

## 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:

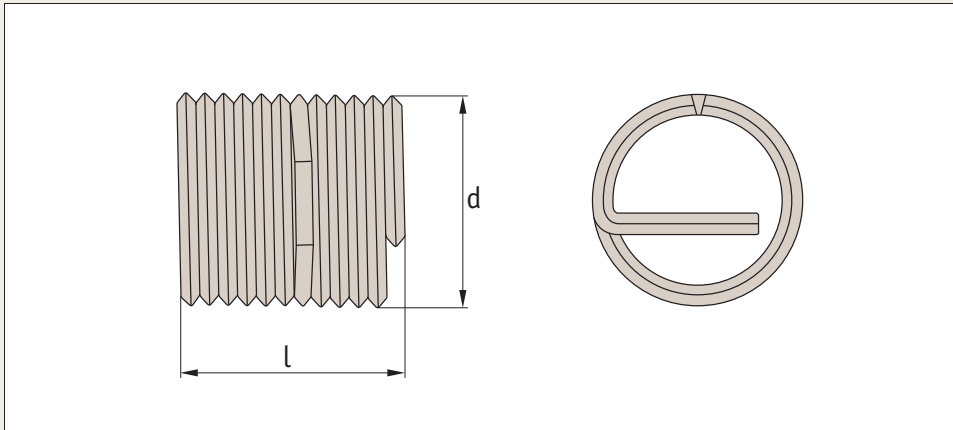
1. Drill Hole
2. Tap with wire insert tap
3. Check hole with gauge
4. Install insert
5. Remove tang
6. Check thread 'go:no-go'.

Order No.	d <sub>1</sub> x pitch	Drill Ø d <sub>2</sub>	C'bore Ø d <sub>3</sub>	l
<b>P0080.020-1.0-A2</b>	M2 x0,4	2,1	2,52 - 2,61	2,0
<b>P0080.020-1.5-A2</b>	M2 x0,4	2,1	2,52 - 2,61	3,0
<b>P0080.020-2.0-A2</b>	M2 x0,4	2,1	2,52 - 2,61	4,0
<b>P0080.020-2.5-A2</b>	M2 x0,4	2,1	2,52 - 2,61	5,0
<b>P0080.020-3.0-A2</b>	M2 x0,4	2,1	2,52 - 2,61	6,0
<b>P0080.025-1.0-A2</b>	M2,5x0,45	2,6	3,08 - 3,18	2,5
<b>P0080.025-1.5-A2</b>	M2,5x0,45	2,6	3,08 - 3,18	3,75
<b>P0080.025-2.0-A2</b>	M2,5x0,45	2,6	3,08 - 3,18	5,0
<b>P0080.025-2.5-A2</b>	M2,5x0,45	2,6	3,08 - 3,18	6,25
<b>P0080.025-3.0-A2</b>	M2,5x0,45	2,6	3,08 - 3,18	7,5
<b>P0080.030-1.0-A2</b>	M3 x0,5	3,2	3,65 - 4,35	3,0
<b>P0080.030-1.5-A2</b>	M3 x0,5	3,2	3,65 - 4,35	4,5
<b>P0080.030-2.0-A2</b>	M3x0,5	3,2	3,65 - 4,35	6,0
<b>P0080.030-2.5-A2</b>	M3 x0,5	3,2	3,65 - 4,35	7,5
<b>P0080.030-3.0-A2</b>	M3 x0,5	3,2	3,65 - 4,35	9,0
<b>P0080.040-1.0-A2</b>	M4 x0,7	4,2	4,9 - 5,06	4,0
<b>P0080.040-1.5-A2</b>	M4 x0,7	4,2	4,9 - 5,06	6,0
<b>P0080.040-2.0-A2</b>	M4 x0,7	4,2	4,9 - 5,06	8,0
<b>P0080.040-2.5-A2</b>	M4 x0,7	4,2	4,9 - 5,06	10,0
<b>P0080.040-3.0-A2</b>	M4 x0,7	4,2	4,9 - 5,06	12,0
<b>P0080.050-1.0-A2</b>	M5 x0,8	5,2	6,04 - 6,21	5,0
<b>P0080.050-1.5-A2</b>	M5 x0,8	5,2	6,04 - 6,21	7,5

Order No.	d <sub>1</sub> x pitch	Drill Ø d <sub>2</sub>	C'bore Ø d <sub>3</sub>	l
<b>P0080.050-2.0-A2</b>	M5 x0,8	5,2	6,04 - 6,21	10,0
<b>P0080.050-2.5-A2</b>	M5 x0,8	5,2	6,04 - 6,21	12,5
<b>P0080.050-3.0-A2</b>	M5 x0,8	5,2	6,04 - 6,21	15,0
<b>P0080.060-1.0-A2</b>	M6 x1,0	6,3	7,3 - 7,51	6,0
<b>P0080.060-1.5-A2</b>	M6 x1,0	6,3	7,3 - 7,51	9,0
<b>P0080.060-2.0-A2</b>	M6 x1,0	6,3	7,3 - 7,51	12,0
<b>P0080.060-2.5-A2</b>	M6 x1,0	6,3	7,3 - 7,51	15,0
<b>P0080.060-3.0-A2</b>	M6 x1,0	6,3	7,3 - 7,51	18,0
<b>P0080.080-1.0-A2</b>	M8 x1,25	8,3	9,62 - 9,89	8,0
<b>P0080.080-1.5-A2</b>	M8 x1,25	8,3	9,62 - 9,89	12,0
<b>P0080.080-2.0-A2</b>	M8 x1,25	8,3	9,62 - 9,89	16,0
<b>P0080.080-2.5-A2</b>	M8 x1,25	8,3	9,62 - 9,89	20,0
<b>P0080.080-3.0-A2</b>	M8 x1,25	8,3	9,62 - 9,89	24,0
<b>P0080.100-1.0-A2</b>	M10x1,5	10,4	11,95 - 12,27	10,0
<b>P0080.100-1.5-A2</b>	M10x1,5	10,4	11,95 - 12,27	15,0
<b>P0080.100-2.0-A2</b>	M10x1,5	10,4	11,95 - 12,27	20,0
<b>P0080.100-2.5-A2</b>	M10x1,5	10,4	11,95 - 12,27	25,0
<b>P0080.100-3.0-A2</b>	M10x1,5	10,4	11,95 - 12,27	30,0
<b>P0080.120-1.0-A2</b>	M12x1,75	12,5	14,27 - 14,65	12,0
<b>P0080.120-1.5-A2</b>	M12x1,75	12,5	14,27 - 14,65	18,0
<b>P0080.120-2.0-A2</b>	M12x1,75	12,5	14,27 - 14,65	24,0
<b>P0080.120-2.5-A2</b>	M12x1,75	12,5	14,27 - 14,65	30,0
<b>P0080.120-3.0-A2</b>	M12x1,75	12,5	14,27 - 14,65	36,0

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

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



## P0081

### 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. These "screw lock" thread inserts (prevailing torque) are useful in applications where there is cyclic vibration or impact. A portion of the thread in the mid area of the insert has polygonal threads and these exert radial pressure on the male thread. It is recommended to use "close fit" thread

tolerance male bolts or screws.

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:

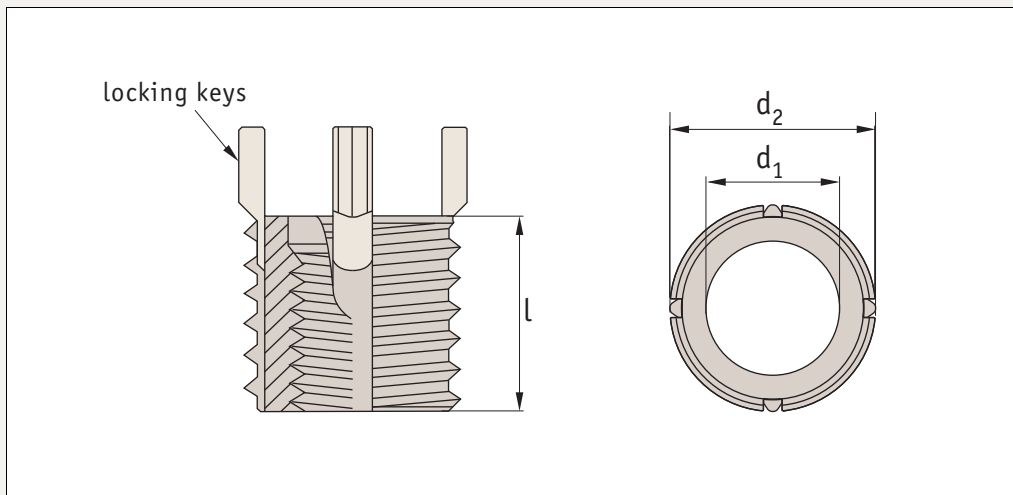
1. Drill Hole
2. Tap with wire insert tap
3. Check hole with gauge
4. Install insert
5. Remove tang
6. Check thread 'go:no-go'.

Order No.	d <sub>1</sub> x pitch	Drill Ø d <sub>2</sub>	C'bore Ø d <sub>3</sub>	l
<b>P0081.020-1.0-A2</b>	M2 x0,4	2,1	2,52 - 2,61	2,0
<b>P0081.020-1.5-A2</b>	M2 x0,4	2,1	2,52 - 2,61	3,0
<b>P0081.020-2.0-A2</b>	M2 x0,4	2,1	2,52 - 2,61	4,0
<b>P0081.020-2.5-A2</b>	M2 x0,4	2,1	2,52 - 2,61	5,0
<b>P0081.020-3.0-A2</b>	M2 x0,4	2,1	2,52 - 2,61	6,0
<b>P0081.025-1.0-A2</b>	M2,5x0,45	2,6	3,08 - 3,18	2,5
<b>P0081.025-1.5-A2</b>	M2,5x0,45	2,6	3,08 - 3,18	3,75
<b>P0081.025-2.0-A2</b>	M2,5x0,45	2,6	3,08 - 3,18	5,0
<b>P0081.025-2.5-A2</b>	M2,5x0,45	2,6	3,08 - 3,18	6,25
<b>P0081.025-3.0-A2</b>	M2,5x0,45	2,6	3,08 - 3,18	7,5
<b>P0081.030-1.0-A2</b>	M3 x0,5	3,2	3,65 - 4,35	3,0
<b>P0081.030-1.5-A2</b>	M3 x0,5	3,2	3,65 - 4,35	4,5
<b>P0081.030-2.0-A2</b>	M3 x0,5	3,2	3,65 - 4,35	6,0
<b>P0081.030-2.5-A2</b>	M3 x0,5	3,2	3,65 - 4,35	7,5
<b>P0081.030-3.0-A2</b>	M3 x0,5	3,2	3,65 - 4,35	9,0
<b>P0081.040-1.0-A2</b>	M4 x0,7	4,2	4,9 - 5,06	4,0
<b>P0081.040-1.5-A2</b>	M4 x0,7	4,2	4,9 - 5,06	6,0
<b>P0081.040-2.0-A2</b>	M4 x0,7	4,2	4,9 - 5,06	8,0
<b>P0081.040-2.5-A2</b>	M4 x0,7	4,2	4,9 - 5,06	10,0
<b>P0081.040-3.0-A2</b>	M4 x0,7	4,2	4,9 - 5,06	12,0

Order No.	d <sub>1</sub> x pitch	Drill Ø d <sub>2</sub>	C'bore Ø d <sub>3</sub>	l
<b>P0081.050-1.0-A2</b>	M5 x0,8	5,2	6,04 - 6,21	5,0
<b>P0081.050-1.5-A2</b>	M5 x0,8	5,2	6,04 - 6,21	7,5
<b>P0081.050-2.0-A2</b>	M5 x0,8	5,2	6,04 - 6,21	10,0
<b>P0081.050-2.5-A2</b>	M5 x0,8	5,2	6,04 - 6,21	12,5
<b>P0081.050-3.0-A2</b>	M5 x0,8	5,2	6,04 - 6,21	15,0
<b>P0081.060-1.0-A2</b>	M6 x1,0	6,3	7,3 - 7,51	6,0
<b>P0080.061-1.5-A2</b>	M6 x1,0	6,3	7,3 - 7,51	9,0
<b>P0080.061-2.0-A2</b>	M6 x1,0	6,3	7,3 - 7,51	12,0
<b>P0081.060-2.5-A2</b>	M6 x1,0	6,3	7,3 - 7,51	15,0
<b>P0081.060-3.0-A2</b>	M6 x1,0	6,3	7,3 - 7,51	18,0
<b>P0081.080-1.0-A2</b>	M8 x1,25	8,3	9,62 - 9,89	8,0
<b>P0081.080-1.5-A2</b>	M8 x1,25	8,3	9,62 - 9,89	12,0
<b>P0081.080-2.0-A2</b>	M8 x1,25	8,3	9,62 - 9,89	16,0
<b>P0081.080-2.5-A2</b>	M8 x1,25	8,3	9,62 - 9,89	20,0
<b>P0081.080-3.0-A2</b>	M8 x1,25	8,3	9,62 - 9,89	24,0
<b>P0081.100-1.0-A2</b>	M10x1,5	10,4	11,95 - 12,27	10,0
<b>P0081.100-1.5-A2</b>	M10x1,5	10,4	11,95 - 12,27	15,0
<b>P0081.100-2.0-A2</b>	M10x1,5	10,4	11,95 - 12,27	20,0
<b>P0081.100-2.5-A2</b>	M10x1,5	10,4	11,95 - 12,27	25,0
<b>P0081.100-3.0-A2</b>	M10x1,5	10,4	11,95 - 12,27	30,0
<b>P0081.120-1.0-A2</b>	M12x1,75	12,5	14,27 - 14,65	12,0

Order No.	d <sub>1</sub> x pitch	Drill Ø d <sub>2</sub>	C'bore Ø d <sub>3</sub>	l
<b>P0081.120-1.5-A2</b>	M12x1,75	12,5	14,27 - 14,65	18,0
<b>P0081.120-2.0-A2</b>	M12x1,75	12,5	14,27 - 14,65	24,0
<b>P0081.120-2.5-A2</b>	M12x1,75	12,5	14,27 - 14,65	30,0
<b>P0081.120-3.0-A2</b>	M12x1,75	12,5	14,27 - 14,65	36,0
<b>P0081.140-1.0-A2</b>	M14x2,0	14,5	16,60 - 17,03	14,0
<b>P0081.140-1.5-A2</b>	M14x2,0	14,5	16,60 - 17,03	21,0
<b>P0081.140-2.0-A2</b>	M14x2,0	14,5	16,60 - 17,03	28,0
<b>P0081.140-2.5-A2</b>	M14x2,0	14,5	16,60 - 17,03	35,0
<b>P0081.140-3.0-A2</b>	M14x2,0	14,5	16,60 - 17,03	42,0
<b>P0081.160-1.0-A2</b>	M16x2,0	16,5	18,60 - 19,03	16,0
<b>P0081.160-1.5-A2</b>	M16x2,0	16,5	18,60 - 19,03	24,0
<b>P0081.160-2.0-A2</b>	M16x2,0	16,5	18,60 - 19,03	32,0
<b>P0081.160-2.5-A2</b>	M16x2,0	16,5	18,60 - 19,03	40,0
<b>P0081.160-3.0-A2</b>	M16x2,0	16,5	18,60 - 19,03	48,0
<b>P0081.180-1.0-A2</b>	M18x2,5	18,8	21,25 - 21,79	18,0
<b>P0081.180-1.5-A2</b>	M18x2,5	18,8	21,25 - 21,79	27,0
<b>P0081.180-2.0-A2</b>	M18x2,5	18,8	21,25 - 21,79	36,0
<b>P0081.180-2.5-A2</b>	M18x2,5	18,8	21,25 - 21,79	45,0
<b>P0081.180-3.0-A2</b>	M18x2,5	18,8	21,25 - 21,79	54,0
<b>P0081.200-1.0-A2</b>	M20x2,5	20,8	23,25 - 23,79	20,0
<b>P0081.200-1.5-A2</b>	M20x2,5	20,8	23,25 - 23,79	30,0
<b>P0081.200-2.0-A2</b>	M20x2,5	20,8	23,25 - 23,79	40,0
<b>P0081.200-2.5-A2</b>	M20x2,5	20,8	23,25 - 23,79	50,0
<b>P0081.200-3.0-A2</b>	M20x2,5	20,8	23,25 - 23,79	60,0
<b>P0081.220-1.0-A2</b>	M22x2,5	22,8	25,25 - 25,79	22,0
<b>P0081.220-1.5-A2</b>	M22x2,5	22,8	25,25 - 25,79	33,0
<b>P0081.220-2.0-A2</b>	M22x2,5	22,8	25,25 - 25,79	44,0
<b>P0081.220-2.5-A2</b>	M22x2,5	22,8	25,25 - 25,79	55,0
<b>P0081.220-3.0-A2</b>	M22x2,5	22,8	25,25 - 25,79	66,0
<b>P0081.240-1.0-A2</b>	M24x3,0	25,0	27,90 - 28,54	24,0
<b>P0081.240-1.5-A2</b>	M24x3,0	25,0	27,90 - 28,54	36,0
<b>P0081.240-2.0-A2</b>	M24x3,0	25,0	27,90 - 28,54	48,0
<b>P0081.240-2.5-A2</b>	M24x3,0	25,0	27,90 - 28,54	60,0

Order No.	d <sub>1</sub> x pitch	Drill Ø d <sub>2</sub>	C'bore Ø d <sub>3</sub>	l
<b>P0081.240-3.0-A2</b>	M24x3,0	25,0	27,90 - 28,54	72,0
<b>P0081.270-1.0-A2</b>	M27x3,0	28,0	30,90 - 31,54	27,0
<b>P0081.270-1.5-A2</b>	M27x3,0	28,0	30,90 - 31,54	40,5
<b>P0081.270-2.0-A2</b>	M27x3,0	28,0	30,90 - 31,54	54,0
<b>P0081.270-2.5-A2</b>	M27x3,0	28,0	30,90 - 31,54	67,5
<b>P0081.270-3.0-A2</b>	M27x3,0	28,0	30,90 - 31,54	81,0
<b>P0081.300-1.0-A2</b>	M30x3,5	31,0	34,55 - 35,30	30,0
<b>P0081.300-1.5-A2</b>	M30x3,5	31,0	34,55 - 35,30	45,0
<b>P0081.300-2.0-A2</b>	M30x3,5	31,0	34,55 - 35,30	60,0
<b>P0081.300-2.5-A2</b>	M30x3,5	31,0	34,55 - 35,30	75,0
<b>P0081.300-3.0-A2</b>	M30x3,5	31,0	34,55 - 35,30	90,0
<b>P0081.330-1.0-A2</b>	M33x3,5	34,0	37,55 - 38,30	33,0
<b>P0081.330-1.5-A2</b>	M33x3,5	34,0	37,55 - 38,30	49,5
<b>P0081.330-2.0-A2</b>	M33x3,5	34,0	37,55 - 38,30	66,0
<b>P0081.330-2.5-A2</b>	M33x3,5	34,0	37,55 - 38,30	82,5
<b>P0081.330-3.0-A2</b>	M33x3,5	34,0	37,55 - 38,30	99,0
<b>P0081.360-1.0-A2</b>	M36x4,0	37,0	41,20 - 42,06	36,0
<b>P0081.360-1.5-A2</b>	M36x4,0	37,0	41,20 - 42,06	54,0
<b>P0081.360-2.0-A2</b>	M36x4,0	37,0	41,20 - 42,06	72,0
<b>P0081.360-2.5-A2</b>	M36x4,0	37,0	41,20 - 42,06	90,0
<b>P0081.360-3.0-A2</b>	M36x4,0	37,0	41,20 - 42,06	108,0
<b>P0081.390-1.0-A2</b>	M39x4,0	40,0	44,20 - 45,06	39,0
<b>P0081.390-1.5-A2</b>	M39x4,0	40,0	44,20 - 45,06	58,5
<b>P0081.390-2.0-A2</b>	M39x4,0	40,0	44,20 - 45,06	78,0
<b>P0081.390-2.5-A2</b>	M39x4,0	40,0	44,20 - 45,06	97,5
<b>P0081.390-3.0-A2</b>	M39x4,0	40,0	44,20 - 45,06	117,0
<b>P0081.420-1.0-A2</b>	M42x4,5	43,0	47,85 - 48,82	42,0
<b>P0081.420-1.5-A2</b>	M42x4,5	43,0	47,85 - 48,82	63,0
<b>P0081.420-2.0-A2</b>	M42x4,5	43,0	47,85 - 48,82	84,0
<b>P0081.420-2.5-A2</b>	M42x4,5	43,0	47,85 - 48,82	105,0
<b>P0081.420-3.0-A2</b>	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.

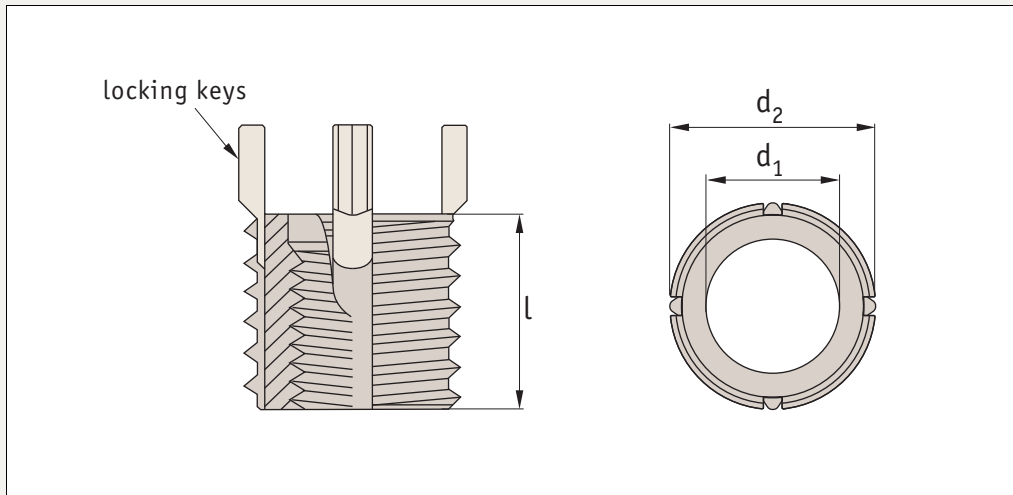
### Tips

Used to easily repair stripped, damaged or worn threads, sizes below M8 have two locking keys (not four). Also used in light weight material (eg aluminium) to provide a strong threaded area for screws and bolts.

Order No.	Material	$d_{1\ 6H}$ x pitch	Thread Type $d_1$	$d_{2\ 6g}$ x pitch	Thread Type $d_2$	$l \pm 0.25$	Drill $\emptyset$	Countersink $\emptyset$ <small>+0.25,-0.0</small>	Tap depth <small>min.</small>
P0083.040-070-CS	Steel	M 4 x 0,7	Coarse	M 8 x 1,25	Coarse	8,0	6,9	8,25	9,5
P0083.050-080-CS	Steel	M 5 x 0,8	Coarse	M10 x 1,25	Fine	10,0	8,8	10,25	12,5
P0083.060-100-CS	Steel	M 6 x 1,0	Coarse	M12 x 1,25	Fine	12,0	10,8	12,25	14,5
P0083.080-125-CS	Steel	M 8 x 1,25	Coarse	M14 x 1,5	Fine	14,0	12,8	14,25	16,5
P0083.080-100-CS	Steel	M 8 x 1,0	Fine	M14 x 1,5	Fine	14,0	12,8	14,25	16,5
P0083.100-150-CS	Steel	M10 x 1,5	Coarse	M16 x 1,5	Fine	16,0	14,75	16,25	18,5
P0083.100-125-CS	Steel	M10 x 1,25	Fine	M16 x 1,5	Fine	16,0	14,75	16,25	18,5
P0083.120-175-CS	Steel	M12 x 1,75	Coarse	M18 x 1,5	Fine	18,0	16,75	18,25	20,5
P0083.120-125-CS	Steel	M12 x 1,25	Fine	M18 x 1,5	Fine	18,0	16,75	18,25	20,5
P0083.140-200-CS	Steel	M14 x 2,0	Coarse	M20 x 1,5	Fine	20,0	18,75	20,25	22,5
P0083.140-150-CS	Steel	M14 x 1,5	Fine	M20 x 1,5	Fine	20,0	18,75	20,25	22,5
P0083.160-200-CS	Steel	M16 x 2,0	Coarse	M22 x 1,5	Fine	22,0	20,5	22,25	24,5
P0083.160-150-CS	Steel	M16 x 1,5	Fine	M22 x 1,5	Fine	22,0	20,5	24,25	24,5
P0083.180-150-CS	Steel	M18 x 1,5	Fine	M24 x 2,0	Fine	24,0	22,5	24,25	26,5
P0083.200-250-CS	Steel	M20 x 2,5	Coarse	M30 x 2,0	Fine	30,0	28,0	30,25	34,5
P0083.200-150-CS	Steel	M20 x 1,5	Fine	M30 x 2,0	Fine	30,0	28,0	32,25	34,5
P0083.220-150-CS	Steel	M22 x 1,5	Fine	M32 x 2,0	Fine	32,0	30,0	32,25	36,5
P0083.240-300-CS	Steel	M24 x 3,0	Coarse	M33 x 2,0	Fine	33,0	31,0	33,25	37,5
P0083.240-200-CS	Steel	M24 x 2,0	Fine	M33 x 2,0	Fine	33,0	31,0	33,25	37,5
P0083.040-070-A2	Stainless	M 4 x 0,7	Coarse	M 8 x 1,25	Coarse	8,0	6,9	8,25	9,5
P0083.050-080-A2	Stainless	M 5 x 0,8	Coarse	M10 x 1,25	Fine	10,0	8,8	10,25	12,5
P0083.060-100-A2	Stainless	M 6 x 1,0	Coarse	M12 x 1,25	Fine	12,0	10,8	12,25	14,5
P0083.080-125-A2	Stainless	M 8 x 1,25	Coarse	M14 x 1,5	Fine	14,0	12,8	14,25	16,5
P0083.080-100-A2	Stainless	M 8 x 1,0	Fine	M14 x 1,5	Fine	14,0	12,8	14,25	16,5
P0083.100-150-A2	Stainless	M10 x 1,5	Coarse	M16 x 1,5	Fine	16,0	14,75	16,25	18,5
P0083.100-125-A2	Stainless	M10 x 1,25	Fine	M16 x 1,5	Fine	16,0	14,75	16,25	18,5
P0083.120-175-A2	Stainless	M12 x 1,75	Coarse	M18 x 1,5	Fine	18,0	16,75	18,25	20,5
P0083.120-125-A2	Stainless	M12 x 1,25	Fine	M18 x 1,5	Fine	18,0	16,75	18,25	20,5

Order No.	Material	$d_1$ <sup>6H</sup> x pitch	Thread Type $d_1$	$d_2$ <sup>6g</sup> x pitch	Thread Type $d_2$	$l \pm 0.25$	Drill $\emptyset$	Countersink $\emptyset$ <small>+0.25,-0.0</small>	Tap depth <small>min.</small>
<b>P0083.140-200-A2</b>	Stainless	M14 x 2,0	Coarse	M20 x 1,5	Fine	20,0	18,75	20,25	22,5
<b>P0083.140-150-A2</b>	Stainless	M14 x 1,5	Fine	M20 x 1,5	Fine	20,0	18,75	20,25	22,5
<b>P0083.160-200-A2</b>	Stainless	M16 x 2,0	Coarse	M22 x 1,5	Fine	22,0	20,5	22,25	24,5
<b>P0083.160-150-A2</b>	Stainless	M16 x 1,5	Fine	M22 x 1,5	Fine	22,0	20,5	24,25	24,5
<b>P0083.180-150-A2</b>	Stainless	M18 x 1,5	Fine	M24 x 1,5	Fine	24,0	22,5	24,25	26,5
<b>P0083.200-250-A2</b>	Stainless	M20 x 2,5	Coarse	M30 x 2,0	Fine	30,0	28,0	30,25	34,5
<b>P0083.200-150-A2</b>	Stainless	M20 x 1,5	Fine	M30 x 2,0	Fine	30,0	28,0	32,25	34,5
<b>P0083.220-150-A2</b>	Stainless	M22 x 1,5	Fine	M32 x 2,0	Fine	32,0	30,0	32,25	36,5
<b>P0083.240-300-A2</b>	Stainless	M24 x 3,0	Coarse	M33 x 2,0	Fine	33,0	31,0	33,25	37,5
<b>P0083.240-200-A2</b>	Stainless	M24 x 2,0	Fine	M33 x 2,0	Fine	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

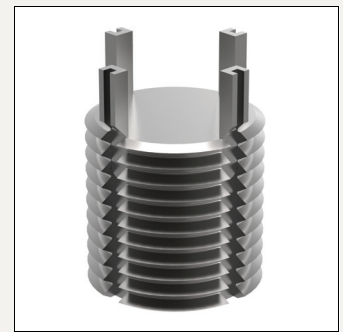
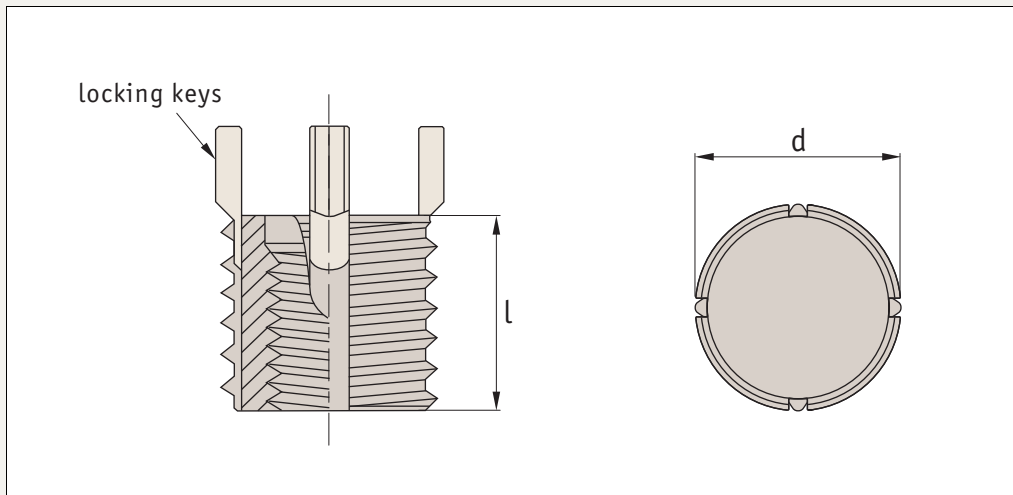
These are the thinner wall versions of the standard thread inserts (part no.

P0083) - 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, sizes below M8 have two locking keys (not four). Also used in light weight material (eg aluminium) to provide a strong threaded area for screws and bolts.

Order No.	Material	$d_1^{6H}$ x pitch	Thread Type $d_1$	$d_2^{6g}$ x pitch	Thread Type $d_2$	$l_{\pm 0,25}$	Drill $\emptyset$	Countersink $\emptyset$ <small>+0.25,-0.0</small>	Tap depth <small>min.</small>
<b>P0084.050-080-CS</b>	Steel	M 5 x 0,80	Coarse	M 8 x 1,25	Coarse	8,0	6,9	8,25	9,5
<b>P0084.060-100-CS</b>	Steel	M 6 x 1,00	Coarse	M10 x 1,25	Fine	10,0	8,8	10,25	11,5
<b>P0084.080-125-CS</b>	Steel	M 8 x 1,25	Coarse	M12 x 1,25	Fine	12,0	10,8	12,25	13,5
<b>P0084.080-100-CS</b>	Steel	M 8 x 1,00	Fine	M12 x 1,25	Fine	12,0	10,8	12,25	13,5
<b>P0084.100-150-CS</b>	Steel	M10 x 1,50	Coarse	M14 x 1,50	Fine	14,0	12,8	14,25	15,5
<b>P0084.100-125-CS</b>	Steel	M10 x 1,25	Fine	M14 x 1,50	Fine	14,0	12,8	14,25	15,5
<b>P0084.120-175-CS</b>	Steel	M12 x 1,75	Coarse	M16 x 1,50	Fine	16,0	14,75	16,25	17,5
<b>P0084.120-125-CS</b>	Steel	M12 x 1,25	Fine	M16 x 1,50	Fine	16,0	14,75	16,25	17,5
<b>P0084.050-080-A2</b>	Stainless	M 5 x 0,80	Coarse	M 8 x 1,25	Coarse	8,0	6,9	8,25	9,5
<b>P0084.060-100-A2</b>	Stainless	M 6 x 1,00	Coarse	M10 x 1,25	Fine	10,0	8,8	10,25	11,5
<b>P0084.080-125-A2</b>	Stainless	M 8 x 1,25	Coarse	M12 x 1,25	Fine	12,0	10,8	12,25	13,5
<b>P0084.080-100-A2</b>	Stainless	M 8 x 1,00	Fine	M12 x 1,25	Fine	12,0	10,8	12,25	13,5
<b>P0084.100-150-A2</b>	Stainless	M10 x 1,50	Coarse	M14 x 1,50	Fine	14,0	12,8	14,25	15,5
<b>P0084.100-125-A2</b>	Stainless	M10 x 1,25	Fine	M14 x 1,50	Fine	14,0	12,8	14,25	15,5
<b>P0084.120-175-A2</b>	Stainless	M12 x 1,75	Coarse	M16 x 1,50	Fine	16,0	14,75	16,25	17,5
<b>P0084.120-125-A2</b>	Stainless	M12 x 1,25	Fine	M16 x 1,50	Fine	16,0	14,75	16,25	17,5



## 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, sizes below M8 have two locking keys (not four). Also used in light weight material (eg aluminium) to provide a strong threaded area for screws and bolts.

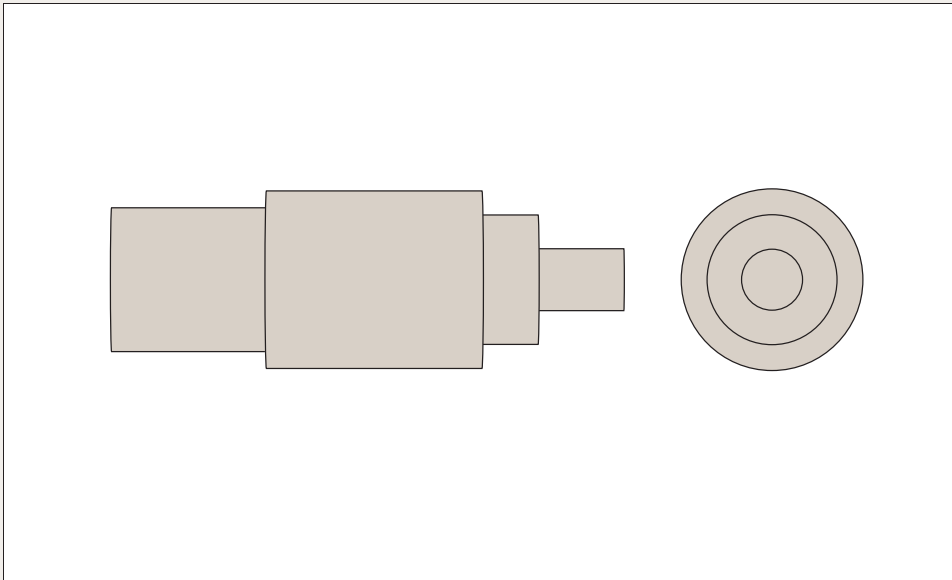
Order No.	Material	$d_{6g}$ x pitch	Thread Type d	$l_{\pm 0,25}$	Drill $\varnothing$	Countersink $\varnothing$ +0.25,-0.0	Tap depth min.
P0087.080-125-CS	Steel	M 8 x 1,25	Coarse	8,0	6,9	8,25	9,5
P0087.100-125-CS	Steel	M10 x 1,25	Fine	10,0	8,8	10,25	12,5
P0087.120-125-CS	Steel	M12 x 1,25	Fine	12,0	10,8	12,25	14,5
P0087.140-150-CS	Steel	M14 x 1,5	Fine	14,0	12,8	14,25	16,5
P0087.160-150-CS	Steel	M16 x 1,5	Fine	16,0	14,75	16,25	18,5
P0087.180-150-CS	Steel	M18 x 1,5	Fine	18,0	16,75	18,25	20,5
P0087.200-150-CS	Steel	M20 x 1,5	Fine	20,0	18,75	20,25	22,5
P0087.220-150-CS	Steel	M22 x 1,5	Fine	22,0	20,5	22,25	24,5
P0087.240-150-CS	Steel	M24 x 2,0	Fine	24,0	22,5	24,25	26,5
P0087.300-150-CS	Steel	M30 x 2,0	Fine	30,0	28,0	30,25	34,5
P0087.320-200-CS	Steel	M32 x 2,0	Fine	32,0	30,0	32,25	36,5
P0087.330-200-CS	Steel	M33 x 2,0	Fine	33,0	31,0	33,25	37,5
P0087.080-125-A2	Stainless	M 8 x 1,25	Coarse	8,0	6,9	8,25	9,5
P0087.100-125-A2	Stainless	M10 x 1,25	Fine	10,0	8,8	10,25	12,5
P0087.120-125-A2	Stainless	M12 x 1,25	Fine	12,0	10,8	12,25	14,5
P0087.140-150-A2	Stainless	M14 x 1,5	Fine	14,0	12,8	14,25	16,5
P0087.160-150-A2	Stainless	M16 x 1,5	Fine	16,0	14,75	16,25	18,5
P0087.180-150-A2	Stainless	M18 x 1,5	Fine	18,0	16,75	18,25	20,5
P0087.200-150-A2	Stainless	M20 x 1,5	Fine	20,0	18,75	20,25	22,5
P0087.220-150-A2	Stainless	M22 x 1,5	Fine	22,0	20,5	22,25	24,5
P0087.240-150-A2	Stainless	M24 x 2,0	Fine	24,0	22,5	24,25	26,5
P0087.300-200-A2	Stainless	M30 x 2,0	Fine	30,0	28,0	30,25	34,5
P0087.320-200-A2	Stainless	M32 x 2,0	Fine	32,0	30,0	32,25	36,5
P0087.330-200-A2	Stainless	M33 x 2,0	Fine	33,0	31,0	33,25	37,5



# Installation Tool

for thread inserts

23-01-18



**P0088**

## Material

Steel, blackened.

## Technical Notes

For thread inserts P0083 and P0084.

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