AMECA

WIRE THREAD INSERTS AMECOIL®

www.ameca-sa.fr

Specialist in custom-made Wire Thread Inserts AMECOIL®

AMECA is recognized for its industrial know-how in mechanical assemblies. Our expertise in the manufacturing of Wire Thread Inserts spans over 40 years and many diverse industries: aeronautics, military, nuclear, railways, etc.

Our optimized organization and expert collaborators ensure high-level responsiveness and customization, with no minimum order to adapt to all types of applications. To provide you with an even wider range of services, you can now have access to turnkey solutions from manufacturing to installation thanks to our custom installation service.

In addition to Wire Thread Inserts, AMECA has developed know how in inserts for mechanical parts and offers a range of complementary solutions—self-tapping inserts, nuts, dowels, keys, and more.

From design to customer service, everything is organized to guarantee the quality and improvement of the processes and products manufacturing.

The quality management system is ISO 9001- and ISO 9100-certified and has obtained ISO 19443/ NSQ100 approval.

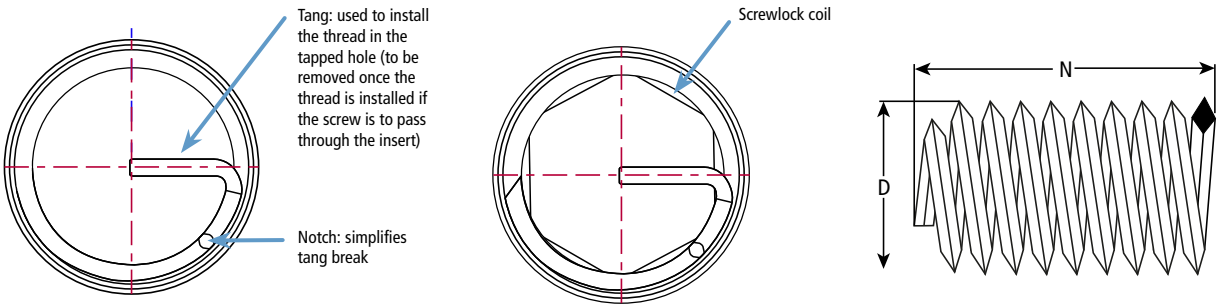
MADE IN FRANCE
FABRIQUÉ EN FRANCE

CONTENTS

Manufactured from a diamond-section wire, the thread insert forms two high-precision concentric threads. One external, to be placed in a tapping, and the other internal, to screw in an element. Each Wire Thread Insert has a tang at one end for quick installation.

Used in all sectors of industry, the **AMECOIL®** Wire Thread Insert is the essential element to secure quality assemblies.

Thanks to its elasticity, the **AMECOIL®** Wire Thread Insert corrects the imperfections of the screw and tapping. This distributes forces over the entire assembly.



TAPPING REPAIR AND REINFORCEMENT

The **AMECOIL®** Wire Thread Insert is used in precision mechanics. In original equipment configurations, it secures high-strength fasteners by creating a reinforced tapping that can be used in several environments:

/// **Screw pull-off strength** for light alloys such as aluminum and cast iron that are subject to high stress. It's easier to replace a damaged screw than a tapping.

/// **Corrosion resistance: AMECOIL®** Wire Thread Inserts, with their anti-oxidation characteristics, are barriers that reduce the effects of corrosion between the screw and mechanical part.

/// **Resistance to high temperatures:** using a nickel-based **AMECOIL®** Wire Thread Insert upholds mechanical characteristics, even in high-temperature environments.

AMECOIL® Wire Thread Inserts are also the right solution for maintenance and repair operations. To maintain the desired final diameter with a damaged tapping or pitch angle defects, the Wire Thread Insert is the solution.

AMECA certifications

ISO 9001
EN 9100
ISO 19443/NSQ100 approval

TECHNOLOGICAL ADVANTAGES OF THE WIRE THREAD INSERT AMECOIL®

RESISTANCE TO PREMATURE WEAR

AMECOIL® Wire Thread Inserts are usually made of stainless steel and have a higher mechanical strength than the material receiving the tapping and thus offer assemblies increased wear resistance.

HOMOGENEOUS LOAD DISTRIBUTION

Thanks to its elasticity, the **AMECOIL®** Wire Thread Insert corrects the imperfections of the screw and tapping. Thus, force distribution is spread out over the entire assembly.

SCREW PULL-OFF RESISTANCE

There are many advantages to using light alloys. On the other hand, they also have a weakness at the tapping. Using **AMECOIL®** stainless steel Wire Thread Inserts provides the assembly greater mechanical strength and thus better screw pull-off resistance.

RESISTANCE TO CORROSIVE ENVIRONMENTS

AMECOIL® Wire Thread Inserts protect against corrosion due to the nature of their alloy.

RESISTANCE TO THERMAL FACTORS

Maintaining the desired mechanical properties of the assembly at high temperatures is possible by using an **AMECOIL®** Wire Thread Insert made from specific alloys.

RESISTANCE TO LOOSENING

AMECOIL® free Wire Thread Inserts have a larger outside diameter than the tapping diameter. The fact that it is placed against the walls of the tapping ensures strong adhesion and removal only with a specific tool.

ANTI-LOOSENING

In order to prevent screw loosening caused by dynamic stresses, vibrations, and/or thermal loads, the **AMECOIL SR AF®** (screwlock) Wire Thread Insert provides two functions in one: elimination of the effects of unscrewing and tapping reinforcement.

DESIGN

AMECOIL® Wire Thread Inserts maintain the assembly's desired mechanical strength while using light alloys and/or reducing the thickness of the receiving part.

FIELDS OF APPLICATION

AERONAUTICS

/// Commercial aircraft

/// Launchers

/// Spacecraft

ENERGY

/// Gas Turbines

/// Nuclear

/// Wind power

RAILWAY

/// Interior fittings

/// Motors

AUTOMOTIVE

/// Engine blocks

/// Anti-vibration systems

DEFENSE

/// Military land vehicles

// Submarines

/// Military aircraft

AGRICULTURE

/// Tractors and tippers

NAVAL

/// Interior fittings

/// Foil

CONSTRUCTION

/// Excavator accessories

/// Hydraulic controls

OTHER APPLICATIONS

/// Industrial machinery

/// Medical

/// Home appliances

TECHNICAL CHARACTERISTICS

DETERMINING THE NOMINAL LENGTH OF THE AMECOIL® WIRE THREAD INSERT

The table below defines the nominal length of **AMECOIL®** according to the receiving material and the class of the screw. This data is established for a temperature of 20°C.

Screw quality

Strength of the support material Rm (N/mm2)*	3.6 - 4.6	4.8 - 5.6	5.8 - 6.6	6.8 - 6.9	8.8	9.8	10.9	12.9	14.9
< 100	1.5 d	1.5 d	2 d	2.5 d	3 d	3 d	-	-	-
> 100 -150	1.5 d	1.5 d	2 d	2 d	2.5 d	2.5 d	2.5 d	2.5 d	3 d
> 150 - 200	1 d	1.5 d	1.5 d	1.5 d	2 d	2 d	2 d	2.5 d	2.5 d
> 200 - 250	1 d	1 d	1.5 d	1.5 d	1.5 d	1.5 d	2 d	2.5 d	2.5 d
> 250 - 300	1 d	1 d	1 d	1 d	1.5 d	1.5 d	1.5 d	2 d	2 d
> 300 – 350	1 d	1 d	1 d	1 d	1 d	1.5 d	1.5 d	1.5 d	2 d
> 350 - 400	1 d	1 d	1 d	1 d	1 d	1 d	1.5 d	1.5 d	1.5 d
> 400	1 d	1 d	1 d	1 d	1 d	1 d	1.5 d	1.5 d	1.5 d

* 1 N/mm2 = 1 Mpa

Threaded lengths are defined to make the screw the weakest element of the assembly. These values are indications and ensure total safety in use. These lengths, as defined, can sometimes be reduced after confirmation through testing. Intermediate lengths are available upon request.

For assemblies subjected to temperatures, the change in the receiving material's strength must be taken into account.

MILITARY, AEROSPACE AND COMMERCIAL STANDARDS

STANDARDS FOR METRIC THREADS

STANDARDS & SPECIFICATIONS	TITLE/DESCRIPTION
DIN8140-1	Wire Thread Inserts For Iso Metric Screw Threads - Part 1: Dimensions, technical specifications
LN9039	Aerospace; inserts, helical coil threads
LN9490	Aerospace series - Clamps, loop type, of corrosion-resistant steel
LN9499	Aerospace series - Inserts, helical coil threads, screw-locking
EN2944	Aerospace series - Inserts, screw thread, helical coil, screw locking, in corrosion resisting steel FE-PA3004

STANDARDS FOR UNC/UNF THREADS

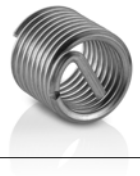
STANDARDS & SPECIFICATIONS	TITLE/DESCRIPTION
NASM122076-122115	Insert, cres, helical coil, coarse thread, 1 dia. Nominal length
NASM124651-124690	Insert, cres, helical coil, fine thread, 1 dia. Nominal length
NASM21209	Insert, screw thread, coarse and fine, screw locking, helical coil,
NASM33537	Insert, screw thread, helical coil, inch series, coarse and fine thread, standard assembly dimensions for
NASM8846	Insert, screw thread, helical coil
NASM122236-122275	Insert, cres helical coil, coarse thread, 3 dia. Nominal length

MATERIALS & TREATMENTS

STAINLESS STEELS

MATERIALS	MAIN CHARACTERISTICS	APPLICATIONS TYPE	MAXIMUM OPERATING TEMPERATURES	SURFACE COATING OPTION	COLOR
AISI 304	• Good resistance to corrosion • Good mechanical properties • Good weldability • Non-magnetic	Food industry, exterior construction and architecture	797°F (425°C) (peak) 599°F (315°C) (continuous)	• Dry lubrication • Cadmium plating • Silver plating • Zinc plating • Tin plating	
AISI 304L	• Low carbon • Very good resistance to intergranular corrosion • Good weldability • Non-magnetic	Low-aggression chemical industry, boilermaking, piping, general use			
AISI 316	Molybdenum steel • Very good resistance to pitting corrosion • Good heat resistance in chlorinated and marine environments • Non-magnetic	Aggressive chemical and food industries	797°F (425°C) (peak) 599°F (315°C) (continuous)	• Dry lubrication • Cadmium plating • Silver plating • Zinc plating • Tin plating	
AISI 316 L	Ultra low carbon molybdenum steel • Very good resistance to intergranular corrosion in chlorinated and marine environments • Non-magnetic	Boilermaking, piping for the highly aggressive chemical industry, shipbuilding, deck fittings			
AISI 316 Ti	Molybdenum steel, titanium stabilized • Excellent corrosion resistance in chlorinated and marine environments • Non-magnetic	Chemical and petroleum industry.			

OTHER MATERIALS

MATERIALS	MAIN CHARACTERISTICS	APPLICATIONS TYPE	MAXIMUM OPERATING TEMPERATURES	SURFACE COATING OPTION	COLOR
PHOSPHO-RUS BRONZE CuSn6	• Better resistance to galvanic corrosion • Non-magnetic • Excellent electrical conductivity	• Aerospace segment • Ideal for saltwater applications	797°F (300°C) (peak) 482°F (250°C) (continuous)	• Cadmium plating	
INCONEL X-750	• Good creep rupture resistance at high temperature • Very good resistance to cryogenic temperatures • Age hardening	• Nuclear reactor • Gas turbines • Rocket motor • Pressure vessels • Aeronautical structures	797°F (750°C) (peak) 482°F (550°C) (continuous)	• Silver plating	
NIMONIC 90	• High rupture resistance under stress and at high temperature • Good resistance to corrosion and oxidation at high temperature • Age hardening	• Fasteners for aeronautics	797°F (900°C) (peak) 482°F (600°C) (continuous)	• Silver plating	
NITRONIC 60	• Anti-seizure • Wear-resistant • Particle-free • Non-magnetic	• Vacuum environments • Valve stems • Locking pins • Brushes • Bearings • Pump shafts and ring • Wire Thread Inserts • Fasteners	482°F (300°C) (continuous)	No additional coating needed	

COATINGS

COATING	ADVANTAGES	COLOR
DRY LUBRICATION MOS2	• Provides additional lubrication for high friction applications • Limits seizure between the insert and fastener • Facilitates installation • Protects against soft corrosion • Resistance to high temperatures (392°F/200°C)	
CADMIUM PLATING	• Superior corrosion protection • Reduces the coefficient of friction between the insert and screw to limit seizure	
SILVER PLATING	• Increases lubricity at high temperatures	
ZINC PLATING	• Superior corrosion protection	
TIN PLATING	• Superior corrosion protection	
ELECTROLYTIC NICKEL PLATING	• Wear resistant • Protection against corrosion	
DYE	• Visual identification of threads	

AMECOIL® WIRE THREAD INSERT RANGE

AMECOIL SR

AMECOIL SR® (Reduced Spiral) thread inserts offer a reduced-diameter notch coil to make installation easier.

AMECOIL SR AF - SCREW LOCKING

AMECOIL SR AF® Wire Thread Inserts have the same technical properties as AMECOIL SR®. They also include a screwlock obtained by the deformation of one or more thread coils. This deformation causes a strong clamping on the thread flank of the screw and cancels the effects of unscrewing caused by dynamic stresses, vibrations, and/or thermal loads. Its red color distinguishes it from the standard thread.

The characteristics obtained are equivalent to the ISO2320 standard for metric threads and conform to the NASM8846 standard for American threads.

AMECOIL BP

Wire Thread Inserts packaged on Strip Feed to improve assembly rates and working conditions.

AMELOCK

AMELOCK is a screw locking nut resulting from the assembly of an AMECOIL AF® thread in a nut. The mechanical characteristics thus obtained are equivalent to the ISO2320 standard (steel screws).

AMECOIL LEFT-HAND

To match reverse threads in applications where this is required, left-hand inserts.

TWININSERT

Composed of two AMECOIL® Wire Thread Inserts, this combination is used to repair tapped holes with special insert dimensions or oversized threads.

//// AMECOIL® - TECHNICAL DATA AND ARTICLE CODES

TECHNICAL DATA & CODING SYSTEM

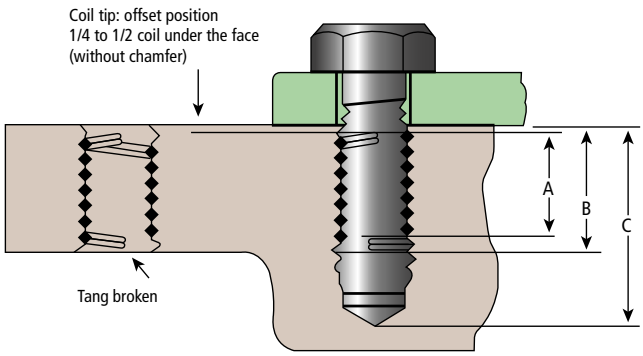
AMECOIL®

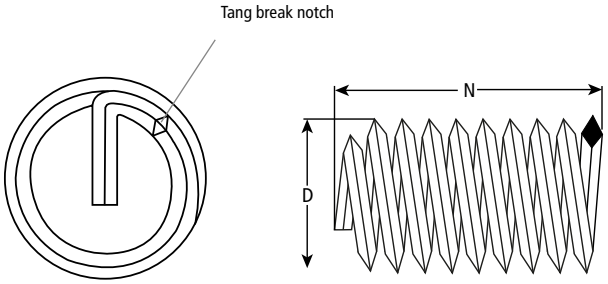
XX XX XXX XXX SR

MATERIAL

- **01 -** Stainless steel AISI 304
- **02 -** Stainless steel AISI 304 screw locking
- **41 -** Stainless steel AISI 304 left-hand
- **42 -** Stainless steel AISI 304 left-hand screw locking
- **07 -** Stainless steel AISI 316
- **09 -** Stainless steel AISI 316 screw locking
- **63 -** Bronze CuSn6
- **64 -** Bronze CuSn6 screw locking
- **65 -** Inconel X-750 silver-plated
- **66 -** Inconel X-750 silver-plated screw locking
- **67 -** Inconel X-750
- **68 -** Inconel X-750 screw locking

For other materials or other surface treatments, please contact us for the correct coding.





NOMINAL DIAMETER: refer to the reference table

PITCH: refer to the reference tables

NOMINAL LENGTH: refer to the reference tables

SR: for an AMECOIL SR® (Reduced Spire) Wire Thread Insert

CAD modeling of AMECOIL® Wire Thread Inserts is available at www.ameca-sa.fr

For Wire Thread Insert installation, use the tools proposed by AMECA (page 46 - 47).

AMECOIL®
THREADED/METRIC INSERTS

Nominal diameter d	Pitch mm P	x d	Installed thread mm A	Nominal length mm B	Drilling tool Ø mm	Hole Ø mm min.	Hole Ø mm max.	Min. drilling depth C	Tap Ø min ext.	Ext. Ø of thread free D min.	Ext. Ø of thread free D max.	Number of free coils ± 1/4 N	Reference AMECOIL SR	Reference AMECOIL SR AF
M 2	0.4	1 d	1.60	2.00	2.10	2.09	2.18	3.6	2.52	2.50	2.80	2.9	0102040002SR	0202040002SR
		1.5 d	2.60	3.00				4.6				4.9	0102040003SR	0202040003SR
		2 d	3.60	4.00				5.6				6.9	0102040004SR	0202040004SR
		2.5 d	4.60	5.00				6.6				8.9	0102040005SR	0202040005SR
		3 d	5.60	6.00				7.6				11.3	0102040006SR	0202040006SR
M 2.5	0.45	1 d	2.10	2.50	2.60	2.60	2.70	5.1	3.08	3.30	3.50	3.5	0125045025SR	0225045025SR
		1.5 d	3.30	3.75				6.3				5.9	0125045375SR	0225045375SR
		2 d	4.60	5.00				7.6				8.1	0125045005SR	0225045005SR
		2.5 d	5.80	6.25				8.9				10.5	0125045625SR	0225045625SR
		3 d	7.10	7.50				10.1				12.8	0125045075SR	0225045075SR
M 3	0.5	1 d	2.50	3.00	3.20	3.11	3.22	5.8	3.65	3.80	4.00	3.9	0103050003SR	0203050003SR
		1.5 d	4.00	4.50				7.3				6.3	0103050045SR	0203050045SR
		2 d	5.50	6.00				8.8				8.7	0103050006SR	0203050006SR
		2.5 d	7.00	7.50				10.3				11.1	0103050075SR	0203050075SR
		3 d	8.50	9.00				11.8				14.2	0103050009SR	0203050009SR
M 3.5	0.6	1 d	2.90	3.50	3.70	3.63	3.76	6.9	4.28	4.55	4.75	3.7	0135060035SR	0235060035SR
		1.5 d	4.70	5.25				8.6				6.3	0135060525SR	0235060525SR
		2 d	6.40	7.00				10.4				8.7	0135060007SR	0235060007SR
		2.5 d	8.20	8.75				12.2				11.2	0135060875SR	0235060875SR
		3 d	9.90	10.50				13.9				13.7	0135060105SR	0235060105SR
M 4	0.7	1 d	3.30	4.00	4.20	4.15	4.29	7.8	4.91	5.15	5.35	3.7	0104070004SR	0204070004SR
		1.5 d	5.30	6.00				9.8				6.1	0104070006SR	0204070006SR
		2 d	7.30	8.00				11.8				8.4	0104070008SR	0204070008SR
		2.5 d	9.30	10.00				13.8				10.9	0104070010SR	0204070010SR
		3 d	11.30	12.00				15.8				13.6	0104070012SR	0204070012SR
M 5	0.8	1 d	4.20	5.00	5.20	5.17	5.33	9.2	6.04	6.25	6.60	4.3	0105080005SR	0205080005SR
		1.5 d	6.70	7.50				11.7				6.9	0105080075SR	0205080075SR
		2 d	9.20	10.00				14.2				9.7	0105080010SR	0205080010SR
		2.5 d	11.70	12.50				16.7				12.3	0105080125SR	0205080125SR
		3 d	14.20	15.00				19.2				14.8	0105080015SR	0205080015SR
M 6	1.0	1 d	5.00	6.00	6.30	6.22	6.41	11.2	7.30	7.60	7.85	4.2	0106100006SR	0206100006SR
		1.5 d	8.00	9.00				14.2				6.9	0106100009SR	0206100009SR
		2 d	11.00	12.00				17.2				9.6	0106100012SR	0206100012SR
		2.5 d	14.00	15.00				20.2				12.3	0106100015SR	0206100015SR
		3 d	17.00	18.00				23.2				14.7	0106100018SR	0206100018SR
M 7	1.0	1 d	6.00	7.00	7.30	7.22	7.41	12.1	8.30	8.65	8.90	5.3	0107100007SR	0207100007SR
		1.5 d	9.50	10.50				15.6				8.2	0107100105SR	0207100105SR
		2 d	12.00	14.00				19.1				11.1	0107100014SR	0207100014SR
		2.5 d	16.50	17.50				22.6				14.3	0107100175SR	0207100175SR
		3 d	20.00	21.00				26.1				17.4	0107100021SR	0207100021SR
M 8 x 100	1.0	1 d	7.00	8.00	8.30	8.22	8.41	13.0	9.30	9.75	70.10	6.1	0108100008SR	0208100008SR
		1.5 d	11.00	12.00				17.0				9.5	0108100012SR	0208100012SR
		2 d	15.00	16.00				21.0				12.9	0108100016SR	0208100016SR
		2.5 d	19.00	20.00				25.0				16.5	0108100020SR	0208100020SR
		3 d	23.00	24.00				29.0				20.0	0108100024SR	0208100024SR
M 8	1.25	1 d	6.80	8.00	8.40	8.27	8.48	14.2	9.62	9.85	10.10	4.7	0108125008SR	0208125008SR
		1.5 d	10.80	12.00				18.2				7.4	0108125012SR	0208125012SR
		2 d	14.80	16.00				22.2				10.6	0108125016SR	0208125016SR
		2.5 d	18.80	20.00				26.2				13.5	0108125020SR	0208125020SR
		3 d	22.80	24.00				30.2				16.6	0108125024SR	0208125024SR
M 9	1.25	1 d	7.80	9.00	9.40	9.27	9.48	15.2	10.62	10.85	11.10	5.6	0109125009SR	0209125009SR
		1.5 d	12.30	13.50				19.7				8.8	0109125135SR	0209125135SR
		2 d	16.80	18.00				24.2				12.0	0109125018SR	0209125018SR
		2.5 d	21.30	22.50				28.7				15.2	0109125225SR	0209125225SR
		3 d	25.80	27.00				33.2				18.4	0109125027SR	0209125027SR

Nominal diameter d	Pitch mm P	x d	Installed thread mm A	Nominal length mm B	Drilling tool Ø mm	Hole Ø mm min.	Hole Ø mm max.	Min. drilling depth C	Tap Ø min ext.	Ext. Ø of thread free D min.	Ext. Ø of thread free D max.	Number of free coils ± 1/4 N	Reference AMECOIL SR	Reference AMECOIL SR AF
M 10 x 100	1.0	1 d	9.00	10.00	10.25	10.22	10.41	15.0	11.30	12.00	12.50	7.6	0110100010SR	0210100010SR
		1.5 d	14.00	15.00				20.0				12.1	0110100015SR	0210100015SR
		2 d	19.00	20.00				25.0				16.3	0110100020SR	0210100020SR
		2.5 d	24.00	25.00				30.0				20.7	0110100025SR	0210100025SR
		3 d	29.00	30.00				35.0				25.1	0110100030SR	0210100030SR
M 10 x 125	1.25	1 d	8.80	10.00	10.40	10.27	10.48	16.2	11.62	12.10	12.50	6.0	0110125010SR	0210125010SR
		1.5 d	13.80	15.00				21.2				9.7	0110125015SR	0210125015SR
		2 d	18.80	20.00				26.2				13.1	0110125020SR	0210125020SR
		2.5 d	23.80	25.00				31.2				16.7	0110125025SR	0210125025SR
		3 d	28.80	30.00				36.2				20.2	0110125030SR	0210125030SR
M 10	1.5	1 d	8.50	10.00	10.50	10.32	10.56	17.3	11.95	12.10	12.50	5.0	0110150010SR	0210150010SR
		1.5 d	13.50	15.00				22.3				8.1	0110150015SR	0210150015SR
		2 d	18.50	20.00				27.3				11.2	0110150020SR	0210150020SR
		2.5 d	23.50	25.00				32.3				14.2	0110150025SR	0210150025SR
		3 d	28.50	30.00				37.3				17.5	0110150030SR	0210150030SR
M 11	1.5	1 d	9.50	11.00	11.50	11.32	11.56	18.3	12.95	13.10	13.50	5.6	0111150011SR	0211150011SR
		1.5 d	15.00	16.50				23.8				8.9	0111150165SR	0211150165SR
		2 d	20.50	22.00				29.3				12.1	0111150022SR	0211150022SR
		2.5 d	26.00	27.50				34.8				15.4	0111150275SR	0211150275SR
		3 d	31.50	33.00				40.3				18.7	0111150033SR	0211150033SR
M 12 x 100	1.0	1 d	11.00	12.00	12.30	12.22	12.41	17.2	13.30	14.30	14.80	9.3	011210012SR	0211210012SR
		1.5 d	17.00	18.00				23.2				14.5	0112100018SR	0212100018SR
		2 d	23.00	24.00				29.2				19.5	0112100024SR	0212100024SR
		2.5 d	29.00	30.00				35.2				24.7	0112100030SR	0212100030SR
		3 d	35.00	36.00				41.2				30.0	0112100036SR	0212100036SR
M 12 x 125	1.25	1 d	10.80	12.00	12.40	12.27	12.48	18.2	13.62	14.40	14.80	7.4	0112125012SR	0212125012SR
		1.5 d	16.80	18.00				24.2				11.6	0112125018SR	0212125018SR
		2 d	22.80	24.00				30.2				15.9	0112125024SR	0212125024SR
		2.5 d	28.80	30.00				36.2				19.9	0112125030SR	0212125030SR
		3 d	34.80	36.00				42.2				24.1	0112125036SR	0212125036SR
M 12 x 150	1.5	1 d	10.50	12.00	12.50	12.32	12.56	19.3	13.95	14.40	14.80	6.2	0112150012SR	0212150012SR
		1.5 d	16.50	18.00				25.3				9.8	0112150018SR	0212150018SR
		2 d	22.50	24.00				31.3				13.5	0112150024SR	0212150024SR
		2.5 d	28.50	30.00				37.3				15.7	0112150030SR	0212150030SR
		3 d	34.50	36.00				43.3				20.8	0112150036SR	0212150036SR
M 12	1.75	1 d	10.30	12.00	12.50	12.38	12.64	20.3	14.27	14.40	14.80	5.2	0112175012SR	0212175012SR
		1.5 d	16.30	18.00				26.3				8.4	0112175018SR	0212175018SR
		2 d	22.30	24.00				32.3				11.7	0112175024SR	0212175024SR
		2.5 d	28.30	30.00				38.3				14.7	0112175030SR	0212175030SR
		3 d	34.30	36.00				44.3				17.4	0112175036SR	0212175036SR
M 14 x 125	1.25	0.5 d	5.80	7.00	14.40	14.27	14.48	13.2	15.62	16.80	17.70	4.0	0114125007SR	0214125007SR
		0.75 d	9.30	10.50				16.7				6.4	0114125105SR	0214125105SR
		1 d	12.80	14.00				20.2				8.8	0114125014SR	0214125014SR
		1.5 d	19.80	21.00				27.2				13.6	0114125021SR	0214125021SR
		2 d	26.80	28.00				34.2				18.4	0114125028SR	0214125028SR
		2.5 d	33.80	35.00				41.2				23.2	0114125035SR	0214125035SR
		3 d	40.80	42.00				48.2				28.5	0114125042SR	0214125042SR
M 14 x 150	1.5	1 d	12.50	14.00	14.50	14.32	14.56	21.3	15.95	16.80	17.70	7.4	0114150014SR	0214150014SR
		1.5 d	19.50	21.00				28.3				11.6	0114150021SR	0214150021SR
		2 d	26.50	28.00				35.3				15.7	0114150028SR	0214150028SR
		2.5 d	33.50	35.00				42.3				19.9	0114150035SR	0214150035SR
		3 d	40.50	42.00				49.3				23.5	0114150042SR	0214150042SR
M 14	2.0	1 d	12.00	14.00	14.50	14.43	14.73	23.3	16.60	16.80	17.70	5.6	0114200014SR	0214200014SR
		1.5 d	19.00	21.00				30.3				8.8	0114200021SR	0214200021SR
		2 d	26.00	28.00				37.3				12.0	0114200028SR	0214200028SR
		2.5 d	33.00	35.00				44.3				15.2	0114200035SR	0214200035SR
		3 d	40.00	42.00				51.3				17.9	0114200042SR	0214200042SR
M 16 x 150	1.5	1 d	14.50	16.00	16.50	16.32	16.56	23.3	17.95	19.00	19.90	8.7	0116150016SR	0216150016SR
		1.5 d	22.50	24.00				31.3				13.4	0115150024SR	0215150024SR
		2 d	30.50	32.00				39.3				18.1	0116150032SR	0216150032SR
		2.5 d	38.50	40.00				47.3				22.9	0116150040SR	0216150040SR

Nominal diameter d	Pitch mm P	x d	Installed thread mm A	Nominal length mm B	Drilling tool Ø mm	Hole Ø mm min.	Hole Ø mm max.	Min. drilling depth C	Tap Ø min ext.	Ext. Ø of thread free D min.	Ext. Ø of thread free D max.	Number of free coils ± 1/4 N	Reference AMECOIL SR	Reference AMECOIL SR AF
M 16	2.0	1 d	14.00	16.00	16.50	16.43	16.73	25.3	18.60	19.00	19.90	6.5	0116200016SR	0216200016SR
		1.5 d	22.00	24.00				33.3				10.1	0116200024SR	0216200024SR
		2 d	30.00	32.00				41.3				13.8	0116200032SR	0216200032SR
		2.5 d	38.00	40.00				49.3				17.5	0116200040SR	0216200040SR
		3 d	46.00	48.00				57.3				20.6	0116200048SR	0216200048SR
M 18 x 150	1.5	0.5 d	7.50	9.00	18.50	18.32	18.56	16.3	19.95	21.50	22.00	4.4	0118150009SR	0218150009SR
		0.75 d	12.00	13.50				20.8				7.0	0118150135SR	0218150135SR
		1 d	16.50	18.00				25.3				9.5	0118150018SR	0218150018SR
		1.5 d	25.50	27.00				34.3				14.9	0118150027SR	0218150027SR
		2 d	34.50	36.00				43.3				20.2	0118150036SR	0218150036SR
M 18 x 200	2.0	0.5 d	7.00	9.00	18.50	18.43	18.73	18.3	20.60	21.50	22.00	3.1	0118200009SR	0218200009SR
		0.75 d	11.50	13.50				22.8				5.1	0118200135SR	0218200135SR
		1 d	16.00	18.00				27.3				7.1	0118200018SR	0218200018SR
		1.5 d	25.00	27.00				36.3				11.2	0118200027SR	0218200027SR
		2 d	34.00	36.00				45.3				15.1	0118200036SR	0218200036SR
		2.5 d	43.00	45.00				54.3				19.1	0118200045SR	0218200045SR
		3 d	52.00	54.00				62.0				22.8	0118200054SR	0218200054SR
M 18	2.5	0.5 d	6.50	9.00	18.75	18.54	18.90	20.2	21.25	21.50	22.00	2.4	0118250009SR	0218250009SR
		0.75 d	11.00	13.50				24.7				4.0	0118250135SR	0218250135SR
		1 d	15.50	18.00				29.2				5.6	0118250018SR	0218250018SR
		1.5 d	24.50	27.00				38.2				9.0	0118250027SR	0218250027SR
		2 d	33.50	36.00				47.2				12.3	0118250036SR	0218250036SR
		2.5 d	42.50	45.00				56.2				15.5	0118250045SR	0218250045SR
		3 d	51.50	54.00				64.0				18.4	0118250054SR	0218250054SR
M 20 x 150	1.5	0.5 d	8.50	10.00	20.50	20.32	20.56	17.3	21.95	23.70	24.20	5.0	0120150010SR	0220150010SR
		0.75 d	13.50	15.00				22.3				7.9	0120150015SR	0220150015SR
		1 d	18.50	20.00				27.3				10.7	0120150020SR	0220150020SR
		1.5 d	28.50	30.00				37.3				16.7	0120150030SR	0220150030SR
		2 d	38.50	40.00				47.3				22.4	0120150040SR	0220150040SR
M 20 x 200	2.0	0.5 d	8.00	10.00	20.50	20.43	20.73	19.3	22.60	23.70	24.20	3.6	0120200010SR	0220200010SR
		0.75 d	13.00	15.00				24.3				5.8	0120200015SR	0220200015SR
		1 d	18.00	20.00				29.3				8.0	0120200020SR	0220200020SR
		1.5 d	28.00	30.00				39.3				12.5	0120200030SR	0220200030SR
		2 d	38.00	40.00				49.3				16.8	0120200040SR	0220200040SR
M 20	2.5	0.5 d	7.50	10.00	20.75	20.54	20.90	21.2	23.25	23.70	24.20	2.7	0120250010SR	0220250010SR
		0.75 d	12.50	15.00				26.2				4.5	0120250015SR	0220250015SR
		1 d	17.50	20.00				31.2				6.3	0120250020SR	0220250020SR
		1.5 d	27.50	30.00				41.2				10.0	0120250030SR	0220250030SR
		2 d	37.50	40.00				51.2				13.7	0120250040SR	0220250040SR
		2.5 d	47.50	50.00				61.2				17.0	0120250050SR	0220250050SR
		3 d	57.50	60.00				71.2				20.6	0120250060SR	0220250060SR
M 22 x 150	1.5	0.5 d	9.50	11.00	22.50	22.32	22.56	18.3	23.95	26.20	26.80	5.5	0122150011SR	0222150011SR
		0.75 d	15.00	16.50				23.8				8.7	0122150165SR	0222150165SR
		1 d	20.50	22.00				29.3				11.7	0122150022SR	0222150022SR
		1.5 d	31.50	33.00				40.3				18.1	0122150033SR	0222150033SR
		2 d	42.50	44.00				51.3				24.6	0122150044SR	0222150044SR
M 22 x 200	2.0	0.5 d	9.00	11.00	22.50	22.43	22.73	20.3	24.60	26.30	26.80	3.9	0122200011SR	0222200011SR
		0.75 d	14.50	16.50				25.8				6.3	0122200165SR	0222200165SR
		1 d	20.00	22.00				31.3				8.7	0122200022SR	0222200022SR
		1.5 d	31.00	33.00				42.3				13.6	0122200033SR	0222200033SR
		2 d	42.00	44.00				53.3				18.4	0122200044SR	0222200044SR
M 22	2.5	0.5 d	8.50	11.00	22.75	22.54	22.90	22.2	25.25	26.30	26.80	3.0	0122250011SR	0222250011SR
		0.75 d	14.00	16.50				27.7				4.9	0122250165SR	0222250165SR
		1 d	19.50	22.00				33.2				6.9	0122250022SR	0222250022SR
		1.5 d	30.50	33.00				44.2				10.9	0122250033SR	0222250033SR
		2 d	41.50	44.00				55.2				15.0	0122250044SR	0222250044SR
		2.5 d	52.20	55.00				66.2				18.5	0122250055SR	0222250055SR
M 24 x 150	1.5	0.5 d	10.50	12.00	24.50	24.32	24.56	19.3	25.95	28.50	29.10	6.1	0124150012SR	0224150012SR
		0.75 d	16.50	18.00				25.3				9.6	0124150018SR	0224150018SR
		1 d	22.50	24.00				31.3				12.9	0124150024SR	0224150024SR
		1.5 d	34.50	36.00				43.3				19.8	0124150036SR	0224150036SR
		2 d	46.50	48.00				55.3				27.0	0124150048SR	0224150048SR

Nominal diameter d	Pitch mm P	x d	Installed thread mm A	Nominal length mm B	Drilling tool Ø mm	Hole Ø mm min.	Hole Ø mm max.	Min. drilling depth C	Tap Ø min ext.	Ext. Ø of thread free D min.	Ext. Ø of thread free D max.	Number of free coils ± 1/4 N	Reference AMECOIL SR	Reference AMECOIL SR AF
M 24 x 200	2.0	0.5 d	10.00	12.00	24.50	24.43	24.73	21.3	26.60	28.60	29.10	4.4	0124200012SR	0224200012SR
		0.75 d	16.00	18.00				27.3				7.1	0124200018SR	0224200018SR
		1 d	22.00	24.00				33.3				9.6	0124200024SR	0224200024SR
		1.5 d	34.00	36.00				45.3				15.0	0124200036SR	0224200036SR
		2 d	46.00	48.00				57.3				20.2	0124200048SR	0224200048SR
M 24	3.0	0.5 d	9.00	12.00	24.75	24.65	25.05	25.1	27.90	28.60	29.10	2.7	0124300012SR	0224300012SR
		0.75 d	15.00	18.00				31.1				4.5	0124300018SR	0224300018SR
		1 d	21.00	24.00				37.1				6.2	0124300024SR	0224300024SR
		1.5 d	33.00	36.00				49.1				10.0	0124300036SR	0224300036SR
		2 d	45.00	48.00				61.1				14.0	0124300048SR	0224300048SR
		2.5 d	57.00	60.00				73.1				17.5	0124300060SR	0224300060SR
M 26 x 150	1.5	0.5 d	11.50	13.00	26.50	26.32	26.56	20.3	27.95	31.00	31.50	6.6	0126150013SR	0226150013SR
		0.75 d	18.00	19.50				26.8				10.3	0126150195SR	0226150195SR
		1 d	24.50	26.00				33.3				14.0	0126150026SR	0226150026SR
		1.5 d	37.50	39.00				46.3				21.4	0126150039SR	0226150039SR
		2 d	50.50	52.00				59.3				28.8	0126150052SR	0226150052SR
M 27 x 150	1.5	0.5 d	12.00	13.50	27.50	27.32	27.56	200.8	28.95	32.20	32.70	7.0	0127150135	0227150135
		0.75 d	18.80	20.30				27.6				10.9	0127150203	0227150203
		1 d	25.50	27.00				34.3				14.9	0127150027	0227150027
		1.5 d	39.00	40.50				47.8				22.7	0127150405	0227150405
		2 d	52.50	54.00				61.3				30.6	0127150054	0227150054
M 27 x 2	2.0	0.5 d	11.50	13.50	27.50	27.43	27.73	22.8	29.60	32.20	32.70	5.0	0127200135SR	0227200135SR
		0.75 d	18.30	20.30				29.6				8.0	0127200203SR	0227200203SR
		1 d	25.00	27.00				36.3				11.0	0127200027SR	0227200027SR
		1.5 d	38.50	40.50				49.8				16.9	0127200405SR	0227200405SR
		2 d	52.00	54.00				63.3				22.8	0127200054SR	0227200054SR
M 27	3.0	0.5 d	10.50	13.50	27.75	27.65	28.05	26.6	30.90	32.20	32.70	3.1	0127300135SR	0227300135SR
		0.75 d	17.30	20.30				33.4				5.1	0127300203SR	0227300203SR
		1 d	24.00	27.00				40.1				7.1	0127300027SR	0227300027SR
		1.5 d	37.50	40.50				53.6				11.1	0127300405SR	0227300405SR
		2 d	51.00	54.00				67.1				15.1	0127300054SR	0227300054SR
M 28 x 150	1.5	0.5 d	12.50	14.00	28.50	28.32	28.56	21.3	29.95	33.10	33.60	7.6	0128150014	0228150014
		0.75 d	19.50	21.00				28.3				11.9	0128150021	0228150021
		1 d	26.50	28.00				35.3				16.2	0128150028	0228150028
		1.5 d	40.50	42.00				49.3				24.8	0128150042	0228150042
		2 d	54.50	56.00				63.3				33.3	0128150056	0228150056
M 30 x 150	1.5	0.5 d	13.50	15.00	30.50	30.22	30.56	22.3	31.95	34.30	35.70	8.1	0130150015	0230150015
		0.75 d	21.00	22.50				29.8				12.5	0130150225	0230150225
		1 d	28.50	30.00				37.3				16.5	0130150030	0230150030
		1.5 d	43.50	45.00				52.3				25.3	0130150045	0230150045
		2 d	58.50	60.00				67.3				34.9	0130150060	0230150060
M 30 x 200	2.0	0.5 d	13.00	15.00	30.50	30.43	30.73	24.3	32.60	35.20	35.70	5.8	0130200015SR	0230200015SR
		0.75 d	20.50	22.50				31.8				9.1	0130200225SR	0230200225SR
		1 d	28.00	30.00				39.3				12.3	0130200030SR	0230200030SR
		1.5 d	43.00	45.00				54.3				19.0	0130200045SR	0230200045SR
		2 d	58.00	60.00				69.3				25.8	0130200030SR	0230200030SR
M 30	3.5	0.5 d	11.50	15.00	31.00	30.76	31.21	30.3	34.55	35.20	35.70	3.0	0130350015SR	0230350015SR
		0.75 d	19.00	22.50				37.8				4.9	0130350225SR	0230350225SR
		1 d	26.50	30.00				45.3				7.0	0130350030SR	0230350030SR
		1.5 d	41.50	45.00				60.3				11.0	0130350045SR	0230350045SR
		2 d	56.50	60.00				75.3				14.9	0130350060SR	0230350060SR
M 33 x 200	2.0	0.5 d	14.50	16.50	33.50	33.43	33.73	25.8	35.60	38.30	38.80	6.5	0133200165SR	0233200145SR
		0.75 d	22.80	24.80				34.1				10.1	0133200248SR	0233200248SR
		1 d	31.00	33.00				42.3				13.7	0133200033SR	0233200033SR
		1.5 d	47.50	49.50				58.8				21.2	0133200495SR	0233200495SR
		2 d	64.00	66.00				75.3				28.5	0133200066SR	0233200066SR
M 33	3.5	0.5 d	13.00	16.50	34.00	33.76	34.21	31.7	37.55	38.30	38.80	3.4	0133350165SR	0233350165SR
		0.75 d	21.30	24.80				40.0				5.6	0133350248SR	0233350248SR
		1 d	29.50	33.00				48.2				7.8	0133350033SR	0233350033SR
		1.5 d	46.00	49.50				64.7				12.2	0133350495SR	0233350495SR
		2 d	62.50	66.00				81.2				16.5	0133350066SR	0233350066SR

Nominal diameter d	Pitch mm P	x d	Installed thread mm A	Nominal length mm B	Drilling tool Ø mm	Hole Ø mm min.	Hole Ø mm max.	Min. drilling depth C	Tap Ø min ext.	Ext. Ø of thread free D min.	Ext. Ø of thread free D max.	Number of free coils ± 1/4 N	Reference AMECOIL SR	Reference AMECOIL SR AF
M 34	1.5	0.5 d	15.50	17.00	34.50	34.32	34.56	24.3	35.95	39.10	39.40	9.2	0134150017	0234150017
		0.75 d	24.00	25.50				32.8				14.3	0134150255	0234150255
		1 d	32.50	34.00				41.3				19.3	0134150034	0234150034
		1.5 d	49.50	51.00				58.3				29.4	0134150051	0234150051
		2 d	66.50	68.00				75.3				39.5	0134150068	0234150068
M 36 x 150	1.5	0.5 d	16.50	18.00	36.50	36.32	36.56	25.3	37.95	42.10	42.60	10.3	0136150018SR	0236150018SR
		0.75 d	25.50	27.00				34.3				15.9	0136150027SR	0236150027SR
		1 d	34.50	36.00				43.3				21.5	0136150036SR	0236150036SR
		1.5 d	52.50	54.00				61.3				32.7	0136150054SR	0236150054SR
		2 d	70.50	72.00				79.3				43.9	0136150072SR	0236150072SR
M 36 x 200	2.0	0.5 d	16.00	18.00	36.50	36.43	36.73	27.3	38.60	42.10	42.60	7.0	0136200018SR	0236200018SR
		0.75 d	25.00	27.00				36.3				11.0	0136200027SR	0236200027SR
		1 d	34.00	36.00				45.3				14.1	0136200036SR	0236200036SR
		1.5 d	52.00	54.00				63.3				21.9	0136200054SR	0236200054SR
		2 d	70.00	72.00				81.3				30.7	0136200072SR	0236200072SR
M 36 x 300	3.0	0.5 d	15.00	18.00	37.00	36.65	37.05	31.1	39.90	42.10	42.60	4.5	0136300018SR	0236300018SR
		0.75 d	24.00	27.00				40.1				7.2	0136300027SR	0236300027SR
		1 d	33.00	36.00				49.1				9.9	0136300036SR	0236300036SR
		1.5 d	51.00	54.00				67.1				15.3	0136300054SR	0236300054SR
		2 d	69.00	72.00				85.1				20.7	0136300072SR	0236300072SR
M 36	4.0	0.5 d	14.00	18.00	37.00	36.87	37.34	34.8	41.20	42.10	42.60	3.2	0136400018SR	0236400018SR
		0.75 d	23.00	27.00				43.8				5.3	0136400027SR	0236400027SR
		1 d	32.00	36.00				52.8				7.0	0136400036SR	0236400036SR
		1.5 d	50.00	54.00				70.8				11.1	0136400054SR	0236400054SR
		2 d	68.00	72.00				88.8				15.2	0136400072SR	0236400072SR
M 39 x 300	3.0	0.5 d	16.50	19.50	40.00	39.65	40.05	32.6	42.90	45.10	45.60	5.0	0139300195SR	0239300195SR
		0.75 d	26.30	29.30				42.4				7.9	0139300293SR	0239300293SR
		1 d	36.00	39.00				52.1				10.8	0139300039SR	0239300039SR
		1.5 d	55.50	58.50				71.6				16.8	0139300585SR	0239300585SR
		2 d	75.00	78.00				91.1				22.5	0139300078SR	0239300078SR
M 39	4.0	0.75 d	25.30	29.30	40.00	39.87	40.34	46.1	44.20	45.10	45.60	5.8	0139400293SR	0239400293SR
		1 d	35.00	39.00				55.8				7.7	0139400039SR	0239400039SR
		1.5 d	54.50	58.50				75.3				12.2	0139400585SR	0239400585SR
		2 d	74.00	78.00				94.8				16.6	0139400078SR	0239400078SR
M 42 x 300	3.0	0.5 d	18.00	21.00	43.00	42.65	43.05	34.1	45.90	48.50	49.00	5.4	0142300021SR	0242300021SR
		0.75 d	28.50	31.50				44.6				8.6	0142300315SR	0242300315SR
		1 d	39.00	42.00				55.1				11.7	0142300042SR	0242300042SR
		1.5 d	60.00	63.00				76.1				18.0	0142300063SR	0242300063SR
		2 d	81.00	84.00				97.1				24.3	0142300084SR	0242300084SR
M 42	4.5	0.75 d	27.00	31.50	43.00	42.98	43.50	49.9	47.85	48.50	49.00	31.5	0142450315SR	0242450315SR
		1 d	37.50	42.00				60.4				42.0	0142450042SR	0242450042SR
		1.5 d	58.50	63.00				81.4				63.0	0142450063SR	0242450063SR
		2 d	79.50	84.00				102.4				84.0	0142450084SR	0242450084SR
M 45 x 300	3.0	0.5 d	19.50	22.50	46.00	45.65	46.05	35.6	48.90	52.00	52.50	5.8	0145300225	0245300225
		0.75 d	30.80	33.80				46.9				9.2	0145300338	0245300338
		1 d	42.00	45.00				58.1				12.6	0145300045	0245300045
		1.5 d	64.50	67.50				80.6				19.3	0145300675	0245300675
		2 d	87.00	90.00				103.1				26.1	0145300090	0245300090
M 45	4.5	0.75 d	29.50	33.80	46.00	45.98	46.50	52.7	50.50	53.10	54.00	5.8	0145450338SR	0245450338SR
		1 d	40.50	45.00				63.9				8.1	0145450045SR	0245450045SR
		1.5 d	63.00	67.50				86.9				12.6	0145450675SR	0245450675SR
		2 d	85.50	90.00				108.9				17.1	0145450090SR	0245450090SR
M 48	5.0	0.75 d	31.00	36.00	49.50	49.10	49.60	56.8	54.50	55.00	56.00	5.7	0148500036SR	0248500036SR
		1 d	43.00	48.00				68.8				7.9	0148500048SR	0248500048SR
		1.5 d	67.00	72.00				92.8				12.4	0148500072SR	0248500072SR
		2 d	91.00	96.00				116.8				16.8	0148500096SR	0248500096SR
M 52	5.0	0.75 d	34.00	39.00	53.50	53.09	53.64	59.8	58.50	58.70	59.70	6.3	0152500039SR	0252500039SR
		1 d	47.00	52.00				72.8				8.8	0152500052SR	0252500052SR
		1.5 d	73.00	78.00				98.8				13.6	0152500078SR	0252500078SR
		2 d	99.00	104.00				124.8				18.4	0152500104SR	0252500104SR
M 55	5.5	0.75 d	36.50	42.00	57.50	57.20	57.80	64.4	63.15	64.80	65.80	6.0	0156550042SR	0256550042SR
		1 d	50.50	56.00				78.4				8.3	0156550056SR	0256550056SR
		1.5 d	78.50	84.00				106.4				12.9	0156550084SR	0256550084SR
		2 d	106.50	112.00				134.4				17.5	0156550112SR	0256550112SR

AMECOIL®
THREADED/UNC INSERTS

Nominal diameter d	Pitch mm P	x d	Installed thread mm A	Nominal length mm B	Drilling tool Ø mm	Hole Ø mm		Min. drilling depth C	Tap Ø min ext.	Ext. Ø of thread free D		Number of free coils ± 1/4 N	Reference AMECOIL SR	Reference AMECOIL SR AF
						min.	max.			min.	max.			
2 - 56	0.453	1d	1.70	2.18	2.40	2.30	2.50	4.2	2.77	2.80	3.00	3.0	0110020086SR	0210020086SR
		1.5 d	2.80	3.28				5.3				5.3	0110020129SR	0210020129SR
		2 d	3.90	4.37				6.4				7.4	0110020172SR	0210020172SR
		2.5 d	5.00	5.46				7.5				9.6	0110020215SR	0210020215SR
		3 d	6.10	6.55				8.6				11.9	0110020258SR	0210020258SR
3 - 48	0.529	1 d	2.00	2.51	2.70	2.65	2.80	4.9	3.20	3.20	3.50	2.9	0110030099SR	0210030099SR
		1.5 d	3.20	3.76				6.2				5.0	0110030148SR	0210030148SR
		2 d	4.50	5.03				7.4				7.3	0110030198SR	0210030198SR
		2.5 d	5.80	6.30				8.7				9.4	0110030248SR	0210030248SR
		3 d	7.00	7.54				10.0				11.5	0110030297SR	0210030297SR
4 - 40	0.635	1 d	2.20	2.84	3.10	3.00	3.15	5.7	3.67	3.60	4.00	2.8	0110040112SR	0210040112SR
		1.5 d	3.60	4.27				7.1				4.8	0110040168SR	0210040168SR
		2 d	5.10	5.69				8.6				6.8	0110040224SR	0210040224SR
		2.5 d	6.50	7.11				10.0				8.9	0110040280SR	0210040280SR
		3 d	7.90	8.53				11.4				10.9	0110040336SR	0210040336SR
5 - 40	0.635	1 d	2.50	3.17	3.40	3.33	3.50	6.0	4.00	4.00	4.40	3.3	0110050125SR	0210050125SR
		1.5 d	4.10	4.75				7.6				5.5	0110050188SR	0210050188SR
		2 d	5.70	6.35				9.2				7.8	0110050250SR	0210050250SR
		2.5 d	7.30	7.92				10.8				10.0	0110050312SR	0210050312SR
		3 d	8.90	9.52				12.4				12.3	0110050375SR	0210050375SR
6 - 32	0.794	1 d	2.70	3.50	3.80	3.68	3.89	7.1	4.54	4.50	4.90	2.8	0110060138SR	0210060138SR
		1.5 d	4.50	5.26				8.8				4.8	0110060207SR	0210060207SR
		2 d	6.20	7.01				10.6				6.9	0110060276SR	0210060276SR
		2.5 d	8.00	8.76				12.3				8.9	0110060345SR	0210060345SR
		3 d	9.70	10.51				14.1				10.8	0110060414SR	0210060414SR
8 - 32	0.794	1 d	3.40	4.16	4.40	4.34	4.52	7.7	5.20	5.20	5.60	3.5	0110080164SR	0210080164SR
		1.5 d	5.50	6.25				9.8				6.0	0110080246SR	0210080246SR
		2 d	7.50	8.33				11.9				8.4	0110080328SR	0210080328SR
		2.5 d	9.60	10.41				14.0				10.8	0110080410SR	0210080410SR
		3 d	11.70	12.50				16.1				13.3	0110080492SR	0210080492SR
10 - 24	1.058	1 d	3.80	4.82	5.20	5.06	5.28	9.6	6.20	6.20	6.60	2.9	0110100190SR	0210100190SR
		1.5 d	6.20	7.24				12.0				5.0	0110100285SR	0210100285SR
		2 d	8.60	9.65				14.4				7.1	0110100380SR	0210100380SR
		2.5 d	11.00	12.06				16.8				9.3	0110100475SR	0210100475SR
		3 d	13.40	14.48				19.2				11.4	0110100570SR	0210100570SR
12 - 24	1.058	1 d	4.40	5.48	5.80	5.72	5.92	10.3	6.86	6.80	7.20	3.5	0110120216SR	0210120216SR
		1.5 d	7.10	8.23				13.0				6.0	0110120324SR	0210120324SR
		2 d	9.90	10.97				15.7				8.4	0110120432SR	0210120432SR
		2.5 d	12.60	13.71				18.5				10.6	0110120540SR	0210120540SR
		3 d	15.40	16.46				21.3				13.1	0110120648SR	0210120648SR
1/4 - 20	1.27	1 d	5.10	6.35	6.70	6.62	6.86	12.1	8.00	8.00	8.40	3.4	0110140250SR	0210140250SR
		1.5 d	8.20	9.52				15.2				5.8	0110140375SR	0210140375SR
		2 d	11.40	12.70				18.4				8.0	0110140500SR	0210140500SR
		2.5 d	14.60	15.87				21.6				10.4	0110140625SR	0210140625SR
		3 d	17.80	19.05				24.8				12.8	0110140750SR	0210140750SR
5/16 - 18	1.411	1 d	6.50	7.92	8.40	8.24	8.49	14.3	9.77	9.70	10.20	4.0	0115160312SR	0215160312SR
		1.5 d	10.50	11.91				18.3				6.6	0115160469SR	0215160469SR
		2 d	14.50	15.87				22.2				9.3	0115160625SR	0215160625SR
		2.5 d	18.40	19.83				26.2				11.9	0115150781SR	0215150781SR
		3 d	22.40	23.80				30.2				14.6	0115160938SR	0215160938SR
3/8 - 16	1.588	1 d	7.90	9.52	10.00	9.89	10.12	16.7	11.59	11.50	12.00	4.4	0110380375SR	0210380375SR
		1.5 d	12.70	14.27				21.4				7.3	0110380562SR	0210380562SR
		2 d	17.50	19.05				26.2				10.0	0110380750SR	0210380750SR
		2.5 d	22.20	23.80				31.0				12.9	0110380938SR	0210380938SR
		3 d	27.00	28.57				35.7				15.8	0110381125SR	0210381125SR

Nominal diameter d	Pitch mm P	x d	Installed thread mm A	Nominal length mm B	Drilling tool Ø mm	Hole Ø mm		Min. drilling depth C	Tap Ø min ext.	Ext. Ø of thread free D		Number of free coils ± 1/4 N	Reference AMECOIL SR	Reference AMECOIL SR AF
						min.	max.			min.	max.			
7/16 - 14	1.814	1 d	9.30	11.11	11.60	11.51	11.78	19.3	13.47	13.40	14.00	4.5	0117160438SR	0217160438SR
		1.5 d	14.90	16.66				24.8				7.4	0117160656SR	0217160656SR
		2 d	20.40	22.22				30.4				10.3	0117160875SR	0217160875SR
		2.5 d	26.00	27.78				35.9				13.1	0117161094SR	0217161094SR
		3 d	31.50	33.32				41.5				16.1	0117161312SR	0217161312SR
1/2 - 13	1.954	1 d	10.70	12.70	13.20	13.12	13.40	21.5	15.24	15.20	15.80	4.9	0110120500SR	0210120500SR
		1.5 d	17.10	19.05				27.8				7.9	0110120750SR	0210120750SR
		2 d	23.40	25.40				34.2				11.0	0110121000SR	0210121000SR
		2.5 d	29.80	31.75				40.5				14.1	0110121250SR	0210121250SR
		3 d	36.10	38.10				46.9				17.1	0110121500SR	0210121500SR
9/16 - 12	2.117	1 d	12.20	14.27	14.90	14.75	15.03	23.8	17.04	17.00	17.60	5.1	0119160562SR	0219160562SR
		1.5 d	19.30	21.43				31.0				8.3	0119160844SR	0219160844SR
		2 d	26.50	28.57				38.1				11.5	0119161125SR	0219161125SR
		2.5 d	33.60	35.71				45.2				14.8	0119161406SR	0219161406SR
		3 d	40.70	42.85				52.4				17.9	0119161688SR	0219161688SR
5/8 - 11	2.309	1 d	13.60	15.87	16.50	16.38	16.68	26.3	18.88	18.90	19.50	5.3	0110580625SR	0210580625SR
		1.5 d	21.50	23.80				34.2				8.5	0110580938SR	0210580938SR
		2 d	29.40	31.75				42.1				11.8	0110581250SR	0210581250SR
		2.5 d	37.40	39.67				50.1				15.0	0110581562SR	0210581562SR
		3 d	45.30	47.62				58.0				18.4	0110581875SR	0210581875SR
3/4 - 10	2.54	1 d	16.50	19.05	19.80	19.60	19.91	30.5	22.35	22.40	23.00	5.9	0110340750SR	0210340750SR
		1.5 d	26.00	28.57				40.0				9.4	0110341125SR	0210341125SR
		2 d	35.50	38.10				49.5				13.0	0110341500SR	0210341500SR
		2.5 d	45.10	47.62				59.0				16.5	0110341875SR	0210341875SR
		3 d	54.60	57.15				68.6				20.1	0110342250SR	0210342250SR
7/8 - 9	2.822	1 d	19.40	22.22	23.00	22.84	23.18	34.9	25.89	26.00	26.70	6.3	0110780875SR	0210780875SR
		1.5 d	30.50	33.32				46.0				10.0	0110781312SR	0210781312SR
		2 d	41.60	44.45				57.2				13.8	0110781750SR	0210781750SR
		2.5 d	52.70	55.55				68.3				17.5	0110782188SR	0210782188SR
		3 d	63.80	66.67				79.4				21.3	0110782625SR	0210782625SR
1" - 8	3.175	1 d	22.20	25.40	26.40	26.09	26.47	39.7	29.53	29.60	30.40	6.4	0111001000SR	0211001000SR
		1.5 d	34.90	38.10				52.4				10.1	0111001500SR	0211001500SR
		2 d	47.00	50.80				65.1				14.0	0111002000SR	0211002000SR
		2.5 d	60.30	63.50				77.8				17.8	0111002500SR	0211002500SR
		3 d	73.00	76.20				90.5				21.6	0111003000SR	0211003000SR
1" 1/8 - 7	3.629	1 d	24.90	28.57	29.50	29.36	29.74	44.9	33.29	33.40	34.40	6.1	0111181125	0211181125
		1.5 d	39.20	42.85				59.2				9.9	0111181688	0211181688
		2 d	53.20	57.15				73.5				13.6	0111182250	0211182250
		2.5 d	67.80	71.42				87.8				17.5	0111182812	0211182812
		3 d	82.00	85.72				102.0				21.3	0111183375	0211183375
1'" 1/4 - 7	3.629	1 d	28.10	31.75	32.80	32.54	32.92	48.1	36.46	36.70	37.70	7.0	0111141250SR	0211141250SR
		1.5 d	44.00	47.62				64.0				11.3	0111141875SR	0211141875SR
		2 d	59.90	63.50				79.8				15.4	0111142500SR	0211142500SR
		2.5 d	75.70	79.37				96.0				19.5	0111143125SR	0211143125SR
		3 d	91.60	95.25				111.8				23.8	0111143750SR	0211143750SR
1" 3/8 - 6	4.234	1 d	30.70	34.92	36.20	35.84	36.35	54.0	40.42	40.60	41.70	6.5	0111381375	0211381375
		1.5 d	48.20	52.37				71.4				10.5	0111382062	0211382062
		2 d	65.70	69.85				88.9				14.4	0111382750	0211382750
		2.5 d	83.00	87.30				106.0				18.4	0111383438	0211383438
		3 d	100.50	104.77				124.0				22.3	0111384125	0211384125
1" 1/2 - 6	4.234	1 d	33.90	38.10	39.50	39.02	39.53	57.2	43.62	43.90	45.00	7.3	0111121500	0211121500
		1.5 d	52.90	57.15				76.2				11.5	0111122250	0211122250
		2 d	72.00	76.20				95.3				15.9	0111123000	0211123000
		2.5 d	91.00	95.25				115.0				20.1	0111123750	0211123750
		3 d	110.00	114.30				133.0				24.5	0111124500	0211124500

AMECOIL®
THREADED/UNF INSERTS

Nominal diameter d	Pitch mm P	x d	Installed thread mm A	Nominal length mm B	Drilling tool Ø mm	Hole Ø mm		Min. drilling depth C	Tap Ø min ext.	Ext. Ø of thread free D		Number of free coils ± 1/4 N	Reference AMECOIL SR	Reference AMECOIL SR AF
						min.	max.			min.	max.			
2 - 64	0.396	1 d	1.80	2.18	2.30	2.29	2.44	4.0	2.70	2.79	3.02	3.6	0120020086SR	0220020086SR
		1.5 d	2.90	3.28				5.0				5.9	0120020129SR	0220020129SR
		2 d	4.00	4.37				6.2				8.1	0120020172SR	0220020172SR
		2.5 d	5.00	5.46				7.3				10.3	0120020215SR	0220020215SR
		3 d	6.20	6.55				8.3				12.6	0120020258SR	0220020258SR
3 - 56	0.453	1 d	2.00	2.51	2.70	2.62	2.77	4.6	3.10	3.30	3.70	3.4	0120030099SR	0220030099SR
		1.5 d	3.30	3.76				5.8				5.6	0120030148SR	0220030148SR
		2 d	4.60	5.03				7.1				8.0	0120030198SR	0220030198SR
		2.5 d	5.80	6.30				8.4				10.4	0120030248SR	0220030248SR
		3 d	7.10	7.54				9.6				12.6	0120030297SR	0220030297SR
4 - 48	0.529	1 d	2.30	2.84	3.00	2.97	3.14	5.2	3.53	3.70	4.10	3.4	0120040112SR	0220040112SR
		1.5 d	3.70	4.27				6.7				5.6	0120040168SR	0220040168SR
		2 d	5.20	5.69				8.1				7.9	0120040224SR	0220040224SR
		2.5 d	6.60	7.11				9.5				10.3	0120040280SR	0220040280SR
		3 d	8.00	8.53				10.5				12.5	0120040336SR	0220040336SR
6 - 40	0.635	1 d	2.90	3.50	3.80	3.66	3.81	6.4	4.33	4.40	4.90	3.5	0120060138SR	0220060138SR
		1.5 d	4.60	5.26				8.1				6.0	0120060207SR	0220060207SR
		2 d	6.40	7.01				9.9				8.4	0120060276SR	0220060276SR
		2.5 d	8.10	8.76				11.6				10.8	0120060345SR	0220060345SR
		3 d	9.90	10.51				13.4				13.3	0120060414SR	0220060414SR
8 - 36	0.706	1 d	3.40	4.16	4.40	4.32	4.47	7.3	5.08	5.20	5.70	3.9	0120080164SR	0220080164SR
		1.5 d	5.50	6.25				9.4				6.5	0120080246SR	0220080246SR
		2 d	7.60	8.33				11.5				9.1	0120080328SR	0220080328SR
		2.5 d	9.70	10.41				13.6				11.6	0120080410SR	0220080410SR
		3 d	11.80	12.50				15.7				14.3	0120080492SR	0220080492SR
10 - 32	0.794	1 d	4.00	4.82	5.10	5.00	5.16	8.4	5.86	6.00	6.50	4.1	0120100190SR	0220100190SR
		1.5 d	6.50	7.24				10.8				6.9	0120100285SR	0220100285SR
		2 d	8.90	9.65				13.2				9.5	0120100380SR	0220100380SR
		2.5 d	11.30	12.06				15.6				12.0	0120100475SR	0220100475SR
		3 d	13.70	14.48				18.0				14.9	0120100570SR	0220100570SR
1/4 - 28	0.907	1 d	5.50	6.35	6.70	6.55	6.72	10.4	7.53	7.80	8.30	5.0	0120140250SR	0220140250SR
		1.5 d	8.60	9.52				13.6				8.3	0120140375SR	0220140375SR
		2 d	11.80	12.70				16.8				11.4	0120140500SR	0220140500SR
		2.5 d	15.00	15.87				20.0				14.5	0120140625SR	0220140625SR
		3 d	18.10	19.05				23.2				17.6	0120140750SR	0220140750SR
5/16 - 24	1.058	1 d	6.90	7.92	8.30	8.17	8.35	12.7	9.31	9.65	10.20	5.5	0125160312SR	0225160312SR
		1.5 d	10.90	11.91				16.7				8.9	0125160469SR	0225160469SR
		2 d	14.90	15.87				20.6				12.3	0125160625SR	0225160625SR
		2.5 d	18.80	19.83				24.6				15.6	0125160781SR	0225160781SR
		3 d	22.70	23.80				28.6				19.0	0125160938SR	0225160938SR
3/8 - 24	1.058	1 d	8.40	9.52	9.90	9.75	9.93	14.3	10.90	11.40	11.90	6.9	0120380375SR	0220380375SR
		1.5 d	13.20	14.27				19.1				11.0	0120380562SR	0220380562SR
		2 d	18.00	19.05				23.8				15.0	0120380750SR	0220380750SR
		2.5 d	22.80	23.80				28.6				19.1	0120380938SR	0220380938SR
		3 d	27.50	28.57				33.3				23.1	0120381125SR	0220381125SR
7/16 - 20	1.270	1 d	9.80	11.11	11.50	11.39	11.59	16.8	12.76	13.30	13.90	6.6	0127160438SR	0227160438SR
		1.5 d	15.40	16.66				22.4				10.6	0127160656SR	0227160656SR
		2 d	20.90	22.22				27.9				14.6	0127160875SR	0227160875SR
		2.5 d	26.50	27.78				33.5				18.5	0127161094SR	0227161094SR
		3 d	32.00	33.32				39.0				22.5	0127161312SR	0227161312SR
1/2 - 20	1.270	1 d	11.40	12.70	13.10	12.97	13.16	18.4	14.35	15.10	15.70	7.9	0120120500SR	0220120500SR
		1.5 d	17.80	19.05				24.8				12.4	0120120750SR	0220120750SR
		2 d	24.10	25.40				31.1				16.9	0120121000SR	0220121000SR
		2.5 d	30.50	31.75				37.5				21.4	0120121250SR	0220121250SR
		3 d	36.80	38.10				43.8				25.9	0120121500SR	0220121500SR

Nominal diameter d	Pitch mm P	x d	Installed thread mm A	Nominal length mm B	Drilling tool Ø mm	Hole Ø mm		Min. drilling depth C	Tap Ø min ext.	Ext. Ø of thread free D		Number of free coils ± 1/4 N	Reference AMECOIL SR	Reference AMECOIL SR AF
						min.	max.			min.	max.			
9/16 - 18	1.411	1 d	12.90	14.27	14.70	14.59	14.79	20.6	16.12	16.90	17.60	8.0	0129160562SR	0229160562SR
		1.5 d	20.10	21.43				27.8				12.5	0129160844SR	0229160844SR
		2 d	27.20	28.57				34.9				17.1	0129161125SR	0229161125SR
		2.5 d	34.40	35.71				42.1				21.8	0129161406SR	0229161406SR
		3 d	41.40	42.85				49.2				26.3	0129161688SR	0229161688SR
5/8 - 18	1.411	1 d	14.50	15.87	16.30	16.18	16.38	22.2	17.71	18.60	19.30	9.0	0120580625SR	0220580625SR
		1.5 d	22.40	23.80				30.2				14.1	0120580938SR	0220580938SR
		2 d	30.40	31.75				38.1				19.3	0120581250SR	0220581250SR
		2.5 d	38.30	39.67				46.0				24.3	0120581562SR	0220581562SR
		3 d	46.20	47.62				54.0				29.4	0120581875SR	0220581875SR
3/4 - 16	1.588	1 d	17.50	19.05	19.50	19.39	19.60	26.2	21.11	22.20	22.90	9.8	0120340750SR	0220340750SR
		1.5 d	27.00	28.57				35.7				15.1	0120341125SR	0220341125SR
		2 d	36.50	38.10				45.2				20.6	0120341500SR	0220341500SR
		2.5 d	46.00	47.62				54.8				26.0	0120341875SR	0220341875SR
		3 d	55.60	57.15				64.3				31.5	0120342250SR	0220342250SR
7/8 - 14	1.814	1 d	20.40	22.22	22.70	22.62	22.84	30.4	24.58	26.00	26.70	9.9	0120780875SR	0220780875SR
		1.5 d	31.50	33.32				41.5				15.5	0120781312SR	0220781312SR
		2 d	42.70	44.45				52.6				21.1	0120781750SR	0220781750SR
		2.5 d	53.80	55.55				63.7				26.6	0120782188SR	0220782188SR
		3 d	64.80	66.67				74.8				32.3	0120782625SR	0220782625SR
1" - 14	1.814	1 d	23.60	25.40	26.00	25.86	26.11	33.6	27.76	84.40	29.40	11.7	0121041000	0221041000
		1.5 d	36.30	38.10				46.3				18.0	0121041500	0221041500
		2 d	49.00	50.80				59.0				24.2	0121042000	0221042000
		2.5 d	61.70	63.50				71.7				30.5	0121042500	0221042500
		3 d	74.40	76.20				84.4				36.8	0121043000	0221043000
1" - 12	2.117	1 d	23.30	25.40	26.00	25.86	26.11	34.9	28.15	29.70	30.40	9.6	0121001000SR	0221001000SR
		1.5 d	36.00	38.10				47.6				15.0	0121001500SR	0221001500SR
		2 d	48.70	50.80				60.3				20.5	0121002000SR	0221002000SR
		2.5 d	61.40	63.50				73.0				26.0	0121002500SR	0221002500SR
		3 d	74.00	76.20				85.7				31.5	0121003000SR	0221003000SR
1" 1/8 - 12	2.117	1 d	26.50	28.57	29.20	29.03	29.29	38.1	31.33	33.10	33.90	11.1	0121181125SR	0221181125SR
		1.5 d	40.70	42.85				52.4				17.3	0121181688SR	0221181688SR
		2 d	55.00	57.15				66.7				23.4	0121182250SR	0221182250SR
		2.5 d	69.30	71.42				81.0				29.5	0121182812SR	0221182812SR
		3 d	83.60	85.72				95.3				35.8	0121183375SR	0221183375SR
1" 1/4 - 12	2.117	1 d	29.70	31.75	32.40	32.21	32.46	41.3	34.50	36.60	37.30	12.5	0121141250SR	0221141250SR
		1.5 d	45.50	47.62				57.2				19.4	0121141875SR	0221141875SR
		2 d	61.40	63.50				73.0				26.3	0121142500SR	0221142500SR
		2.5 d	77.20	79.37				88.9				33.0	0121143125SR	0221143125SR
		3 d	93.10	95.25				104.8				39.9	0121143750SR	0221143750SR
1" 3/8 - 12	2.117	1 d	32.80	34.92	35.50	35.38	35.63	13.8	37.68	40.00	40.90	13.8	0121381375	0221381375
		1.5 d	50.30	52.37				21.3				21.4	0121382062	0221382062
		2 d	67.80	69.85				28.9				28.9	0121382750	0221382750
		2.5 d	85.20	87.30				36.5				36.5	0121383438	0221383438
		3 d	102.60	104.77				44.0				44.0	0121384125	0221384125
1" 1/2 - 12	2.117	1 d	36.00	38.10	38.70	38.56	38.81	47.6	40.85	43.40	44.30	15.3	0121121500	0221121500
		1.5 d	55.10	57.15				66.7				23.5	0121152250	0221152250
		2 d	74.10	76.20				85.7				31.6	0121123000	0221123000
		2.5 d	93.10	95.25				104.8				39.9	0121123750	0221123750
		3 d	112.20	114.30				123.8				48.1	0121124500	0221124500

AMECOIL®
WIRE THREAD INSERTS/8UN

The tapping for AMECOIL® 8UN family inserts is done using STANDARD taps 1/8" larger than the Wire Thread Insert size to be installed

Nominal diameter d	Pitch P	x d	Installed thread mm A	Nominal length mm B	Drilling tool Ø mm	Hole Ø mm		Min. drilling depth C	Standard tap	Tap Ø max ext.	Min. tapping length mm	Ext. Ø of thread free D		Number of free coils ± 1/4 N	Reference AMECOIL	Reference AMECOIL AF
						min.	max.					min.	max.			
1" 1/8	8UN	1 d	25.40	28.58	28.80	28.70	29.34	46.06	1" 1/4 - 8UN	32.03	31.88	32.10	32.90	7.4	0161181125	0261181125
		1.5 d	39.70	42.87				60.35			46.17			11.6	0161181688	0261181688
		2 d	54.00	57.17				74.65			60.47			15.8	0161182250	0261182250
1" 1/4	8UN	1 d	28.57	31.75	32.00	31.87	32.51	49.30	1" 3/8 - 8UN	35.20	35.05	35.30	36.30	8.3	0161141250	0261141250
		1.5 d	44.44	47.62				65.00			50.80			13.0	0161141875	0261141875
		2 d	60.32	63.50				81.00			66.80			17.6	0161142500	0261142500
1" 3/8	8UN	1 d	31.75	34.93	35.10	35.05	35.69	52.41	1" 1/2 - 8UN	38.38	38.23	38.60	39.80	9.3	0161381875	0261381875
		1.5 d	49.21	52.39				69.87			55.69			14.4	0161382062	0261382062
		2 d	66.98	69.85				87.33			73.15			19.5	0161382750	0261382750
1" 1/2	8UN	1 d	34.93	38.10	38.30	38.22	38.86	55.63	1" 5/8 - 8UN	41.55	41.40	41.90	43.00	10.2	0161121500	0261121500
		1.5 d	5.98	57.15				74.68			60.45			15.8	0161122250	0261122250
		2 d	73.03	76.20				93.73			79.50			21.4	0161123000	0261123000
1" 5/8	8UN	1 d	38.10	41.28	41.50	41.40	42.04	58.76	1" 3/4 - 8UN	44.73	44.58	47.30	48.30	10.7	0161581625	0261581625
		1.5 d	58.74	61.91				79.39			65.21			16.5	0161582438	0261582438
		2 d	79.38	82.55				100.03			85.85			22.3	0161583250	0261583250
1" 3/4	8UN	1 d	41.28	44.45	44.70	44.57	45.21	61.98	1" 7/8 - 8UN	47.90	47.75	50.60	51.80	11.6	0161341750	0261341750
		1.5 d	63.50	66.68				84.07			69.85			17.9	0161342625	0261342625
		2 d	85.73	88.90				106.43			92.20			24.1	0161343500	0261343500
1" 7/8	8UN	1 d	44.45	47.63	48.00	47.75	48.39	65.11	2" - 8UN	51.08	50.93	54.00	54.90	12.6	0161781875	0261781875
		1.5 d	68.26	71.44				88.92			74.74			19.4	0161782812	0261782812
		2 d	92.08	95.25				112.73			98.55			26.1	0161783750	0261783750
2"	8UN	1 d	47.63	50.80	51.00	50.92	51.56	68.33	2" 1/8 - 8UN	54.25	54.10	56.90	57.80	13.7	0162002000	0262002000
		1.5 d	73.03	76.20				93.73			79.50			21.0	0162003000	0262003000
		2 d	98.43	101.60				119.13			104.90			28.3	0162004000	0262004000
2" 1/4	8UN	1 d	53.98	57.15	57.40	57.27	57.91	74.68	2" 3/8 - 8UN	60.33	60.45	64.30	65.20	15.4	0162142250	0262142250
		1.5 d	82.56	85.73				103.15			89.00			23.5	0162143375	0262143375
		2 d	111.13	114.30				131.83			117.60			31.7	0162144500	0262144500
2" 1/2	8UN	1 d	60.33	63.50	63.70	63.62	64.26	81.03	2" 5/8 - 8UN	66.68	66.80	71.20	72.10	17.2	0162122500	0262122500
		1.5 d	92.08	95.25				112.78			98.55			26.3	0162123750	0262123750
		2 d	123.83	127.00				144.53			130.30			35.4	0162125000	0262125000
2" 3/4	8UN	1 d	66.68	69.85	71.10	69.97	70.61	87.38	2" 7/8 - 8UN	73.03	73.15	78.10	79.00	19.1	0162342750	0262342750
		1.5 d	101.61	104.78				122.17			108.10			29.1	0162344125	0262344125
		2 d	136.53	139.70				157.23			143.00			39.1	0162345500	0262345500
3"	8UN	1 d	73.03	76.20	76.50	76.32	76.96	93.73	3" 1/8 - 8UN	79.38	79.50	84.90	85.80	20.9	0163003000	0263003000
		1.5 d	111.13	114.30				117.60			117.60			31.8	0163004500	0263004500
		2 d	149.23	152.40				155.70			155.70			42.8	0163006000	0263006000

AMECOIL®
THREADED/BSP INSERTS

Nominal diameter d	Pitch mm P	x d	Installed thread mm A	Nominal length mm B	Drilling tool Ø mm	Hole Ø mm		Min. drilling depth C	Tap Ø min ext.	Ext. Ø of thread free D		Number of free coils ± 1/4 N	Reference AMECOIL	Reference AMECOIL AF
						min.	max.			min.	max.			
1/8 - 28	0.907	1 d	2.30	3.20	10.00	9.91	10.16	7.3	10.82	11.50	12.00	2.2	0140180125	0240180125
		1.5 d	3.80	4.80				8.9				3.6	0140180187	0240180187
		2 d	5.40	6.40				10.5				5.1	0140180250	0240180250
		2.5 d	7.00	7.90				12.0				6.7	0140180312	0240180312
		3 d	8.60	9.50				13.7				8.2	0140180375	0240180375
1/4 - 19	1.337	1 d	8.20	6.40	13.60	13.46	13.72	12.4	14.74	15.70	16.20	3.3	0140140250	0240140250
		1.5 d	12.90	9.50				15.6				5.5	0140140375	0240140375
		2 d	17.70	12.70				18.7				7.6	0140140500	0240140500
		2.5 d	22.50	15.90				21.9				9.7	0140140625	0240140625
		3 d	27.20	19.10				25.1				11.8	0140140750	0240140750
3/8 - 19	1.337	1 d	8.20	9.50	17.20	17.02	17.27	15.6	18.25	19.50	20.00	5.4	0140380375	0240380375
		1.5 d	12.90	14.30				20.3				8.5	0140380562	0240380562
		2 d	17.70	19.10				25.1				11.6	0140380750	0240380750
		2.5 d	22.50	23.80				29.8				14.8	0140380937	0240380937
		3 d	27.20	28.60				34.6				17.9	0140381125	0240381125
1/2 - 14	1.814	1 d	10.90	12.70	21.50	21.34	21.59	20.8	23.09	24.60	25.20	5.3	0140120500	0240120500
		1.5 d	17.30	19.10				27.2				8.5	0140120750	0240120750
		2 d	23.60	25.40				33.5				11.5	0140121000	0240121000
		2.5 d	30.00	31.80				39.9				14.6	0140121250	0240121250
		3 d	36.30	38.10				46.3				17.7	0140121500	0240121500
5/8 - 14	1.814	1 d	14.10	15.90	23.50	23.24	23.55	24.0	25.05	26.70	27.40	6.8	0140580625	0240580625
		1.5 d	22.00	23.80				31.9				10.7	0140580937	0240580937
		2 d	30.00	31.80				39.9				14.5	0140581250	0240581250
		2.5 d	37.90	39.70				47.8				18.4	0140581562	0240581562
		3 d	45.80	47.60				55.7				22.2	0140581875	0240581875
3/4 - 14	1.814	1 d	17.30	19.10	27.00	26.75	27.08	27.2	28.59	30.50	31.20	8.5	0140340750	0240340750
		1.5 d	26.80	28.60				36.7				13.2	0140341125	0240341125
		2 d	36.30	38.10				46.2				17.9	0140341500	0240341500
		2.5 d	45.80	47.60				55.8				22.5	0140341875	0240341875
		3 d	55.30	57.20				65.3				27.2	0140342250	0240342250
7/8 - 14	1.814	1 d	20.40	22.20	30.70	30.48	30.81	30.4	32.35	34.60	35.30	10.0	0140780875	0240780875
		1.5 d	31.50	33.30				41.5				15.5	0140781312	0240781312
		2 d	42.70	44.50				52.6				20.9	0140781750	0240781750
		2.5 d	53.70	55.50				63.4				26.4	0140782187	0240782187
		3 d	64.90	66.70				74.8				31.9	0140782625	0240782625
1" - 11	2.309	1 d	23.10	25.40	33.70	33.53	33.91	35.8	35.96	38.40	39.20	8.9	0141001000	0241001000
		1.5 d	35.80	38.10				48.5				13.7	0141001500	0241001500
		2 d	48.50	50.80				61.3				18.6	0141002000	0241002000
		2.5 d	61.20	63.50				73.9				23.5	0141002500	0241002500
		3 d	73.90	76.20				86.6				28.4	0141003000	0241003000
1" 1/4 - 11	2.309	1 d	29.40	31.80	42.50	42.29	42.67	42.2	44.63	47.70	48.50	11.4	0141141250	0241141250
		1.5 d	45.30	47.60				58.0				17.6	0141141875	0241141875
		2 d	61.20	63.50				73.9				23.7	0141142500	0241142500
		2.5 d	77.10	79.40				89.9				29.9	0141143125	0241143125
		3 d	92.90	95.20				105.7				36.1	0141143750	0241143750
1" 1/2 - 11	2.309	1 d	35.80	38.10	48.50	48.41	48.79	48.5	50.53	54.10	54.90	13.9	0141121500	0241121500
		1.5 d	54.80	57.20				67.6				21.3	0141122250	0241122250
		2 d	73.90	76.20				86.7				28.8	0141123000	0241123000
		2.5 d	92.90	95.20				105.7				36.2	0141123750	0241123750
		3 d	112.00	114.20				124.7				43.6	0141124500	0241124500

AMECOIL®
THREADED/BSF INSERTS

Nominal diameter d	Pitch mm P	x d	Installed thread mm A	Nominal length mm B	Drilling tool Ø mm	Hole Ø mm min.	Hole Ø mm max.	Min. drilling depth C	Tap Ø min ext.	Ext. Ø of thread free D min.	Ext. Ø of thread free D max.	Number of free coils ± 1/4 N	Reference AMECOIL	Reference AMECOIL AF
1/4 - 26	0.977	1 d	5.40	6.40	6.70	6.53	6.71	10.7	7.51	7.90	8.40	4.6	0150140250	0250140250
		1.5 d	8.60	9.50				13.9				7.2	0150140375	0250140375
		2 d	11.70	12.70				17.1				9.9	0150140500	0250140500
		2.5 d	14.90	15.90				20.3				12.6	0150140625	0250140625
		3 d	18.10	19.10				23.5				15.3	0150140750	0250140750
5/16 - 22	1.155	1 d	6.80	7.90	8.30	8.20	8.38	13.1	9.30	9.80	10.30	4.9	0155160312	0255160312
		1.5 d	10.80	11.90				17.1				7.8	0155160469	0255160469
		2 d	14.70	15.90				21.1				10.7	0155160625	0255160625
		2.5 d	18.70	19.80				25.0				13.6	0155160781	0255160781
		3 d	22.70	23.80				29.0				16.5	0155160938	0255160938
3/8 - 20	1.270	1 d	8.30	9.50	9.90	9.78	9.96	15.2	11.02	11.60	12.10	5.5	0150380375	0250380375
		1.5 d	13.00	14.30				20.0				8.7	0150380562	0250380562
		2 d	17.80	19.10				24.8				11.9	0150380750	0250380750
		2.5 d	22.50	23.80				29.5				15.1	0150380937	0250380937
		3 d	27.30	28.60				34.3				18.3	0150381125	0250381125
7/16 - 18	1.411	1 d	9.70	11.10	11.50	11.43	11.63	17.5	12.78	13.60	14.10	5.9	0157160438	0257160438
		1.5 d	15.20	16.70				23.0				9.2	0157160656	0257160656
		2 d	20.80	22.20				28.6				12.6	0157160875	0257160875
		2.5 d	26.30	27.80				34.1				15.9	0157161093	0257161093
		3 d	31.90	33.30				39.7				19.3	0157161312	0257161312
1/2 - 16	1.588	1 d	11.10	12.70	13.20	13.03	13.26	19.8	14.57	15.50	16.00	6.0	0150120500	0250120500
		1.5 d	17.50	19.10				26.2				9.4	0150120750	0250120750
		2 d	23.80	25.40				32.5				12.9	0150121000	0250121000
		2.5 d	30.20	31.80				38.9				16.3	0150121250	0250121250
		3 d	36.50	38.10				45.3				19.7	0150121500	0250121500
9/16 - 16	1.588	1 d	12.70	14.30	14.70	14.66	14.88	21.4	16.16	17.20	17.80	6.9	0159160562	0259160562
		1.5 d	19.90	21.50				28.6				10.7	0159160844	0259160844
		2 d	27.00	28.60				35.7				14.6	0159161125	0259161125
		2.5 d	34.10	35.70				42.9				18.5	0159161406	0259161406
		3 d	41.30	42.90				50.0				22.4	0159161687	0259161687
5/8 - 14	1.814	1 d	14.10	15.90	16.40	16.26	16.49	24.0	18.01	19.10	19.70	6.7	0150580625	0250580625
		1.5 d	22.00	23.80				32.0				10.5	0150580937	0250580937
		2 d	30.00	31.80				39.9				14.3	0150581250	0250581250
		2.5 d	37.90	39.70				47.8				18.1	0150581562	0250581562
		3 d	45.80	47.60				55.8				21.9	0150581875	0250581875
3/4 - 12	2.117	1 d	16.90	19.10	19.50	19.43	19.69	28.6	21.53	22.90	23.50	7.0	0150340750	0250340750
		1.5 d	26.50	28.60				38.1				10.9	0150341125	0250341125
		2 d	36.00	38.10				47.6				14.8	0150341500	0250341500
		2.5 d	45.50	47.60				57.2				18.7	0150341875	0250341875
		3 d	55.10	57.20				66.7				22.6	0150342250	0250342250
7/8 - 11	2.309	1 d	18.70	22.20	22.70	22.61	22.86	32.6	24.94	26.50	27.30	7.5	0150780875	0250780875
		1.5 d	30.80	33.30				43.7				11.7	0150781312	0250781312
		2 d	40.90	44.50				54.8				15.8	0150781750	0250781750
		2.5 d	52.00	55.60				65.9				20.0	0150782187	0250782187
		3 d	61.40	66.70				70.1				24.2	0150782625	0250782625
1" - 10	2.540	1 d	22.90	25.40	26.50	26.19	26.52	36.8	28.38	30.20	31.00	7.9	0151001000	0251001000
		1.5 d	35.60	38.10				49.5				12.2	0151001500	0251001500
		2 d	48.30	50.80				62.2				16.6	0151002000	0251002000
		2.5 d	61.00	63.50				74.9				21.0	0151002500	0251002500
		3 d	73.70	76.20				87.6				25.4	0151003000	0251003000

Nominal diameter d	Pitch mm P	x d	Installed thread mm A	Nominal length mm B	Drilling tool Ø mm	Hole Ø mm		Min. drilling depth C	Tap Ø min ext.	Ext. Ø of thread free D		Number of free coils ± 1/4 N	Reference AMECOIL	Reference AMECOIL AF
						min.	max.			min.	max.			
1″ 1/8 - 9	2.822	1 d	25.80	28.60	29.50	29.36	29.72	41.3	31.88	33.90	34.70	8.0	0151181125	0251181125
		1.5 d	40.00	42.90				55.6				12.4	0151181687	0251181687
		2 d	54.30	57.20				69.9				16.9	0151182250	0251182250
		2.5 d	68.60	71.40				84.1				21.3	0151182812	0251182812
		3 d	82.90	85.70				98.5				25.8	0151183375	0251183375
1″ 1/4 - 9	2.822	1 d	28.90	31.80	32.70	32.54	32.89	44.5	35.06	37.30	38.10	9.0	0151141250	0251141250
		1.5 d	44.80	47.60				60.3				14.0	0151141875	0251141875
		2 d	60.70	63.50				76.2				19.0	0151142500	0251142500
		2.5 d	76.60	79.40				92.1				23.9	0151143125	0251143125
		3 d	92.40	95.30				108.0				28.9	0151143750	0251143750
1″ 3/8 - 8	3.175	1 d	31.70	34.90	36.00	35.71	36.07	49.2	38.64	41.20	42.10	8.8	0151381375	0251381375
		1.5 d	49.20	52.40				66.7				13.9	0151382062	0251382062
		2 d	66.70	69.90				84.1				18.9	0151382750	0251382750
		2.5 d	84.10	87.30				101.6				23.9	0151383437	0251383437
		3 d	101.60	104.80				119.0				28.8	0151384125	0251384125

AMECOIL®
THREADED/BSW INSERTS

Nominal diameter d	Pitch mm P	x d	Installed thread mm A	Nominal length mm B	Drilling tool Ø mm	Hole Ø mm		Min. drilling depth C	Tap Ø min ext.	Ext. Ø of thread free D		Number of free coils ± 1/4 N	Reference AMECOIL	Reference AMECOIL AF
						min.	max.			min.	max.			
1/8 - 40	0.635	1 d	2.50	3.20	3.40	3.28	3.43	6.0	3.93	4.00	4.40	2.2	0130180125	0230180125
		1.5 d	4.10	4.80				7.6				3.6	0130180187	0230180187
		2 d	5.70	6.30				9.2				5.1	0130180250	0230180250
		2.5 d	7.30	7.90				10.8				6.7	0130180312	0230180312
		3 d	8.90	9.50				12.4				8.2	0130180375	0230180375
3/16 - 24	1.058	1 d	3.70	4.80	5.10	4.98	5.13	9.5	6.01	6.10	6.50	3.3	0133160187	0233160187
		1.5 d	6.10	7.10				11.9				5.4	0133160281	0233160281
		2 d	8.50	9.50				14.3				7.5	0133160375	0233160375
		2.5 d	10.90	11.90				16.7				9.6	0133160468	0233160468
		3 d	13.20	14.30				19.1				11.7	0133160562	0233160562
1/4 - 20	1.27	1 d	5.10	6.40	6.70	6.63	6.78	12.1	7.84	7.90	8.40	5.4	0130140250	0230140250
		1.5 d	8.20	9.50				15.2				8.5	0130140375	0230140375
		2 d	11.40	12.70				18.4				11.6	0130140500	0230140500
		2.5 d	14.60	15.90				21.6				14.8	0130140625	0230140625
		3 d	17.80	19.10				24.8				17.9	0130140750	0230140750
5/16 - 18	1.411	1 d	6.50	7.90	8.40	8.33	8.48	14.3	9.59	9.70	10.20	5.3	0135160312	0235160312
		1.5 d	10.50	11.90				18.3				8.4	0135160469	0235160469
		2 d	14.50	15.90				22.2				11.4	0135160625	0235160625
		2.5 d	18.40	19.80				26.2				14.5	0135160781	0235160781
		3 d	22.40	23.80				30.1				17.6	0135160937	0235160937
3/8 - 16	1.588	1 d	7.90	9.50	10.00	9.91	10.11	16.7	11.39	11.50	12.00	6.8	0130380375	0230380375
		1.5 d	12.70	14.30				21.4				10.7	0103805625	0210380562
		2 d	17.50	19.10				26.2				14.5	0130380750	0230380750
		2.5 d	22.20	23.80				31.0				18.4	0130380937	0230380937
		3 d	27.00	28.60				35.7				22.2	0130381125	0230381125
7/16 - 14	1.814	1 d	9.30	11.10	11.60	11.51	11.76	19.3	13.24	13.50	14.00	8.4	0137160437	0237160437
		1.5 d	14.90	16.70				24.8				13.1	0137160656	0237160656
		2 d	20.40	22.20				30.4				17.7	0137160875	0237160875
		2.5 d	26.00	27.80				35.9				22.4	0137161093	0237161093
		3 d	31.50	33.30				41.5				27.0	0137161312	0237161312
1/2 - 12	2.117	1 d	10.60	12.70	13.20	13.08	13.34	22.2	15.17	15.40	16.00	10.0	0130120500	0230120500
		1.5 d	17.00	19.10				28.6				15.5	0130120750	0230120750
		2 d	23.30	25.40				34.9				20.9	0130121000	0230121000
		2.5 d	29.70	31.80				41.3				26.4	0130121250	0230121250
		3 d	36.00	38.10				47.6				31.9	0130121500	0230121500
9/16 - 12	2.117	1 d	12.20	14.30	14.80	14.68	14.94	23.8	16.76	17.00	17.60	8.9	0139160562	0239160562
		1.5 d	19.30	21.50				31.0				13.7	0139160844	0239160844
		2 d	26.50	28.60				38.1				18.6	0139161125	0239161125
		2.5 d	33.60	35.70				45.2				23.5	0139161406	0239161406
		3 d	40.80	42.90				52.4				28.4	0139161687	0239161687
5/8 - 11	2.309	1 d	13.60	15.90	16.70	16.59	16.84	26.3	18.57	18.90	19.50	11.4	0130580625	0230580625
		1.5 d	21.50	23.80				34.2				17.6	0130580937	0230580937
		2 d	29.40	31.80				42.1				23.7	0130581250	0230581250
		2.5 d	37.40	39.70				50.1				29.9	0130581562	0230581562
		3 d	45.30	47.60				58.0				36.1	0130581875	0230581875
11/16 - 11	2.309	1 d	15.20	17.50	18.30	18.21	18.47	27.9	20.16	20.50	21.10	13.9	0131160687	0231160687
		1.5 d	23.90	26.20				36.6				21.3	0131161031	0231161031
		2 d	32.60	34.90				45.3				28.8	0131161375	0231161375
		2.5 d	41.30	43.60				54.0				36.2	0131161718	0231161718
		3 d	50.00	52.40				62.8				43.6	0131162062	0231162062

Nominal diameter d	Pitch mm P	x d	Installed thread mm A	Nominal length mm B	Drilling tool Ø mm	Hole Ø mm		Min. drilling depth C	Tap Ø min ext.	Ext. Ø of thread free D		Number of free coils ± 1/4 N	Reference AMECOIL	Reference AMECOIL AF
						min.	max.			min.	max.			
3/4 - 10	2.54	1 d	16.50	16.10	20.00	19.84	20.09	30.5	22.02	22.40	23.00	5.9	0130340750	0230340750
		1.5 d	26.00	28.60				40.0				9.3	0130341125	0230341125
		2 d	35.50	38.10				49.5				12.7	0130341500	0230341500
		2.5 d	45.10	47.60				59.0				16.1	0130341875	0230341875
		3 d	54.60	57.20				68.6				19.5	0130342250	0230342250
7/8 - 9	2.822	1 d	19.40	22.20	23.00	23.01	23.27	34.9	25.52	26.00	26.70	6.2	0130780875	0230780875
		1.5 d	30.50	33.30				46.0				9.8	0130781231	0230781231
		2 d	41.60	44.50				57.2				13.3	0130781750	0230781750
		2.5 d	52.70	55.50				68.3				16.9	0130782187	0230782187
		3 d	63.90	66.70				79.4				20.5	0130782625	0230782625
1" - 8	3.175	1 d	22.20	25.40	26.50	26.19	26.52	39.7	29.10	27.70	30.40	6.3	0131001000	0231001000
		1.5 d	34.90	38.10				52.4				10.0	0131001500	0231001500
		2 d	47.60	50.80				65.1				13.6	0131002000	0231002000
		2.5 d	60.30	63.50				77.8				17.2	0131002500	0231002500
		3 d	73.00	76.20				90.5				20.8	0131003000	0231003000
1" 1/8 - 7	3.629	1 d	24.90	28.60	30.00	29.74	30.12	44.9	32.80	33.50	34.40	6.4	0131181125	0231181125
		1.5 d	39.20	42.90				59.2				10.1	0131181687	0231181687
		2 d	53.50	57.20				73.5				13.9	0131182250	0231182250
		2.5 d	67.80	71.40				87.8				17.6	0131182812	0231182812
		3 d	56.70	85.70				102.0				21.5	0131183375	0231183375
1" 1/4 - 7	3.629	1 d	28.10	31.80	33.00	32.92	33.30	48.1	35.97	36.70	37.70	7.3	0131141250	0231141250
		1.5 d	4.00	47.60				64.0				11.4	0131141875	0231141875
		2 d	59.90	63.50				79.8				15.6	0131142500	0231142500
		2.5 d	75.80	79.40				95.7				19.8	0131143125	0231143125
		3 d	91.60	95.20				111.6				24.0	0131143750	0231143750
1" 1/2 - 6	4.234	1 d	33.90	38.10	39.70	39.27	39.90	57.2	43.02	43.90	45.10	7.4	0131121500	0231121500
		1.5 d	52.90	57.20				76.2				11.8	0131122250	0231122250
		2 d	72.00	76.20				95.3				16.1	0131123000	0231123000
		2.5 d	91.00	95.20				114.3				20.4	0131123750	0231123750
		3 d	100.00	114.30				133.3				24.7	0131124500	0231124500

AMECOIL® STRIP FEED

APPLICATIONS

AMECOIL Wire Thread Insert packaging on Strip Feed is suitable for the repeated installation of many inserts.

Installation is recommended with fixed installation units or an electric or pneumatic installation tool (page 56 and 61).

ADVANTAGES

- Reduced labor costs with improved installation efficiency
- Eliminates the risk of mixing threads
- Improves working conditions

REFERENCES

Article code prefix:

51 - Stainless Steel 302/304 Strip Feed

52 - Stainless steel 302/304 Screw locking Strip Feed

50 - Stainless Steel 316 Strip Feed

29 - Stainless Steel 316 Screw locking Strip Feed

53 - Bronze Strip Feed

54 - Bronze Screw locking Strip Feed

▶ Other materials and coatings on request.

Metric

Nominal diameter d	Pitch mm P	x d	Nominal length mm B	Number of Wire Thread Inserts	Reference	
					AMECOIL SR	AMECOIL SR AF
M 2.5	0.45	1 d	2.50	5000	5125045025SR	5225045025SR
		1.5 d	3.75	4000	5125045375SR	5225045375SR
		2 d	5.00	3000	5125045005SR	5225045005SR
M 3	0.5	1 d	3.00	4000	5103050003SR	5203050003SR
		1.5 d	4.50	2800	5103050045SR	5203050045SR
		2 d	6.00	2200	5103050006SR	5203050006SR
M 4	0.7	1 d	4.00	2200	5104070004SR	5204070004SR
		1.5 d	6.00	1500	5104070006SR	5204070006SR
		2 d	8.00	1300	5104070008SR	5204070008SR
M 5	0.8	1 d	5.00	1500	5105080005SR	5205080005SR
		1.5 d	7.50	1000	5105080075SR	5205080075SR
		2 d	10.00	800	5105080010SR	5205080010SR
M 6	1.0	1 d	6.00	1000	5106100006SR	5206100006SR
		1.5 d	9.00	750	5106100009SR	5206100009SR
		2 d	12.00	500	5106100012SR	5206100012SR

Metric (continued)

Nominal diameter d	Pitch mm P	x d	Nominal length mm B	Number of Wire Thread Inserts	Reference	
					AMECOIL SR	AMECOIL SR AF
M 7	1.0	1 d	7.00	800	5107100007SR	5207100007SR
		1.5 d	10.50	600	5107100105SR	5207100105SR
		2 d	14.00	400	5107100014SR	5207100014SR
M 8 x 100	1.0	1 d	8.00	650	5108100008SR	5208100008SR
		1.5 d	12.00	400	5108100012SR	5208100012SR
		2 d	16.00	300	5108100016SR	5208100016SR
M 8	1.25	1 d	8.00	650	5108125008SR	5208125008SR
		1.5 d	12.00	400	5108125012SR	5208125012SR
		2 d	16.00	300	5108125016SR	5208125016SR
M 10 x 100	1.0	1 d	10.00	400	5110100010SR	5210100010SR
		1.5 d	15.00	250	5110100015SR	5210100015SR
		2 d	20.00	200	5110100020SR	5210100020SR
M 10 x 125	1.25	1 d	10.00	400	5110125010SR	5210125010SR
		1.5 d	15.00	250	5110125015SR	5210125015SR
		2 d	20.00	200	5110125020SR	5210125020SR
M 10	1.5	1 d	10.00	400	5110150010SR	5210150010SR
		1.5 d	15.00	250	5110150015SR	5210150015SR
		2 d	20.00	200	5110150020SR	5210150020SR

▶ On request for sizes M12 to M16.

UNC

Nominal diameter d	Pitch mm P	x d	Nominal length mm B	Number of Wire Thread Inserts	Reference	
					AMECOIL SR	AMECOIL SR AF
4 - 40	0.635	1 d	2.84	3 000	5110040112SR	5210040112SR
		1.5 d	4.27	2 500	5110040168SR	5210040168SR
		2 d	5.69	2 000	5110040224SR	5210040224SR
6 - 32	0.794	1 d	3.50	2 000	5110060138SR	5210060138SR
		1.5 d	5.26	1500	5110060207SR	5210060207SR
		2 d	7.01	1500	5110060276SR	5210060276SR
8 - 32	0.794	1 d	4.16	2 000	5110080164SR	5210080164SR
		1.5 d	6.25	1500	5110080246SR	5210080246SR
		2 d	8.33	1300	5110080328SR	5210080328SR

▶ Other dimensions on request.

UNF

Nominal diameter d	Pitch mm P	x d	Nominal length mm B	Number of Wire Thread Inserts	Reference	
					AMECOIL SR	AMECOIL SR AF
10 - 32	0.794	1 d	4.82	1500	5120100190SR	5220100190SR
		1.5 d	7.24	1000	5120100285SR	5220100285SR
		2 d	9.65	800	5120100380SR	5220100380SR
1/4 - 28	0.907	1 d	6.35	1000	5120140250SR	5220140250SR
		1.5 d	9.52	750	5120140375SR	5220140375SR
		2 d	12.70	500	5120140500SR	5220140500SR

▶ Other dimensions on request.

▶ On request for BSW, BSP and BSF pitches.

AMELOCK - SCREW LOCKING NUT

The AMELOCK is a hexagonal metal safety nut that locks thanks to the deformed part of a screw locking AMECOIL AF® stainless steel Wire Thread Insert which is placed in the nut.

APPLICATIONS

It is suitable for maintenance operations requiring speed while maintaining the advantages of a safety nut.

ADVANTAGES

- No need for pins, locknuts, or washers
- Lock retention guaranteed for 15 assembly/disassembly operations
- High resistance to vibration
- Resistance to high temperatures, up to 1112°F (600°C) depending on the model
- The symmetry of the Wire Thread Insert does not affect the direction of installation

REFERENCES

Nominal diameter d	Pitch mm P	Overall dimensions		Reference	
		On flats mm	Height mm	STEEL Z nut	Stainless steel nut
M 5	0.80	8	5	3300805080	3330305080
M 6	1.00	10	6	3300806100	3330306100
M 8	1.25	13	8	3300808125	3330308125
M 10	1.50	16	10	3300810150	3330310150
M 12	1.75	18	12	3300812175	3330312175
M 14	2.00	21	14	3300814200	3330314200
M 16	2.00	24	16	3300816200	3330316200

▶ Other dimensions, materials, and coatings on request.

TWININSERT

APPLICATIONS

Using a TWININSERT assembly, consisting of two Wire Thread Inserts mounted one after the other, makes it possible to keep using the desired/original screw.

ADVANTAGES

- Repairing a threaded hole while maintaining the original dimensions of the screw

REFERENCES

Metric

Nominal diameter d	Pitch mm P	Tap Ø max	Wire Thread INSERTS #1 (Exterior)				Wire Thread INSERTS #2 (Interior)				Twininsert tool #1 Reference
			Length x1.5 d		Length x2 d		Length x1.5 d		Length x2 d		
			Nominal length mm B	Reference	Nominal length mm B	Reference	Reference	AF part number	Reference	AF part number	
M 2.5	0.45	3.6	3.75	7725045375	5.00	7725045005	7725045034	7925045034	7725045046	1925045046	05725045
M 3	0.5	4.3	4.50	7703050045	6.00	7703050006	7703050004	7903050004	7703050055	7903050055	05703050
M 3.5	0.6	5.0	5.25	7735060525	7.00	7735060007	7735060047	7935060047	7735060064	7935060064	05735060
M 4	0.7	5.8	6.00	7704070006	8.00	7704070008	77040070053	7940070053	7704070073	7904070073	05704070
M 5	0.8	7.1	7.50	7705080075	10.00	7705080010	7705080067	7905080067	7705080092	7905080092	05705080
M 6	1.0	8.6	9.00	7706100009	12.00	7706100012	7706100008	7906100008	7706100011	7906100011	05706100
M 7	1.0	9.6	10.50	7707100105	14.00	7707100014	7707100095	7907100095	7707100013	7907100013	05707100
M 8	1.0	10.6	12.00	7708100012	16.00	7708100016	7708100011	7908100011	7708100015	7908100015	05708100
M 8	1.25	11.2	12.00	7708125012	16.00	7708125016	7708125108	7908125108	7708125148	7908125148	05708125
M 10	1.0	12.6	15.00	7710100015	20.00	7710100020	7710100014	7910100014	7710100019	7910100019	05710100
M 10	1.25	13.2	15.00	7710125015	20.00	7710125020	7710125138	7910125138	7710125188	7910125188	05710125
M 10	1.5	13.8	15.00	7710150015	20.00	7710150020	7710150135	7910150135	7710150185	7910150185	05710150
M 12	1.25	15.2	18.00	7712125018	24.00	7712125024	7712125168	7912125168	7712125228	7912125228	05712125
M 12	1.5	15.8	18.00	7712150018	24.00	7712150024	7712150165	7912150165	7712150225	7912150225	05712150
M 12	1.75	16.5	18.00	7712175018	24.00	7712175024	7712175163	7912175163	7712175223	7912175223	05712175
M 14	1.5	17.8	21.00	7714150021	28.00	7714150028	7714150195	7914150195	7714150265	7914150265	05714150
M 14	2.0	19.1	21.00	7714200021	28.00	7714200028	7714200019	7914200019	7714200026	7914200026	05714200
M 16	1.5	19.8	24.00	7716150024	32.00	7716150032	7716150225	7916150225	7716150305	7916150305	05716150
M 16	2.0	21.1	24.00	7716200024	32.00	7716200032	7716200022	7916200022	7716200030	7916200030	05716200
M 18	1.5	21.8	27.00	7718150027	36.00	7718150036	7718150255	7918150255	7718150345	7918150345	05718150
M 18	2.0	23.1	27.00	7718200027	36.00	7718200036	7718200025	7918200025	7718200034	7918200034	05718200
M 18	2.5	24.3	27.00	7718250027	36.00	7718250036	7718250245	7918250245	7718250335	7918250335	05718250
M 20	1.5	23.8	30.00	7720150030	40.00	7720150040	7720150285	7920150285	7720150385	7920150385	05720150
M 20	2.0	25.1	30.00	7720200030	40.00	7720200040	7720200028	7920200028	7720200038	7920200038	05720200
M 20	2.5	26.3	30.00	7720250030	40.00	7720250040	7720250275	7920250275	7720250375	7920250375	05720250

▶ Other dimensions on request.

UNC

Nominal diameter d	Pitch mm P	Tap Ø max	Wire Thread INSERTS #1 (Exterior)				Wire Thread INSERTS #2 (Interior)				Twininsert tool #1
			Length x1.5 d		Length x2 d		Length x1.5 d		Length x2 d		
			Nominal length mm B	Reference	Nominal length mm B	Reference	Reference	AF part number	Reference	AF part number	Reference
4 - 40	0.64	4.6	4.27	7710040168	5.69	7710040224	7710040143	7910040143	7710040199	7910040199	05700440
6 - 32	0.8	5.7	5.26	7710060207	7.01	7710060276	7710060176	7910060176	7710060245	7910060245	05700632
8 - 32	0.8	6.3	6.25	7710080246	8.33	7710080328	7710080215	7910080215	7710080297	7910080297	05700832
10 - 24	1.1	7.7	7.24	7710100285	9.65	7710100380	7710100243	7910100243	7710100338	7910100338	05701024
1/4 - 20	1.3	9.7	9.52	7710140375	12.70	7710140500	7710140325	7910140325	7710140450	7910140450	05701420
5/16 - 18	1.4	11.7	11.91	7715160469	15.87	7715160625	7715160413	7915160413	7715160569	7915160569	05751618
3/8 - 16	1.6	13.8	14.27	7710380562	19.05	7710380750	7710380500	7910380500	7710380688	7910380688	05703816
7/16 - 14	1.8	15.9	16.66	7717160656	22.22	7717160875	7717160585	7917160585	1117160804	7917160804	05771614
1/2 - 13	2.0	17.9	19.05	7710120750	25.40	7710121000	7710120673	7910120673	7710120923	7910120923	05701212
9/16 - 12	2.1	19.9	21.43	7719160844	28.57	7719161125	7719160761	7919160761	7719161042	7919161042	05791612
5/8 - 11	2.3	22.0	23.80	7710580938	31.75	7710581250	7710580847	7910580847	7710581159	7910581159	05705811
3/4 - 10	2.5	27.8	28.57	7710341125	38.10	7710341500	7710341025	7910341025	7710341400	7910341400	05703410

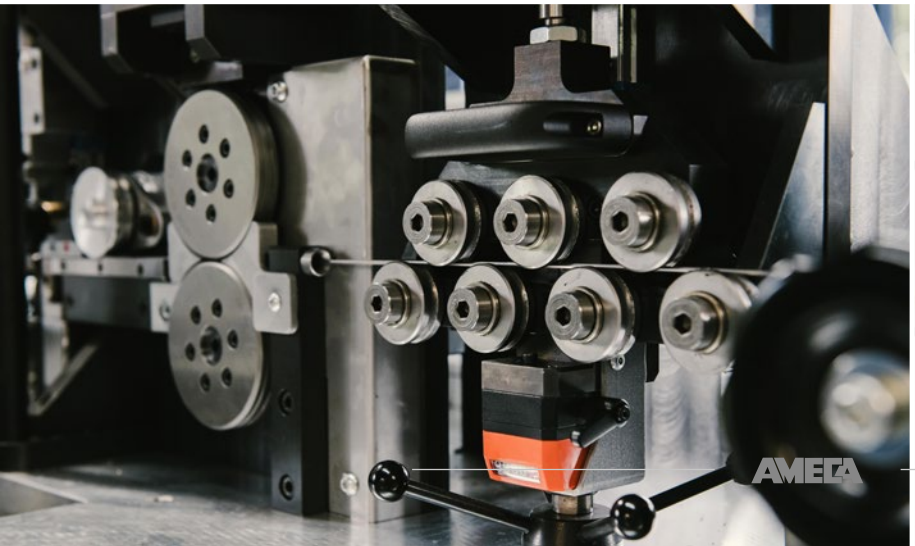
UNF

Nominal diameter d	Pitch mm P	Tap Ø max	Wire Thread INSERTS #1 (Exterior)				Wire Thread INSERTS #2 (Interior)				Twininsert tool #1
			Length x1.5 d		Length x2 d		Length x1.5 d		Length x2 d		
			Nominal length mm B	Reference	Nominal length mm B	Reference	Reference	AF part number	Reference	AF part number	Reference
6 - 40	0.64	5.2	5.26	7720060207	7.01	7720060276	7720060182	7920060182	7720060251	7920060251	05700640
10 - 32	0.8	7.0	7.24	7720100285	9.65	7720100380	7720100254	7920100254	7720100349	7920100349	05701032
1/4 - 28	0.9	8.8	9.52	7720140375	12.70	7720140500	7720140339	7920140339	7720140464	7920140464	05701428
5/16 - 24	1.1	10.8	11.91	7725160469	15.87	7725160625	7725160427	7925160427	7725160583	7925160583	05751624
3/8 - 24	1.1	12.4	14.27	7720380562	19.05	7720380750	7720380251	7920380251	7720380708	7920380708	05703824
7/16 - 20	1.3	14.5	16.66	7727160656	22.22	7727160875	7727160606	7927160606	7727160825	7927160825	05771620
1/2 - 20	1.3	16.1	19.05	7720120750	25.40	7720121000	7720120700	7920120700	7720120950	7920120950	05701220
9/16 - 18	1.4	18.1	21.43	7729160844	28.57	7729161125	7729160788	7929160788	7729161069	7929161069	05791618
5/8 - 18	1.41	19.6	23.80	7720580938	31.75	7720581250	7720580882	7920580882	7720581164	7920581164	05705818
3/4 - 16	1.6	23.3	28.57	7720341125	28.10	7720341500	7720341062	7920341062	77203441438	7903441438	05703416










//// INSTALLATION SYSTEMS

ASSEMBLY SERVICE ON MECHANICAL PARTS

CUSTOM INSTALLATION SERVICE FROM TECHNICAL STUDY TO ASSEMBLY.

In addition to the manufacture of Wire Thread Inserts, AMECA offers an installation service for your mechanical parts with our automatic installation solutions for threads from M2.5 to M12. For larger diameters, please contact us.

ADVANTAGES

- Time saving
- Savings in assembly and labor costs
- Reliability of the assembly

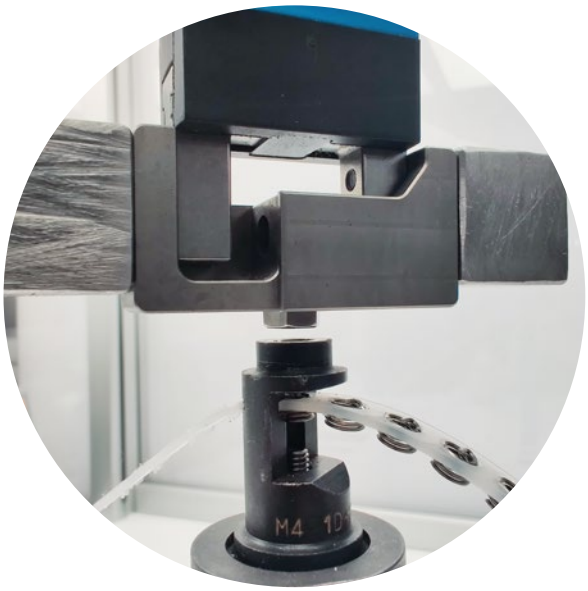
What does our assembly service include?

1. Technical service

- Technical study and drawing creation
- Co-designing a solution that integrates an AMECOIL® Wire Thread Insert
- Integration according to customer drawings

2. Installation of Wire Thread Inserts on your parts

3. Packaging and delivery



INSTALLATION PRINCIPLES

Whether for one-time use in manual installation, or for large-scale production in semi-automatic and automatic installation, AMECOIL® Wire Thread Inserts can be installed easily and quickly. Find the necessary installation tools: pages 46 to 47.

Watch the video

DRILLING

Drill the pilot hole using a standard drilling tool (pages 15 to 29). Do not chamfer. For drilling diameter and depth, refer to the Wire Thread Insert tables (pages 15 to 29).

TAPPING

Make the tapping for an AMECOIL® Wire Thread Insert in the hole using an AMECA tap (pages 40 to 44), refer to the Wire Thread Insert tables (pages 15 to 29). AMECA taps are suitable for blind and through holes. Checking all tappings with the corresponding control gauges (page 40 to 44) is recommended.

PLACEMENT ON INSTALLATION TOOL

Place the Wire Thread Insert in the opening of the tool with the thread tang pointing towards the tapped end of the tool. Screw the Wire Thread Insert into the tool until it is flush with the thread at the end.

INSTALLATION

Center the device facing the tapping. Turn the crank without pushing on the tang to screw the thread into the tapping. For proper installation, the thread should be ¼ to ½ turn below the surface. Caution: Do not turn in the opposite direction of rotation as the tang may break.

Once the first thread is in place, you can set the stop on your installation tool to ensure the identical installation position for the others. To do this, unscrew the pressure screw of the stop to place the stop in contact with the body of the tool, then retighten the pressure screw.

TANG BREAK

Break the tang using the AMECA manual or automatic breaker (page 54). This operation is only necessary if the screw is to pass through the insert. For Wire Thread Inserts larger than M20, use a pair of pliers to break the tang.

DISMANTLING

If disassembly is necessary, use an extractor (page 54)

TAPS & CONTROL GAUGES

TAPS

AMECA taps are suitable for blind and through holes. Checking all tappings with the corresponding control gauges is recommended.

Rough tap Manual or machine for through holes and blind holes. For sizes larger than M24, we recommend using this before using the finishing tap.

Finishing tap Manual or machine for through holes and blind holes. For diameters larger than M24 or for use in hard materials, this is used after the rough tap.

Gun tap machine for through holes, ideal for forward chip removal.

Helical fluted tap Machine for blind holes, ideal for chip removal as well as for ductile materials.

AMECA taps are designed for machining in standard materials with a hardness of 21 HCR or less. Consult us for other applications.

CONTROL GAUGE

The double-threaded control gauge F/R (5H metric/3B imperial) makes it possible to check the tapping before installing the AMECOIL Wire Thread Insert.

Metric

METRIC Ø x Wire Thread Insert pitch		Reference	Control pads GO/NO GO References
M 2 x 40	Rough tap	080102040	0602040
	Finisher	080202040	
	Gun	080302040	
	Helical	080402040	
M 2.5 x 45	Rough tap	080125045	0625045
	Finisher	080225045	
	Gun	080325045	
	Helical	080425045	
M 3 x 50	Rough tap	080103050	0603050
	Finisher	080203050	
	Gun	080303050	
	Helical	080403050	
M 3.5 x 60	Rough tap	080135060	0635060
	Finisher	080235060	
	Gun	080335060	
	Helical	080435060	
M 4 x 70	Rough tap	080104070	0604070
	Finisher	080204070	
	Gun	080304070	
	Helical	080404070	
M 5 x 80	Rough tap	080105080	0605080
	Finisher	080205080	
	Gun	080305080	
	Helical	080405080	
M 6 x 100	Rough tap	080106100	0606100
	Finisher	080206100	
	Gun	080306100	
	Helical	080406100	
M 7 x 100	Rough tap	080107100	0607100
	Finisher	080207100	
	Gun	080307100	
	Helical	080407100	
M 8 x 100	Rough tap	080108100	0608100
	Finisher	080208100	
	Gun	080308100	
	Helical	080408100	
M 8 x 125	Rough tap	080108125	0608125
	Finisher	080208125	
	Gun	080308125	
	Helical	080408125	
M 9 x 125	Rough tap	080109125	0609125
	Finisher	080209125	
	Gun	080309125	
	Helical	080409125	
M 10 x 100	Rough tap	080110100	0610100
	Finisher	080210100	
	Gun	080310100	
	Helical	080410100	
M 10 x 125	Rough tap	080110125	0610125
	Finisher	080210125	
	Gun	080310125	
	Helical	080410125	

METRIC Ø x Wire Thread Insert pitch		Reference	Control pads GO/NO GO References
M 10 x 150	Rough tap	080110150	0610150
	Finisher	080210150	
	Gun	080310150	
	Helical	080410150	
M 11 x 150	Rough tap	080111150	0611150
	Finisher	080211150	
	Gun	080311150	
	Helical	080411150	
M 12 x 100	Rough tap	080112100	0612100
	Finisher	080212100	
	Gun	080312100	
	Helical	080412100	
M 12 x 125	Rough tap	080112125	0612125
	Finisher	080212125	
	Gun	080312125	
	Helical	080412125	
M 12 x 150	Rough tap	080112150	0612150
	Finisher	080212150	
	Gun	080312150	
	Helical	080412150	
M 12 x 175	Rough tap	080112175	0612175
	Finisher	080212175	
	Gun	080312175	
	Helical	080412175	
M 14 x 125	Rough tap	080114125	0614125
	Finisher	080214125	
	Gun	080314125	
	Helical	080414125	
M 14 x 150	Rough tap	080114150	0614150
	Finisher	080214150	
	Gun	080314150	
	Helical	080414150	
M 14 x 200	Rough tap	080114200	0614200
	Finisher	080214200	
	Gun	080314200	
	Helical	080414200	
M 16 x 150	Rough tap	080116150	0616150
	Finisher	080216150	
	Gun	080316150	
	Helical	080416150	
M 16 x 200	Rough tap	080116200	0616200
	Finisher	080216200	
	Gun	080316200	
	Helical	080416200	
M 18 x 150	Rough tap	080118150	0618150
	Finisher	080218150	
	Gun	080318150	
	Helical	080418150	
M 18 x 200	Rough tap	080118200	0618200
	Finisher	080218200	
	Gun	080318200	
	Helical	080418200	

▶ To obtain the dimensions and other types of taps, please consult us.

Metric (continued)

METRIC Ø x Wire Thread Insert pitch		Reference	Control pads GO/NO GO References
M 18 x 250	Rough tap	080118250	0618250
	Finisher	080218250	
	Gun	080318250	
	Helical	080418250	
M 20 x 150	Rough tap	080120150	0620150
	Finisher	080220150	
	Gun	080320150	
	Helical	080420150	
M 20 x 200	Rough tap	080120200	0620200
	Finisher	080220200	
	Gun	080320200	
	Helical	080420200	
M 20 x 250	Rough tap	080120250	0620250
	Finisher	080220250	
	Gun	080320250	
	Helical	080420250	
M 22 x 150	Rough tap	080122150	0622150
	Finisher	080222150	
	Gun	080322150	
	Helical	080422150	
M 22 x 200	Rough tap	080122200	0622200
	Finisher	080222200	
	Gun	080322200	
	Helical	080422200	
M 22 x 250	Rough tap	080122250	0622250
	Finisher	080222250	
	Gun	080322250	
	Helical	080422250	
M 24 x 150	Rough tap	080124150	0624150
	Finisher	080224150	
	Gun	080324150	
	Helical	080424150	
M 24 x 200	Rough tap	080124200	0624200
	Finisher	080224200	
	Gun	080324200	
	Helical	080424200	
M 24 x 300	Rough tap	080124300	0624300
	Finisher	080224300	
	Gun	080324300	
	Helical	080424300	
M 26 x 150	Rough tap	080126150	0626150
	Finisher	080226150	
	Gun	080326150	
	Helical	080426150	
M 27 x 150	Rough tap	080127150	0627150
	Finisher	080227150	
	Gun	080327150	
	Helical	080427150	
M 27 x 200	Rough tap	080127200	0627200
	Finisher	080227200	
	Gun	080327200	
	Helical	080427200	
M 27 x 300	Rough tap	080127300	0627300
	Finisher	080227300	
	Gun	080327300	
	Helical	080427300	

METRIC Ø x Wire Thread Insert pitch		Reference	Control pads GO/NO GO References
M 30 x 150	Rough tap	080130150	0630150
	Finisher	080230150	
	Gun	080330150	
	Helical	080430150	
M 30 x 200	Rough tap	080130200	0630200
	Finisher	080230200	
	Gun	080330200	
	Helical	080430200	
M 30 x 350	Rough tap	080130350	0630350
	Finisher	080230350	
	Gun	080330350	
	Helical	080430350	
M 33 x 200	Rough tap	080133200	0633200
	Finisher	080233200	
	Gun	080333200	
	Helical	080433200	
M 36 x 150	Rough tap	080136150	0636150
	Finisher	080236150	
	Gun	080336150	
	Helical	080436150	
M 39 x 400	Rough tap	080139400	0639400
	Finisher	080239400	
	Gun	080339400	
	Helical	080439400	
M 45 x 450	Rough tap	080145450	0645450
	Finisher	080245450	
	Gun	080345450	
	Helical	080445450	

▶ To obtain the dimensions and other types of taps, please consult us.

UNC

UNC Ø x Wire Thread Insert pitch		References	GO/NO GO control pads
2 - 56	Rough tap	08011002	0602056
	Finisher	08021002	
	Gun	08031002	
	Helical	08041002	
3 - 48	Rough tap	08011003	0603048
	Finisher	08021003	
	Gun	08031003	
	Helical	08041003	
4 - 40	Rough tap	08011004	0604040
	Finisher	08021004	
	Gun	08031004	
	Helical	08041004	
5 - 40	Rough tap	08011005	0605040
	Finisher	08021005	
	Gun	08031005	
	Helical	08041005	
6 - 32	Rough tap	08011006	0606032
	Finisher	08021006	
	Gun	08031006	
	Helical	08041006	
8 - 32	Rough tap	08011008	0608032
	Finisher	08021008	
	Gun	08031008	
	Helical	08041008	
10 - 24	Rough tap	08011010	0610024
	Finisher	08021010	
	Gun	08031010	
	Helical	08041010	
12 - 24	Rough tap	08011012	0612024
	Finisher	08021012	
	Gun	08031012	
	Helical	08041012	
1/4 - 20	Rough tap	08011014	0601420
	Finisher	08021014	
	Gun	08031014	
	Helical	08041014	
5/16 - 18	Rough tap	08011516	0651618
	Finisher	08021516	
	Gun	08031516	
	Helical	08041516	
3/8 - 16	Rough tap	08011038	0603816
	Finisher	08021038	
	Gun	08031038	
	Helical	08041038	
7/16 - 14	Rough tap	08011716	0671614
	Finisher	08021716	
	Gun	08031716	
	Helical	08041716	
1/2 - 13	Rough tap	08011012	0601213
	Finisher	08021012	
	Gun	08031012	
	Helical	08041012	
9/16 - 12	Rough tap	08011916	0691612
	Finisher	08021916	
	Gun	08031916	
	Helical	08041916	

UNC Ø x Wire Thread Insert pitch		References	GO/NO GO control pads
5/8 - 11	Rough tap	08011058	0605811
	Finisher	08021058	
	Gun	08031058	
	Helical	08041058	
3/4 - 10	Rough tap	08011034	0603410
	Finisher	08021034	
	Gun	08031034	
	Helical	08041034	
7/8 - 9	Rough tap	08011078	0607809
	Finisher	08021078	
	Gun	08031078	
	Helical	08041078	
1" - 8	Rough tap	08011100	0610008
	Finisher	08021100	
	Gun	08031100	
	Helical	08041100	
1" 1/8 - 7	Rough tap	08011118	0611807
	Finisher	08021118	
	Gun	08031118	
	Helical	08041118	
1" 1/4 - 7	Rough tap	08011114	0611407
	Finisher	08021114	
	Gun	08031114	
	Helical	08041114	
1" 3/8 - 6	Rough tap	08011138	0613806
	Finisher	08021138	
	Gun	08031138	
	Helical	08041138	
1" 1/2 - 6	Rough tap	08011112	0611206
	Finisher	08021112	
	Gun	08031112	
	Helical	08041112	

▶ To obtain the dimensions and other types of taps, please consult us.

UNF

UNF Ø x Wire Thread Insert pitch		References	GO/NO GO control pads
2 - 64	Rough tap	08012002	0602064
	Finisher	08022002	
	Gun	08032002	
	Helical	08042002	
4 - 48	Rough tap	08012004	0604048
	Finisher	08022004	
	Gun	08032004	
	Helical	08042004	
6 - 40	Rough tap	08012006	0606040
	Finisher	08022006	
	Gun	08032006	
	Helical	08042006	
8 - 36	Rough tap	08012008	0608036
	Finisher	08022008	
	Gun	08032008	
	Helical	08042008	
10 - 32	Rough tap	08012010	0610032
	Finisher	08022010	
	Gun	08032010	
	Helical	08042010	
1/4 - 28	Rough tap	08012014	0601428
	Finisher	08022014	
	Gun	08032014	
	Helical	08042014	
5/16 - 24	Rough tap	08012516	0651624
	Finisher	08022516	
	Gun	08032516	
	Helical	08042516	
3/8 - 24	Rough tap	08012038	0603824
	Finisher	08022038	
	Gun	08032038	
	Helical	08042038	
7/16 - 20	Rough tap	08012716	0671620
	Finisher	08022716	
	Gun	08032716	
	Helical	08042716	
1/2 - 20	Rough tap	08012012	0601220
	Finisher	08022012	
	Gun	08032012	
	Helical	08042012	
9/16 - 18	Rough tap	08012916	0691618
	Finisher	08022916	
	Gun	08032916	
	Helical	08042916	
5/8 - 18	Rough tap	08012058	0605818
	Finisher	08022058	
	Gun	08032058	
	Helical	08042058	

UNF Ø x Wire Thread Insert pitch		References	GO/NO GO control pads
3/4 - 16	Rough tap	08012034	0603416
	Finisher	08022034	
	Gun	08032034	
	Helical	08042034	
7/8 - 14	Rough tap	08012078	0607814
	Finisher	08022078	
	Gun	08032078	
	Helical	08042078	
1″ - 12	Rough tap	08012100	0610012
	Finisher	08022100	
	Gun	08032100	
	Helical	08042100	
1″ 1/8 - 12	Rough tap	08012118	0611812
	Finisher	08022118	
	Gun	08032118	
	Helical	08042118	
1″ 1/4 - 12	Rough tap	08012114	0611412
	Finisher	08022114	
	Gun	08032114	
	Helical	08042114	

▶ To obtain the dimensions and other types of taps, please consult us.

INSTALLATION DEVICES

Wire Thread Inserts have an outside diameter greater than the tapping in which they are to be installed. There are three types of installation tools: manual tools, power tools, and pneumatic tools. The choice between these different tools depends on the diameter of the AMECOIL® Wire Thread Insert and the volume to be installed.

MANUAL INSTALLATION DEVICES

AMECOIL® Wire Thread Insert have an outside diameter greater than the tapping in which they are to be installed. The installation tool reduces the thread diameter by the threaded nozzle or direct mounting for mandrel tools.

Model	Spindle type	Pitch type	Description
1	Smooth spindle	Standard pitch from Ø M2 to M16	INDUS tool, suitable for all types of professional installation.
2	Threaded spindle	Fine pitch from Ø M2 to M16	For AMECOIL SR® Wire Thread Inserts. The threaded spindle facilitates the installation of fine pitches.
3	Threaded spindle	Small Ø ≤ M4 standard or fine pitch	Tool #1 BIS. Facilitates and guarantees a better installation of fine and small diameter threads. The small size of the nozzle allows access to difficult areas. Ideal for bronze threads.
4	Smooth spindle	Standard pitches Ø ≥ M18	One-dimensional INDUS tool suitable for all types of professional installation from Ø M18. It is not possible to remove the crimped nozzle.
5	Threaded spindle	Fine pitch from Ø ≥ M18	Unidimensional tool with threaded spindle facilitating the installation of fine pitches. It is not possible to remove the crimped nozzle.
6	Smooth spindle	Wide pitch Ø ≥ M27	Mandrel tool.

Metric	Smooth spindle tool		Threaded spindle tool		Tool #1 BIS		Mandrel tool	
M2 x 40	→		→		05202040AM	❸	-	
M2.5 x 45	→		05125045AM	❷	05225045AM		-	
M3 x 50	0503050AM	❶	05103050AM		05203050AM		-	
M3.5 x 60	0535060AM		-		05203050AM		-	
M4 x 70	0504070AM		-		05235060AM		-	
M5 x 80	0505080AM		05105080AM	❷	05204070AM		-	
M6 x 100	0506100AM		05106100AM		-		-	
M7 x 100	0507100AM		05107100AM		-		-	
M8 x 100	0508100AM		05108100AM		-		-	
M8 x 125	0508125AM		05108125AM		-		-	
M9 x 125	0509125AM		05109125AM		-		-	
M10 x 100	→		05110100AM		-		-	
M10 x 125	0510125AM	❶	05110125AM		-		-	
M10 x 150	0510150AM		05110150AM		-		-	
M11 x 150	0511150AM		-		-		-	
M12 x 100	→		05112100AM	❷	-		-	
M12 x 125	→		05112125AM		-		-	
M12 x 150	0512150AM	❶	05112150AM		-		-	
M12 x 175	0512175AM		05112175AM		-		-	
M14 x 125	→		05114125AM		-		-	
M14 x 150	0514150AM	❶	05114150AM		-		-	
M14 x 200	0514200AM		05114200AM		-		-	
M16 x 150	→		05116150AM		-		-	
M16 x 200	0516200AM	❶	05116200AM		-		-	
M18 x 150	→		05118150AM	❺	-		-	
M18 x 200	0518200AM	❹	05118200AM		-		-	
M18 x 250	0518250AM		-		-		-	
M20 x 150	→		05120150AM	❺	-		-	
M20 x 200	0520200AM	❹	05120200AM		-		-	
M20 x 250	0520250AM		-		-		-	
M22 x 150	→		05122150AM	❺	-		-	
M22 x 200	0522200AM	❹	05122200AM		-		-	
M22 x 250	0522250AM		-		-		-	
M24 x 150	→		05124150AM	❺	-		-	
M24 x 200	0524200AM	❹	05124200AM		-		-	
M24 x 300	0524300AM		-		-		-	
M26 x 150	→		05126150AM	❺	-		-	
M27 x 150	→		05127150AM		-		-	
M27 x 200	0527200AM	❹	05127200AM		-		-	
M27 x 300	→		→		→		05273000AM	❻
M28 x 150	→		05128150AM	❺	-		-	
M30 x 150	→		05130150AM		-		-	
M30 x 200	0530200AM	❹	05130200AM		-		-	
M30 x 350	→		→		→		0530350AM	❻
M33 x 200	0533200AM	❹	05133200AM	❺	-			
M33 x 350	→		→		→		0533350AM	❻
M34 x 150	→		05134150AM	❺	-		-	
M36 x 150	→		05136150AM		-		-	
M36 x 200	0536200AM	❹	05136200AM		-		-	
M36 x 300	→		05136300AM		-		0536300AM	❻
M36 x 400	→		→		→		0536400AM	
M39 x 300	053930012AM	❹	-		-		0539300AM	
M39 x 400	→		→		→		0539400AM	
M42 x 300	054230012AM	❹	054230011AM	❺	-		-	
M42 x 450	→		→		→		0542450AM	❻
M45 x 300	054530012AM	❹	054530011AM	❺	-		-	
M45 x 450	→		→		→		0545450AM	❻

▶ For UNC / UNF / BSP / BSF / BSW or any other diameter please contact us to obtain the appropriate part number.

It is recommended to use a manual tool with threaded mandrel for fine pitch sizes.

Although this is not a pre-requisite, the use of a manual tool N°1 BIS is recommended if the tapping is not easily accessible :
The nozzle diameter of this tool has been reduced to the minimum to allow access to difficult areas (for diameters up to M4)

REPAIR KITS

To repair damaged tappings, AMECOIL SR® Wire Thread Inserts are available in both metric and inch repair kits. They consist of inserts, a drilling tool, a tap, an installation tool, and a breaker.

INDUS REPAIR KITS

The INDUS repair kit is designed for professional industrial maintenance repairs.

MONOKIT

Metric MONOKIT

Metric	Hole Ø mm	Drilling tool	Tap	Breaker	INDUS tool	Thread # 1.5D	References
M2.5 x 45	2.60	0520126	080225045	0525K	0525045AM	20	1125045375AM
M3 x 50	3.20	0520132	080203050	0525K	0503050AM	20	1103050045AM
M4 x 70	4.20	0520142	080204070	0504K	0504070AM	20	1104070006AM
M5 x 80	5.20	0520153	080205080	0504K	0505080AM	20	1105080075AM
M6 x 100	6.30	0520163	080206100	0506K	0506100AM	20	1106100009AM
M7 x 100	7.30	0520173	080207100	0506K	0507100AM	20	1107100105AM
M8 x 100	8.30	0520183	080208100	0508K	0508100AM	20	1108100012AM
M8 x 125	8.40	0520184	080208125	0508K	0508125AM	15	1108125012AM
M9 x 125	9.40	0520194	080209125	0508K	0509125AM	15	1109125135AM
M10 x 100	10.25	05201103	080210100	0510K	0510100AM	15	1110100015AM
M10 x 125	10.40	05201104	080210125	0510K	0510125AM	15	1110125015AM
M10 x 150	10.50	05201104	080210150	0510K	0510150AM	10	1110150015AM
M11 x 150	11.50	05201115	080211150	0510K	0511150AM	10	1111150165AM
M12 x 100	12.30	05201123	080212100	0510K	0512100AM	10	1112100018AM
M12 x 125	12.40	05201124	080212125	0510K	0512125AM	10	1112125018AM
M12 x 150	12.50	05201125	080212150	0510K	0512150AM	10	1112150018AM
M12 x 175	12.50	05201125	080212175	0510K	0512175AM	10	1112175018AM
M14 x 125	14.40	05201145	080214125	0514K	0514125AM	10	1114125021AM
M14 x 150	14.50	05201145	080214150	0514K	0514150AM	10	1114150021AM
M14 x 200	14.50	05201145	080214200	0514K	0514200AM	10	1114200021AM
M16 x 150	16.50	05201165	080216150	0514K	0516150AM	10	1116150024AM
M16 x 200	16.50	05201165	080216200	0514K	0516200AM	10	1116200024AM
M18 x 150	18.50	05201185	080218150	0514K	0518150AM	5	1118150027AM
M18 x 200	18.50	05201185	080218200	0514K	0518200AM	5	1118200027AM

Metric MONOKIT (continued)

Metric	Hole Ø mm	Drilling tool	Tap	Breaker	INDUS tool	Thread # 1.5D	References
M18 x 250	18.75	052011875	080218250	0514K	0518250AM	5	1118250027AM
M20 x 150	20.50	05201205	080220150	0521	0520150AM	5	1120150030AM
M20 x 200	20.50	05201205	080220200	0521	0520200AM	5	1120200030AM
M20 x 250	20.75	052012075	080220250	0521	0520250AM	5	1120250030AM
M22 x 150	22.50		080222150	0522	0522150AM	5	1122150033AM
M22 x 200	22.50		080222200	0522	0522200AM	5	1122200033AM
M22 x 250	22.75		080222250	0522	0522250AM	5	1122250033AM
M24 x 150	24.50		080224150	0524	0524150AM	5	1124150036AM
M24 x 200	24.50		080224200	0524	0524200AM	5	1124200036AM
M24 x 300	24.75		080224300	0524	0524300AM	5	1124300036AM

UNC MONOKIT

UNC	Ø mm	Drilling tool	Tap	Breaker	INDUS tool	Thread # 1.5D	References
2 - 56	2.40	0520124	08021002	0525K	0500256AM	20	1310020129AM
4 - 40	3.10	0520131	08021004	0525K	0500440AM	20	1310040168AM
6 - 32	3.80	05201380	08021006	0525K	0500632AM	20	1310060207AM
8 - 32	4.40	0520144	08021008	0504K	0500832AM	20	1310080246AM
10 - 24	5.10	0520153	08021010	0504K	0501024AM	20	1310100285AM
1/4 - 20	6.70	0520167	08021014	0506K	0501420AM	20	1310140375AM
5/16 - 18	6.70	0520184	08021516	0506K	0551618AM	20	1315160469AM
3/8 - 16	8.30	0520010	08021038	0508K	0503816AM	15	1310380562AM
7/16 - 14	9.90	05201116	08021716	0510K	0571614AM	10	1317160656AM
1/2 - 13	11.50	052011325	08021012	0510K	0501213AM	10	1310120750AM
9/16 - 12	13.10	05201150	08021916	0514K	0591612AM	10	1319160844AM
5/8 - 11	14.70	05201165	08021058	0514K	0505811AM	10	1310580938AM
3/4 - 10	19.80		08021034	0514K	053410AM	5	1310341125AM
7/8 - 9	20.50		08022078	0522	057809AM	5	1310781312AM
1" - 8	24.50		08021100	0524	051008AM	5	1311001500AM

UNC MONOKIT

UNF	Ø mm	Drilling tool	Tap	Breaker	INDUS tool	Thread # 1.5D	References
6 - 40	3.80	05201380	08022006	0525K	0500640AM	20	1220060207AM
10 -32	5.20	0520151	08022010	0504K	0501032AM	20	1220100285AM
1/4 - 28	6.70	0520167	08022014	0506K	0501428AM	20	1220140375AM
5/16 - 24	8.40	0520183	08022516	0508K	0551624AM	20	1225160469AM
3/8 - 24	10.00	0520199	08022038	0510K	0503824AM	15	1220380562AM
7/16 - 20	11.60	05201115	08022716	0510K	0571620AM	10	1227160656AM
1/2 - 20	13.20	05201130	08022012	0510K	0501220AM	10	1220120750AM
9/16 - 18	14.90	052011475	08022916	0514K	0591618AM	10	1229160844AM
5/8 - 11	16.50	052011625	08022058	0514K	0505818AM	10	1220580938AM
3/4 - 16	19.50		08022034	0514K	053416AM	5	1220341125AM
7/8 - 14	22.50		08022078	0522	057814AM	5	1210781312AM
1" - 12	24.75		08022100	0524	051012AM	5	1211001500AM

MULTIKIT

Metric MULTIKIT

Metric	Hole Ø mm	Drilling tool	Tap	Breaker	Nozzle + Smooth Spindle Set	Thread # 1.5D	References
M5 x 80	5.20	0520153	080205080	0504K	051605080	20	1805080001AM
M6 x 100	6.30	0520163	080206100	0506K	051606100	20	
M8 x 125	8.40	0520184	080208125	0508K	051608125	15	
M10 x 150	10.50	05201104	080210150	0510K	051610150	10	
M12 x 175	12.50	05201125	080212175	0510K	051612175	10	
M3 x 50	3.20	0520132	080203050	0525K	051603050	20	1803050001AM
M4 x 70	4.20	0520142	080204070	0504K	051604070	20	
M5 x 80	5.20	0520153	080205080	0504K	051605080	20	
M6 x 100	6.30	0520163	080206100	0506K	051606100	20	
M6 x 100	6.30	0520163	080206100	0506K	051606100	20	1806100001AM
M8 x 125	8.40	0520184	080208125	0508K	051608125	15	
M10 x 150	10.50	05201104	080210150	0510K	051610150	10	
M12 x 175	12.50	05201125	080212175	0510K	051612175	10	

UNC MULTIKIT

UNC	Hole Ø mm	Drilling tool	Tap	Breaker	Nozzle + Smooth Spindle Set	Thread # 1.5D	References
1/4 - 20	6.70	0520167	08021014	0506K	051601420	20	1914200002AM
5/16 - 18	6.70	0520184	08021516	0506K	051651618	20	
3/8 - 16	8.30	0520010	08021038	0508K	051603816	15	
7/16 - 14	9.90	05201116	08021716	0510K	051671614	10	
1/4 - 20	6.70	0520167	08021014	0506K	051601420	20	1914200001AM
5/16 - 18	6.70	0520184	08021516	0506K	051651618	20	
3/8 - 16	8.30	0520010	08021038	0508K	051603816	15	
1/2 - 13	11.50	052011325	08021012	0510K	051601213	10	

UNF MULTIKIT

UNF	Hole Ø mm	Drilling tool	Tap	Breaker	Nozzle + Smooth Spindle Set	Thread # 1.5D	References
1/4 - 28	6.70	0520167	08022014	0506K	051601428	20	1914280002AM
5/16 - 24	8.40	0520183	08022516	0508K	051651624	20	
3/8 - 24	10.00	0520199	08022038	0510K	051603824	15	
7/16 - 20	11.60	05201115	08022716	0510K	051671620	10	
1/4 - 28	6.70	0520167	08022014	0506K	051601428	20	1914280001AM
5/16 - 24	8.40	0520183	08022516	0508K	051651624	20	
3/8 - 24	10.00	0520199	08022038	0510K	051603824	15	
1/2 - 20	13.20	05201130	08022012	0510K	051601220	10	

STANDARD REPAIR KITS

The STANDARD repair kit is suitable for simple, one-off tapping repairs.

MONOKIT

Metric MONOKIT

Metric	Hole Ø mm	Drilling tool	Tap	Breaker	STANDARD tool	Thread # 1.5D	References
M2.5 x 45	2.60	0520126	080225045	0525K	55250451	20	1025045375SRAM
M3 x 50	3.20	0520132	080203050	0525K	55030501	20	1003050045SRAM
M4 x 70	4.20	0520142	080204070	0504K	55040701	20	1004070006SRAM
M5 x 80	5.20	0520153	080205080	0504K	55050801	20	1005080075SRAM
M6 x 100	6.30	0520163	080206100	0506K	55061001	20	1006100009SRAM
M7 x 100	7.30	0520173	080207100	0506K	55071001	20	1007100105SRAM
M8 x 100	8.30	0520183	080208100	0508K	55081001	20	1008100012SRAM
M8 x 125	8.40	0520184	080208125	0508K	55081251	20	1008125012SRAM
M9 x 125	9.40	0520194	080209125	0508K	55091251	15	1009125135SRAM
M10 x 100	10.25	05201103	080210100	0510K	55101001	15	1010100015SRAM
M10 x 125	10.40	05201104	080210125	0510K	55101251	15	1010125015SRAM
M10 x 150	10.50	05201104	080210150	0510K	55101501	15	1010150015SRAM
M11 x 150	11.50	05201115	080211150	0510K	55111501	10	1011150165SRAM
M12 x 100	12.30	05201123	080212100	0510K	55121001	10	1012100018SRAM
M12 x 125	12.40	05201124	080212125	0510K	55121251	10	1012125018SRAM
M12 x 150	12.50	05201125	080212150	0510K	55121501	10	1012150018SRAM
M12 x 175	12.50	05201125	080212175	0510K	55121751	10	1012175018SRAM
M14 x 125	14.40		080214125		55141251	10	1014125021SRAM
M14 x 150	14.50		080214150		55141501	10	1014150021SRAM
M14 x 200	14.50		080214200		55142001	10	1014200021SRAM
M16 x 150	16.50		080216150		55161501	10	1016150024SRAM
M16 x 200	16.50		080216200		55162001	10	1016200024SRAM
M18 x 200	18.50		080218200		55182001	5	1018200027SRAM
M18 x 250	18.75		080218250		55182501	5	1018250027SRAM
M20 x 200	20.50		080220200		55202001	5	1020200030SRAM
M20 x 250	20.75		080220250		55202501	5	1020250030SRAM
M22 x 200	22.50		080222200		55222001	5	1022200033SRAM
M22 x 250	22.75		080222250		55222501	5	1022250033SRAM
M24 x 200	24.50		080224200		55242001	5	1024200036SRAM
M24 x 300	24.75		080224300		55243001	5	1024300036SRAM

UNC MONOKIT

UNC	Hole Ø mm	Drilling tool	Tap	Breaker	STANDARD tool	Thread # 1.5D	References
2 - 56	2.40	0520124	08021002	0525K	55100201	20	1010020129SRAM
4 - 40	3.10	0520131	08021004	0525K	55100401	20	1010040168SRAM
6 - 32	3.80	05201380	08021006	0525K	55100601	20	1010060207SRAM
8 - 32	4.40	0520144	08021008	0504K	55100801	20	1010080246SRAM
10 - 24	5.10	0520153	08021010	0504K	55101001	20	1010100285SRAM
1/4 - 20	6.70	0520167	08021014	0506K	55101401	20	1010140375SRAM
5/16 - 18	6.70	0520184	08021516	0506K	55151601	20	1015160469SRAM
3/8 - 16	8.30	0520010	08021038	0508K	55103801	15	1010380562SRAM
7/16 - 14	9.90	05201116	08021716	0510K	55171601	10	1017160656SRAM
1/2 - 13	11.50	052011325	08021012	0510K	55101201	10	1010120750SRAM
9/16 - 12	13.10		08021916		55191601	10	1019160844SRAM
5/8 - 11	14.70		08021058		55105801	10	1010580938SRAM
3/4 - 10	19.80		08021034		55103411	5	1010341125SRAM
7/8 - 9	20.50		08022078		55107801	5	1010781312SRAM
1″ - 8	24.50		08021100		55111001	5	1011001500SRAM

UNC MONOKIT

UNF	Hole Ø mm	Drilling tool	Tap	Breaker	STANDARD tool	Thread # 1.5D	References
6 - 40	3.80	05201380	08022006	0525K	55200601	20	1020060207SRAM
10 -32	5.20	0520151	08022010	0504K	55201001	20	1020100285SRAM
1/4 - 28	6.70	0520167	08022014	0506K	55201401	20	1020140375SRAM
5/16 - 24	8.40	0520184	08022516	0506K	55251601	20	1025160469SRAM
3/8 - 24	10.00	0520199	08022038	0508K	55203801	15	1020380562SRAM
7/16 - 20	11.60	05201115	08022716	0510K	55271601	10	1027160656SRAM
1/2 - 20	13.20	05201130	08022012	0510K	55201201	10	1020120750SRAM
9/16 - 18	14.90		08022916		55291601	10	1029160844SRAM
5/8 - 11	16.50		08022058		55205801	10	1020580938SRAM
3/4 - 16	19.50		08022034		55203411	5	1020341125SRAM
7/8 - 14	22.50		08022078		55207801	5	1020781312SRAM
1″ - 12	24.75		08022100		55211001	5	1021001500SRAM

MULTIKIT

Metric MULTIKIT

Metric	Hole Ø mm	Drilling tool	Tap	Breaker	STANDARD tool	Thread # 1.5D	References
M5 x 80	5.20	0520153	080205080	0504K	55050801	20	1005080001AM
M6 x 100	6.30	0520163	080206100	0506K	55061001	20	
M8 x 125	8.40	0520184	080208125	0508K	55081251	20	
M10 x 150	10.50	05201104	080210150	0510K	55101501	15	
M12 x 175	12.50	05201125	080212175	0510K	55121751	10	
M3 x 50	3.20	0520132	080203050	0525K	55030501	20	1003050001AM
M4 x 70	4.20	0520142	080204070	0504K	55040701	20	
M5 x 80	5.20	0520153	080205080	0504K	55050801	20	
M6 x 100	6.30	0520163	080206100	0506K	55061001	20	
M6 x 100	6.30	0520163	080206100	0506K	55061001	20	1006100001AM
M8 x 125	8.40	0520184	080208125	0508K	55081251	20	
M10 x 150	10.50	05201104	080210150	0510K	55101501	15	
M12 x 175	12.50	05201125	080212175	0510K	55121751	10	

UNC MULTIKIT

UNC	Hole Ø mm	Drilling tool	Tap	Breaker	STANDARD tool	Thread # 1.5D	References
1/4 - 20	6.70	0520167	08021014	0506K	55101401	20	1014200003AM
5/16 - 18	6.70	0520184	08021516	0506K	55151601	20	
3/8 - 16	8.30	0520010	08021038	0508K	55103801	15	
7/16 - 14	9.90	05201116	08021716	0510K	55171601	10	
1/2 - 13	11.50	052011325	08021012	0510K	55101201	10	
1/4 - 20	6.70	0520167	08021014	0506K	55101401	20	1014200002AM
5/16 - 18	6.70	0520184	08021516	0506K	55151601	20	
3/8 - 16	8.30	0520010	08021038	0508K	55103801	15	
7/16 - 14	9.90	05201116	08021716	0510K	55171601	10	
1/4 - 20	6.70	0520167	08021014	0506K	55101401	20	1014200001AM
5/16 - 18	6.70	0520184	08021516	0506K	55151601	20	
3/8 - 16	8.30	0520010	08021038	0508K	55103801	15	
1/2 - 13	11.50	052011325	08021012	0510K	55101201	10	

UNF MULTIKIT

UNF	Hole Ø mm	Drilling tool	Tap	Breaker	STANDARD tool	Thread # 1.5D	References
1/4 - 28	6.70	0520167	08022014	0506K	55201401	20	1014280003AM
5/16 - 24	8.40	0520184	08022516	0506K	55251601	20	
3/8 - 24	10.00	0520199	08022038	0508K	55203801	15	
7/16 - 20	11.60	05201115	08022716	0510K	55271601	10	
1/2 - 20	13.20	05201130	08022012	0510K	55201201	10	
1/4 - 28	6.70	0520167	08022014	0506K	55201401	20	1014280002AM
5/16 - 24	8.40	0520184	08022516	0506K	55251601	20	
3/8 - 24	10.00	0520199	08022038	0508K	55203801	15	
7/16 - 20	11.60	05201115	08022716	0510K	55271601	10	
1/4 - 28	6.70	0520167	08022014	0506K	55201401	20	1014280001AM
5/16 - 24	8.40	0520184	08022516	0506K	55251601	20	
3/8 - 24	10.00	0520199	08022038	0508K	55203801	15	
1/2 - 20	13.20	05201130	08022012	0510K	55201201	10	

BREAKERS/EXTRACTORS

The breaker breaks the tang of the Wire Thread Insert, thus allowing space to insert the screw.

BREAK PUNCH

Ideal for the occasional Wire Thread Insert installation. It is used in addition to a hammer. To do this, give the breaker a sharp blow with a hammer.

AUTOMATIC BREAKER

Ideal for repeated threading operations, the self-releasing breaker can be used with one hand and does not require any other tools for installation. Pre-setting and striking regularity ensure efficiency and speed.

EXTRACTOR

If necessary, the Wire Thread Insert can be removed manually with an extractor. To do this, insert the blade on the extraction tool into the AMECOIL® inserts until the V-section of the blade is facing the upper end of the insert. Strike the head of the tool with a light blow. Then, while maintaining constant pressure of the blade against the insert, unscrew the extraction tool until the insert is completely removed.

Metric	UNC	UNF	BSW	BSP	BSF	Breaker		Extractor	
						Manuel	Automatic	Extractor	No.
M 2	2 - 56	2 - 64	-	-	-	0520	0500002	0566	1
M 2.5	4 - 40	-	1/8 - 40	-	-	0525	0500025	0566	1
M 3	-	-	-	-	-	0503	0500003	0566	1
M 3.5	6 - 32	6 - 40	-	-	-	0503	0500035	0566	1
M 4	8 - 32	8 - 36	-	-	-	0504	0500004	0566	1
M 5	10/12 - 24	10 - 32	3/16 - 24	-	-	0505	0500005	0566	1
M 6	1/4 - 20	1/4 - 28	1/4 - 20	-	-	0506	0500006	0566	1
M 7	5/16 - 18	-	5/16 - 18	-	9/32 - 26	0507	0500007	0566	1
M 8	-	5/16 - 24	-	-	5/16 - 22	0508	0500008	0566	1
M 9	3/8 - 16	-	3/8 - 16	-	-	0509	-	0567	2
M 10	-	3/8 - 24	-	1/8	3/8 - 20	0510	0500010	0567	2
M 11	7/16 - 14	7/16 - 20	7/16 - 14	-	7/16 - 18	0511	-	0567	2
M 12	1/2 - 13	1/2 - 20	1/2 - 12	-	1/2 - 16	0512	0500012	0567	2
M 14	9/16 - 12	9/16 - 18	9/16 - 12	1/4	9/16 - 16	0514	0500014	0568	3
M 16	5/8 - 11	5/8 - 18	5/8 - 11	-	5/8 - 14	0516	-	0568	3
M 18	3/4 - 10	3/4 - 16	3/4 - 10	3/8	11/16 - 14	0518	-	0568	3
M 20	-	-	-	-	-	0521	-	0568	3
M 22	-	-	-	1/2	-	0522	-	0568	3
M 24	1" - 8	-	-	-	-	0524	-	0569	4
M 26	-	-	-	-	-	0526	-	0569	4
M 27	-	-	-	-	-	0527	-	0569	4
M 28	-	-	-	-	-	0528	-	0569	4
M 30	1" 1/4	-	-	-	-	0530	-	0569	4
M 33	-	-	-	-	-	On request	-	0570	5
M 34	-	-	-	-	-		-	0570	5
M 36	-	-	-	-	-		-	0570	5
M 39	-	-	-	-	-		-	0570	5
M 42	-	-	-	-	-		-	0571	6
M 45	-	-	-	-	-		-	0571	6

Watch the video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RÉGLAGE DE LA BUTÉE

ELECTRICAL INSTALLATION DEVICES

Electric installation tools are recommended for AMECOIL® insert diameters smaller than M12. For the installation of inserts on Strip Feed, they are suitable for "Pick & Place" installation.

GXT SCREWDRIVERS

APPLICATIONS

The GXT straight electric screwdriver is adapted to a fast installation rate of AMECOIL® inserts from M2 to M8 (GXT 120) and from M5 to M10 (GXT 220). It is used with the SR hexagonal spindle (page 56). It is ultra-robust and has a mechanical cut-off by clutch spring. It offers a variety of torques, speeds and features to meet all requirements.

The mechanical maintaining device, that can be added to the electric screwdriver, offers optimal guidance of the Wire Thread Insert in the tapping.

ADVANTAGES

- **Productivity**
  - › Programmable functions and digital settings
  - › Multi-sequence operation: screwing / waiting / unscrewing
  - › Torque or angle release
  - › Overload and temperature protection

- **Quality**
  - › Brushless motor (maintenance free)
  - › Non-contact starting, reversibility and break
  - › Progressive start
  - › LED indicator on the screwdriver for signaling and adjustment
  - › Conductive body

- **Comfort**
  - › Optimized ergonomics
  - › Excellent weight/ergonomics ratio
  - › Silent engine

TECHNICAL CHARACTERISTICS

The GXT 120 is suitable for diameters from M2 to M12 and the GXT 220 is suitable for diameters from M12 to M16.

Model	GXT 120	GXT 220
Speed (rpm)	300 to 700	600 to 1200
Power supply output voltage	30 or 40 V (selectable)	30 or 40 V (selectable)
Torque (Nm)	0.2~ 1.2	0.6~ 2.15
Threaded Driver	6 hex socket 1/4"	6 hex socket 1/4"
Weight (kg)	0.43	0.60
Reference	350304 + maintaining system > 3503052 (M2 to M8) > 3503053 (M10 to M16) + adapter ring 3503042	350305 + maintaining system > 3503052 (M2 to M8) > 3503053 (M10 to M16)

The XS-40D controller completes the screwing process and makes it more reliable

Model	XS-40D
Voltage (VAC)	220
Low voltage (V)	30
High voltage (V)	40
Current (A)	3
Weight (kg)	0.86
Size (mm)	90 x 150 x 55
Reference	350065

ADDITIONAL ACCESSORIES

6 HEX SPINDLE SR See page 62 for part numbers.

CONTROLLED SCREWDRIVER MD

APPLICATIONS

The MD electric straight screwdriver is controlled by sensors for torque and angle. Lightweight and ergonomic, it is designed for high-speed vertical AMECOIL® threading operations requiring precision and traceability. Ideal to install several thread diameters in series. Suitable for the installation of threads from M2 to M10. For larger diameters, please contact us.

ADVANTAGES

- **Productivity**
  - › Pre-programming up to 15 part numbers
  - › Multi-sequence operation: screwing / waiting / unscrewing
  - › Torque or angle release
  - › Overload and temperature protection
- **Quality**
  - › Setting the acceleration on the first turn
  - › Torque and speed adaptable to the thread
  - › Brushless motor (maintenance free)
  - › Non-contact starting, reversibility and break
- **Comfort**
  - › Controller touch screen with quick program selection
  - › Optimized ergonomics
  - › Excellent weight/ergonomics ratio
  - › Silent engine

TECHNICAL CHARACTERISTICS

The MD2611-A is suitable for diameters from M2 to M10. For other dimensions, please contact us.

Model	MD2611-A
Speed (rpm)	100 to 900
Torque (Nm)	0.4 - 3.3
XXX?	HEX 1/4"
Weight (kg)	0.545
Reference	2582612

The MDC-26 controller completes the screwing process and makes it more reliable. It has a total of 15 screwing programs with 15 customizable parameters (screwing mode, torque, angle, speed, time) as well as advanced functions.

Model	MDC-26
Input supply voltage	AC230V, 50/60Hz, 2.5A
Input supply voltage	DC38V 3.5A
Fuse	2x T5A / 230V
Operating conditions	0 ~ 104°F / 15 ~ 80% RH (non-condensing)
Display screen	5" LCD Color 800x480 dots - Tactile & Multilingual
Communications	1 x RS232C, 1 x Ethernet
Protocol	Modbus RTU, Modbus TCP/IP
Inputs / Outputs	15x inputs and 8x outputs assignable via SUB-D25 port
Screwing programs	15
Torque adjustment	- 10% ~ +10%
Automatic recognition	Automatic detection and recognition of the connected tool as soon as the controller is switched on
Error display	System and communication error codes (3 groups)
Monitoring of screwing quality	Checking the screwing data (OK/NOK) with angle control
SD card	Includes 1 industrial SD card 8GB
Weight (kg)	2.5
Size (mm)	146(L) x 114(H) x 203(W)
Reference	2582610 (+ cable 2582609)

ADDITIONAL ACCESSORIES

6 HEX SPINDLE SR See page 62

PNEUMATIC INSTALLATION DEVICES

PNEUMATIC EQUIPMENT FOR ALL AMECOIL® TYPES

Pneumatic installation tools are recommended for all AMECOIL® insert diameters larger than M12. This type of tool is also suitable to install AMECOIL Strip Feed® threads

Metric	ALL TYPES AMECOIL® Body + Motor			
M2.5 x 45	2511210			
M3 x 50				
M4 x 70				
M5 x 80				
M6 x 100				
M7 x 100		2511607	2511614	
M8 x 100				
M8 x 125				
M9 x 125				
M10 x 100				
M10 x 125				
M10 x 150				
M11 x 150				
M12 x 100				
M12 x 125				
M12 x 150				
M12 x 175				
M14 x 125				2591418
M14 x 150				
M14 x 200				
M16 x 150				
M16 x 200				
M18 x 150				
M18 x 200				
M18 x 250				
M20 x 150				
M20 x 200				
M20 x 250				
M22 x 200				
M22 x 250				
M24 x 150				
M24 x 200				
M24 x 300				

ADDITIONAL ACCESSORIES

Equipment for AMECOIL® in bulk
(page 63)

Complete equipment for AMECOIL BP®
(page 63)

AMECOIL SR® SPECIFIC PNEUMATIC EQUIPMENT

The specific pneumatic installation tool AMECOIL SR® is recommended for the installation of Wire Thread Inserts from M12 to M18. The depth stop can be easily adjusted and the hexagon spindle can be interchanged for the installation of different sizes.

Metric	SPECIFIC AMECOIL SR® Body + Motor	
M2.5 x 45	258502	
M3 x 50		
M4 x 70		
M5 x 80		
M6 x 100		
M7 x 100		
M8 x 100		
M8 x 125		
M9 x 125		
M10 x 100		
M10 x 125		
M10 x 150		
M11 x 150		
M12 x 100		
M12 x 125		
M12 x 150		
M12 x 175		
M14 x 125		258503
M14 x 150		
M14 x 200		
M16 x 150		
M16 x 200		
M18 x 150		
M18 x 200		
M18 x 250		
M20 x 150		
M20 x 200		
M20 x 250		
M22 x 200		
M22 x 250		
M24 x 150		
M24 x 200		
M24 x 300		

ADDITIONAL ACCESSORIES

6 HEX SPINDLE SR See page 62

ACCESSORIES FOR INSTALLATION DEVICES

HEX SPINDLE SR

The hexagonal spindle is used to install AMECOIL SR® Wire Thread Inserts. It fits on electric screwdrivers and the specific pneumatic installation tool for AMECOIL SR®.

Metric	SR Spindle Part numbers	SR AR spindle Part numbers
M2.5 x 45	3511125045	3512125045
M3 x 50	3511103050	3512103050
M4 x 70	3511104070	3512104070
M5 x 80	3511105080	3512105080
M6 x 100	3511106100	3512106100
M7 x 100	3511107100	
M8 x 100	3511108100	
M8 x 125	3511105125	
M9 x 125	3511109125	
M10 x 100	3511110100	
M10 x 125	3511110125	
M10 x 150	3511110150	
M11 x 150	3511111150	
M12 x 125	3511112125	
M12 x 150	3511112150	
M12 x 175	3511112175	
M14 x 125	3511114125	
M14 x 150	3511114150	
M14 x 200	3511114200	
M16 x 150	3511116150	
M16 x 200	3511116200	
M18 x 250	3511118250	
M20 x 250	3511120250	
M24 x 300	3511124300	

PNEUMATIC EQUIPMENT FOR ALL AMECOIL® TYPES

The equipment compatible with the AMECOIL® and AMECOIL SR® pneumatic thread applicator is adaptable according to the type of the installation in bulk or strip feed Wire Thread Inserts.

Complete equipment for AMECOIL® in bulk

Complete equipment for AMECOIL BP®

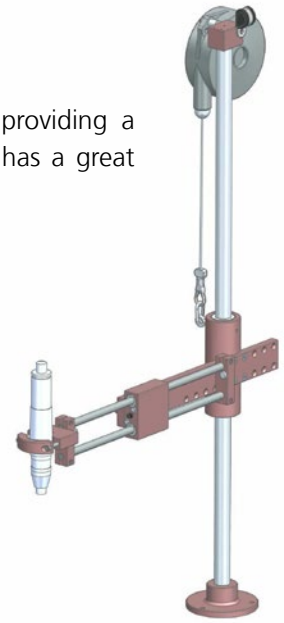
Metric	Complete equipment AMECOIL bulk				Complete equipment for AMECOIL Strip Feed		
					1D	1.25/ 2D	2.5D
M2.5 x 45	25125				251253	251255	251254
M2.5 x 45 AF	251252				251256	251257	251258
M3 x 50	25103				251033	251035	251034
M3 x 50 AF	251032				251036	251037	251038
M4 x 70	25104				251043	251045	251044
M4 x 70 AF	251042				251043	251045	251044
M5 x 80	25105				251053	251055	251054
M5 x 80 AF	251052				251053	251055	251054
M6 x 100	25106				251063	251065	251064
M6 x 100 AF	25107				251063	251065	251064
M7 x 100	25107				On request		
M8 x 100	251081						
M8 x 125	25108						
M10 x 100	251101						
M10 x 125	251102						
M10 x 150	25110						
M12 x 100	251121						
M12 x 125	251122						
M12 x 150	251123						
M12 x 175	25112						
M14 x 125	DEVICE 2511614	259141251	DEVICE 2591418	-			
M14 x 150		259141501		251143			
M14 x 200		259142001		25114			
M16 x 150		259161501		251163			
M16 x 200		259162001		25116			
M18 x 150		259181501		251181			
M18 x 200				251182			
M18 x 250				25118			
M20 x 150				251201			
M20 x 200				251202			
M20 x 250				25120			
M24 x 150				251241			
M24 x 200				251242			

BEAM/ARM FOR ELECTRIC SCREWDRIVERS

LINEAR ARM

APPLICATIONS

The linear torque arm solves most workstation ergonomic issues by providing a mounting bracket for electric screwdrivers and pneumatic fasteners. It has a great flexibility for movement control in the workstation.



ADVANTAGES

- Elimination of musculoskeletal disorders
- Perpendicularity of the tool in relation to the assembly
- Flexible operation due to bearings
- Improvement of the operator's comfort

TECHNICAL CHARACTERISTICS

Model	BA 12	BA 25
Max. torque (Nm)	12	25
Ø tool (mm)	27 - 50	28 - 52
Stroke	225	250
Maximum load (kg)	1, 2	2.2
Reference	251325120	251325250

ADDITIONAL ARTICLES

Electric screwdrivers (pages 56 - 59)

Mounting ring to adapt electric screwdrivers to the Cartesian arm (pages 64 - 65)

MOUNTING RING for GXT 120: p/n 3503041

MOUNTING RING for GXT 220: p/n 3503051

Pneumatic screwdrivers (pages 60 - 61)

ARTICULATED ARM

APPLICATIONS

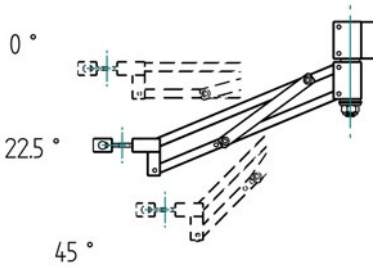
The articulated arm has a rotating joint allowing a very high flexibility of operation. Mobile and foldable, like a human arm, it is particularly suitable for small work spaces.

ADVANTAGES

- Avoids the torque reaction effect
- Optimized performance/size ratio
- Relief of the effort developed by the operator

TECHNICAL CHARACTERISTICS

Model	BA 12 R	BA 25 R
Max. torque (Nm)	12	25
Ø tool (mm)	27 - 50	28 - 52
Maximum load (kg)	1, 2	2.2
Max. radius (mm) at 22.5	450	460
Reference	251325120R	251325250R



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Pneumatic screwdrivers (pages 60 - 61)

Notes

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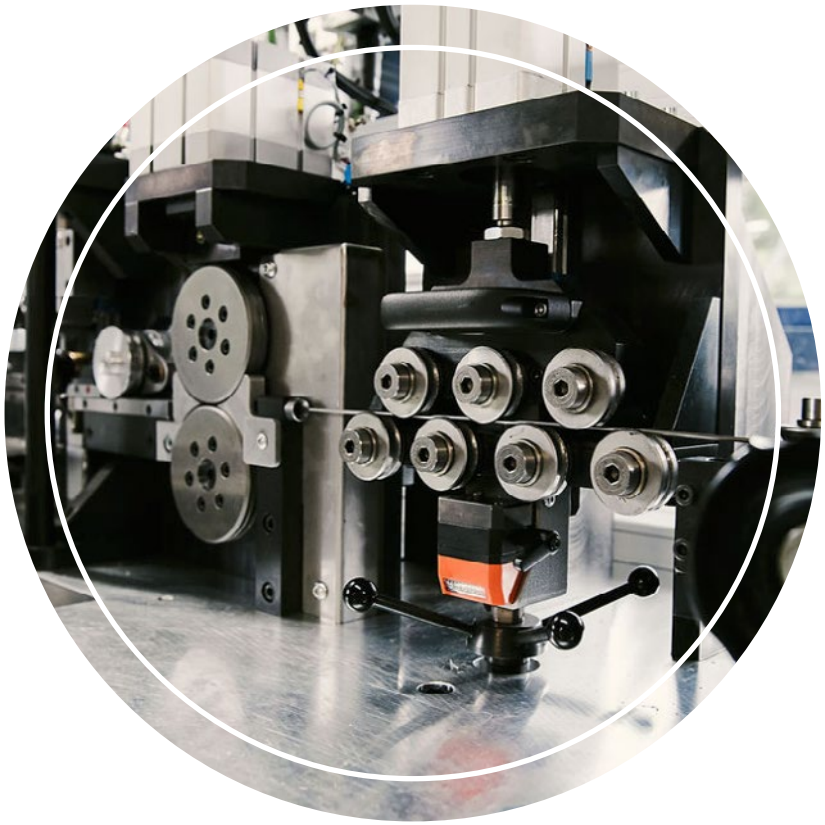
ALL MECHANICAL FASTENERS IN A COMPLETE AND UNIQUE RANGE



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