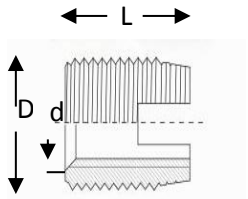
Thread Inserts with Cutting Slots

אינסרטים



M12x1.5	M10x1.5	M8x1,25	M6x1	M6x1	M5x0.8	M4x0.7	M3x0,5	M2.5x0.45	M2x0,4*	d
M16x1,5	M14x1,5	M12x1,5	M10x1,5	M9x1	M8x1,0	M6,5x0,75	M5x0,5	M4,5x0,5	M4,5x0,5	D
22mm	18mm	15mm	14mm	12mm	10mm	8mm	6mm	6mm	6mm	L

M24x3.0	M22X2.5	M20x2.5	M18x2.5	M16x2.0	M14x2	M14x1.5	M12x1.75	d
M30x1,5	M26x1,5	M26x1,5	M22x1,5	M20x1,5	M18x1,5	M18x1,5	M16x1,5	D
30mm	30mm	27mm	24mm	22mm	24mm	24mm	22mm	L

UNC

UNC 5/8x11	UNC 1/2x13	UNC 7/16x14	UNC 3/8x16	UNC 5/16x18	UNC 1/4x20	UNC 10x24	UNC 8x32	UNC 6x32	UNC 4x40	d
M 20x1,5	M 18x1,5	M16X1.5	M14X1.5	M 12x1,5	M10X1.5	M8X1	M6.5x0,75	M6x0.75	M5x0.5	D
22 mm	22 mm	22 mm	18 mm	15 mm	14 mm	10 mm	8 mm	8 mm	6 mm	L

UNF

UNF 5/8x18	UNF 1/2x20	UNF 7/16x20	UNF 3/8x24	UNF 5/16x24	UNF 1/4x28	UNF 10x32	UNF 8x36	UNF 6x40	UNF 4x40	d
M 20x1,5	M 18x1,5	M16X1.5	M14X1.5	M 12x1,5	M10X1.5	M8X1	M6.5x0,75	M6x0.75	M5x0.5	D
22 mm	22 mm	22 mm	18 mm	15 mm	14 mm	10 mm	8 mm	8 mm	6 mm	L

Installation by hand

1. Drilling

Clear the damaged thread with a drill bit or create a new hole in the parent material. For strong, hard and tough materials it is recommended to tap the thread (max. intermediate tap) before the installation of BaerFix® Inserts.

2. Screwing BaerFix® Insert on the inserting tool

Screw the BaerFix® Insert, with cutting slots or holes pointing downwards, on the inserting tool. Lock the BaerFix® Insert with the nut by wrench.

3. Installing the insert

Screw the BaerFix® Insert into the borehole. The BaerFix® Thread Insert is self-tapping. The inserting tool has a 1/4" hexagonal shank and can be used by a cordless screwdriver or a wrench socket.

4. Screwing off the inserting tool

Unlock the countermut by a wrench and screw off the inserting tool. Created bolted connections with BaerFix® Inserts are vibration resistant, wear-free and have a high load capacity in materials with low shearing strength.

Installation by machine

1. Drilling

Clear the damaged thread with a drill bit or create a new hole in the parent material. For strong, hard and tough materials it is recommended to tap the thread (max. intermediate tap) before the installation of BaerFix® Inserts.

2. Configure the machine

Position the workpiece to ensure that hole and machine spindle are in alignment. Set the dimensions, speed values and driving depth (about 0,1 mm till 0,2 mm under the workpiece surface). Turn the external shell, so the stop pin can hold and drive the shell while rotating in clockwise direction. Screw the BaerFix® Insert, with cutting slots or holes pointing downwards, 2 till 4 windings on the inserting tool.

3. Installing the insert

Actuate the machine for screwing the insert into the hole, until the chosen driving depth is reached. Avoid a hard touchdown of the inserting tool on the workpiece to prevent damages on the inserting tool, thread insert or workpiece.

4. Screwing off the inserting tool

Set the machine on reverse running. The stop pin holds the shell while rotating in counterclockwise direction and screws out the inserting tool.