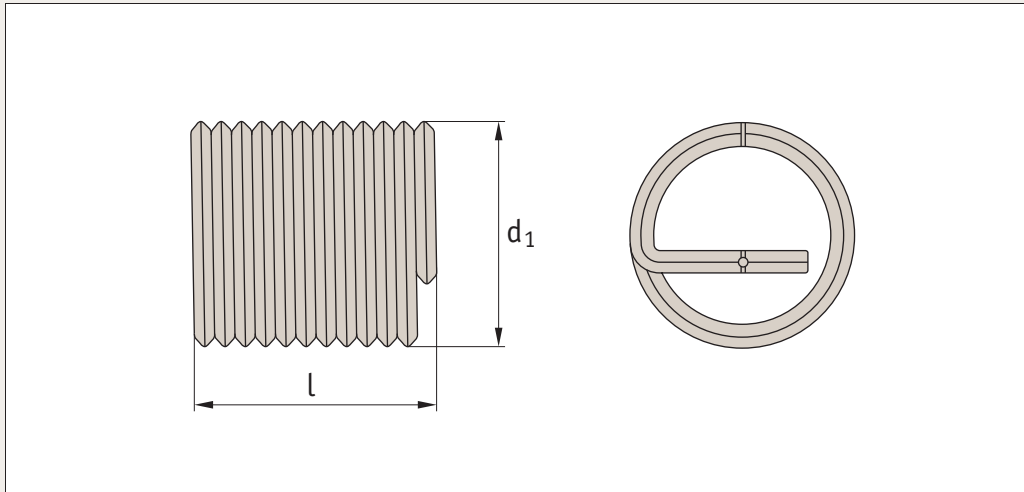




P0080



Material

Stainless steel (A2, AISI 304).

Technical Notes

To DIN 8140-1A

These inserts are used for the repair and reinforcement of cracked and damaged threads. Thread inserts are oversized so that when installed they are kept in position by the pressure between the sides of the hole and the coils.

Threads are metric coarse threads, other pitches available on request.

Temperature range for use -160° C to +420° C and can withstand temperature surges up to +500° C.

Tips

A special tap is required to install these inserts.

The installation procedure includes the following steps:

1. Drill Hole
2. Tap with wire insert tap
3. Check hole with gauge
4. Install insert
5. Remove tang
6. Check thread 'go:no-go'.

Order No.	d ₁ x pitch	Drill Ø d ₂	C'bore Ø d ₃	l
P0080.020-1.0-A2	M2 x0,4	2,1	2,52 - 2,61	2,0
P0080.020-1.5-A2	M2 x0,4	2,1	2,52 - 2,61	3,0
P0080.020-2.0-A2	M2 x0,4	2,1	2,52 - 2,61	2,0
P0080.020-2.5-A2	M2 x0,4	2,1	2,52 - 2,61	5,0
P0080.020-3.0-A2	M2 x0,4	2,1	2,52 - 2,61	6,0
P0080.025-1.0-A2	M2,5x0,45	2,6	3,08 - 3,18	2,5
P0080.025-1.5-A2	M2,5x0,45	2,6	3,08 - 3,18	3,75
P0080.025-2.0-A2	M2,5x0,45	2,6	3,08 - 3,18	5,0
P0080.025-2.5-A2	M2,5x0,45	2,6	3,08 - 3,18	6,25
P0080.025-3.0-A2	M2,5x0,45	2,6	3,08 - 3,18	7,5
P0080.030-1.0-A2	M3 x0,5	3,2	3,65 - 4,35	3,0
P0080.030-1.5-A2	M3 x0,5	3,2	3,65 - 4,35	4,5
P0080.030-2.0-A2	M3 x0,5	3,2	3,65 - 4,35	6,0
P0080.030-2.5-A2	M3 x0,5	3,2	3,65 - 4,35	7,5
P0080.030-3.0-A2	M3 x0,5	3,2	3,65 - 4,35	9,0
P0080.040-1.0-A2	M4 x0,7	4,2	4,9 - 5,06	4,0
P0080.040-1.5-A2	M4 x0,7	4,2	4,9 - 5,06	6,0
P0080.040-2.0-A2	M4 x0,7	4,2	4,9 - 5,06	8,0
P0080.040-2.5-A2	M4 x0,7	4,2	4,9 - 5,06	10,0
P0080.040-3.0-A2	M4 x0,7	4,2	4,9 - 5,06	12,0
P0080.050-1.0-A2	M5 x0,8	5,2	6,04 - 6,21	5,0
P0080.050-1.5-A2	M5 x0,8	5,2	6,04 - 6,21	7,5

Order No.	d ₁ x pitch	Drill Ø d ₂	C'bore Ø d ₃	l
P0080.050-2.0-A2	M5 x0,8	5,2	6,04 - 6,21	10,0
P0080.050-2.5-A2	M5 x0,8	5,2	6,04 - 6,21	12,5
P0080.050-3.0-A2	M5 x0,8	5,2	6,04 - 6,21	15,0
P0080.060-1.0-A2	M6 x1,0	6,3	7,3 - 7,51	6,0
P0080.060-1.5-A2	M6 x1,0	6,3	7,3 - 7,51	9,0
P0080.060-2.0-A2	M6 x1,0	6,3	7,3 - 7,51	12,0
P0080.060-2.5-A2	M6 x1,0	6,3	7,3 - 7,51	15,0
P0080.060-3.0-A2	M6 x1,0	6,3	7,3 - 7,51	18,0
P0080.080-1.0-A2	M8 x1,25	8,3	9,62 - 9,89	8,0
P0080.080-1.5-A2	M8 x1,25	8,3	9,62 - 9,89	12,0
P0080.080-2.0-A2	M8 x1,25	8,3	9,62 - 9,89	16,0
P0080.080-2.5-A2	M8 x1,25	8,3	9,62 - 9,89	20,0
P0080.080-3.0-A2	M8 x1,25	8,3	9,62 - 9,89	24,0
P0080.100-1.0-A2	M10x1,5	10,4	11,95 - 12,27	10,0
P0080.100-1.5-A2	M10x1,5	10,4	11,95 - 12,27	15,0
P0080.100-2.0-A2	M10x1,5	10,4	11,95 - 12,27	20,0
P0080.100-2.5-A2	M10x1,5	10,4	11,95 - 12,27	25,0
P0080.100-3.0-A2	M10x1,5	10,4	11,95 - 12,27	30,0
P0080.120-1.0-A2	M12x1,75	12,5	14,27 - 14,65	12,0
P0080.120-1.5-A2	M12x1,75	12,5	14,27 - 14,65	18,0
P0080.120-2.0-A2	M12x1,75	12,5	14,27 - 14,65	24,0
P0080.120-2.5-A2	M12x1,75	12,5	14,27 - 14,65	30,0

Wire Thread Inserts - Free Running

A2 stainless

Threaded Spacers

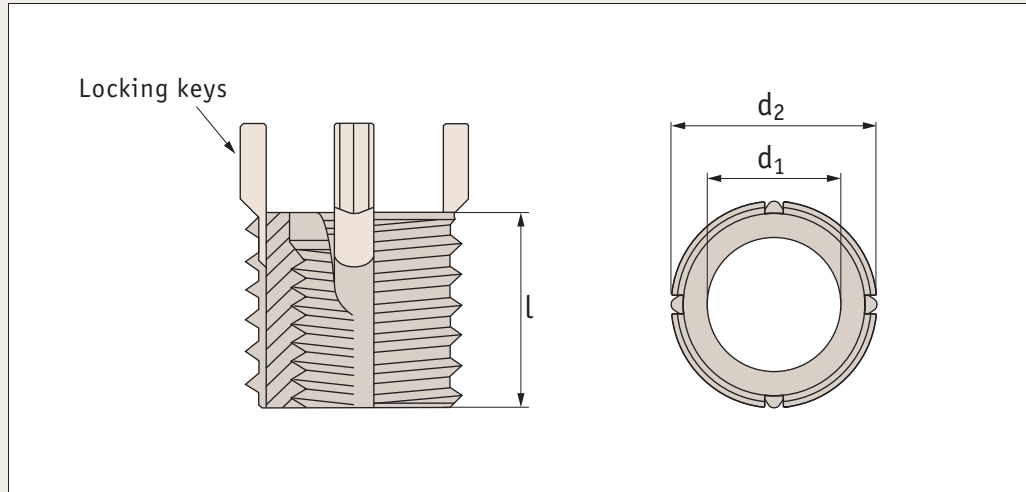


Order No.	d ₁ x pitch	Drill Ø d ₂	C'bore Ø d ₃	l
P0080.120-3.0-A2	M12x1,75	12,5	14,27 - 14,65	36,0
P0080.140-1.0-A2	M14x2,0	14,5	16,60 - 17,03	14,0
P0080.140-1.5-A2	M14x2,0	14,5	16,60 - 17,03	21,0
P0080.140-2.0-A2	M14x2,0	14,5	16,60 - 17,03	28,0
P0080.140-1.5-A2	M14x2,0	14,5	16,60 - 17,03	35,0
P0080.140-3.0-A2	M14x2,0	14,5	16,60 - 17,03	42,0
P0080.160-1.0-A2	M16x2,0	16,5	18,60 - 19,03	16,0
P0080.160-1.5-A2	M16x2,0	16,5	18,60 - 19,03	24,0
P0080.160-2.0-A2	M16x2,0	16,5	18,60 - 19,03	32,0
P0080.160-2.5-A2	M16x2,0	16,5	18,60 - 19,03	40,0
P0080.160-3.0-A2	M16x2,0	16,5	18,60 - 19,03	48,0
P0080.180-1.0-A2	M18x2,5	18,8	21,25 - 21,79	18,0
P0080.180-1.5-A2	M18x2,5	18,8	21,25 - 21,79	27,0
P0080.180-2.0-A2	M18x2,5	18,8	21,25 - 21,79	36,0
P0080.180-2.5-A2	M18x2,5	18,8	21,25 - 21,79	45,0
P0080.180-3.0-A2	M18x2,5	18,8	21,25 - 21,79	54,0
P0080.200-1.0-A2	M20x2,5	20,8	23,25 - 23,79	20,0
P0080.200-1.5-A2	M20x2,5	20,8	23,25 - 23,79	30,0
P0080.200-2.0-A2	M20x2,5	20,8	23,25 - 23,79	40,0
P0080.200-2.5-A2	M20x2,5	20,8	23,25 - 23,79	50,0
P0080.200-3.0-A2	M20x2,5	20,8	23,25 - 23,79	60,0
P0080.220-1.0-A2	M22x2,5	22,8	25,25 - 25,79	22,0
P0080.220-1.5-A2	M22x2,5	22,8	25,25 - 25,79	33,0
P0080.220-2.0-A2	M22x2,5	22,8	25,25 - 25,79	44,0
P0080.220-2.5-A2	M22x2,5	22,8	25,25 - 25,79	55,0
P0080.220-3.0-A2	M22x2,5	22,8	25,25 - 25,79	66,0
P0080.240-1.0-A2	M24x3,0	25,0	27,90 - 28,54	24,0
P0080.240-1.5-A2	M24x3,0	25,0	27,90 - 28,54	36,0
P0080.240-2.0-A2	M24x3,0	25,0	27,90 - 28,54	48,0
P0080.240-2.5-A2	M24x3,0	25,0	27,90 - 28,54	60,0
P0080.240-3.0-A2	M24x3,0	25,0	27,90 - 28,54	72,0

Order No.	d ₁ x pitch	Drill Ø d ₂	C'bore Ø d ₃	l
P0080.270-1.0-A2	M27x3,0	28,0	30,90 - 31,54	27,0
P0080.270-1.5-A2	M27x3,0	28,0	30,90 - 31,54	40,5
P0080.270-2.0-A2	M27x3,0	28,0	30,90 - 31,54	54,0
P0080.270-2.5-A2	M27x3,0	28,0	30,90 - 31,54	67,5
P0080.270-3.0-A2	M27x3,0	28,0	30,90 - 31,54	81,0
P0080.300-1.0-A2	M30x3,5	31,0	34,55 - 35,30	30,0
P0080.300-1.5-A2	M30x3,5	31,0	34,55 - 35,30	45,0
P0080.300-2.0-A2	M30x3,5	31,0	34,55 - 35,30	60,0
P0080.300-2.5-A2	M30x3,5	31,0	34,55 - 35,30	75,0
P0080.300-3.0-A2	M30x3,5	31,0	34,55 - 35,30	90,0
P0080.330-1.0-A2	M33x3,5	34,0	37,55 - 38,30	33,0
P0080.330-1.5-A2	M33x3,5	34,0	37,55 - 38,30	49,5
P0080.330-2.0-A2	M33x3,5	34,0	37,55 - 38,30	66,0
P0080.330-2.5-A2	M33x3,5	34,0	37,55 - 38,30	82,5
P0080.330-3.0-A2	M33x3,5	34,0	37,55 - 38,30	99,0
P0080.360-1.0-A2	M36x4,0	37,0	41,20 - 42,06	36,0
P0080.360-1.5-A2	M36x4,0	37,0	41,20 - 42,06	54,0
P0080.360-2.0-A2	M36x4,0	37,0	41,20 - 42,06	72,0
P0080.360-2.5-A2	M36x4,0	37,0	41,20 - 42,06	90,0
P0080.360-3.0-A2	M36x4,0	37,0	41,20 - 42,06	108,0
P0080.390-1.0-A2	M39x4,0	40,0	44,20 - 45,06	39,0
P0080.390-1.5-A2	M39x4,0	40,0	44,20 - 45,06	58,5
P0080.390-2.0-A2	M39x4,0	40,0	44,20 - 45,06	78,0
P0080.390-2.5-A2	M39x4,0	40,0	44,20 - 45,06	97,5
P0080.390-3.0-A2	M39x4,0	40,0	44,20 - 45,06	117,0
P0080.420-1.0-A2	M42x4,5	43,0	47,85 - 48,82	42,0
P0080.420-1.5-A2	M42x4,5	43,0	47,85 - 48,82	63,0
P0080.420-2.0-A2	M42x4,5	43,0	47,85 - 48,82	84,0
P0080.420-2.5-A2	M42x4,5	43,0	47,85 - 48,82	105,0
P0080.420-3.0-A2	M42x4,5	43,0	47,85 - 48,82	126,0



P0083



Material

Carbon steel (AISI 1215), phosphate finish or stainless steel (A2, AISI 303 series, passivated).

Technical Notes

Easy to install with standard drills and taps.

Solid one piece construction, with positive mechanical lock against rotation.

Tips

Used to easily repair stripped, damaged or worn threads.

Also used in light weight material (eg aluminium) to provide a strong threaded area for screws and bolts.

Sizes below M8 have two locking keys (not four).

Order No.	Material	d _{1 6H} x pitch	d _{2 6g} x pitch	l ± 0.25	Drill Ø	Countersink Ø +0.25,-0.0	Tap depth min.
P0083.040-070-CS	Steel	M 4 x 0,7	M 8 x 1,25	8,0	6,9	8,25	9,5
P0083.050-080-CS	Steel	M 5 x 0,8	M10 x 1,25	10,0	8,8	10,25	12,5
P0083.060-100-CS	Steel	M 6 x 1,0	M12 x 1,25	12,0	10,8	12,25	14,5
P0083.080-125-CS	Steel	M 8 x 1,25	M14 x 1,5	14,0	12,8	14,25	16,5
P0083.080-100-CS	Steel	M 8 x 1,0	M14 x 1,5	14,0	12,8	14,25	16,5
P0083.100-150-CS	Steel	M10 x 1,5	M16 x 1,5	16,0	14,75	16,25	18,5
P0083.100-125-CS	Steel	M10 x 1,25	M16 x 1,5	16,0	14,75	16,25	18,5
P0083.120-175-CS	Steel	M12 x 1,75	M18 x 1,5	18,0	16,75	18,25	20,5
P0083.120-125-CS	Steel	M12 x 1,25	M18 x 1,5	18,0	16,75	18,25	20,5
P0083.140-200-CS	Steel	M14 x 2,0	M20 x 1,5	20,0	18,75	20,25	22,5
P0083.140-150-CS	Steel	M14 x 1,5	M20 x 1,5	20,0	18,75	20,25	22,5
P0083.160-200-CS	Steel	M16 x 2,0	M22 x 1,5	22,0	20,5	22,25	24,5
P0083.160-150-CS	Steel	M16 x 1,5	M22 x 1,5	22,0	20,5	24,25	24,5
P0083.180-150-CS	Steel	M18 x 1,5	M24 x 1,5	24,0	22,5	24,25	26,5
P0083.200-250-CS	Steel	M20 x 2,5	M30 x 2,0	30,0	28,0	30,25	34,5
P0083.200-150-CS	Steel	M20 x 1,5	M30 x 2,0	30,0	28,0	32,25	34,5
P0083.220-150-CS	Steel	M22 x 1,5	M32 x 2,0	32,0	30,0	32,25	36,5
P0083.240-300-CS	Steel	M24 x 3,0	M33 x 2,0	33,0	31,0	33,25	37,5
P0083.240-200-CS	Steel	M24 x 2,0	M33 x 2,0	33,0	31,0	33,25	37,5
P0083.040-070-A2	Stainless	M 4 x 0,7	M 8 x 1,25	8,0	6,9	8,25	9,5
P0083.050-080-A2	Stainless	M 5 x 0,8	M10 x 1,25	10,0	8,8	10,25	12,5
P0083.060-100-A2	Stainless	M 6 x 1,0	M12 x 1,25	12,0	10,8	12,25	14,5
P0083.080-125-A2	Stainless	M 8 x 1,25	M14 x 1,5	14,0	12,8	14,25	16,5
P0083.080-100-A2	Stainless	M 8 x 1,0	M14 x 1,5	14,0	12,8	14,25	16,5
P0083.100-150-A2	Stainless	M10 x 1,5	M16 x 1,5	16,0	14,75	16,25	18,5
P0083.100-125-A2	Stainless	M10 x 1,25	M16 x 1,5	16,0	14,75	16,25	18,5
P0083.125-175-A2	Stainless	M12 x 1,75	M18 x 1,5	18,0	16,75	18,25	20,5
P0083.120-125-A2	Stainless	M12 x 1,25	M18 x 1,5	18,0	16,75	18,25	20,5

Thread Inserts - Heavy Duty

commercial grade

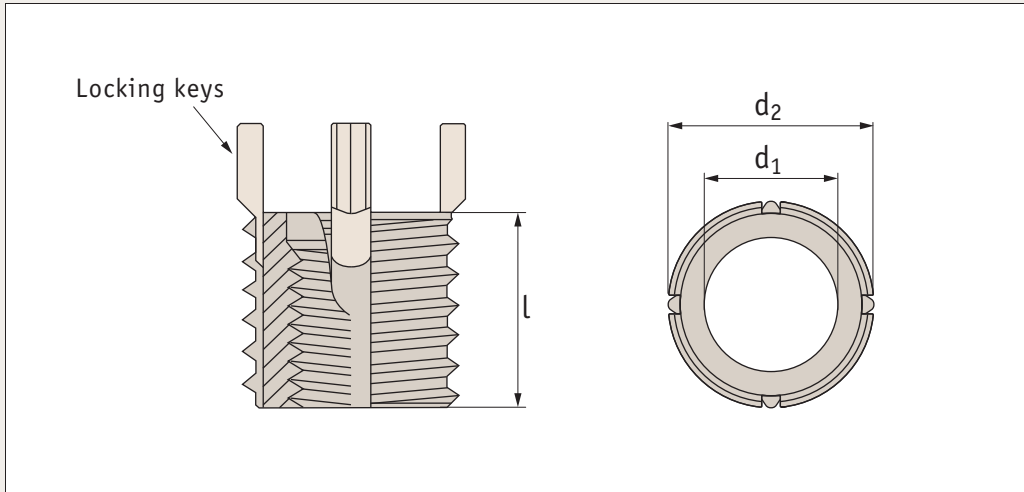
Threaded Inserts



Order No.	Material	$d_{1\ 6H}$ x pitch	$d_{2\ 6g}$ x pitch	$l_{\pm 0.25}$	Drill \emptyset	Countersink \emptyset +0.25,-0.0	Tap depth min.
P0083.140-200-A2	Stainless	M14 x 2,0	M20 x 1,5	20,0	18,75	20,25	22,5
P0083.140-150-A2	Stainless	M14 x 1,5	M20 x 1,5	20,0	18,75	20,25	22,5
P0083.160-200-A2	Stainless	M16 x 2,0	M22 x 1,5	22,0	20,5	22,25	24,5
P0083.160-150-A2	Stainless	M16 x 1,5	M22 x 1,5	22,0	20,5	24,25	24,5
P0083.180-150-A2	Stainless	M18 x 1,5	M24 x 1,5	24,0	22,5	24,25	26,5
P0083.200-250-A2	Stainless	M20 x 2,5	M30 x 2,0	30,0	28,0	30,25	34,5
P0083.200-150-A2	Stainless	M20 x 1,5	M30 x 2,0	30,0	28,0	32,25	34,5
P0083.220-150-A2	Stainless	M22 x 1,5	M32 x 2,0	32,0	30,0	32,25	36,5
P0083.240-300-A2	Stainless	M24 x 3,0	M33 x 2,0	33,0	31,0	33,25	37,5
P0083.240-200-A2	Stainless	M24 x 2,0	M33 x 2,0	33,0	31,0	33,25	37,5



P0084



Material

Carbon steel (AISI 1215), phosphate finish or stainless steel (A2, AISI 303 series, passivated).

Technical Notes

These are the thinner wall versions of the standard thread inserts (part no. P0296) - for lighter duty applications. Easy to install with standard drills and taps.

Solid one piece construction, with positive mechanical lock against rotation.

Tips

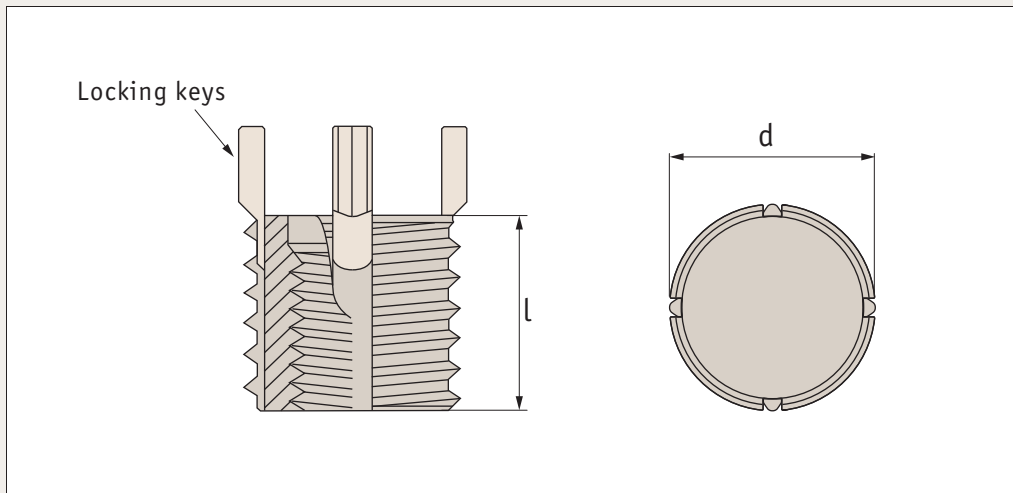
Used to easily repair stripped, damaged or worn threads. Also used in light weight material (eg aluminium) to provide a strong threaded area for screws and bolts.

Order No.	Material	$d_{1\ 6H} \times \text{pitch}$	$d_{2\ 6g} \times \text{pitch}$	$l \pm 0,25$	Drill \emptyset	Countersink \emptyset <small>+0.25,-0.0</small>	Tap depth <small>min.</small>
P0084.050-080-CS	Steel	M 5 x 0,8	M 8 x 1,25	8,0	6,9	8,25	9,5
P0084.060-100-CS	Steel	M 6 x 1,0	M10 x 1,25	10,0	8,8	10,25	11,5
P0084.080-125-CS	Steel	M 8 x 1,25	M12 x 1,25	12,0	10,8	12,25	13,5
P0084.080-100-CS	Steel	M 8 x 1,0	M12 x 1,25	12,0	10,8	12,25	13,5
P0084.100-150-CS	Steel	M10 x 1,5	M14 x 1,5	14,0	12,8	14,25	15,5
P0084.100-125-CS	Steel	M10 x 1,25	M14 x 1,5	14,0	12,8	14,25	15,5
P0084.120-175-CS	Steel	M12 x 1,75	M16 x 1,5	16,0	14,75	16,25	17,5
P0084.120-125-CS	Steel	M12 x 1,25	M16 x 1,5	16,0	14,75	16,25	17,5
P0084.050-080-A2	Stainless	M 5 x 0,8	M 8 x 1,25	8,0	6,9	8,25	9,5
P0084.060-100-A2	Stainless	M 6 x 1,0	M10 x 1,25	10,0	8,8	10,25	11,5
P0084.080-125-A2	Stainless	M 8 x 1,25	M12 x 1,25	12,0	10,8	12,25	13,5
P0084.080-100-A2	Stainless	M 8 x 1,0	M12 x 1,25	12,0	10,8	12,25	13,5
P0084.100-150-A2	Stainless	M10 x 1,5	M14 x 1,5	14,0	12,8	14,25	15,5
P0084.100-125-A2	Stainless	M10 x 1,25	M14 x 1,5	14,0	12,8	14,25	15,5
P0084.120-175-A2	Stainless	M12 x 1,75	M16 x 1,5	16,0	14,75	16,25	17,5
P0084.120-125-A2	Stainless	M12 x 1,25	M16 x 1,5	16,0	14,75	16,25	17,5

Thread Inserts - Solid

commercial grade

Threaded Inserts



P0087

Material

Carbon steel (AISI 1215), phosphate finish or stainless steel (A2, AISI 303 series, passivated).

Technical Notes

These solid body thread inserts allow any thread size to be drilled into the inserts after installation.

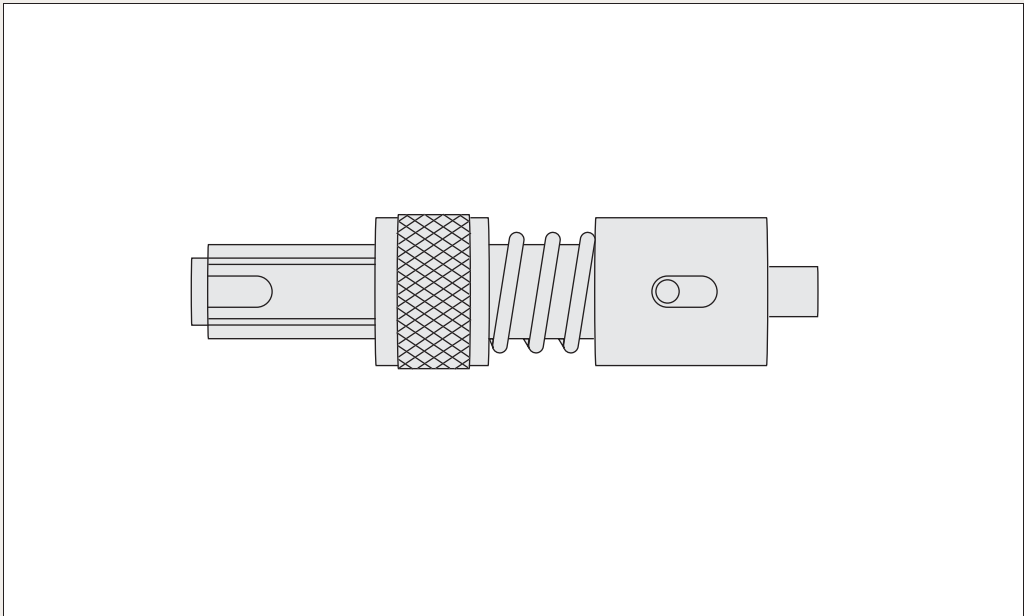
Tips

Used to easily repair stripped, damaged or worn threads. Also used in light weight material (eg. aluminium) to provide a strong threaded area for screws and bolts.

Order No.	Material	d _{6g} x pitch	l ± 0,25	Drill Ø	Countersink Ø +0,25,-0,0	Tap depth min.
P0087.080-125-CS	Steel	M 8 x 1,25	8,0	6,9	8,25	9,5
P0087.100-125-CS	Steel	M10 x 1,25	10,0	8,8	10,25	12,5
P0087.120-125-CS	Steel	M12 x 1,25	12,0	10,8	12,25	14,5
P0087.140-150-CS	Steel	M14 x 1,5	14,0	12,8	14,25	16,5
P0087.160-150-CS	Steel	M16 x 1,5	16,0	14,75	16,25	18,5
P0087.180-150-CS	Steel	M18 x 1,5	18,0	16,75	18,25	20,5
P0087.200-150-CS	Steel	M20 x 1,5	20,0	18,75	20,25	22,5
P0087.220-150-CS	Steel	M22 x 1,5	22,0	20,5	22,25	24,5
P0087.240-150-CS	Steel	M24 x 1,5	24,0	22,5	24,25	26,5
P0087.300-150-CS	Steel	M30 x 2,0	30,0	28,0	30,25	34,5
P0087.320-200-CS	Steel	M32 x 2,0	32,0	30,0	32,25	36,5
P0087.330-200-CS	Steel	M33 x 2,0	33,0	31,0	33,25	37,5
P0087.080-125-A2	Stainless	M 8 x 1,25	8,0	6,9	8,25	9,5
P0087.100-125-A2	Stainless	M10 x 1,25	10,0	8,8	10,25	12,5
P0087.120-125-A2	Stainless	M12 x 1,25	12,0	10,8	12,25	14,5
P0087.140-150-A2	Stainless	M14 x 1,5	14,0	12,8	14,25	16,5
P0087.160-150-A2	Stainless	M16 x 1,5	16,0	14,75	16,25	18,5
P0087.180-150-A2	Stainless	M18 x 1,5	18,0	16,75	18,25	20,5
P0087.200-150-A2	Stainless	M20 x 1,5	20,0	18,75	20,25	22,5
P0087.220-150-A2	Stainless	M22 x 1,5	22,0	20,5	22,25	24,5
P0087.240-150-A2	Stainless	M24 x 1,5	24,0	22,5	24,25	26,5
P0087.300-200-A2	Stainless	M30 x 2,0	30,0	28,0	30,25	34,5
P0087.320-200-A2	Stainless	M32 x 2,0	32,0	30,0	32,25	36,5
P0087.330-200-A2	Stainless	M33 x 2,0	33,0	31,0	33,25	37,5



P0088



Material
Steel, blackened.

Technical Notes
For thread inserts P0083 and P0084.

Order No.	For internal thread = d ₁	For external thread = d ₂	Drill Ø	Countersink Ø +0.25,-0.0	Tap size 6H	Tap depth _{min.}	To remove drill Ø	Remove drill depth
P0088.040-HD	P0083 M 4	M 8x1,25	6,90	8,25	M 8x1,25	9,5	5,50	4,00
P0088.050-HD	P0083 M 5	M10x1,25	8,80	10,25	M10x1,25	12,5	7,50	4,75
P0088.060-HD	P0083 M 6	M12x1,25	10,80	12,25	M12x1,25	14,5	9,50	4,75
P0088.080-HD	P0083 M 8	M14x1,50	12,80	14,25	M14x1,50	16,5	11,50	4,75
P0088.100-HD	P0083 M10	M16x1,50	14,75	16,25	M16x1,50	18,5	13,50	4,75
P0088.120-HD	P0083 M12	M18x1,50	16,75	18,25	M18x1,50	20,5	15,50	4,75
P0088.140-HD	P0083 M14	M20x1,50	18,75	20,25	M20x1,50	22,5	17,50	4,75
P0088.160-HD	P0083 M16	M22x1,50	20,50	22,25	M22x1,50	24,5	17,75	6,35
P0088.180-HD	P0083 M18	M24x1,50	22,50	24,25	M24x1,50	26,5	19,75	6,35
P0088.200-HD	P0083 M20	M30x2,00	28,00	30,25	M30x2,00	34,5	25,75	6,35
P0088.220-HD	P0083 M22	M32x2,00	30,00	32,25	M32x2,00	36,5	27,75	6,35
P0088.240-HD	P0083 M24	M33x2,00	31,00	33,25	M33x2,00	37,5	28,75	6,35
P0088.050-TW	P0084 M 5	M 8x1,25	9,5	8,25	M22x1,50	24,5	17,75	6,35
P0088.060-TW	P0084 M 6	M10x1,25	11,5	10,25	M24x1,50	26,5	19,75	6,35
P0088.080-TW	P0084 M 8	M12x1,25	13,5	12,25	M30x2,00	34,5	25,75	6,35
P0088.100-TW	P0084 M10	M14x1,50	15,5	14,25	M33x2,00	37,5	28,75	6,35
P0088.120-TW	P0084 M12	M16x1,50	17,5	16,25	M33x2,00	37,5	28,75	6,35