18	EBW14	5		
NPT 1/2 x 14	EBW22	5		

BAER GERMANY

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.

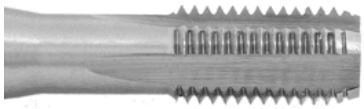
Thread designations

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

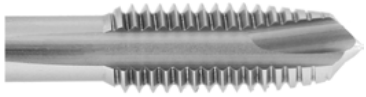
Compatibility

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



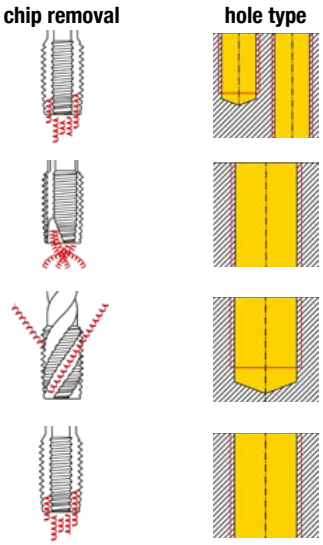
Bottoming tap
chamfer: Form D (3-4 pitches)
for through hole and blind hole



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



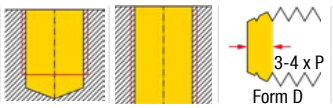
BaerCoil® Bottoming Taps for Wire Thread Inserts

Bottoming Taps can be used by hand or machine

HSSG

EG

STI



works standard

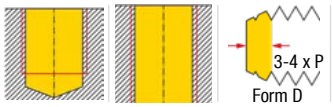
M	D1	D2	L1	L2	□		No.	€
M 2 x 0,4	2,52	2,80	44,5	9,5	2,24	2,1	B3001-1	7,28
M 2,2 x 0,45	2,79	3,15	48,0	11,0	2,50	2,3	B3002-1	10,20
M 2,5 x 0,45	3,09	3,15	48,0	11,0	2,50	2,6	B3003-1	7,28
M 3 x 0,5	3,65	4,00	53,0	13,0	3,15	3,2	B3005-1	6,39
M 3,5 x 0,6	4,28	4,50	53,0	13,0	3,55	3,7	B3006-1	7,00
M 4 x 0,7	4,91	5,00	58,0	16,0	4,00	4,2	B3007-1	6,39
M 5 x 0,8	6,04	6,3	66,0	19,0	5,00	5,3	B3008-1	6,39
M 6 x 0,75	6,98	8,00	72,0	22,0	6,30	6,2	B3071-1	34,70
M 6 x 1,0	7,30	8,00	72,0	22,0	6,30	6,3	B3009-1	6,39
M 7 x 1,0	8,30	9,00	72,0	22,0	7,10	7,3	B3010-1	7,94
M 8 x 0,75	8,90	9,60	77,0	33,0	7,20	8,2	B3072-1	34,70
M 8 x 1,0	9,30	10,00	80,0	24,0	8,00	8,3	B3012-1	7,94
M 8 x 1,25	9,62	10,00	80,0	24,0	8,00	8,3	B3011-1	7,94
M 9 x 1,0	10,30	8,20	90,0	35,0	6,10	9,3	B3073-1	35,30
M 9 x 1,25	10,62	8,00	85,0	25,0	6,30	9,3	B3013-1	9,82
M 10 x 1,0	11,30	8,00	85,0	25,0	6,30	10,3	B3017-1	9,82
M 10 x 1,25	11,62	8,00	85,0	25,0	6,30	10,3	B3016-1	9,82
M 10 x 1,5	11,95	9,00	89,0	29,0	7,10	10,4	B3015-1	9,82
M 11 x 1,0	12,25	9,30	86,0	42,0	6,90	11,3	B3074-1	54,90
M 11 x 1,25	12,62	9,00	89,0	29,0	7,10	11,3	B3075-1	12,92
M 11 x 1,5	12,95	9,00	89,0	29,0	7,10	11,4	B3018-1	11,03
M 12 x 1,0	13,30	10,90	91,0	42,0	8,10	12,3	B3023-1	14,20
M 12 x 1,25	13,62	11,20	95,0	30,0	9,00	12,3	B3022-1	13,45
M 12 x 1,5	13,95	11,20	95,0	30,0	9,00	12,4	B3021-1	13,45
M 12 x 1,75	14,27	11,20	95,0	30,0	9,00	12,4	B3020-1	11,03
M 13 x 1,25	14,62	11,30	95,0	32,0	8,90	13,4	B3076-1	72,00
M 13 x 1,5	14,95	12,50	102,0	32,0	11,2	13,4	B3077-1	72,00
M 13 x 1,75	15,25	12,50	102,0	32,0	11,2	13,4	B3078-1	72,00
M 14 x 1,0	15,30	12,50	102,0	32,0	10,0	14,4	B3030-1	15,33
M 14 x 1,25	15,57	12,5	102	32	10,0	14,4	B3029-1	15,33
M 14 x 1,5	15,95	12,5	102	32	10,0	14,5	B3028-1	15,33
M 14 x 2,0	16,60	12,5	102	32	10,0	14,5	B3027-1	15,33
M 15 x 1,5	16,95	12,5	102	32	10,0	15,5	B3079-1	74,00
M 15 x 2,0	17,60	14,0	112	37	11,2	15,5	B3080-1	74,00
M 16 x 1,5	17,95	14,0	104	29	11,2	16,5	B3034-1	18,74
M 16 x 2,0	18,60	14,0	112	37	11,2	16,5	B3033-1	18,74

M	D1	D2	L1	L2	□		No.	€
M 18 x 1,5	19,95	14,0	104	29	11,2	18,5	B3037-1	26,67
M 18 x 2,0	20,60	16,6	113	51	12,4	18,5	B3036-1	26,67
M 18 x 2,5	21,25	16,0	118	38	12,5	18,5	B3035-1	26,67
M 20 x 1,5	21,95	16,0	113	33	12,5	20,5	B3040-1	29,61
M 20 x 2,0	22,60	16,0	113	33	12,5	20,5	B3039-1	29,61
M 20 x 2,5	23,25	16,0	118	38	12,5	20,5	B3038-1	29,61
M 22 x 1,5	23,95	19,3	124	58	14,4	22,5	B3043-1	34,13
M 22 x 2,0	24,60	20,3	130	64	15,2	22,5	B3042-1	34,13
M 22 x 2,5	25,25	20,3	130	64	15,2	22,5	B3041-1	34,13
M 24 x 1,5	26,02	18,0	120	35	14,0	24,5	B3046-1	40,40
M 24 x 2,0	26,60	20,0	127	37	16,0	24,5	B3045-1	40,40
M 24 x 3,0	27,90	23,0	138	66	17,0	24,5	B3044-1	40,40
M 26 x 1,5	27,95	20,0	127	37	16,0	26,5	B3049	117,45
M 27 x 1,5	28,95	20,0	127	37	16,0	27,5	B3052	117,45
M 27 x 2,0	29,60	20,0	127	37	16,0	27,5	B3051	117,45
M 27 x 3,0	30,90	22,4	151	51	18,0	27,5	B3050	117,45
M 28 x 1,5	29,95	20,0	127	37	16,0	28,5	B3053	117,45
M 30 x 1,5	31,95	22,4	137	37	18,0	30,5	B3056	154,10
M 30 x 2,0	32,60	22,4	137	37	18,0	30,5	B3055	154,10
M 30 x 3,0	33,90	22,4	137	37	18,0	30,5	B3081-1	364,00
M 30 x 3,5	34,55	25,0	162	57	20,0	30,5	B3054-1	154,10
M 33 x 2,0	35,60	25,0	144	37	20,0	33,5	B3058	159,85
M 33 x 3,5	37,55	25,0	162	57	20,0	33,5	B3057	159,85
M 36 x 1,5	37,95	28,0	150	39	22,4	36,5	B3063	178,20
M 36 x 2,0	38,60	28,0	150	39	22,4	36,5	B3062	178,20
M 36 x 3,0	39,90	28,0	170	60	22,4	36,5	B3061	178,20
M 36 x 4,0	41,20	28,0	170	60	22,4	36,5	B3060	178,20
M 39 x 2,0	41,60	31,5	187	67	25,0	39,5	B3066-1	451,00
M 39 x 3,0	42,90	31,5	187	67	25,0	39,5	B3065-1	233,00
M 39 x 4,0	44,20	31,5	187	67	25,0	39,5	B3064-1	273,50
M 42 x 2,0	44,60	35,5	200	70	28,0	42,5	B3070-1	472,50
M 42 x 3,0	45,90	35,5	200	70	28,0	42,8	B3069-1	255,25
M 42 x 4,0	47,20	35,5	200	70	28,0	43,0	B3068-1	472,50
M 42 x 4,5	47,85	35,5	200	70	28,0	43,0	B3067-1	385,20
M 52 x 5,0	58,50	40,0	221	76	34,0	53,5	B3082-1	738,00

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	9,66
UNC 3 x 48	3,20	4,0	53	13	3,15	2,60	B3121	58,80
UNC 4 x 40	3,67	4,0	53	13	3,15	3,00	B3101	9,60
UNC 5 x 40	4,00	4,0	53	13	3,15	3,40	B3102	9,60
UNC 6 x 32	4,54	5,0	58	16	4,00	3,70	B3103	9,60
UNC 8 x 32	5,20	5,6	62	17	4,50	4,40	B3104	9,60
UNC 10 x 24	6,20	6,3	66	19	5,00	5,10	B3105	9,60
UNC 12 x 24	6,86	7,1	66	19	5,60	5,70	B3106	9,60
UNC 1/4 x 20	8,00	8,0	73	30	6,00	6,70	B3107	6,30
UNC 5/16 x 18	9,77	9,6	77	33	7,20	8,30	B3108	7,00
UNC 3/8 x 16	11,59	9,3	85	42	6,90	9,90	B3109	7,30
UNC 7/16 x 14	13,47	10,8	91	43	8,10	11,60	B3110	9,70
UNC 1/2 x 13	15,24	12,1	96	46	9,00	13,00	B3111	11,10
UNC 9/16 x 12	17,03	14,0	112	37	11,20	14,80	B3112	18,60
UNC 5/8 x 11	18,87	14,0	112	37	11,20	16,50	B3113	22,90
UNC 11/16x11	20,50	14,0	112	37	11,20	18,50	B3122	280,25
UNC 3/4 x 10	22,35	16,0	118	38	12,50	19,75	B3114	27,80
UNC 7/8 x 9	25,89	18,0	130	45	14,00	23,00	B3115	40,10
UNC 1“ x 8	29,52	20,0	138	48	16,00	26,25	B3116	40,10
UNC 1.1/8 x 7	33,29	22,4	151	51	18,0	29,5	B3117	110,80
UNC 1.1/4 x 7	36,46	25,0	162	57	20,0	33,0	B3118	133,00
UNC 1.3/8 x 6	40,42	28,0	170	60	22,4	36,0	B3119	159,00
UNC 1.1/2 x 6	43,60	31,5	187	67	25,0	39,0	B3120	213,00

UNF	D1	D2	L1	L2	□		No.	€
UNF 3 x 56	3,10	4,00	53	13	3,15	2,6	B3150	58,07
UNF 4 x 48	3,53	4,00	53	13	3,15	3,0	B3151	9,60
UNF 5 x 44	4,33	4,50	53	13	3,55	3,3	B31511	9,90
UNF 6 x 40	4,33	4,5	53	13	3,55	3,7	B3152	9,60
UNF 8 x 36	5,08	5,6	62	17	4,5	4,4	B3153	9,60
UNF 10 x 32	5,86	6,3	66	19	5	5,1	B3154	9,60
UNF 1/4 x 28	7,53	8	73	30	6	6,6	B3155	6,30
UNF 5/16 x 24	9,31	9,6	78	33	7,2	8,2	B3156	7,00
UNF 3/8 x 24	10,9	8,1	80	36	6,1	9,8	B3157	7,20
UNF 7/16 x 20	12,76	9,25	84	43	6,9	11,5	B3158	9,60
UNF 1/2 x 20	14,35	10,8	91	43	8,1	13	B3159	10,90
UNF 9/16 x 18	16,12	12,5	104	29	10	14,8	B3160	18,40
UNF 5/8 x 18	17,71	14	104	29	11,2	16,3	B3161	22,70
UNF 3/4 x 16	21,11	14	104	29	11,2	19,5	B3162	27,79
UNF 7/8 x 14	24,58	18	120	35	14	22,8	B3163	40,08
UNF 1“ x 12	28,15	20	127	37	16	26	B3164	40,08
UNF 1“ x 14	27,8	20	127	37	16	26	B3165	40,61
UNF 1.1/8 x 12	31,32	22,4	137	37	18	29	B3166	113,00
UNF 1.1/4 x 12	34,5	25	144	39	20	32,5	B3167	136,00
UNF 1.3/8 x 12	37,68	28	150	39	22,4	35,5	B3168	162,50
UNF 1.1/2 x 12	40,85	28	150	39	22,4	38,5	B3169	217,50

BA	D1	D2	L1	L2	□		No.	€
BA 0	7,12	7,1	66	19	5,6	6,2	B3321	14,70
BA 1	6,33	6,3	66	19	5,0	5,5	B3322	76,65
BA 2	5,61	6,3	66	19	5,0	4,9	B3323	14,70
BA 3	4,92	5,0	58	16	4,0	4,2	B3324	94,50
BA 4	4,35	4,5	53	13	3,6	3,8	B3325	14,70
BA 5	3,87	4,0	53	13	3,2	3,3	B3326	94,50
BA 6	3,40	3,6	50	13	2,8	2,9	B3327	14,70

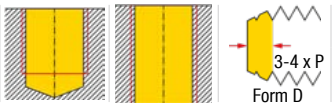
UNF	D1	D2	L1	L2	□		No.	€
G 1/8 x 28	10,82	8,0	59	15	6,3	10,0	B3311	9,30
G 1/4 x 19	14,74	11,2	67	19	9,0	13,5	B3312	11,80
G 3/8 x 19	18,25	14,0	75	21	11,2	17,0	B3313	15,30
G 1/2 x 14	23,09	16,0	87	26	12,5	21,5	B3314	24,90
G 5/8 x 14	25,05	18,0	91	26	14,0	23,5	B3315	36,70
G 3/4 x 14	28,59	20,0	96	28	16,0	27,0	B3316	36,70
G 7/8 x 14	32,35	22,4	102	29	18,0	30,5	B3318	110,90
G 1“ x 11	35,96	25,0	109	33	20,0	33,5	B3317	58,40
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

HSSG EG STI



works standard

BSW	D1	D2	L1	L2	□		No.	€
BSW 1/8 x 40	3,93	4,0	53	13	3,15	3,40	B3201	9,00
BSW 3/16 x 24	6,01	6,3	56	19	6,00	5,10	B3202	9,00
BSW 1/4 x 20	7,84	8,0	72	22	7,20	6,70	B3203	9,00
BSW 5/16 x 18	9,59	10,0	80	24	6,90	8,30	B3204	10,00
BSW 3/8 x 16	11,39	8,0	85	25	8,10	9,90	B3205	10,35
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	15,70
BSW 9/16 x 12	16,76	12,5	102	32	10,00	14,80	B3208	26,05
BSW 5/8 x 11	18,57	14,0	112	37	11,20	16,70	B3209	32,20
BSW 11/16x11	20,20	14,0	112	37	11,20	18,50	B3210	39,20
BSW 3/4 x10	22,02	16,0	118	38	12,50	20,00	B3211	39,20
BSW 7/8 x 9	25,52	18,0	130	45	14,00	23,00	B3212	56,60
BSW 1“ x 8	29,10	20,0	138	48	16,00	26,50	B3213	56,60
BSW 1.1/8 x 7	32,80	22,4	151	51	18,00	29,50	B3214	470,40
BSW 1.1/4 x 7	35,97	25,0	162	57	20,00	33,00	B3215	600,60
BSW 1.3/8 x 6	39,88	28,0	170	60	22,40	36,00	B3216	761,25
BSW 1.1/2 x 6	43,02	31,5	187	67	25,00	39,00	B3217	780,68

BSF	D1	D2	L1	L2	□		No.	€
BSF 3/16 x 32	5,71	6,3	66	19	5,0	5,0	B3251	9,00
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	9,00
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	10,00
BSF 3/8 x 20	11,02	8,0	85	25	6,3	9,9	B3256	10,35
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	15,70
BSF 9/16 x 16	16,16	12,5	102	32	10,0	14,8	B3259	26,05
BSF 5/8 x 14	18,01	14,0	112	37	11,2	16,4	B3260	32,20
BSF 11/16x 14	19.60	14,0	112	37	11,2	18,0	B3261	39,20
BSF 3/4 x 12	21,53	16,0	118	38	12,5	19,5	B3262	39,20
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	56,60
BSF 1“ x 10	28,38	20,0	138	48	16,0	26,5	B3265	56,60
BSF 1.1/8 x 9	31,88	22,4	137	37	18,0	29,5	B3265	56,60
BSF 1.1/4 x 9	35,06	25,0	144	39	20,0	32,5	B3266	720,62
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	14,39
BSB 5/16 x 26	9,1	10,0	76	20	8,0	8,2	B3342	15,54
BSB 3/8 x 26	10,7	8,0	82	22	6,3	9,8	B3343	16,28
BSB 7/16 x 26	12,3	9,0	84	24	7,1	11,5	B3344	21,74
BSB 1/2 x 26	13,9	11,2	90	25	9,0	12,8	B3345	24,68

BSC	D1	D2	L1	L2	□		No.	€
BSC 5/16 x 26	9,1	10,0	76	20	8,0	8,2	B3331	76,13
BSC 3/8 x 26	10,7	8,0	82	22	6,3	9,8	B3332	108,15
BSC 7/16 x 26	12,3	9,0	84	24	7,1	11,5	B3333	132,20
BSC 1/2 x 26	13,9	11,2	90	25	9,0	12,8	B3334	170,10

special sizes	D1	D2	L1	L2	□		No.	€
UNEF 1/4 x 32	7,3	8,0	69	19	6,3	6,5	B3350	77,70
Harley 1/4 x 24	7,8	8,0	69	29	6,3	6,5	B3351	43,58
Harley 7/16 x 16	13,2	10,8	91	42	8,2	11,5	B3352	43,58
Cummins 11/16x16		14,0	112	37	14,0	18,0	B3353	290,22
Carburetor 7/8 x 20		18,0	120	35	14,0	22,5	B3354	380,31
Carburetor 1“ x 20		20,0	127	37	16,0	26,0	B3355	480,38

NPT	D1	D2	L1	L2	□		No.	€
NPT 1/8 x 27		7	65	19	5,5	9,9	B3370	230,16
NPT 1/4 x 19		11	70	25	9,0	13,5	B3371	256,20
NPT 3/8 x 18		12	75	26	9,0	17,0	B3372	352,28
NPT 1/2 x 14		16	80	31	12,0	21,5	B3373	470,40
NPT 3/4 x 14		20	100	33	16,0	27,0	B3374	554,51
NPT 1“ x 11,5		25	110	38	20,0	33,5	B3375	772,70

* prices on request

8 - UN	D1	D2	L1	L2	□		No.	€
1.1/8 x 8		20,0	138	59	16,0	28,5	B3360	110,80
1.1/4 x 8		22,4	151	51	18,0	32,0	B3361	132,93
1.3/8 x 8		25,0	162	57	20,0	35,0	B3362	158,95
1.1/2 x 8		28,0	170	60	22,4	38,0	B3363	212,85
1.5/8 x 8		28,0	170	60	22,4	41,0	B3364	222,50
1.3/4 x 8		31,5	187	67	25,0	44,5	B3365	323,50
1.7/8 x 8		31,5	187	67	25,0	47,5	B3366	323,50
2“ x 8		35,5	200	70	28,0	51,0	B3367	642,30

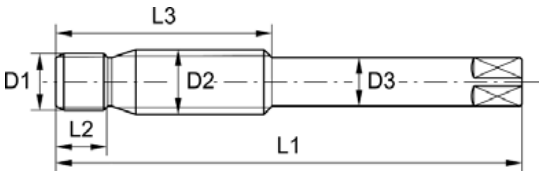
BaerCoil® Taps with pilot nose

HSSG	EG STI	works standard

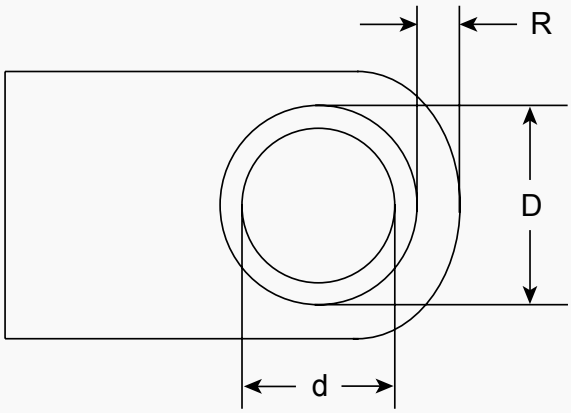
M	D1	D2	D3	L1	L2	□		No.	€
M 6 x 1,0	6,0	7,30	8,0	70	8	28	6,3	B3630	12,80
M 8 x 1,25	8,0	9,62	8,0	75	8	32	6,3	B3631	13,95
M 10 x 1,0*	10,0	11,30	8,0	73	8	32	6,3	B3632	17,65
M 10 x 1,5	10,0	11,95	9,0	80	9	37	7,1	B3633	17,65
M 12 x 1,25*	12,0	13,62	11,0	81	8	33	9,0	B3634	24,20
M 14 x 1,25*	14,0	15,57	12,5	90	8	48	10,0	B3635	26,40
M 18 x 1,5*	18,0	19,95	16,0	116	10	47	12,5	B3636	39,50

* 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



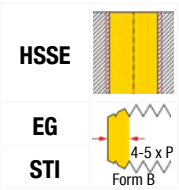
d = nominal diameter
D = outside diameter of holding thread
R = residual wall thickness

R (min) = 0,375 x D

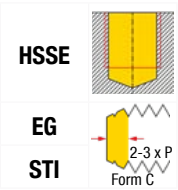
The minimum wall thickness mainly depends on individual operating data.

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



through hole



blind hole

M	D1	D2	L1	L2	□		No.	€
M 3 x 0,5	3,65	4,0	53	13,0	3,15	3,2	B3505	11,34
M 3,5 x 0,6	4,28	4,5	53	13,0	3,55	3,7	B3506	11,34
M 4 x 0,7	4,91	5,0	58	16,0	4,00	4,2	B3507	12,08
M 5 x 0,8	6,04	6,3	66	19,0	5,00	5,3	B3508	12,08
M 6 x 1,0	7,30	8,0	72	22,0	6,30	6,3	B3509	12,08
M 7 x 1,0	8,30	9,0	72	22,0	7,10	7,3	B3510	16,07
M 8 x 1,0	9,30	10,0	80	24,0	8,00	8,3	B3512	17,33
M 8 x 1,25	9,62	10,0	80	24,0	8,00	8,3	B3511	17,33
M 10 x 1,0	11,20	8,0	85	25,0	6,30	10,3	B3517	20,48
M 10 x 1,5	11,95	9,0	89	29,0	7,10	10,4	B3515	20,48
M 12 x 1,25	13,62	11,2	95	30,0	9,00	12,3	B3522	27,30
M 12 x 1,5	13,95	11,2	95	30,0	9,00	12,4	B3521	27,30
M 12 x 1,75	14,27	11,2	95	30,0	9,00	12,4	B3520	22,05
M 14 x 1,25	15,57	12,5	102	32,0	10,00	14,4	B3529	30,45
M 14 x 1,5	15,95	12,5	102	32,0	10,00	14,5	B3528	30,45
M 14 x 2,0	16,60	12,5	102	32,0	10,00	14,5	B3527	27,30
M 16 x 2,0	18,60	14,0	112	37,0	11,20	16,5	B3533	40,95

M	D1	D2	L1	L2	□		No.	€
M 2 x 0,4	2,52	2,8	44,5	9,5	2,24	2,1	B3704	16,70
M 3 x 0,5	3,65	4,0	53	13,0	3,15	3,2	B3705	11,55
M 3,5 x 0,6	4,28	4,5	53	13,0	3,55	3,7	B3706	16,28
M 4 x 0,7	4,91	5,0	58	16,0	4,00	4,2	B3707	12,81
M 5 x 0,8	6,04	6,3	66	19,0	5,00	5,3	B3708	12,81
M 6 x 1,0	7,30	8,0	72	22,0	6,30	6,3	B3709	12,81
M 7 x 1,0	8,30	9,65	72	33,0	7,30	7,3	B3710	16,91
M 8 x 1,0	9,30	10,0	80	24,0	8,00	8,3	B3712	20,48
M 8 x 1,25	9,62	10,0	80	24,0	8,00	8,3	B3711	16,91
M 10 x 1,0	11,20	8,0	85	25,0	6,30	10,3	B3717	24,68
M 10 x 1,5	11,95	9,0	89	29,0	7,10	10,4	B3715	19,74
M 12 x 1,25	13,62	11,2	95	30,0	9,00	12,3	B3722	31,29
M 12 x 1,5	13,95	11,2	95	30,0	9,00	12,4	B3721	31,29
M 12 x 1,75	14,27	11,2	95	30,0	9,00	12,4	B3720	22,05
M 14 x 1,25	15,57	12,5	102	32,0	10,00	14,4	B3729	31,29
M 14 x 1,5	15,95	12,5	102	32,0	10,00	14,5	B3728	36,75
M 14 x 2,0	16,60	12,5	102	32,0	10,00	14,5	B3727	40,95
M 16 x 2,0	18,60	14,0	112	37,0	11,20	16,5	B3733	44,94
M 18 x 1,5	19,95	16,5	113	51,0	12,40	18,5	B3737	50,40

Harley	D1	D2	L1	L2	□		No.	€
1/4 x 24	7,8	8,0	69	29	6,3	6,5	B3351	43,58
7/16 x 16	13,2	10,8	91	42	8,2	11,5	B3352	43,58

BaerCoil® Machine taps - PRO for Wire Thread Inserts

HSSE		
EG	DIN	
STI	371/376	4-5 x P Form B

through hole

HSSE		
EG	DIN	
STI	371/376	2-3 x P Form C

blind 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	61,64
M 3 x 0,5	3,65	4,5	63	10,0	3,4	3,2	B3506P	29,40
M 4 x 0,7	4,91	6,0	70	13,0	4,9	4,2	B3507P	29,80
M 5 x 0,8	6,04	6,0	80	13,0	4,9	5,3	B3508P	39,59
M 6 x 1,0	7,30	8,0	90	17,0	6,2	6,3	B3509P	31,40
M 8 x 1,25	9,62	10,0	100	18,0	8,0	8,3	B3511P	44,25
M 10 x 1,5	11,95	9,0	110	22,0	7,0	10,4	B3515P	56,70
M 12 x 1,75	14,27	11,0	110	26,0	9,0	12,4	B3520P	76,55
M 16 x 2,0	18,60	14,0	125	27,0	11,0	16,5	B3527P	147,00
M 20 x 2,5	23,25	18,0	160	34,0	14,5	20,5	B3533P	225,75

M	D1	D2	L1	L2	□		No.	€
M 2,5 x 0,45	3,09	3,5	56	6,0	2,7	2,6	B3703P	65,05
M 3 x 0,5	3,65	4,5	63	6,0	3,4	3,2	B3705P	25,25
M 4 x 0,7	4,91	6,0	70	8,0	4,9	4,2	B3707P	24,75
M 5 x 0,8	6,04	6,0	80	8,0	4,9	5,3	B3708P	39,48
M 6 x 1,0	7,30	8,0	90	10,0	6,2	6,3	B3709P	24,90
M 8 x 1,25	9,62	10,0	100	16,0	8,0	8,3	B3711P	30,60
M 10 x 1,5	11,95	9,0	110	15,0	7,0	10,4	B3715P	41,10
M 12 x 1,75	14,27	11,0	110	20,0	9,0	12,4	B3720P	44,05
M 16 x 2,0	18,60	14,0	125	22,0	11,0	16,5	B3733P	152,36
M 20 x 2,5	23,25	18,0	160	30,0	14,5	20,5	B3738P	227,56

UNC	D1	D2	L1	L2	□		No.	€
UNC 4 x 40	3,67	4,5	63	13,0	3,4	3,0	B3901P	82,53
UNC 6 x 32	4,54	6,0	70	14,0	4,9	3,7	B3902P	77,28
UNC 10 x 24	6,20	7,0	80	17,0	5,5	5,1	B3903P	82,53
UNC 1/4 x 20	8,00	8,0	90	20,0	6,2	6,7	B3904P	78,86
UNC 5/16 x 18	9,77	10,0	100	22,0	8,0	8,3	B3905P	94,61
UNC 3/8 x 16	11,59	12,0	110	21,0	9,0	9,9	B3906P	108,15
UNC 7/16 x 14	13,47	11,0	110	26,0	9,0	11,6	B3907P	135,14
UNC 1/2 x 13	15,24	12,0	110	27,0	9,0	13,0	B3908P	142,70
UNC 9/16 x 12	17,03	14,0	125	26,0	11,0	14,8	B3909P	210,21
UNC 5/8 x 11	18,87	14,0	125	30,0	11,0	16,5	B3910P	189,21
UNC 3/4 x 10	22,35	18,0	140	32,0	14,5	19,75	B3911P	250,74

UNC	D1	D2	L1	L2	□		No.	€
UNC 4 x 40	3,67	4,5	63	7,0	3,4	3,0	B3921P	84,11
UNC 6 x 32	4,54	6,0	70	8,0	4,9	3,7	B3922P	81,06
UNC 8 x 32	5,20	6,0	80	8,0	4,9	4,4	B3923P	82,53
UNC 10 x 24	6,20	7,0	80	10,0	5,5	5,1	B3924P	85,58
UNC 1/4 x 20	8,00	8,0	90	14,0	6,2	6,7	B3925P	94,61
UNC 5/16 x 18	9,77	10,0	100	16,0	8,0	8,3	B3926P	99,12
UNC 3/8 x 16	11,59	12,0	110	16,0	9,0	9,9	B3927P	111,09
UNC 7/16 x 14	13,47	11,0	110	20,0	9,0	11,6	B3928P	153,20
UNC 1/2 x 13	15,24	12,0	110	22,0	9,0	13,0	B3929P	156,14
UNC 9/16 x 12	17,03	14,0	125	22,0	11,0	14,8	B3930P	214,73
UNC 5/8 x 11	18,87	14,0	125	25,0	11,0	16,5	B3931P	207,17
UNC 3/4 x 10	22,35	18,0	140	27,0	14,5	19,75	B3932P	258,30

UNF	D1	D2	L1	L2	□		No.	€
UNF 4 x 48	3,53	4,0	56	12,0	3,0	3,0	B3950P	85,58
UNF 6 x 40	4,33	6,0	70	14,0	4,9	3,7	B3951P	84,11
UNF 8 x 36	5,08	6,0	70	13,0	4,9	4,4	B3952P	84,11
UNF 10 x 32	5,86	6,0	80	13,0	4,9	5,1	B3953P	90,09
UNF 1/4 x 28	7,53	8,0	90	17,0	6,2	6,6	B3954P	94,61
UNF 5/16 x 24	9,31	10,0	100	18,0	8,0	8,2	B3955P	99,12
UNF 3/8 x 24	10,90	12,0	110	18,0	9,0	9,8	B3956P	106,58
UNF 7/16 x 20	12,76		100	22,0		11,5	B3957P	145,64
UNF 1/2 x 20	14,35		100	22,0		13,0	B3958P	135,14
UNF 9/16 x 18	16,12		100	22,0		14,8	B3959P	223,76
UNF 5/8 x 18	17,71		110	25,0		16,3	B3960P	201,18
UNF 3/4 x 16	21,11		125	25,0		19,5	B3961P	265,76

UNF	D1	D2	L1	L2	□		No.	€
UNF 4 x 48	3,53	4,0	56	7,0	3,0	3,0	B3970P	100,59
UNF 6 x 40	4,33	6,0	70	8,0	4,9	3,7	B3971P	99,12
UNF 8 x 36	5,08	6,0	70	8,0	4,9	4,4	B3972P	99,12
UNF 10 x 32	5,86	6,0	80	8,0	4,9	5,1	B3973P	108,15
UNF 1/4 x 28	7,53	8,0	90	10,0	6,2	6,6	B3974P	118,65
UNF 5/16 x 24	9,31	10,0	100	10,0	8,0	8,2	B3975P	132,09
UNF 3/8 x 24	10,90	12,0	110	11,0	9,0	9,8	B3976P	135,14
UNF 7/16 x 20	12,76		100	13,0		11,5	B3977P	169,68
UNF 1/2 x 20	14,35		100	15,0		13,0	B3978P	165,17
UNF 9/16 x 18	16,12		100	15,0		14,8	B3979P	267,23
UNF 5/8 x 18	17,71		110	17,0		16,3	B3980P	244,76

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

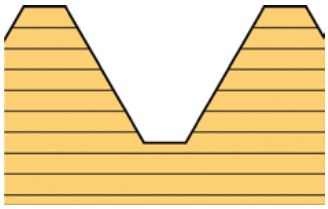
BaerCoil®

Forming Taps

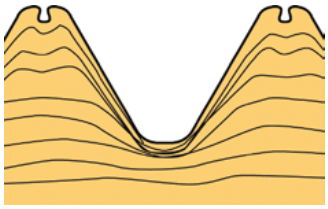
BaerCoil® Forming Taps

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.

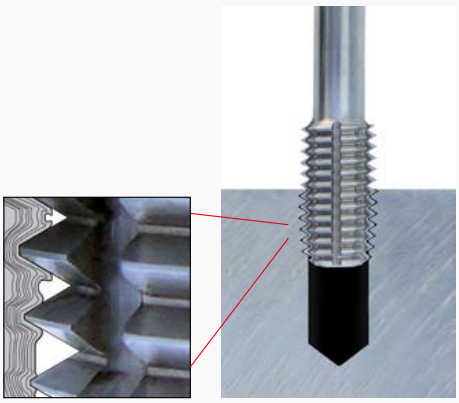
Result: The thread into which the BaerCoil® wire thread insert is turned has a significantly **higher load capacity**. The process of thread forming is **faster** and produces a **better surface** than thread cutting. Additionally there are no chips, and the thread forming tap has a **longer life time**.



Grain structure of a cutted thread



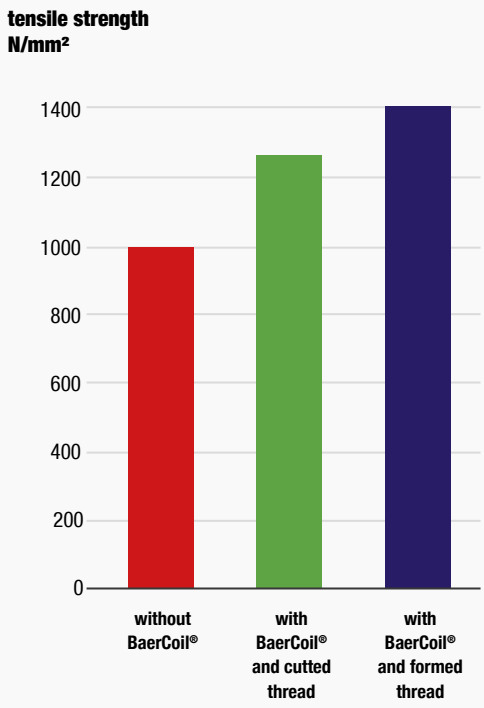
Grain structure of a formed thread
The patent material gets compressed, will be strengthed and the resistance of the thread gets increased



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.



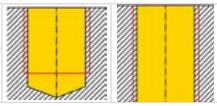
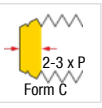
Advantages:

- 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			
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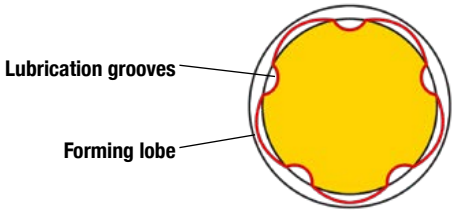
works standard



M	D1	D2	L1	L2	□		No.	€
M 2 x 0,4	2,54	2,8	50	9,0	2,10	2,35	B3601	47,36
M 2,5 x 0,45	3,11	3,5	56	10,0	2,70	2,90	B3603	47,36
M 3 x 0,5	3,68	4,5	63	12,0	3,40	3,40	B3605	39,90
M 4 x 0,7	4,94	6,0	70	14,0	4,90	4,60	B3607	40,95
M 5 x 0,8	6,07	6,0	80	16,0	4,90	5,65	B3608	42,53
M 6 x 1,0	7,34	8,0	90	18,0	6,20	6,85	B3609	45,15
M 8 x 1,25	9,67	10,0	99	20,0	8,00	9,05	B3611	52,50
M 10 x 1,5	11,99	9,0	100	22,0	7,00	11,30	B3615	55,65
M 12 x 1,75	14,33	11,0	110	25,0	9,00	13,50	B3620	71,93

Please inquire further thread standards and dimensions.

Find forming speeds on page 63

BAER GERMANY

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.	€
		UNC 4 x 40 UNC 5 x 40							
M 3 x 0,5	M 3,5 x 0,6	UNC 6 x 32 UNF 4 x 48 UNF 6 x 40	BSW 1/8 x 40	5 BA		100	5	EBW03	6,35
		UNC 8 x 32		4 BA					
M 4 x 0,7		UNC 10 x 24 UNF 8 x 36	BSF 3/16 x 32	3 BA		100	5	EBW04	6,35
		UNC 12 x 24	BSW 3/16 x 24	2 BA					
M 5 x 0,8		UNF 10 x 32	BSF 7/32 x 28	1 BA		100	5	EBW05	6,35
M 6 x 1,0		UNC 1/4 x 20	BSW 1/4 x 20	0 BA	UNEF 1/4 x 32				
M 6 x 0,75		UNF 1/4 x 28	BSF 1/4 x 26 BSF 9/32 x 26		Harley 1/4 x 24 BSB 1/4 x 26	100	5	EBW06	6,35
		UNC 5/16 x 18	BSW 5/16 x 18		BSC 5/16 x 26				
M 7 x 1,0		UNF 5/16 x 24	BSF 5/16 x 22		BSB 5/16 x 26	100	7	EBW07	7,20
M 8 x 1,25	M 9 x 1,25	UNC 3/8 x 16	BSW 3/8 x 16		BSC 3/8 x 26				
M 8 x 1,0 M 8 x 0,75	M 9 x 1,0	UNF 3/8 x 24	BSF 3/8 x 20		BSB 3/8 x 26	100	7	EBW08	7,20
M 10 x 1,5	M 11 x 1,5	UNC 7/16 x 14	BSW 7/16 x 14	G 1/8 x 28	Harley 7/16 x 16				
M 10 x 1,25 M 10 x 1,0	M 11 x 1,25 M 11 x 1,0	UNF 7/16 x 20	BSF 7/16 x 18	NPT 1/8 x 27	BSC 7/16 x 26 BSB 7/16 x 26	100	7	EBW10	8,00
M 12 x 1,75	M 12 x 1,0	UNC 1/2 x 13	BSW 1/2 x 12	G 1/4 x 19	BSC 1/2 x 26				
M 12 x 1,5 M 12 x 1,25	M 13 x 1,5 M 13 x 1,25	UNF 1/2 x 20	BSF 1/2 x 16		BSB 1/2 x 26	100	7	EBW12	9,30
M 14 x 2,0	M 15 x 2,0	UNC 9/16 x 12	BSW 9/16 x 12	G 3/8 x 19	11/16 x 16				
M 14 x 1,5 M 14 x 1,25 M 14 x 1,0	M 15 x 1,5 M 16 x 2,0 M 16 x 1,5	UNC 5/8 x 11 UNF 9/16 x 18 UNF 5/8 x 18	BSW 5/8 x 11 BSF 9/16 x 16 BSF 5/8 x 14	NPT 1/4 x 19		100	7	EBW14	10,90

Compatibility

BaerCoil® wire thread inserts and tools are compatible with wire thread inserts and tools from other manufacturers, in most cases. Baer- Coil® 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

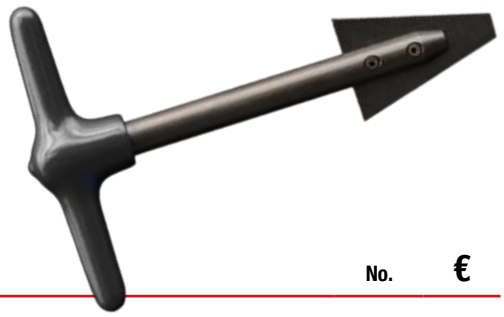
M	UNC UNF	BSW BSF	G (BSP) NPT	8-UN	No.	€
M 2 x 0,4 M 2,2 x 0,45	UNC 2 x 56 UNF 2 x 64				EBW01	13,13
M 2,5 x 0,45	UNC 3 x 48 UNF 3 x 56		BA 6		EBW02	13,13
M 18 x 2,5 M 18 x 2,0 M 18 x 1,5	UNC 3/4 x 10	BSW 3/4 x 10 BSF 3/4 x 12 BSF 13/16 x 12			EBW18	25,10
M 20 x 2,5 M 20 x 2,0 M 20 x 1,5	UNF 3/4 x 16				EBW20	25,10
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	31,40
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	31,40
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	66,05
M 28 x 1,5					EBW28	36,65
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	66,05
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	66,05
M 33 x 3,5 M 33 x 2,0					EBW33	50,19
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	66,05
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	75,50
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	75,50

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	9,21
M 4 x 0,7	48,00 mm	7,00 mm	1/4“	KEBW04	9,21
M 5 x 0,8	57,00 mm	8,00 mm	1/4“	KEBW05	9,21
M 6 x 1,0	62,00 mm	10,00 mm	1/4“	KEBW06	9,21
M 7 x 1,0	72,00 mm	11,00 mm	1/4“	KEBW07	9,70
M 8 x 1,25	72,00 mm	13,00 mm	1/4“	KEBW08	11,22
M 10 x 1,0	77,00 mm	17,00 mm	1/4“	KEBW1010	12,92
M 10 x 1,5	82,00 mm	17,00 mm	1/4“	KEBW10	12,53
M 12 x 1,25	79,00 mm	19,00 mm	1/4“	KEBW1212	14,68
M 12 x 1,5	79,00 mm	19,00 mm	1/4“	KEBW1215	14,68
M 12 x 1,75	92,00 mm	19,00 mm	1/4“	KEBW12	13,83
M 14 x 1,5	94,00 mm	21,00 mm	1/4“	KEBW1415	14,68
M 14 x 2,0	94,00 mm	21,00 mm	1/4“	KEBW1420	14,68
UNC 1/4 x 20	62,00 mm	7/16 ''	1/4“	KEBW21	10,46
UNC 5/16 x 18	67,00 mm	1/2 ''	1/4“	KEBW22	10,46
UNC 3/8 x 16	77,00 mm	9/16 ''	1/4“	KEBW23	12,76
UNC 7/16 x 14	87,00 mm	11/16 ''	1/4“	KEBW24	14,20
UNC 1/2 x 13	97,00 mm	3/4 ''	1/4“	KEBW25	14,86
UNF 1/4 x 28	62,00 mm	7/16 ''	1/4“	KEBW31	10,46
UNF 5/16 x 24	67,00 mm	1/2 ''	1/4“	KEBW32	10,46
UNF 3/8 x 24	77,00 mm	9/16 ''	1/4“	KEBW33	12,76
UNF 7/16 x 20	87,00 mm	11/16 ''	1/4“	KEBW34	14,20
UNF 1/2 x 20	97,00 mm	3/4 ''	1/4“	KEBW35	14,86

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	46,73
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	28,25
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	33,81
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	112,25
M 38 – M 65				UN 1.5/8“ – UN 2“	B7055	149,63

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	5,57
M 2,5 x 0,45		UNC 3 x 48 UNF 3 x 56		6 BA			BZ002	2,78
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	2,50
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	2,50
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	2,50
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	2,65
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	2,80
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	2,80
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	3,40

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	9,82
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	10,92

BaerCoil® Drill Bits

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

DIN 338 - HSS straight shank drill bit

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	0,84
2,30 mm	M 2,2 x 0,45		UNC 2 x 56	UNF 2 x 64			338	16123	0,84
2,60 mm	M 2,5 x 0,45		UNC 3 x 48	UNF 3 x 56			338	16126	0,84
3,00 mm			UNC 4 x 40	UNF 4 x 48			338	16130	0,91
3,20 mm	M 3 x 0,5						338	16132	0,91
3,30 mm				UNF 5 x 44			338	16133	0,91
3,40 mm			UNC 5 x 40		BSW 1/8 x 40		338	16134	0,95
3,70 mm	M 3,5 x 0,6		UNC 6 x 32	UNF 6 x 40			338	16137	1,12
4,20 mm	M 4 x 0,7						338	16142	1,33
4,40 mm				UNF 8 x 36			338	16144	1,50
4,50 mm			UNC 8 x 32				338	16145	1,50
5,00 mm					BSW 3/16 x 24	BSF 3/16 x 32	338	16150	1,58
5,10 mm				UNF 10 x 32			338	16151	1,79
5,20 mm	M 5 x 0,8		UNC 10 x 24				338	16152	1,79
5,80 mm			UNC 12 x 24			BSF 7/32 x 28	338	16158	2,00
6,30 mm	M 6 x 1,0	M 6 x 0,75					338	16163	2,21
6,60 mm				UNF 1/4 x 28		BSF 1/4 x 26	338	16166	2,52
6,70 mm			UNC 1/4 x 20		BSW 1/4 x 20		338	16167	2,52
7,30 mm	M 7 x 1,0					BSF 9/32 x 26	338	16173	2,94
8,20 mm	M 8 x 0,75			UNF 5/16 x 24			338	16182	4,20
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	4,20
9,30 mm	M 9 x 1,25	M 9 x 1,0					338	16193	4,20
9,80 mm				UNF 3/8 x 24			338	16198	4,83
9,90 mm			UNC 3/8 x 16		BSW 3/8 x 16	BSF 3/8 x 20	338	16199	4,83
10,30 mm	M 10 x 1,0	M 10 x 1,25					338	161103	6,30
10,40 mm	M 10 x 1,5						338	161104	6,30
11,30 mm	M 11 x 1,0						338	161113	7,67
11,40 mm	M 11 x 1,5	M 11 x 1,25					338	161114	7,67
11,50 mm				UNF 7/16 x 20		BSF 7/16 x 18	338	161115	7,67
11,60 mm			UNC 7/16 x 14		BSW 7/16 x 14		338	161116	7,67
12,30 mm	M 12 x 1,0	M 12 x 1,25					338	161123	9,87
12,40 mm	M 12 x 1,75	M 12 x 1,5					338	161124	9,87
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	9,87
13,25 mm	M 13 x 1,25	M 13 x 1,5					338-A	130133	35,18
14,40 mm	M 14 x 1,0	M 14 x 1,25					338-A	111144	35,18
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	16,80
14,75 mm			UNC 9/16 x 12		BSW 9/16 x 12		345	130147	51,45
15,50 mm	M 15 x 2,0	M 15 x 1,5					338-A	111155	22,89
16,25 mm				UNF 5/8 x 18		BSF 5/8 x 14	345	130162	51,45
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	25,41
18,00 mm			UNC 11/16x11		BSW 11/16x11	BSF 11/16x14	338-A	111180	30,45
18,50 mm	M 18 x 2,5	M 18 x 2,0 M 18 x 1,5					338-A	111185	31,29
19,50 mm				UNF 3/4 x 16		BSF 3/4 x 12	338-A	111195	34,65
19,75 mm			UNC 3/4 x 10		BSW 3/4 x 10		345	130197	51,45
20,50 mm	M 20 x 2,5	M 20 x 2,0 M 20 x 1,5					338-A	111205	50,40
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	58,28
23,00 mm			UNC 7/8 x 9		BSW 7/8 x 9		338-A	111230	60,90
24,50 mm	M 24 x 3,0	M 24 x 2,0 M 24 x 1,5					345	130245	58,28
26,00 mm			UNC 1“ x 8	UNF 1“ x 12/14	BSW 1“ x 8	BSF 1“ x 10	338-A	111260	82,95

BaerCoil® Drill Bits

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

DIN 338 - HSS straight shank drill bit

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	93,45
27,50 mm	M 27 x 2,0	M 27 x 1,5					345	130275	93,45
28,50 mm	M 28 x 1,5						345	130285	101,85
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	124,95
30,50 mm	M 30 x 3,5	M 30 x 2,0 M 30 x 1,5					345	130305	126,00
32,50 mm				UNF 1.1/4“ x 12		BSF 1.1/4“ x 9	345	130325	160,65
33,00 mm			UNC 1.1/4“ x 7		BSW 1.1/4“ x 7		345	130330	173,25
33,50 mm	M 33 x 3,5	M 33 x 2,0					345	130335	179,55
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	207,90
36,50 mm	M 36 x 3,0	M 36 x 2,0 M 36 x 1,5					345	130365	229,95
37,00 mm	M 36 x 4,0						345	130370	264,60
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	267,75
39,50 mm	M 39 x 2,0						345	130395	267,75
40,00 mm	M 39 x 4,0						345	130400	267,75
42,50 mm	M 42 x 2,0						345	130425	310,80
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	310,80

Ø	G (BSP)	BSB	BSC	NPT	BA		DIN	No.	€
2,90 mm					BA 6		338	16129	0,91
3,20 mm					BA 5		338	16132	0,91
3,80 mm					BA 4		338	16138	1,12
4,30 mm					BA 3		338	16143	1,50
4,90 mm					BA 2		338	16149	1,58
5,50 mm					BA 1		338	16155	2,00
6,20 mm					BA 0		338	16162	2,21
6,60 mm		BSB 1/4 x 26				UNEF 1/4 x 32 Harley 1/4 x 24	338	16166	2,52
8,20 mm		BSB 5/16 x 26	BSC 5/16 x 26				338	16182	4,20
9,80 mm		BSB 3/8 x 26	BSC 3/8 x 26				338	16198	4,83
9,90 mm	G 1/8 x 28			NPT 1/8 x 27			338	16199	4,83
11,50 mm		BSB 7/16 x 26	BSC 7/16 x 26			Harley 7/16 x 16	338	161115	7,67
13,00 mm		BSB 1/2 x 26	BSC 1/2 x 26				338	161130	9,87
13,50 mm	G 1/4 x 19			NPT 1/4 x 19			338-A	111135	27,09
17,00 mm	G 3/8 x 19			NPT 3/8 x 18			338-A	111170	27,09
18,00 mm						Cummins 11/16x16	338-A	111180	30,45
21,50 mm	G 1/2 x 14			NPT 1/2 x 14			338-A	111215	47,25
22,50 mm						Carburetor 7/8 x 20	345	130225	58,28
23,50 mm	G 5/8 x 14						345	130235	60,90
26,00 mm						Carburetor 1“ x 20	338-A	111260	82,95
27,00 mm	G 3/4 x 14			NPT 3/4 x 14			338-A	111270	88,20
28,50 mm						UN 1.1/8“ x 8	345	130285	101,85
32,00 mm						UN 1.1/4“ x 8	345	130320	155,40
33,50 mm	G 1“ x 11			NPT 1“ x 11,5			345	130335	179,55
35,00 mm						UN 1.3/8“ x 8	345	130350	205,80
38,00 mm						UN 1.1/2“ x 8	345	130380	264,60
41,00 mm						UN 1.5/8“ x 8	345	130410	267,75
42,50 mm	G 1.1/4“ x 11						345	130425	310,80
44,50 mm						UN 1.3/4“ x 8	345	130445	324,45
47,50 mm						UN 1.7/8“ x 8	345	130475	415,80
48,50 mm	G 1.1/2“ x 11						345	130485	415,80

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.

Advantages:

- 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®

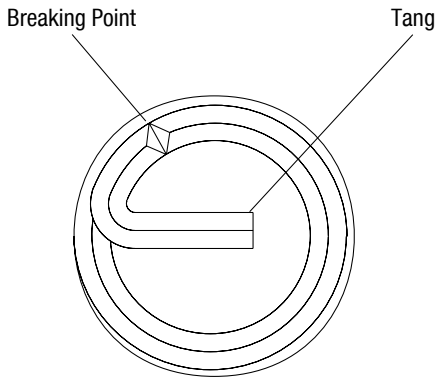
Technical Data

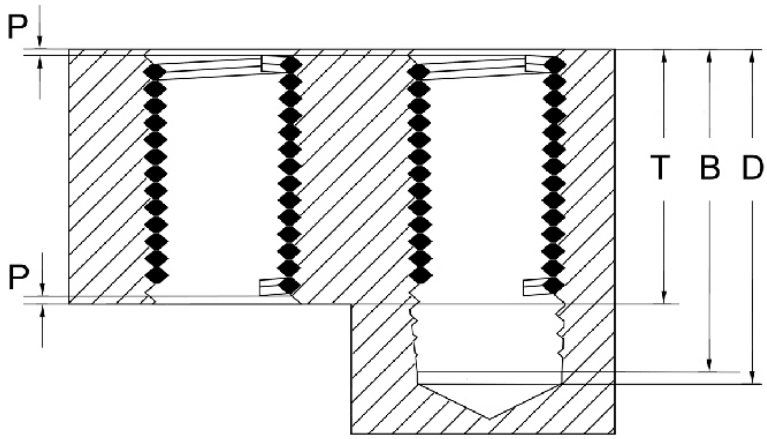
BAER GERMANY

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 (mm)	
	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 (mm)	
	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 (mm)	
	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

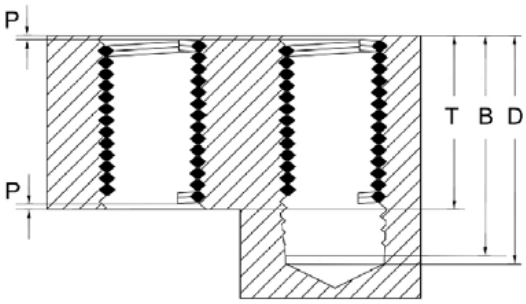
UNF	1,0 D			1,5 D			2,0 D			2,5 D			3,0 D			F (mm)	
	T	D	B	T	D	B	T	D	B	T	D	B	T	D	B	min.	max.
2 x 64	0.086	0.156	0.141	0.129	0.199	0.184	0.172	0.242	0.227	0.215	0.285	0.270	0.258	0.328	0.313	0.105	0.116
3 x 56	0.099	0.179	0.161	0.148	0.228	0.210	0.198	0.278	0.260	0.248	0.328	0.310	0.297	0.377	0.359	0.120	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 (mm)	
	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 (mm)	
	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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