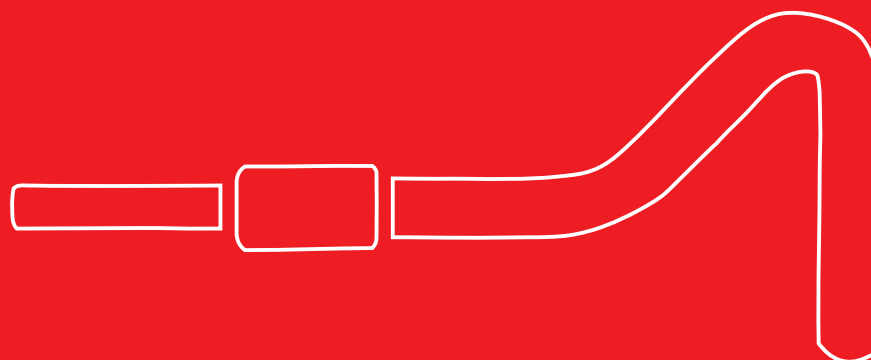


THREAD REPAIR TOOLS

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Thread inserts

Standard design, stainless steel and free running.

Thread reinforcement for materials with low shearing strength, e.g. aluminium alloys and magnesium alloys as well as to repair enables worn and damaged threads.

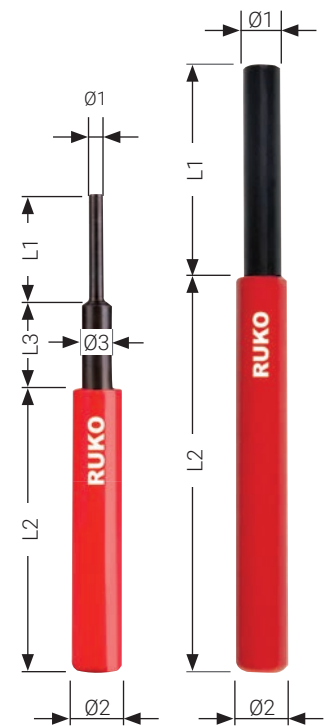
Packaging: plastic



Nominal thread size	Pitch mm	Height = factor x Ø		
M 3	0.50	1.0	244 303	50
M 4	0.70	1.0	244 304	50
M 5	0.80	1.0	244 305	50
M 6	1.00	1.0	244 306	50
M 8	1.25	1.0	244 308	50
M 10	1.50	1.0	244 310	50
M 12	1.75	1.0	244 312	25
M 14	2.00	1.0	244 314	25
MF 14	1.25	1.0	244 315	25

M 3	0.50	1.5	244 403	50
M 4	0.70	1.5	244 404	50
M 5	0.80	1.5	244 405	50
M 6	1.00	1.5	244 406	50
M 8	1.25	1.5	244 408	50
M 10	1.50	1.5	244 410	50
M 12	1.75	1.5	244 412	25
M 14	2.00	1.5	244 414	25
MF 14	1.25	1.5	244 415	25

M 3	0.50	2.0	244 503	50
M 4	0.70	2.0	244 504	50
M 5	0.80	2.0	244 505	50
M 6	1.00	2.0	244 506	50
M 8	1.25	2.0	244 508	50
M 10	1.50	2.0	244 510	50
M 12	1.75	2.0	244 512	25
M 14	2.00	2.0	244 514	25
MF 14	1.25	2.0	244 515	25



Pin-breaker

Nominal thread size	Ø1 mm	Ø2 mm	Ø3 mm	L1 mm	L2 mm	L3 mm		
M 3	2.0	9.8	6.0	15.0	75.0	25.0	244 163	1
M 4	2.7	9.8	6.0	20.0	75.0	20.0	244 164	1
M 5	3.5	9.8	-	22.0	75.0	18.0	244 165	1
M 6	4.6	9.8	-	22.0	75.0	18.0	244 166	1
M 8	6.0	9.8	-	40.0	75.0	-	244 168	1
M 10	7.5	9.8	-	40.0	75.0	-	244 170	1
M 12	9.0	12.2	-	40.0	75.0	-	244 172	1
M 14	10.0	14.5	-	40.0	80.0	-	244 174	1

Fitting-tools


Nominal thread size	Ø mm	L1 mm		
M 3	2.0	60.0	244 183	1
M 4	2.8	60.0	244 184	1
M 5	3.5	60.0	244 185	1
M 6	4.8	60.0	244 186	1
M 8	6.0	80.0	244 188	1
M 10	7.5	80.0	244 190	1
M 12	9.5	80.0	244 192	1
M 14	11.2	80.0	244 194	1



ProCoil thread repair assortment



Picture shows ProCoil thread repair kit 86-piece (244 208). See table for other versions.

		
86 <small>tlg./pcs.</small>	Assortment M 5 - M 12 5 twist drills HSS Ø 5.2 6.2 8.3 10.3 12.4 mm + 5 single-cut taps DIN 352 HSS - M 5 M 6 M 8 M 10 M 12 + 5 fitting tools M 5 M 6 M 8 M 10 M 12 + 5 pin-breakers Ø 3.5 - 4.6 - 6.0 - 7.5 - 9.0 mm + 60 inserts M 5 - M 10 - each 5 x Ø 1.0 / 1.5 / 2.0: Height = 1.0 x Ø + 6 inserts M 12 - each 2 x Ø 1.0 / 1.5 / 2.0: Height = 1.0 x Ø	244 208
77 <small>tlg./pcs.</small>	Assortment M 6 - M 14 for spark plug threads 5 twist drills HSS Ø 6.2 8.3 10.3 12.4 14.5 mm + 5 single-cut taps DIN 352 HSS - M 6 M 8 M 10 M 12 MF 14 + 5 fitting tools M 6 M 8 M 10 M 12 MF 14 + 5 pin-breakers Ø 4.6 6.0 7.5 9.0 10.0 mm + 45 inserts M 6 - M 10 - each 5 x Ø 1.0 / 1.5 / 2.0: Height = 1.0 x Ø + 12 inserts M 12 - MF 14 - each 2 x Ø 1.0 / 1.5 / 2.0: Height = 1.0 x Ø	244 209



ProCoil thread repair sets

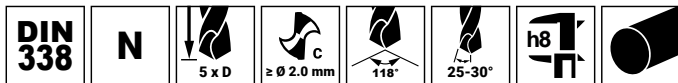


Picture shows 19-piece thread repair kit (244 206).
See table for other versions.

	Set M 3	1 twist drill Ø 3.1 mm + 1 single-cut tap DIN 352 HSS for thread M 3 x 0.5 + 1 fitting tool M 3 + 1 pin-Breaker Ø 2.0 mm + each 5 inserts Height = 1.0 x Ø / Height = 1.5 x Ø / Height = 2.0 x Ø	244 200
	Set M 4	1 twist drill Ø 4.1 mm + 1 single-cut tap DIN 352 HSS for thread M 4 x 0.7 + 1 fitting tool M 4 + 1 pin-Breaker Ø 2.7 mm + each 5 inserts Height = 1.0 x Ø / Height = 1.5 x Ø / Height = 2.0 x Ø	244 201
	Set M 5	1 twist drill Ø 5.2 mm + 1 single-cut tap DIN 352 HSS for thread M 5 x 0.8 + 1 fitting tool M 5 + 1 pin-Breaker Ø 3.5 mm + each 5 inserts Height = 1.0 x Ø / Height = 1.5 x Ø / Height = 2.0 x Ø	244 202
	Set M 6	1 twist drill Ø 6.2 mm + 1 single-cut tap DIN 352 HSS for thread M 6 x 1.0 + 1 fitting tool M 6 + 1 pin-Breaker Ø 4.6 mm + each 5 inserts Height = 1.0 x Ø / Height = 1.5 x Ø / Height = 2.0 x Ø	244 203
	Set M 8	1 twist drill Ø 8.3 mm + 1 single-cut tap DIN 352 HSS for thread M 8 x 1.25 + 1 fitting tool M 8 + 1 pin-Breaker Ø 6.0 mm + each 5 inserts Height = 1.0 x Ø / Height = 1.5 x Ø / Height = 2.0 x Ø	244 204
	Set M 10	1 twist drill Ø 10.3 mm + 1 single-cut tap DIN 352 HSS for thread M 10 x 1.5 + 1 fitting tool M 10 + 1 pin-Breaker Ø 7.5 mm + each 5 inserts Height = 1.0 x Ø / Height = 1.5 x Ø / Height = 2.0 x Ø	244 205
	Set M 12	1 twist drill Ø 12.4 mm + 1 single-cut tap DIN 352 HSS for thread M 12 x 1.75 + 1 fitting tool M 12 + 1 pin-Breaker Ø 9.0 mm + each 5 inserts Height = 1.0 x Ø / Height = 1.5 x Ø / Height = 2.0 x Ø	244 206
	Set M 14	1 twist drill Ø 14.5 mm + 1 single-cut tap DIN 352 HSS for thread M 14 x 2.0 + 1 fitting tool M 14 + 1 pin-Breaker Ø 10.0 mm + each 5 inserts Height = 1.0 x Ø / Height = 1.5 x Ø / Height = 2.0 x Ø	244 207

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Accessories



Twist drill DIN 338 type N HSS-G



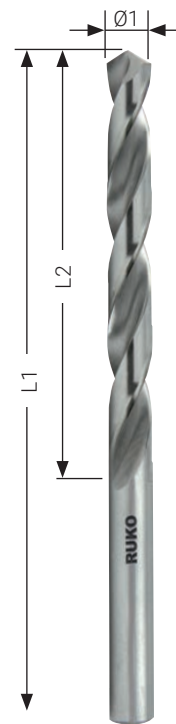
High-performance, ground twist drill made from high-speed steel.

The fully ground twist drill has increased concentricity.

Areas of application: for steel, alloyed and unalloyed cast steel (up to 900 N/mm² strength), grey cast iron, malleable cast iron, ductile cast iron and die cast iron, sintered iron, nickel silver, graphite, short-chipping aluminium alloys, brass and bronze.

Packaging: plastic tube

For thread	Thread core hole Ø1 mm	L1 mm	L2 mm	HSS	
M 3	3.10	65.0	36.0	214 031	10
M 4	4.10	75.0	43.0	214 041	10
M 5	5.20	86.0	52.0	214 052	10
M 6	6.20	101.0	63.0	214 062	10
M 8	8.30	117.0	75.0	214 083	10
M 10	10.30	133.0	87.0	214 103	10
M 12	12.40	151.0	101.0	214 124	5
M 14 + MF 14	14.50	169.0	114.0	214 145	5



Single-cut tap HSS for ProCoil



The single-cut tap HSS for through threads in unalloyed and low-alloyed steels up to a strength of 800 N/mm², malleable cast iron and non-ferrous metals. The thread can be cut in one operation by hand or machine.

Packaging: plastic tube

For thread	Thread core hole Ø1 mm	M mm	L1 mm	L2 mm	HSS	
M 3	3.10	3.6	53.0	13.0	244 603	1
M 4	4.10	4.9	58.0	16.0	244 604	1
M 5	5.20	6.0	66.0	19.0	244 605	1
M 6	6.20	7.3	72.0	22.0	244 606	1
M 8	8.30	9.6	80.0	24.0	244 608	1
M 10	10.30	11.9	89.0	29.0	244 610	1
M 12	12.40	14.3	95.0	30.0	244 612	1
M 14	14.50	16.6	102.0	32.0	244 614	1
MF 14	14.50	15.6	102.0	32.0	244 615	1

