



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	4,0
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	M3x0,5	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
P0080.120-3.0-A2	M12x1,75	12,5	14,27 - 14,65	36,0

Order No.	d ₁ x pitch	Drill Ø d ₂	C'bore Ø d ₃	l
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
P0080.140-2.5-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