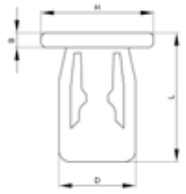
Jacknut



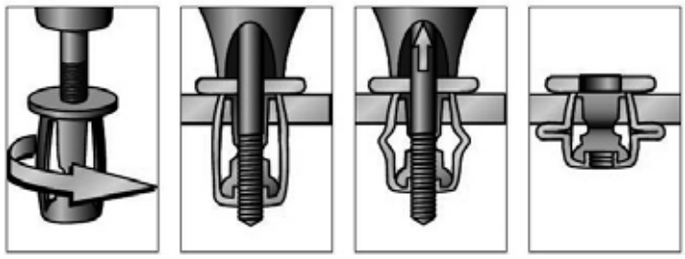
Technical data

3

Type	4SJN	6SJN	8SJN
For nom. size	M4	M5	M6
Hole ø ≈	8,25	9,95	11,25
Material thickness (min.)	0,4	0,4	0,4
Material thickness (max.)	4,8	4,8	4,8
D	7,8	9,7	11,1
H	11,9	13,5	15,9
B	1,9	1,9	1,9
L	16,6	18,2	18,6
Assembly data			
Tightening torque in Nm	1,3	2,2	3,4
Pull-out force in kN	1,4	2,8	4,7

- Assembly data: values valid for 1,5mm steel plate

Assembly sequence

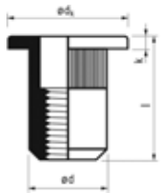


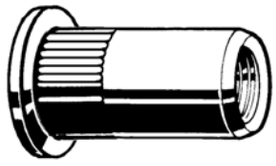
65411 Jacknut **N61B**

Thread	Metric thread
Material	Steel
Surface treatment	Zinc plated
Packaging	Standard

Type	✉	Art.number	Type	✉	Art.number	Type	✉	Art.number
4SJN	100	65411.040.015	6SJN	100	65411.050.017	8SJN	100	65411.060.018

Blind rivet nuts cylindrical Stainless steel open serrated shank



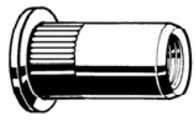


Technical data

Type	ø d	l [+0,5/-0]	Grip range	Drill ø	ø d_k	k	ø d [+0/-0,2]
4 OCH 30	M4	11,0	0,5-3,0	6,0	9,0	≤ 1,1	5,9
4 OCH 55	M4	14,0	3,0-5,5	6,0	9,0	≤ 1,1	5,9
5 OCH 30	M5	13,0	0,5-3,0	7,0	10,0	≤ 1,1	6,9
5 OCH 55	M5	16,0	3,0-8,0	7,0	10,0	≤ 1,1	6,9
5 OCH 80	M5	19,0	5,5-8,0	7,0	10,0	≤ 1,1	6,9
6 OCH 30	M6	16,0	0,5-3,0	9,0	12,0	≤ 1,6	8,9
6 OCH 55	M6	18,5	3,0-5,5	9,0	12,0	≤ 1,6	8,9
8 OCH 30	M8	17,5	0,5-3,0	11,0	15,0	≤ 1,6	10,9
8 OCH 55	M8	20,0	3,0-5,5	11,0	15,0	≤ 1,6	10,9
10 OCH 30	M10	19,0	0,5-3,0	13,0	16,0	≤ 2,1	12,9
10 OCH 60	M10	24,0	3,0-6,0	13,0	16,0	≤ 2,1	12,9

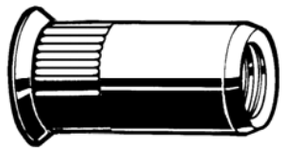
69025 **Blind rivet nuts cylindrical Stainless steel open serrated shank** **F07A**

Material Stainless steel A2
Packaging Standard



Type	✉	Art.number	Type	✉	Art.number	Type	✉	Art.number
4 OCH 30	250	69025.040.030	6 OCH 30	250	69025.060.030	10 OCH 30	250	69025.100.030
5 OCH 30	250	69025.050.030	6 OCH 55	250	69025.060.055	10 OCH 60	250	69025.100.060
5 OCH 55	250	69025.050.055	8 OCH 30	250	69025.080.030			
5 OCH 80	250	69025.050.080	8 OCH 55	250	69025.080.055			

Blind rivet nuts countersunk open Stainless steel serrated shank

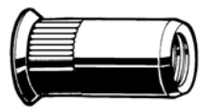


Technical data

Type	4 OCSH 40	5 OCSH 40	6 OCSH 40	8 OCSH 40	10 OCSH 45
ø d	M4	M5	M6	M8	M10
l [+0,5/-0]	12,5	13,5	15,5	18,5	21,0
Grip range	1,5-4,0	1,5-4,0	1,5-4,0	1,5-4,0	2,0-4,5
Drill ø	6,0	7,0	9,0	11,0	13,0
ø d_k	8,5	9,5	11,5	13,5	15,5
k	≤ 1,5	≤ 1,5	≤ 1,5	≤ 1,5	≤ 1,8
ø d [+0/-0,2]	5,9	6,9	8,9	10,9	12,9

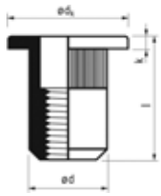
69045 **Blind rivet nuts countersunk open Stainless steel serrated shank** **F07A**

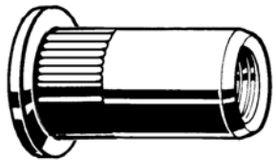
Material Stainless steel A2
Packaging Standard



Type	✉	Art.number	Type	✉	Art.number	Type	✉	Art.number
4 OCSH 40	250	69045.040.040	6 OCSH 40	250	69045.060.040	10 OCSH 45	250	69045.100.045
5 OCSH 40	250	69045.050.040	8 OCSH 40	250	69045.080.040			

Blind rivet nuts cylindrical Steel zinc open serrated shank



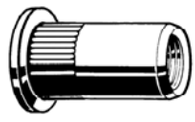


Technical data

Type	ø d	l [+0,5/-0]	Grip range	Drill ø	ø d_k	k	ø d [+0/-0,2]
3 OCH 30	M3	10,5	0,5-3,0	5,0	7,0	≤ 0,9	4,9
3 OCH 55	M3	13,0	3,0-5,5	5,0	7,0	≤ 0,9	4,9
4 OCH 30	M4	11,0	0,5-3,0	6,0	9,0	≤ 1,1	5,9
4 OCH 55	M4	14,0	3,0-5,5	6,0	9,0	≤ 1,1	5,9
5 OCH 30	M5	13,0	0,5-3,0	7,0	10,0	≤ 1,1	6,9
5 OCH 55	M5	16,0	3,0-5,5	7,0	10,0	≤ 1,1	6,9
5 OCH 80	M5	149,0	5,5-8,0	7,0	10,0	≤ 1,1	6,9
6 OCH 30	M6	16,0	0,5-3,0	9,0	12,0	≤ 1,6	8,9
6 OCH 55	M6	18,5	3,0-5,5	9,0	12,0	≤ 1,6	8,9
6 OCH 80	M6	21,0	5,5-8,0	9,0	12,0	≤ 1,6	8,9
8 OCH 30	M8	17,5	0,5-3,0	11,0	15,0	≤ 1,6	10,9
8 OCH 55	M8	20,0	3,0-5,5	11,0	15,0	≤ 1,6	10,9
8 OCH 80	M8	22,5	5,5-9,0	11,0	15,0	≤ 1,6	10,9
8 OCH 105	M8	25,0	8,0-10,5	11,0	15,0	≤ 1,6	10,9
10 OCH 30	M10	19,0	0,5-3,0	12,0	16,0	≤ 2,1	11,9
10 OCH 60	M10	24,0	3,0-6,0	12,0	16,0	≤ 2,1	11,9
10 OCH 90	M10	27,0	6,0-9,0	12,0	16,0	≤ 2,1	11,9
10 OCH 120	M10	30,0	9,0-12,0	12,0	16,0	≤ 2,1	11,9
12 OCH 40	M12	25,0	1,0-4,0	16,0	22,0	≤ 2,1	15,9
12 OCH 70	M12	28,0	4,0-7,0	16,0	22,0	≤ 2,1	15,9
12 OCH 100	M12	31,0	7,0-10,0	16,0	22,0	≤ 2,1	15,9

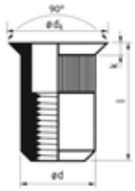
69135 **Blind rivet nuts cylindrical Steel zinc open serrated shank** **F07A**

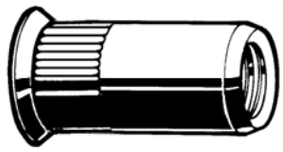
Material Steel
Surface treatment Zinc plated
Packaging Standard



Type	✉	Art.number	Type	✉	Art.number	Type	✉	Art.number
4 OCH 30	250	69135.040.030	6 OCH 80	250	69135.060.080	10 OCH 90	100	69135.100.090
4 OCH 55	250	69135.040.055	8 OCH 30	250	69135.080.030	10 OCH 120	100	69135.100.120
5 OCH 30	250	69135.050.030	8 OCH 55	250	69135.080.055	12 OCH 40	100	69135.120.040
5 OCH 55	250	69135.050.055	8 OCH 80	250	69135.080.080	12 OCH 70	100	69135.120.070
5 OCH 80	250	69135.050.080	8 OCH 105	250	69135.080.105	12 OCH 100	100	69135.120.100
6 OCH 30	250	69135.060.030	10 OCH 30	250	69135.100.030			
6 OCH 55	250	69135.060.055	10 OCH 60	250	69135.100.060			

Blind rivet nuts countersunk open Steel zinc serrated shank





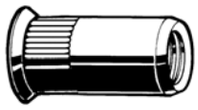
Technical data

3

Type	ø d	l [+0,5/-0]	Grip range	Drill ø	ø d_k	k	ø d [+0/-0,2]
3 OCSH 40	M3	11,5	1,5-4,0	5,0	7,5	≤ 1,5	4,9
3 OCSH 65	M3	14,0	4,0-6,5	5,5	7,5	≤ 1,5	4,9
4 OCSH 40	M4	12,5	1,5-4,0	6,0	8,5	≤ 1,5	5,9
4 OCSH 65	M4	15,0	4,0-6,5	6,0	8,5	≤ 1,5	5,9
5 OCSH 40	M5	13,5	1,5-4,0	7,0	9,5	≤ 1,5	6,9
5 OCSH 65	M5	16,0	4,0-6,5	7,0	9,5	≤ 1,5	6,9
5 OCSH 90	M5	18,5	6,5-9,0	7,0	9,5	≤ 1,5	6,9
6 OCSH 40	M6	15,5	1,4-4,0	9,0	11,5	≤ 1,5	8,9
6 OCSH 65	M6	18,0	4,0-6,5	9,0	11,5	≤ 1,5	8,9
6 OCSH 90	M6	20,5	6,5-9,0	9,0	11,5	≤ 1,5	8,9
8 OCSH 40	M8	18,5	1,5-4,0	11,0	13,5	≤ 1,5	10,9
8 OCSH 65	M8	21,0	4,0-6,5	11,0	13,5	≤ 1,5	10,9
8 OCSH 90	M8	233,5	6,5-9,0	11,0	13,5	≤ 1,5	10,9
10 OCSH 45	M10	21,0	2,0-4,5	12,0	14,5	≤ 1,7	11,9
10 OCSH 75	M10	24,0	4,5-7,5	12,0	14,5	≤ 1,7	11,9
10 OCSH 105	M10	27,0	7,5-10,5	12,0	14,5	≤ 1,7	11,9
12 OCSH 45	M12	24,5	2,0-4,5	16,0	19,0	≤ 1,9	15,9
12 OCSH 75	M12	27,5	4,5-7,5	16,0	19,0	≤ 1,9	15,9
12 OCSH 105	M12	31,0	7,5-10,5	16,0	19,0	≤ 1,9	15,9

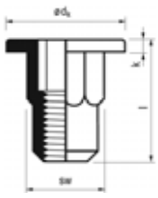
69155 **Blind rivet nuts countersunk open Steel zinc serrated shank** **F07A**

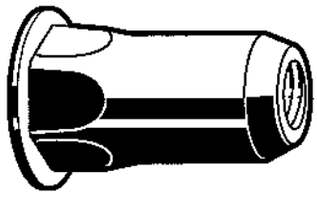
Material Steel
Surface treatment Zinc plated
Packaging Standard



Type	✉	Art.number	Type	✉	Art.number	Type	✉	Art.number
4 OCSH 40	250	69155.040.040	6 OCSH 65	250	69155.060.065	10 OCSH 75	250	69155.100.075
4 OCSH 65	250	69155.040.065	6 OCSH 90	250	69155.060.090	10 OCSH 105	100	69155.100.105
5 OCSH 40	250	69155.050.040	8 OCSH 40	250	69155.080.040	12 OCSH 45	100	69155.120.045
5 OCSH 65	250	69155.050.065	8 OCSH 65	250	69155.080.065	12 OCSH 75	100	69155.120.075
5 OCSH 90	250	69155.050.090	8 OCSH 90	250	69155.080.090	12 OCSH 105	100	69155.120.105
6 OCSH 40	250	69155.060.040	10 OCSH 45	250	69155.100.045			

Blind rivet nuts cylindrical Steel zinc open hexagon shank





Technical data

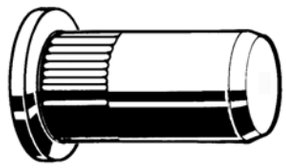
Type	4 OCH 20	5 OCH 30	6 OCH 30	8 OCH 35	10 OCH 35
ø d	M4	M5	M6	M8	M10
L	10,5	13,0	16,0	17,0	23,0
Grip range	0,3-2,0	0,7-3,0	0,5-3,0	0,5-3,5	0,8-3,5
Hole hexagon	6,0	7,0	9,0	11,0	13,0
ø d_k	9,0	10,0	13,0	16,0	19,0
k	≤ 0,8	≤ 1,0	≤ 1,5	≤ 1,5	≤ 2,0
W.a.f. (s)	5,9	6,9	8,9	10,9	12,9

69170 **Blind rivet nuts cylindrical Steel zinc open hexagon shank** **F07A**

Material Steel
Surface treatment Zinc plated
Packaging Standard

Type	✉	Art.number	Type	✉	Art.number	Type	✉	Art.number
4 OCH 20	250	69170.040.020	6 OCH 30	250	69170.060.030	10 OCH 35	250	69170.100.035
5 OCH 30	250	69170.050.030	8 OCH 35	250	69170.080.035			

Blind rivet nuts cylindrical Steel zinc serrated shank



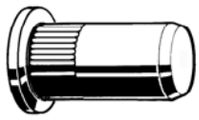
Technical data

3

Type	ø d	l [+0,5/-0]	Grip range	Drill ø	ø d_k	k	ø d [+0/-0,2]
3 CCH 30	M3	15,0	0,5-3,0	5,0	7,0	≤ 0,9	4,9
3 CCH 55	M3	17,5	3,0-5,5	5,0	7,0	≤ 0,9	4,9
4 CCH 30	M4	16,0	0,5-3,0	6,0	9,0	≤ 1,1	5,9
4 CCH 55	M4	19,0	3,0-5,5	6,0	9,0	≤ 1,1	5,9
5 CCH 30	M5	18,5	0,5-3,0	7,0	10,0	≤ 1,1	6,9
5 CCH 55	m5	21,5	3,0-5,5	7,0	10,0	≤ 1,1	6,9
5 CCH 80	M5	24,5	5,5-8,0	7,0	10,0	≤ 1,1	6,9
6 CCH 30	M6	21,5	0,5-3,0	9,0	12,0	≤ 1,6	8,9
6 CCH 55	M6	24,0	3,0-5,5	9,0	12,0	≤ 1,6	8,9
6 CCH 80	M6	26,5	5,5-8,0	9,0	12,0	≤ 1,6	8,9
8 CCH 30	M8	26,0	0,5-3,0	11,0	15,0	≤ 1,6	10,9
8 CCH 55	M8	28,5	3,0-5,5	11,0	15,0	≤ 1,6	10,9
8 CCH 80	M8	31,0	5,5-8,0	11,0	15,0	≤ 1,6	10,9
8 CCH 105	M8	33,5	8,0-10,5	11,0	15,0	≤ 1,6	10,9
10 CCH 30	M10	28,0	0,5-3,0	12,0	16,0	≤ 2,1	11,9
10 CCH 60	M10	33,0	3,0-6,0	12,0	16,0	≤ 2,1	11,9
10 CCH 90	M10	36,0	6,0-9,0	12,0	16,0	≤2,1	11,9
10 CCH 120	M10	39,0	9,0-12,0	12,0	16,0	≤ 2,1	11,9

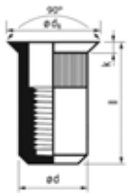
69190 Blind rivet nuts cylindrical Steel zinc serrated shank **F07A**

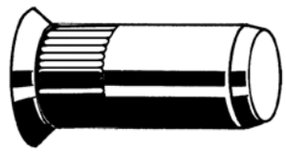
Material Steel
Surface treatment Zinc plated
Packaging Standard



Type	✉	Art.number	Type	✉	Art.number	Type	✉	Art.number
4 CCH 30	250	69190.040.030	6 CCH 55	250	69190.060.055	10 CCH 30	250	69190.100.030
4 CCH 55	250	69190.040.055	6 CCH 80	250	69190.060.080	10 CCH 60	250	69190.100.060
5 CCH 30	250	69190.050.030	8 CCH 30	250	69190.080.030	10 CCH 90	100	69190.100.090
5 CCH 55	250	69190.050.055	8 CCH 55	250	69190.080.055	10 CCH 120	100	69190.100.120
5 CCH 80	250	69190.050.080	8 CCH 80	250	69190.080.080			
6 CCH 30	250	69190.060.030	8 CCH 105	250	69190.080.105			

Blind rivet nuts countersunk Steel zinc serrated shank



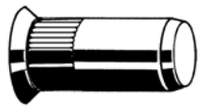


Technical data

Type	ø d	l [+0,5/-0]	Grip range	Drill ø	ø d_k	k	ø d [+0/-0,2]
3 CCSH 40	M3	16,0	1,5-4,0	5,0	7,5	≤ 1,5	4,9
3 CCSH 65	M3	18,5	4,0-6,5	5,0	7,5	≤ 1,5	4,9
4 CCSH 40	M4	17,5	1,5-4,0	6,0	8,5	≤ 1,5	5,9
4 CCSH 65	M4	20,0	4,0-6,5	6,0	8,5	≤ 1,5	5,9
5 CCSH 40	M5	20,0	1,5-4,0	7,0	9,5	≤ 1,5	6,9
5 CCSH 65	M5	22,5	4,0-6,5	7,0	9,5	≤ 1,5	6,9
5 CCSH 90	M5	25,0	6,5-9,0	7,0	9,5	≤ 1,5	6,9
6 CCSH 40	M6	23,0	1,5-4,0	8,0	11,5	≤ 1,5	8,9
6 CCSH 65	M6	25,5	4,0-6,5	8,0	11,5	≤ 1,5	8,9
6 CCSH 90	M6	28,0	6,5-9,0	8,0	11,5	≤ 1,5	8,9
8 CCSH 40	M8	27,0	1,5-4,0	11,0	13,5	≤ 1,5	10,9
8 CCSH 65	M8	29,5	4,0-6,5	11,0	13,5	≤ 1,5	10,9
8 CCSH 90	M8	32,0	6,5-9,0	11,0	13,5	≤ 1,5	10,9
10 CCSH 45	M10	30,0	2,0-4,5	12,0	14,5	≤ 1,7	11,9
10 CCSH 75	M10	33,0	4,5-7,5	12,0	14,5	≤ 1,7	11,9
10 CCSH 105	M10	36,0	7,5-10,5	12,0	14,5	≤ 1,7	11,9
12 CCSH 45	M12	34,5	2,0-4,5	16,0	19,0	≤ 1,9	15,9
12 CCSH 75	M12	37,5	4,5-7,5	16,0	19,0	≤ 1,9	15,9
12 CCSH 110	M12	41,0	7,5-11,0	16,0	19,0	≤ 1,9	15,9

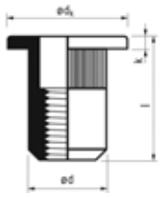
69195 **Blind rivet nuts countersunk Steel zinc serrated shank** **F07A**

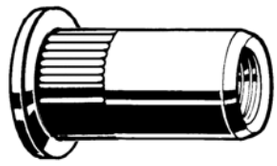
Material Steel
Surface treatment Zinc plated
Packaging Standard



Type	✉	Art.number	Type	✉	Art.number	Type	✉	Art.number
4 CCSH 40	250	69195.040.040	6 CCSH 65	250	69195.060.065	10 CCSH 75	250	69195.100.075
4 CCSH 65	250	69195.040.065	6 CCSH 90	250	69195.060.090	10 CCSH 105	100	69195.100.105
5 CCSH 40	250	69195.050.040	8 CCSH 40	250	69195.080.040	12 CCSH 45	100	69195.120.045
5 CCSH 65	250	69195.050.065	8 CCSH 65	250	69195.080.065	12 CCSH 75	100	69195.120.075
5 CCSH 90	250	69195.050.090	8 CCSH 90	250	69195.080.090	12 CCSH 110	100	69195.120.110
6 CCSH 40	250	69195.060.040	10 CCSH 45	250	69195.100.045			

Blind rivet nuts cylindrical aluminium open serrated shank





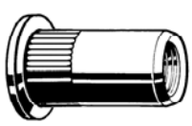
Technical data

3

Type	ø d	l [+0,5/-0]	Grip range	Drill ø	ø d_k	k	ø d [+0/-0,2]
3 OCH 30	M3	10,5	0,5-3,0	5,0	7,0	≤ 0,9	4,9
3 OCH 55	M3	13,0	3,0-5,5	5,0	7,0	≤ 0,9	4,9
4 OCH 30	M4	11,0	0,5-3,0	6,0	9,0	≤ 1,1	5,9
4 OCH 55	M4	14,0	3,0-5,5	6,0	9,0	≤ 1,1	5,9
5 OCH 30	M5	13,0	0,5-3,0	7,0	10,0	≤ 1,1	6,9
5 OCH 55	M5	16,0	3,0-5,5	7,0	10,0	≤ 1,1	6,9
5 OCH 80	M5	19,0	5,5-8,0	7,0	10,0	≤ 1,1	6,9
6 OCH 30	M6	16,0	0,5-3,0	9,0	12,0	≤ 1,6	8,9
6 OCH 55	M6	18,5	3,0-5,5	9,0	12,0	≤ 1,6	8,9
6 OCH 80	M6	21,0	5,5-8,0	9,0	12,0	≤ 1,6	8,9
8 OCH 30	M8	17,5	0,5-3,0	11,0	15,0	≤ 1,6	10,9
8 OCH 55	M8	20,0	3,0-5,5	11,0	15,0	≤ 1,6	10,9
8 OCH 80	M8	22,5	5,5-8,0	11,0	15,0	≤ 1,6	10,9
8 OCH 105	M8	25,0	8,0-10,5	11,0	15,0	≤ 1,6	10,9
10 OCH 30	M10	19,0	0,5-3,0	12,0	16,0	≤ 2,1	11,9
10 OCH 60	M10	24,0	3,0-6,0	12,0	16,0	≤ 2,1	11,9
10 OCH 90	M10	27,0	6,0-9,0	12,0	16,0	≤ 2,1	11,9
10 OCH 120	M10	30,0	9,0-12,0	12,0	16,0	≤ 2,1	11,9
12 OCH 40	M12	25,0	1,0-4,0	16,0	22,0	≤ 2,1	15,9
12 OCH 70	M12	28,0	4,0-7,0	16,0	22,0	≤ 2,1	15,9
12 OCH 100	M12	31,0	7,0-10,0	16,0	22,0	≤ 2,1	15,9

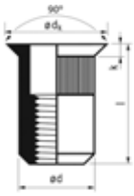
69315 **Blind rivet nuts cylindrical aluminium open serrated shank** **F07A**

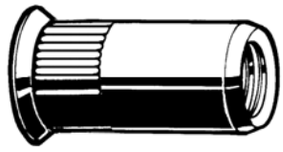
Material Aluminium
Packaging Standard



Type	✉	Art.number	Type	✉	Art.number	Type	✉	Art.number
4 OCH 30	250	69315.040.030	6 OCH 80	250	69315.060.080	10 OCH 60	250	69315.100.060
5 OCH 30	250	69315.050.030	8 OCH 30	250	69315.080.030	10 OCH 90	100	69315.100.090
5 OCH 55	250	69315.050.055	8 OCH 55	250	69315.080.055	10 OCH 120	100	69315.100.120
5 OCH 80	250	69315.050.080	8 OCH 80	250	69315.080.080	12 OCH 40	100	69315.120.040
6 OCH 30	250	69315.060.030	8 OCH 105	250	69315.080.105	12 OCH 70	100	69315.120.070
6 OCH 55	250	69315.060.055	10 OCH 30	250	69315.100.030	12 OCH 100	100	69315.120.100

Blind rivet nuts countersunk open aluminium serrated shank



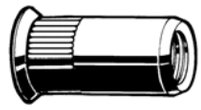


Technical data

Type	ø d	l [+0,5/-0]	Grip range	Drill ø	ø d_k	k	ø d [+0/-0,2]
3 OCSH 40	M3	11,5	1,5-4,0	5,0	7,5	≤ 1,5	4,9
3 OCSH 65	M3	14,0	4,0-6,5	5,0	7,5	≤ 1,5	4,9
4 OCSH 40	M4	12,5	1,5-4,0	6,0	8,5	≤ 1,5	5,9
4 OCSH 65	M4	15,0	4,0-6,5	6,0	8,5	≤	5,9
5 OCSH 40	M5	13,5	1,5-4,0	7,0	9,5	≤ 1,5	6,9
5 OCSH 65	M5	16,0	4,0-6,5	7,0	≤ 1,5	6,9	-
5 OCSH 90	M5	18,5	6,5-9,0	7,0	9,5	≤ 1,5	6,9
6 OCSH 40	M6	15,5	1,5-4,0	9,0	11,5	≤ 1,5	8,9
6 OCSH 65	M6	18,0	4,0-6,5	9,0	11,5	≤ 1,5	8,9
6 OCSH 90	M6	20,5	6,5-9,0	9,0	11,5	≤ 1,5	8,9
8 OCSH 40	M8	18,5	1,5-4,0	11,0	13,5	≤ 1,5	10,9
8 OCSH 65	M8	21,0	4,0-6,5	11,0	13,5	≤ 1,5	10,9
8 OCSH 90	M8	23,5	6,5-9,0	11,0	13,5	≤ 1,5	10,9
10 OCSH 45	M10	21,0	2,0-4,5	12,0	14,5	≤ 1,7	11,9
10 OCSH 75	M10	24,0	4,5-7,5	12,0	14,5	≤ 1,7	11,9
10 OCSH 105	M10	27,0	7,5-10,5	12,0	14,5	≤ 1,7	11,9
12 OCSH 45	M12	24,5	2,0-4,5	16,0	19,0	≤ 1,9	15,9
12 OCSH 75	M12	27,5	4,5-7,5	16,0	19,0	≤ 1,9	15,9
12 OCSH 105	M12	31,0	7,5-10,5	16,0	19,0	≤ 1,9	15,9

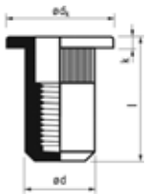
69335 **Blind rivet nuts countersunk open aluminium serrated shank** **F07A**

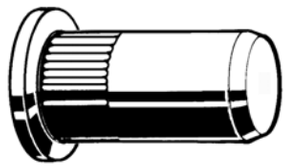
Material Aluminium
Packaging Standard



Type	✉	Art.number	Type	✉	Art.number	Type	✉	Art.number
4 OCSH 40	250	69335.040.040	6 OCSH 90	250	69335.060.090	10 OCSH 105	100	69335.100.105
5 OCSH 40	250	69335.050.040	8 OCSH 40	250	69335.080.040	12 OCSH 45	100	69335.120.045
5 OCSH 65	250	69335.050.065	8 OCSH 65	250	69335.080.065	12 OCSH 75	100	69335.120.075
5 OCSH 90	250	69335.050.090	8 OCSH 90	250	69335.080.090	12 OCSH 105	100	69335.120.105
6 OCSH 40	250	69335.060.040	10 OCSH 45	250	69335.100.045			
6 OCSH 65	250	69335.060.065	10 OCSH 75	250	69335.100.075			

Blind rivet nuts cylindrical aluminium serrated shank





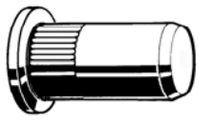
Technical data

3

Type	ø d	l [+0,5/-0]	Grip range	Drill ø	ø d_k	k	ø d [+0/-0,2]
3 CCH 30	M3	15,0	0,5-3,0	5,0	7,0	≤ 0,9	4,9
3 CCH 55	M3	17,5	3,0-5,5	5,0	7,0	≤ 0,9	4,9
4 CCH 30	M4	16,0	0,5-3,0	6,0	9,0	≤ 1,1	5,9
4 CCH 55	M4	19,0	3,0-5,5	6,0	9,0	≤ 1,1	5,9
5 CCH 30	M5	18,5	0,5-3,0	7,0	10,0	≤ 1,1	6,9
5 CCH 55	M5	21,5	3,0-5,5	7,0	10,0	≤ 1,1	6,9
5 CCH 80	M5	24,5	5,5-8,0	7,0	10,0	≤ 1,1	6,9
6 CCH 30	M6	21,5	0,5-3,0	9,0	12,0	≤ 1,6	8,9
6 CCH 55	M6	24,0	3,0-5,5	9,0	12,0	≤ 1,6	8,9
6 CCH 80	M6	26,5	5,5-8,0	9,0	12,0	≤ 1,6	8,9
8 CCH 30	M8	26,0	0,5-3,0	11,0	15,0	≤ 1,6	10,9
8 CCH 55	M8	28,5	3,0-5,5	11,0	15,0	≤ 1,6	10,9
8 CCH 80	M8	31,0	5,5-8,0	11,0	15,0	≤ 1,6	10,9
8 CCH 105	M8	33,5	8,0-10,5	11,0	15,0	≤ 1,6	10,9
10 CCH 30	M10	28,0	0,5-3,0	12,0	16,0	≤ 2,1	11,9
10 CCH 60	M10	33,0	3,0-6,0	12,0	16,0	≤ 2,1	11,9
10 CCH 90	M10	36,0	6,0-9,0	12,0	16,0	≤ 2,1	11,9
10 CCH 120	M10	39,0	9,0-10,5	12,0	16,0	≤ 2,1	11,9

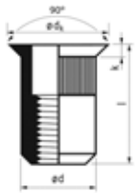
69355 **Blind rivet nuts cylindrical aluminium serrated shank** **F07A**

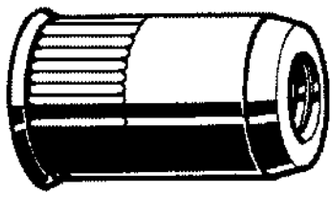
Material Aluminium
Packaging Standard



Type	✉	Art.number	Type	✉	Art.number	Type	✉	Art.number
4 CCH 30	250	69355.040.030	6 CCH 55	250	69355.060.055	8 CCH 105	250	69355.080.105
5 CCH 30	250	69355.050.030	6 CCH 80	250	69355.060.080	10 CCH 30	250	69355.100.030
5 CCH 55	250	69355.050.055	8 CCH 30	250	69355.080.030	10 CCH 60	250	69355.100.060
5 CCH 80	250	69355.050.080	8 CCH 55	250	69355.080.055	10 CCH 90	100	69355.100.090
6 CCH 30	250	69355.060.030	8 CCH 80	250	69355.080.080	10 CCH 120	100	69355.100.120

Blind rivet nuts reduced countersunk open Steel zinc serrated shank



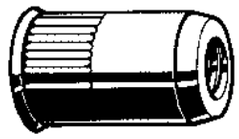


Technical data

Type	3 ORCSH 30	4 ORCSH 30	5 ORCSH 30	6 ORCSH 30	8 ORCSH 30	10 ORCSH 35
ø d	M3	M4	M5	M6	M8	M10
l [+0,5/-0]	9,5	10,0	11,5	14,0	15,0	19,5
Grip range	0,5-3,0	0,5-3,0	0,5-3,0	0,5-3,0	0,5-3,0	0,8-3,5
Drill ø	5,0	6,0	7,0	9,0	11,0	12,0
ø d_k	6,0	7,0	8,0	10,0	12,0	13,5
k	≤ 0,7	≤ 0,7	≤ 0,7	≤ 0,7	≤ 0,7	≤ 0,9
ø d [+0/-0,2]	4,9	5,9	6,9	8,9	10,9	11,9

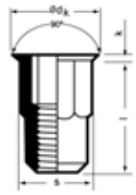
69435 **Blind rivet nuts reduced countersunk open Steel zinc serrated shank** **F07A**

Material Steel
Surface treatment Zinc plated
Packaging Standard



Type	✉	Art.number	Type	✉	Art.number	Type	✉	Art.number
4 ORCSH 30	250	69435.040.030	6 ORCSH 30	250	69435.060.030	10 ORCSH 35	250	69435.100.035
5 ORCSH 30	250	69435.050.030	8 ORCSH 30	250	69435.080.030			

Blind rivet nuts reduced countersunk open Stainless steel hexagon shank



Technical data

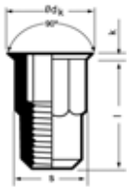
Type	4 ORCSH 30	5 ORCSH 30	6 ORCSH 30	8 ORCSH 30	10 ORCSH 35
ø d	M4	M5	M6	M8	M10
l [+0,5/-0]	12,5	14,0	16,0	17,0	20,5
Grip range	0,5-3,0	0,5-3,0	0,5-3,0	00,5-3,0	0,8-6,5
Hole hexagon	6,1	7,1	9,1	11,1	13,1
ø d_k	7,0	8,0	10,0	12,0	14,5
k	≤ 0,9	≤ 0,9	≤ 0,9	≤ 0,9	≤1,1
W.a.f. (s)	6,0	7,0	9,0	11,0	13,0

69440 **Blind rivet nuts reduced countersunk open Stainless steel hexagon shank** **F07A**

Material Stainless steel A2
Packaging Standard

Type	✉	Art.number	Type	✉	Art.number	Type	✉	Art.number
4 ORCSH 30	250	69440.040.030	6 ORCSH30	250	69440.060.030	10 ORCSH 35	250	69440.100.035
5 ORCSH 30	250	69440.050.030	8 ORCSH 30	250	69440.080.030			

Blind rivet nuts reduced countersunk open Steel zinc hexagon shank



Technical data

3

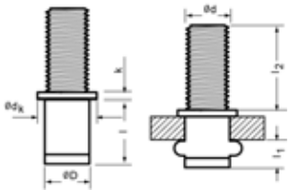
Type	3 ORCSH 30	4 ORCSH 30	5 ORCSH 30	6 ORCSH 30	8 ORCSH 30	10 ORCSH 35
ø d	M3	M4	M5	M6	M8	M10
l [+0,5/-0]	10,5	12,5	14,0	16,0	17,0	20,5
Grip range	0,5-3,0	0,5-3,0	0,5-3,0	0,5-3,0	0,5-3,0	0,8-3,5
Hole hexagon	5,1	6,1	7,1	9,1	11,1	13,1
ø d_k	6,5	7,0	8,0	10,0	12,0	14,5
k	≤ 0,8	≤ 0,8	≤ 0,8	≤ 0,8	≤ 0,8	≤ 0,8
W.a.f. (s)	5,0	6,0	7,0	9,0	11,0	13,0

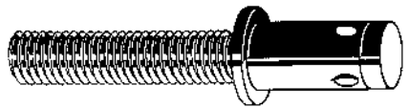
69450 Blind rivet nuts reduced countersunk open Steel zinc hexagon shank **F07A**

Material Steel
Surface treatment Zinc plated
Packaging Standard

Type	✉	Art.number	Type	✉	Art.number	Type	✉	Art.number
4 ORCSH 30	250	69450.040.030	6 ORCSH 30	250	69450.060.030	10 ORCSH 35	250	69450.100.035
5 ORCSH 30	250	69450.050.030	8 ORCSH 30	250	69450.080.030			

Blind rivet screw cylindrical Steel zinc





Technical data

Type	Grip range	Drill ø	ø d_k	k	ø d	L_1	L_2	l [+1/-0,5]
M4X2010	0,5-2,0	5,5	8,0	0,5	5,4	3,5	10	8,0
M4X2015	0,5-2,0	5,5	8,0	0,5	5,4	3,5	15	8,0
M4X3010	2,0-3,0	5,5	8,0	0,5	5,4	4,0	10	8,0
M4X3015	2,0-3,0	5,5	8,0	0,5	5,4	4,0	15	8,0
M5X2010	0,5-2,0	6,6	9,0	0,8	6,5	4,5	10	9,0
M5X2015	0,5-2,0	6,6	9,0	0,8	6,5	4,5	15	9,0
M5X3510	2,0-3,5	6,6	9,0	0,8	6,5	4,5	10	10,5
M5X3515	2,0-3,5	6,6	9,0	0,8	6,5	4,5	15	10,5
M6X2510	0,5-2,5	7,8	10,0	1,0	7,7	5,0	10	10,0
M6X2515	0,5-2,5	7,8	10,0	1,0	7,7	5,0	15	10,0
M6X4010	2,5-4,0	7,8	10,0	1,0	7,7	5,5	10	11,5
M6X4015	2,5-4,0	7,8	10,0	1,0	7,7	5,0	15	11,5
M8X3020	1,0-3,0	9,9	12,0	1,5	9,8	7,0	15	12,5
M8X3515	1,0-3,0	9,9	12,0	1,5	9,8	7,0	20	12,5
M8X5015	3,0-5,0	9,9	12,0	1,5	9,8	7,0	15	15,0
M8X5020	3,0-5,0	9,9	12,0	1,5	9,8	7,0	20	15,0

69975 Blind rivet screw cylindrical Steel zinc **F09A**

Material Steel
Surface treatment Zinc plated
Packaging Standard

Type	✉	Art.number	Type	✉	Art.number	Type	✉	Art.number
M4X2010	250	69975.042.010	M5X3510	250	69975.053.510	M8X3020	250	69975.083.020
M4X2015	250	69975.042.015	M5X3515	250	69975.053.515	M8X3515	250	69975.083.515
M4X3010	250	69975.043.010	M6X2510	250	69975.062.510	M8X5015	250	69975.085.015
M4X3015	250	69975.043.015	M6X2515	250	69975.062.515	M8X5020	250	69975.085.020
M5X2010	250	69975.052.010	M6X4010	250	69975.064.010			
M5X2015	250	69975.052.015	M6X4015	250	69975.064.015			

Blind rivet tool

		M3			M4			M5			M6			M8			M10			M12		
		Al	St	St.st.	Al	St	St.st.	Al	St	St.st.	Al	St	St.st.	Al	St	St.st.	Al	St	St.st.	Al	St	St.st.
F 360																						
F 510																						
F 511																						
F 612																						
FEZ 12																						

additional option

recommended capacity

69685	**Blind rivet tool**	**T90A**
Packaging	Standard	

Type	✉	Art.number	
FEZ 12	1	69685.012.001	• Unique hand tool with built-in transmission of power, allowing setting of large size blind rivet nuts with little effort. • Equipped with stroke setting mechanism and a quick-release mandrel system. • Capacity: M5 - M12. • Weight: 2,5 kg. • Dimensions: 555 mm. • Body: Aluminium. • Lever: Steel. • Equipment: Conversion kit blind rivet nuts M5 - M12.
F 360	1	69685.360.001	• Professional hand tool for setting blind rivet nuts and blind rivet bolts. • Equipped with stroke setting mechanism and quick-release mandrel system. • Capacity: M3 - M6. • Weight: 0,8 kg. • Dimensions: 280 mm. • Body: Aluminium. • Lever: Steel. • Equipment: Conversion kit blind rivet nuts M3 - M6. • Equipment: Conversion kit blind rivet bolts M4 - M6.
F 510	1	69685.510.001	• Powerful tool for setting blind rivet nuts and bolts, equipped with both a stroke setting mechanism ensuring every blind rivet nut and bolt to be set with equal clamping force, and a quick-release mandrel system. • Capacity: M5 - M10. • Weight: 2,2 kg. • Dimensions: 555 mm. • Body: ABS plastic with steel parts. • Lever: Steel. • Equipment: Conversion kit blind rivet nuts M5 - M10. • Equipment: Conversion kit blind rivet bolts M5 - M8.

69685 Blind rivet tool

Type	✉	Art.number	Type	✉	Art.number	Type	✉	Art.number
F 511	1	69685.511.001						
F 612	1	69685.612.001						

- Powerful tool for setting blind rivet nuts and bolts, equipped with both a stroke setting mechanism ensuring every blind rivet nut and bolt to be set with equal clamping force, and a quick-release mandrel system.
- The quick-release spindle provides quick installation.
- Capacity: M5 - M10.
- Weight: 2,4 kg.
- Dimensions: 555 mm.
- Body: ABS plastic with steel parts.
- Lever: Steel.
- Equipment: Conversion kit blind rivet nuts M5 - M10.
- Equipment: Conversion kit blind rivet bolts M5 - M8.

- Powerful compact blind rivet nut tool with built-in ratched key.
- Especially suited to place large size blind rivet nuts in small areas.
- Equipped with ideal stroke setting mechanism and quick-release mandrel system.
- Capacity: M6 - M12.
- Weight: 1,1 kg.
- Dimensions: 210 mm.
- Body: Steel.
- Lever: Steel.
- Equipment: Conversion kit blind rivet nuts M6 - M12.
- Equipment: Conversion kit blind rivet bolts M5 - M8.

Blind rivet nut assortment

69670 Blind rivet nut assortment **F90A**

Packaging Standard

Type	✉	Art.number	
F360	1	69670.360.001	• Set in aluminium case. • F360 Robust hand tool for blind rivet nuts and blind rivet bolts with 6 (x 30 pieces) sizes of rivet nuts: M4, M5, M6 (cylindrical and reduced countersunk).

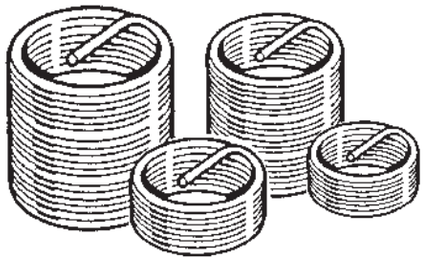
AMECOIL Wire thread inserts

Application
AMECOIL wire thread inserts are not only economical for recovering worn or damaged screw threads but also very suitable to achieve high-loadable internal thread in metal and non-metal materials. AMECOIL wire thread inserts can be used at temperatures from -40°C up to +400°C.

Material
AMECOIL wire thread inserts are produced from a stainless steel A2 wire of diamond cross-section, that is wound in a coil like a spring.

Threads
The internal screw thread of the nut-part of the AMECOIL wire thread insert is conforming to the normal tolerancefield 6H. For details concerning the external screw thread in the material see DIN 8140-2.

Assembly
For assembly of AMECOIL wire thread inserts see also the assembly sequence:
- drill the hole (do not countersink)
- tapping the thread with the special AMECOIL tap, the sizes of the thread of the special AMECOIL taps are larger than of a standard tap!
- screwing in the AMECOIL wire thread insert with AMECOIL manuel fitting tool by 1/4 to 1/2 pitch under the surface of the part
- breaking-off the engaging stem of the AMECOIL wire thread insert up to ø 18 mm after fitting with the AMECOIL tang break, for sizes larger than M18 resp. 5/8 UNC/UNF a pointed plier has to be used
- assembly ready
- disassembly of a AMECOIL wire thread insert is possible with the special extractor.



Guide values for determination of the nominal length L ①

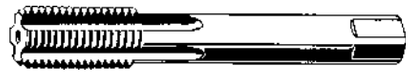
Tensile strenght material R_m in N/mm²		Property class/yield strength bolt in N/mm² ②			
above	up to and incl.	5.8/400	8.8/640	10.9/900	12.9/1080
-	150	2 d	2,5 d	2,5 d	2,5 d
150	200	1,5 d	2 d	2 d	2,5 d
200	250	1,5 d	1,5 d	2 d	2,5 d
250	300	1 d	1,5 d	1,5 d	2 d
300	400	1 d	1 d	1,5 d	1,5 d

① Corresponding to the proofloads of DIN ISO 898-2.

② d = nominal size of the wire thread insert.

Technical brochure available on request.

Machine oversized tap for wire thread insert M



- ATTENTION: the sizes of the thread of the special AMECOIL taps are larger than of a standard tap!
- Technical brochure available on request.

Article groups

Material		Packaging	Code	Page
St HSS		Standard	71310	3-140
St HSS	for blind holes	Standard	71410	3-140

71310 AMECOIL Machine tap oversized for wire thread insert **S91A**

Material Steel HSS
Packaging Standard

d	✉	Art.number	d	✉	Art.number	d	✉	Art.number
M3	1	71310.030.001	M8	1	71310.080.001	M18	1	71310.180.001
M4	1	71310.040.001	M10	1	71310.100.001	M20	1	71310.200.001
M5	1	71310.050.001	M12	1	71310.120.001	M22	1	71310.220.001
M6	1	71310.060.001	M14	1	71310.140.001	M24	1	71310.240.001
M7	1	71310.070.001	M16	1	71310.160.001	M27	1	71310.270.001

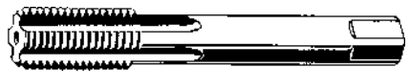
71410 AMECOIL Machine tap oversized for wire thread insert **S91A**

Material Steel HSS
Packaging Standard

d	✉	Art.number	d	✉	Art.number	d	✉	Art.number
M6	1	71410.060.001	M10	1	71410.100.001	M16	1	71410.160.001
M8	1	71410.080.001	M12	1	71410.120.001			

- Recommended for blind holes.
- Machinetap up to and including M8 sharp pointed and over M8 with flat point.

Machine tap for wire thread insert MF



- ATTENTION: the sizes of the thread of the special AMECOIL taps are larger than of a standard tap!
- Technical brochure available on request.

71320 AMECOIL Machine tap for wire thread insert MF **S91A**

Material Steel HSS
Packaging Standard

d x P	✉	Art.number	d x P	✉	Art.number	d x P	✉	Art.number
M8X1,00	1	71320.080.100	M12X1,50	1	71320.120.150	M18X1,50	1	71320.180.150
M10X1,00	1	71320.100.100				M20X1,50	1	71320.200.150
M10X1,25	1	71320.100.125	M14X1,25	1	71320.140.125	M22X1,50	1	71320.220.150
			M14X1,50	1	71320.140.150	M24X1,50	1	71320.240.150
M12X1,00	1	71320.120.100						
M12X1,25	1	71320.120.125	M16X1,50	1	71320.160.150			

Staged tap for spark plug wire thread inserts

- ATTENTION: the sizes of the thread of the special AMECOIL taps are larger than of a standard tap!
- Technical brochure available on request.

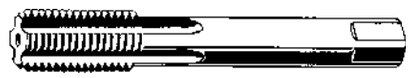
3

71930 AMECOIL Staged tap for spark plug wire thread inserts **S91A**

Material Steel HSS
Packaging Standard

d x P	✉	Art.number	d x P	✉	Art.number	d x P	✉	Art.number
M12X1,25	1	71930.120.125						
M14X1,25	1	71930.140.125						

Machine tap for wire thread insert UNC



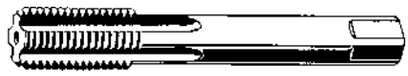
- ATTENTION: the sizes of the thread of the special AMECOIL taps are larger than of a standard tap!
- Technical brochure available on request.

71340 AMECOIL Machine tap for wire thread inserts **S91A**

Material Steel HSS
Packaging Standard

d	✉	Art.number	d	✉	Art.number	d	✉	Art.number
1/4	1	71340.063.001	1/2	1	71340.127.001	7/8	1	71340.222.001
5/16	1	71340.079.001	9/16	1	71340.142.001	1.IN.	1	71340.254.001
3/8	1	71340.096.001	5/8	1	71340.158.001			
7/16	1	71340.111.001	3/4	1	71340.191.001			

Machine tap for wire thread insert UNF



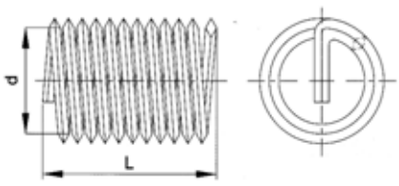
- ATTENTION: the sizes of the thread of the special AMECOIL taps are larger than of a standard tap!
- Technical brochure is available on request.

71330 AMECOIL Machine tap for wire thread inserts **S91A**

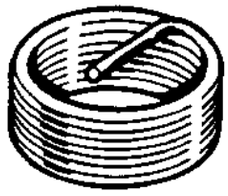
Material Steel HSS
Packaging Standard

d	✉	Art.number	d	✉	Art.number	d	✉	Art.number
1/4	1	71330.063.001	1/2	1	71330.127.001	7/8	1	71330.222.001
5/16	1	71330.079.001	9/16	1	71330.142.001	1.IN.	1	71330.255.001
3/8	1	71330.096.001	5/8	1	71330.158.001			
7/16	1	71330.111.001	3/4	1	71330.191.001			

Wire thread insert



DIN 8140-1A



Technical data

3

d (nom.)	P	Drill ø
M3	0,5	3,2
M4	0,7	4,2
M5	0,8	5,2
M6	1	6,3
M7	1	7,3

d (nom.)	P	Drill ø
M8	1,25	8,4
M10	1,5	10,5
M12	1,75	12,5
M14	2	14,5
M16	2	16,5

d (nom.)	P	Drill ø
M18	2,5	18,75
M20	2,5	20,75
M22	2,5	22,75
M24	3	24,75
M27	3	27,75

- L - P = thread length after assembly.
- Technical brochure available on request.

Article groups

Thread	Material	Colour		Packaging	Code	Page
M	St.St. A2			Standard	71110	3-144
M	St.St. A2	Red	prevailing torque type	Standard	71210	3-144

71110 AMECOIL Wire thread insert — S07A

Thread Metric thread
Material Stainless steel A2
Packaging Standard

d (nom.) x L	✉	Art.number	d (nom.) x L	✉	Art.number	d (nom.) x L	✉	Art.number
M3X4,5	50	71110.030.004	M7X10,5	50	71110.070.010	M14X28	25	71110.140.028
M4X4	50	71110.040.004	M8X8	50	71110.080.008			
M4X6	50	71110.040.006	M8X12	50	71110.080.012	M16X16	25	71110.160.016
M4X8	50	71110.040.008	M8X16	50	71110.080.016	M16X24	25	71110.160.024
						M16X32	25	71110.160.032
M5X5	50	71110.050.005	M10X10	25	71110.100.010			
M5X7,5	50	71110.050.007	M10X15	25	71110.100.015	M18X27	10	71110.180.027
M5X10	50	71110.050.010	M10X20	25	71110.100.020	M20X30	10	71110.200.030
						M20X40	10	71110.200.040
M6X6	50	71110.060.006	M12X12	25	71110.120.012			
M6X9	50	71110.060.009	M12X18	25	71110.120.018	M22X33	10	71110.220.033
M6X12	50	71110.060.012	M12X24	25	71110.120.024	M24X36	10	71110.240.036
M6X18	50	71110.060.018				M27X40,5	10	71110.270.040
			M14X21	25	71110.140.021			

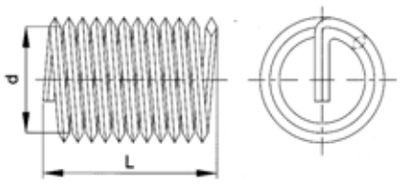
71210 AMECOIL Prevailing torque type wire thread insert — S07A

Thread Metric thread
Material Stainless steel A2
Colour Red
Packaging Standard
DIN 8140-1B

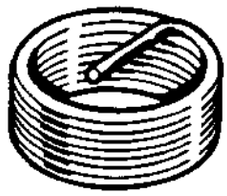
d (nom.) x L	✉	Art.number	d (nom.) x L	✉	Art.number	d (nom.) x L	✉	Art.number
M6X9	50	71210.060.009	M10X15	25	71210.100.015	M16X24	25	71210.160.024
M8X12	50	71210.080.012	M12X18	25	71210.120.018			

- The prevailing torque type wire thread insert achieves its locking ability, between bolt and AMECOIL, by polygonal deformation of one or more spirals of the wire thread insert.
- They are painted red for easier identification with the standard type.

Wire thread insert MF



DIN 8140-1A



Technical data

d (nom.) x P	Drill ø
M8x1	8,3
M10x1,25	10,4
M12x1,5	12,5
M14x1,5	14,5
M16x1,5	16,5

- L - P = thread length after assembly.
- Technical brochure available on request.

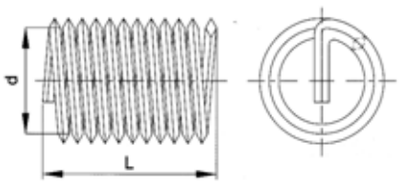
71120 AMECOIL Wire thread insert **S07A**

Thread Metric fine thread
Material Stainless steel A2
Packaging Standard

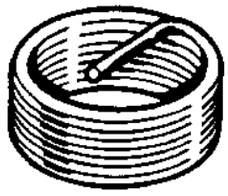
AMECA

d (nom.) x P x L	✉	Art.number	d (nom.) x P x L	✉	Art.number	d (nom.) x P x L	✉	Art.number
M8X1,00X12	50	71120.080.012	M12X1,50X18	25	71120.120.018	M16X1,50X24	25	71120.160.024
M10X1,25X10	25	71120.100.010	M14X1,50X14	25	71120.140.014			
M10X1,25X15	25	71120.100.015	M14X1,50X21	25	71120.140.021			
M10X1,25X20	25	71120.100.020						
			M16X1,50X16	25	71120.160.016			

Wire thread insert MEF



DIN 8140-1A



Technical data

3

d (nom.) x P	Drill ø
M10x1	10,25
M12x1	12,4
M12x1,25	12,4
M14x1,25	14,4
M18x1,5	18,5
M20x1,5	20,5
M22x1,5	22,5
M24x1,5	24,5

- L - P = thread length after assembly.
- Technical brochure available on request.

Article groups

Thread	Material		Packaging	Code	Page
MEF	St.St. A2		Standard	71121	3-146
MEF	St.St. A2	for spark plug	Standard	71920	3-146

71121 AMECOIL Wire thread insert — S07A

Thread Metric extra fine thread
Material Stainless steel A2
Packaging Standard

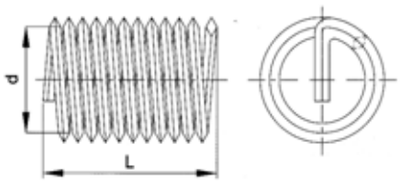
d (nom.) x P x L	✉	Art.number	d (nom.) x P x L	✉	Art.number	d (nom.) x P x L	✉	Art.number
M10X1,00X15	25	71121.100.015	M18X1,50X12	10	71121.180.012	M20X1,50X30	10	71121.200.030
M12X1,25X18	25	71121.120.018	M18X1,50X18	10	71121.180.018			
M12X1,00X18	25	71121.121.018	M18X1,50X27	10	71121.180.027	M22X1,50X22	10	71121.220.022
						M24X1,50X24	10	71121.240.024
M14X1,25X14	25	71121.140.014	M20X1,50X20	10	71121.200.020			

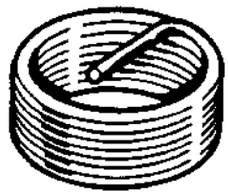
71920 AMECOIL Wire thread insert for spark plugs — S07A

Thread Metric extra fine thread
Material Stainless steel A2
Packaging Standard

d (nom.) x P x L	✉	Art.number	d (nom.) x P x L	✉	Art.number	d (nom.) x P x L	✉	Art.number
M12X1,25X10,5	25	71920.120.010	M14X1,25X10,5	25	71920.140.010	M14X1,25X18	25	71920.140.018
M14X1,25X7,5	25	71920.140.007						

Wire thread insert UNC





Technical data

d (nom.)	Threads per inch	Drill ø
1/4	20	6,7
5/16	18	8,4
3/8	16	10
7/16	14	11,6
1/2	13	13,2
9/16	12	14,9
5/8	11	16,5
3/4	10	19,8
7/8	9	23
1.IN.	8	26,4

- L - P = thread length after assembly.
- Technical brochure available on request.

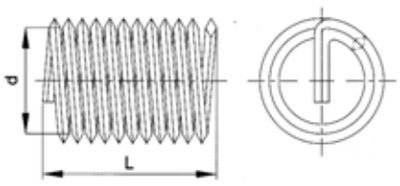
71140 AMECOIL Wire thread insert **S07A**

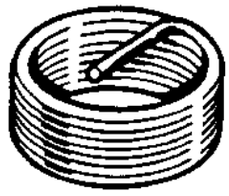
Thread Unified National Coarse
Material Stainless steel A2
Packaging Standard

AMECA

d (nom.) x L	✉	Art.number	d (nom.) x L	✉	Art.number	d (nom.) x L	✉	Art.number
1/4X9,5	50	71140.063.009	1/2X19,1	25	71140.127.019	7/8X33,3	10	71140.222.033
5/16X11,9	50	71140.079.011	9/16X21,4	25	71140.142.021	1.IN.X38,1	10	71140.254.038
3/8X14,3	25	71140.096.014	5/8X23,8	25	71140.158.023			
7/16X16,7	25	71140.111.016	3/4X28,6	10	71140.191.028			

Wire thread insert UNF





Technical data

3

d (nom.)	Threads per inch	Drill ø
1/4	28	6,7
5/16	24	8,3
3/8	24	9,9
7/16	20	11,5
1/2	20	13,1
9/16	18	14,7
5/8	18	16,3
3/4	16	19,5
7/8	14	22,7
1.IN.	12	26

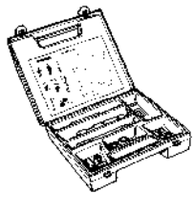
- L - P = thread length after assembly.
- Technical brochure available on request.

71130 AMECOIL Wire thread insert **S07A**

Thread Unified National Fine
Material Stainless steel A2
Packaging Standard

d (nom.) x L	✉	Art.number	d (nom.) x L	✉	Art.number	d (nom.) x L	✉	Art.number
1/4X9,5	50	71130.063.009	1/2X19,1	25	71130.127.019	7/8X22,2	10	71130.222.022
5/16X11,9	50	71130.079.011	9/16X14,3	25	71130.142.014	1.IN.-12GX25,4	10	71130.255.025
3/8X14,3	25	71130.096.014	5/8X15,9	25	71130.158.015			
7/16X16,7	25	71130.111.016	3/4X19,1	10	71130.191.019			

Workshop kit wire thread insert M



71010 AMECOIL Workshop kit wire thread insert **S90A**

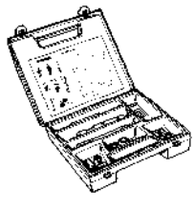
Material Stainless steel A2
Packaging Standard

AMECA

d (nom.) x L	✉	Art.number	d (nom.) x L	✉	Art.number	d (nom.) x L	✉	Art.number
M3X4,5	1	71010.030.004	M8X12	1	71010.080.012	M18X27	1	71010.180.027
M4X6	1	71010.040.006	M10X15	1	71010.100.015	M20X30	1	71010.200.030
M5X7,5	1	71010.050.007	M12X18	1	71010.120.018	M22X33	1	71010.220.033
M6X9	1	71010.060.009	M14X21	1	71010.140.021	M24X36	1	71010.240.036
M7X10,5	1	71010.070.010	M16X24	1	71010.160.024			

- Contents:
- Complete unidimensional manuel fitting tool
- Machine tap (≥ M18 with extra starting tap)
- Tang break
- Stainless steel A2 wire thread inserts acc. to DIN 8140

Workshop kit wire thread insert MF



71020 AMECOIL Workshop kit wire thread insert MF **S90A**

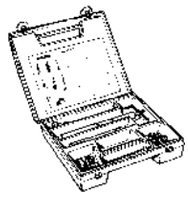
Material Stainless steel A2
Packaging Standard

AMECA

d (nom.) x P x L	✉	Art.number	d (nom.) x P x L	✉	Art.number	d (nom.) x P x L	✉	Art.number
M8X1,00X12	1	71020.080.012	M12X1,50X18	1	71020.120.018	M16X1,50X16	1	71020.160.016
M10X1,25X15	1	71020.100.015	M14X1,50X14	1	71020.140.014			

- Contents:
- Complete unidimensional manuel fitting tool
- Machine tap
- Tang break
- Stainless steel A2 wire thread inserts acc. to DIN 8140

Workshop kit wire thread insert MEF



- Technical brochure available on request.

3

Article groups

Material	Packaging	Code	Page
St.St. A2	Standard	71021	3-150
St.St. A2	Standard	71910	3-150

71021 AMECOIL Workshop kit wire thread insert MEF **S90A**

Material Stainless steel A2
Packaging Standard

d (nom.) x P x L	✉	Art.number	d (nom.) x P x L	✉	Art.number	d (nom.) x P x L	✉	Art.number
M10X1,00X15	1	71021.100.015	M18X1,50X18	1	71021.180.018	M24X1,50X24	1	71021.240.024
M12X1,25X18	1	71021.120.018	M20X1,50X20	1	71021.200.020			
M14X1,25X14	1	71021.140.014	M22X1,50X22	1	71021.220.022			

- These workshop kits are made from plastic, contents wire thread inserts and accessories and are for frequent use of one size.
- Contents:
- Complete unidimensional manuel fitting tool
- Machine tap
- Tang break
- Stainless steel A2 wire thread inserts acc. to DIN 8140-1A

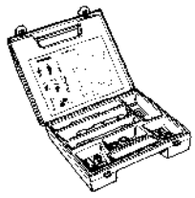
71910 AMECOIL Workshop kit wire thread insert MEF **S90A**

Material Stainless steel A2
Packaging Standard

d (nom.) x P	✉	Art.number	
M12X1,25	1	71910.120.125	• Contents: • Manual fitting tool with nozzle • Carrier adapted to length for M12 x 1,25 x 10,5 / M12 x 1,25 x 18 • Staged tap • 10 stainless steel A2 wire thread inserts M12 x 1,25 x 10,5 / M12 x 1,25 x 18 acc. to DIN 8140-1A
M14X1,25	1	71910.140.125	• Contents: • Manual fitting tool with nozzle • Carrier adapted to length for M14 x 1,25 x 7,5 / M14 x 1,25 x 10,5 / M14 x 1,25 x 18 • Staged tap • 10 stainless steel A2 wire thread inserts M14 x 1,25 x 7,5 acc. to DIN 8140-1A • 20 stainless steel A2 wire thread inserts M14 x 1,25 x 10,5 acc. to DIN 8140-1A • 10 stainless steel A2 wire thread inserts M14 x 1,25 x 18 acc. to DIN 8140-1A

- These workshop kits are made from plastic, contents wire thread inserts and accessories and are recommended for general use.

Workshop kit wire thread insert UNC



71040 AMECOIL Workshop kit wire thread insert UNC **S90A**

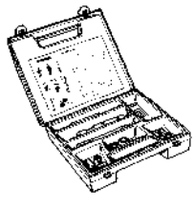
Material Stainless steel A2
Packaging Standard

AMECA

d (nom.) x L	✉	Art.number	d (nom.) x L	✉	Art.number	d (nom.) x L	✉	Art.number
1/4X9,5	1	71040.063.009	1/2X19,1	1	71040.127.019	7/8X33,3	1	71040.222.033
5/16X11,9	1	71040.079.011	9/16X21,4	1	71040.142.021	1.IN.X38,1	1	71040.254.038
3/8X14,3	1	71040.096.014	5/8X23,8	1	71040.158.023			
7/16X16,7	1	71040.111.016	3/4X28,6	1	71040.191.028			

- Contents:
- Complete unidimensional manuel fitting tool
- Machine tap (≥ 5/8 UNC with extra starting tap)
- Tang break
- Stainless steel A2 wire thread inserts

Workshop kit wire thread insert UNF



71030 AMECOIL Workshop kit wire thread insert UNF **S90A**

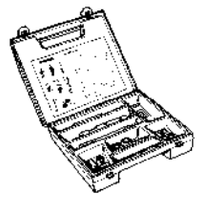
Material Stainless steel A2
Packaging Standard

AMECA

d (nom.) x L	✉	Art.number	d (nom.) x L	✉	Art.number	d (nom.) x L	✉	Art.number
1/4X9,5	1	71030.063.009	1/2X19,1	1	71030.127.019	7/8X22,2	1	71030.222.022
5/16X11,9	1	71030.079.011	9/16X14,3	1	71030.142.014	1.IN.-12GX25,4	1	71030.255.025
3/8X14,3	1	71030.096.014	5/8X15,9	1	71030.158.015			
7/16X16,7	1	71030.111.016	3/4X19,1	1	71030.191.019			

- Contents:
- Complete unidimensional manuel fitting tool
- Machine tap
- Tang break
- Stainless steel A2 wire thread inserts

Workshop kit wire thread insert BSW



- Whitworth thread (BSW/BSF) is not internationally recommended.
- It is advised to use metric (M/MF) or unified threads (UNC/UNF).

3

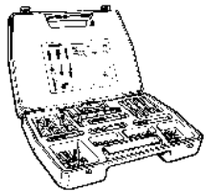
71050 AMECOIL Workshop kit wire thread insert BSW **S90A**

Material Stainless steel A2
Packaging Standard

d (nom.) x L	✉	Art.number	d (nom.) x L	✉	Art.number	d (nom.) x L	✉	Art.number
1/2X19,1	1	71050.127.019						

- Contents:
- Complete unidimensional manuel fitting tool
- Machine tap
- Tang break
- Stainless steel A2 wire thread inserts

Repair kit with wire thread inserts

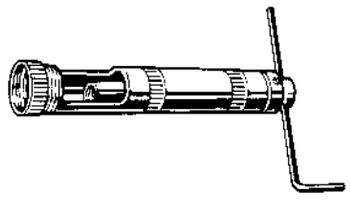


71090 AMECOIL Repair kit with wire thread inserts **S90A**

Packaging Standard

No.	✉	Art.number	
No.1-MM	1	71090.100.010	• Repair kit no. 1 with/for metric wire thread inserts • Contents: • Manual fitting tool no. 3. • Nozzle and mandrel for M6 / M8 / M10 and M12. • Tang break for each size. • Machine tap for each size. • 15 stainless steel A2 wire thread inserts M6 x 9 / M8 x 12 / M10 x 15 / M12 x 18 acc. to DIN 8140. • ATTENTION: nozzles and mandrels M6 and M8 are specially for manual fitting tool no. 3 adjusted and only replaceable by nozzles and mandrels article group 71711. • For nozzles and mandrels M10 / M12, see group code 71710.
No.2-MM	1	71090.100.020	• Repair kit no. 2 with/for metric wire thread inserts. • Contents: • Manual fitting tool no. 4. • Nozzle and mandrel for M6 / M8 / M10 / M12 / M14 x 1,25. • Tang break for each size. • Machine tap for each size (for M14 x 1,25 staged tap). • 15 stainless steel A2 wire thread inserts M6 x 9 / M8 x 12 / M10 x 15 / M12 x 18 / M14 x 1,25 x 14 acc. to DIN 8140. • ATTENTION: nozzles and mandrels M6 / M8 / M10 / M12 / M14 x 1,25 are specially for manual fitting tool no. 4 adjusted and only replaceable by nozzles and mandrels article groups 71712 and 71722
No.1C-NC	1	71090.400.010	• Repair kit no. 1C with/for UNC wire thread inserts. • Contents: • Manual fitting tool no. 3. • Nozzle and mandrel for 1/4 / 5/16 / 3/8 / 7/16 / 1/2 UNC. • Tang break for each size. • Machine tap for each size. • 15 stainless steel A2 wire thread inserts 1/4 x 9,5 / 5/16 x 11,9 / 3/8 x 14,3 / 7/16 x 16,7 / 1/2 x 19,1 UNC. • ATTENTION: nozzles and mandrels 1/4 UNC en 5/16 UNC are specially for manual fitting tool no. 3 adjusted and only replaceable by nozzles and mandrels article group 71741. • For nozzles and mandrels 3/8 / 7/16 / 1/2 UNC, see article group 71740.
No.1D-NF	1	71090.500.010	• Repair kit no. 1D with/for UNF wire thread inserts. • Contents: • Manual fitting tool no. 3. • Nozzle and mandrel for 1/4 / 5/16 / 3/8 / 7/16 / 1/2 UNF. • Tang break for each size. • Machine tap for each size. • 15 stainless steel A2 wire thread inserts 1/4 x 9,5 / 5/16 x 11,9 / 3/8 x 14,3 / 7/16 x 16,7 / 1/2 x 19,1 UNF. • ATTENTION: nozzles and mandrels 1/4 UNF en 5/16 UNF are specially for manual fitting tool no. 3 adjusted and only replaceable by nozzles and mandrels article group 71731. • For nozzles and mandrels 3/8 / 7/16 / 1/2 UNF, see article group 71730.

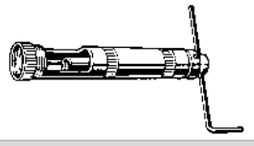
Multidimensional manual fitting tool



71510 AMECOIL Multidimensional manual fitting tool **S91A**

Packaging Standard

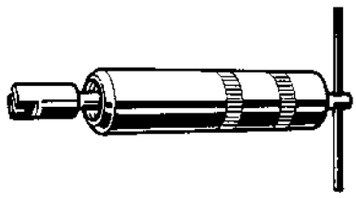
AMECA



No.	✉	Art.number	
No.1	1	71510.000.001	• Suitable for wire thread insert: • M4 / M5
No.2	1	71510.000.002	• Suitable for wire thread insert: • M6 / M7 / M8 / M8x1 / 1/4 UNC / 5/16 UNC / 1/4 UNF / 5/16 UNF
No.3	1	71510.000.003	• Suitable for wire thread insert: • M10 / M12 / M10x1 / M10x1,25 / M12x1 / M12x1,25 / M12x1,5 / 3/8 UNC / 7/16 UNC / 1/2 UNC / 3/8 UNF / 7/16 UNF / 1/2 UNF
No.4	1	71510.000.004	• Suitable for wire thread insert: • M14 / M16 / M14x1,25 / M14x1,5 / M16x1,5 / 9/16 UNC / 5/8 UNC / 9/16 UNF / 5/8 UNF / 1/2 BSW

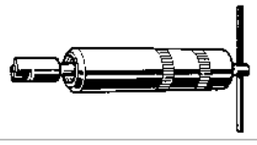
- Intended for the fitting of wire thread inserts.
- Excl. nozzle and mandrel, these have to be ordered, per diameter, separately.
- Aluminium body with steel inside work.

Complete manual fitting tool



71610 AMECOIL Complete manual fitting tool Metric S91A

Packaging Standard

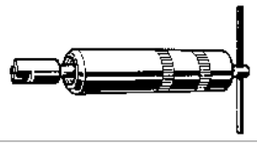


d	✉	Art.number	d	✉	Art.number	d	✉	Art.number
M18	1	71610.180.001	M22	1	71610.220.001	M27	1	71610.270.001
M20	1	71610.200.001	M24	1	71610.240.001			

- Complete manual fitting tool.
- Intended for the fitting of metric wire thread inserts.
- Aluminium with steel inside work.

71620 AMECOIL Complete manual fitting tool Metric fine S91A

Packaging Standard

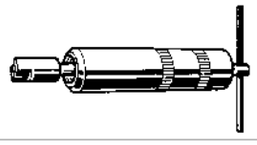


d x P	✉	Art.number	d x P	✉	Art.number	d x P	✉	Art.number
M18X1,50	1	71620.180.150	M22X1,50	1	71620.220.150			
M20X1,50	1	71620.200.150	M24X1,50	1	71620.240.150			

- Complete manual fitting tool.
- Intended for the fitting of metric extra fine wire thread inserts.
- Aluminium with steel inside work.

71940 AMECOIL Manual fitting tool with nozzle Metric S91A

Packaging Standard

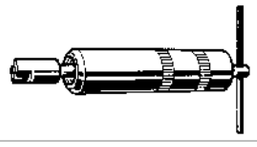


d x P	✉	Art.number	d x P	✉	Art.number	d x P	✉	Art.number
M12X1,25	1	71940.120.125	M14X1,25	1	71940.140.125			

- Manual fitting tool with nozzle.
- Suitable the fitting of spark plug wire thread inserts.
- Excl. carrier adapted to length, to be ordered separately per diameter and length (d nom. x L) wire thread insert.
- Aluminium body with steel inside work.

71640 AMECOIL Complete manual fitting tool UNC S91A

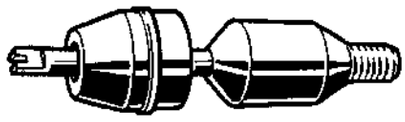
Packaging Standard



d	✉	Art.number	d	✉	Art.number	d	✉	Art.number
3/4	1	71640.191.001	7/8	1	71640.222.001	1.IN.	1	71640.254.001

- Complete manual fitting tool.
- Intended for the fitting of UNC wire thread inserts.
- Aluminium with steel inside work.

Nozzle and mandrel for manual fitting

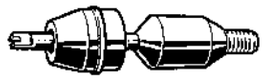


3

71710 AMECOIL Nozzle and mandrel for manual fitting Metric — S91A

Packaging Standard

AMECA

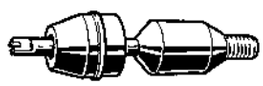


d	✉	Art.number	
M3	1	71710.030.001	• Nozzle and mandrel for manual fitting tool no. 1 • Suitable for wire thread insert: M3
M4	1	71710.040.001	• Nozzle and mandrel for manual fitting tool no. 1 • Suitable for wire thread insert: M4
M5	1	71710.050.001	• Nozzle and mandrel for manual fitting tool no. 1 • Suitable for wire thread insert: M5
M6	1	71710.060.001	• Nozzle and mandrel for manual fitting tool no. 2 • Suitable for wire thread insert: M6.
M7	1	71710.070.001	• Nozzle and mandrel for manual fitting tool no. 2 • Suitable for wire thread insert: M7
M8	1	71710.080.001	• Nozzle and mandrel for manual fitting tool no. 2 • Suitable for wire thread insert: M8
M10	1	71710.100.001	• Nozzle and mandrel for manual fitting tool no. 3 • Suitable for wire thread insert: M10
M12	1	71710.120.001	• Nozzle and mandrel for manual fitting tool no.3 • Suitable for wire thread insert: M12
M14	1	71710.140.001	• Nozzle and mandrel for manual fitting tool no. 4 • Suitable for wire thread insert: M14
M16	1	71710.160.001	• Nozzle and mandrel for manual fitting tool no. 4 • Suitable for wire thread insert: M16

71711 AMECOIL Nozzle and mandrel for manual fitting Metric — S91A

Packaging Standard

AMECA



d	✉	Art.number	
M6-ASS1	1	71711.060.001	• Nozzle and mandrel for manual fitting tool no. 3 (repair kit no.1) • Suitable for wire thread insert: M6
M8-ASS1	1	71711.080.001	• Nozzle and mandrel for manual fitting tool no. 3 (repair kit no. 1) • Suitable for wire thread insert: M8

71720 AMECOIL Nozzle and mandrel for manual fitting Metric fine — S91A

Packaging Standard

AMECA

d x P	✉	Art.number	
M8X1,00	1	71720.080.100	• Nozzle and mandrel for manual fitting tool no. 2 • Suitable for wire thread insert: M8x1
M10X1,00	1	71720.100.100	• Nozzle and mandrel for manual fitting tool no. 3 • Suitable for wire thread insert: M10x1
M10X1,25	1	71720.100.125	• Nozzle and mandrel for manual fitting tool no. 3 • Suitable for wire thread insert: M10x1,25
M12X1,00	1	71720.120.100	• Nozzle and mandrel for manual fitting tool no. 3 • Suitable for wire thread insert: M12x1

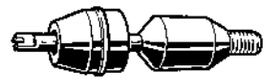
71720 AMECOIL Nozzle and mandrel for manual fitting Metric fine

d	✉	Art.number	
M12X1,25	1	71720.120.125	• Nozzle and mandrel for manual fitting tool no. 3 • Suitable for wire thread insert: M12x1,25
M12X1,50	1	71720.120.150	• Nozzle and mandrel for manual fitting tool no. 3 • Suitable for wire thread insert: M12x1,5
M14X1,25	1	71720.140.125	• Nozzle and mandrel for manual fitting tool no. 4 • Suitable for wire thread insert: M14x1,25
M14X1,50	1	71720.140.150	• Nozzle and mandrel for manual fitting tool no. 4 • Suitable for wire thread insert: M14x1,5
M16X1,50	1	71720.160.150	• Nozzle and mandrel for manual fitting tool no. 4 • Suitable for wire thread insert: M16x1,5

3

71740 AMECOIL Nozzle and mandrel for manual fitting UNC S91A

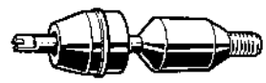
Packaging Standard



d	✉	Art.number	
1/4	1	71740.063.001	• Nozzle and mandrel for manual fitting tool no. 2 • Suitable for wire thread insert: 1/4 UNC
5/16	1	71740.079.001	• Nozzle and mandrel for manual fitting tool no. 2 • Suitable for wire thread insert: 5/16 UNC
3/8	1	71740.096.001	• Nozzle and mandrel for manual fitting tool no. 3 • Suitable for wire thread insert: 3/8 UNC
7/16	1	71740.111.001	• Nozzle and mandrel for manual fitting tool no. 3 • Suitable for wire thread insert: 7/16 UNC
1/2	1	71740.127.001	• Nozzle and mandrel for manual fitting tool no. 3 • Suitable for wire thread insert: 1/2 UNC
9/16	1	71740.142.001	• Nozzle and mandrel for manual fitting tool no. 4 • Suitable for wire thread insert: 9/16 UNC
5/8	1	71740.158.001	• Nozzle and mandrel for manual fitting tool no. 4 • Suitable for wire thread insert: 5/8 UNC

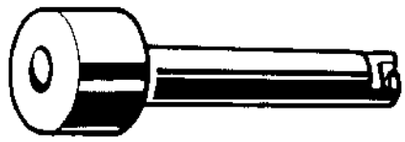
71730 AMECOIL Nozzle and mandrel for manual fitting UNF S91A

Packaging Standard



d	✉	Art.number	
1/4	1	71730.063.001	• Nozzle and mandrel for manual fitting tool no. 2 • Suitable for wire thread insert: 1/4 UNF
5/16	1	71730.079.001	• Nozzle and mandrel for manual fitting tool no. 2 • Suitable for wire thread insert: 5/16 UNF
3/8	1	71730.096.001	• Nozzle and mandrel for manual fitting tool no. 3 • Suitable for wire thread insert: 3/8 UNF
7/16	1	71730.111.001	• Nozzle and mandrel for manual fitting tool no. 3 • Suitable for wire thread insert: 7/16 UNF
1/2	1	71730.127.001	• Nozzle and mandrel for manual fitting tool no. 3 • Suitable for wire thread insert: 1/2 UNF
9/16	1	71730.142.001	• Nozzle and mandrel for manual fitting tool no. 4 • Suitable for wire thread insert: 9/16 UNF
5/8	1	71730.158.001	• Nozzle and mandrel for manual fitting tool no. 4 • Suitable for wire thread insert: 5/8 UNF

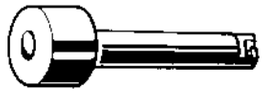
Carrier adapted



71950 AMECOIL Carrier adapted **S91A**

3

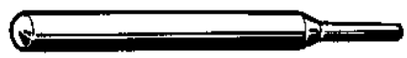
Packaging Standard



d x P x L	✉	Art.number	d x P x L	✉	Art.number	d x P x L	✉	Art.number
M12X1,25X10,5	1	71950.120.010	M14X1,25X7,5	1	71950.140.007	M14X1,25X18	1	71950.140.018
M12X1,25X18	1	71950.120.018	M14X1,25X10,5	1	71950.140.010			

- For manual fitting tool with nozzle.

Tang break



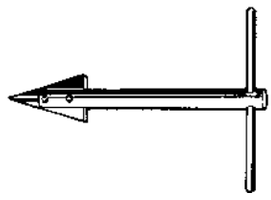
71810 AMECOIL Tang break **S91A**

Packaging Standard

For use with nr.	✉	Art.number	For use with nr.	✉	Art.number	For use with nr.	✉	Art.number
M3	1	71810.030.001	M7	1	71810.070.001	M14 - 9/16	1	71810.140.001
M4	1	71810.040.001	M8 - 5/16	1	71810.080.001	M16 - 5/8	1	71810.160.001
M5	1	71810.050.001	M10 - 3/8 - 7/16	1	71810.100.001	M18	1	71810.180.001
M6 - 1/4	1	71810.060.001	M12 - 1/2	1	71810.120.001			

- Intended to use for breaking off the engaging stem after fitting of the wire thread insert.
- ATTENTION: for sizes larger than M18 resp. 5/8 UNC/UNF a pointed plier has to be used.

Extractor



71860	AMECOIL Extractor	S91A
Packaging	Standard	

No.	✉	Art.number	
No.1	1	71860.000.001	• Suitable for wire thread insert: • M3 / M4 / M5 / M6 / M7 / M8 / 1/4 / 5/16
No.2	1	71860.000.002	• Suitable for wire thread insert: • M5 / M6 / M7 / M8 / M10 / M12 / 1/4 / 5/16 / 3/8 / 7/16
No.3	1	71860.000.003	• Suitable for wire thread insert: • M10 / M12 / M14 / M16 / M18 / M20 / M22 / M24 / 3/8 / 7/16 / 1/2 / 9/16 / 5/8

- Intended to use when an inserted wire thread insert has been poorly positioned and has to be extracted (metric / metric fine / UNC / UNF / BSW).
- ATTENTION: if the screwthread has not been damaged, a new wire thread insert can be fitted.

FABORY Self-cutting threaded inserts

General
The principle of the *FABORY* self-cutting threaded insert is quite simple. Not only "soft" materials i.e. aluminium, copper, brass, plastic and hardwood, but also metal with a tensile-strength of up to 420 N/mm² can easily be fitted with a reliable metric screw thread, and pretapping, is not necessary. Worn and damaged screw threads can now be quickly and easily repaired with a *FABORY* self-cutting threaded insert.

Function
The *FABORY* self-cutting threaded insert uses an external thread to cut its way into the workpiece, and the metric internal thread offers an exceptional fixing with high-tensile values.

Fitting
For fitting the *FABORY* self-tapping thread inserts, three handy tools are available:
- hand tool **type 610**
- hand/machine tool **type 620**
- hand/machine tool **type 6102**
  - exclusively suitable for the *FABORY* self-tapping thread inserts with a hexagon socket, **types 302 2** and **308 2**

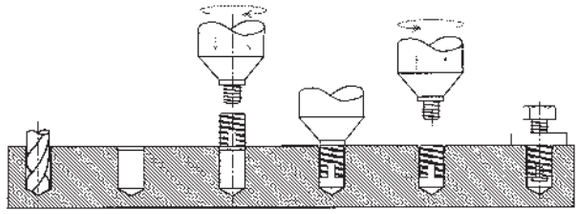
For application in materials with a high tensile strength, we recommend:
- the use of a suitable lubricant, and/or
- pre-tapping with hand tap no. 1 (taper tap, marked with one ring)

Types of thread insert
- **Type 302**, provided with two flutes and:
  - o in steel version, applicable in somewhat softer materials, with a tensile strength up to 300 N/mm²
  - o in stainless steel version, applicable in materials with a tensile strength up to 320 N/mm²
- **Type 307**, provided with three radial cutting holes, and applicable in somewhat harder materials, with a tensile strength from 360 to 420 N/mm²
- **Type 308**, same as type 307, but this type is the longer version of type 307
- **Type 302 2**, provided with two flutes, with hexagon socket, and applicable in somewhat softer materials with a tensile strength up to 300 N/mm²
- **Type 308 2**, provided with three radial cutting holes, with hexagon socket, long version, and applicable in somewhat harder materials, with a tensile strength from 360 to 420 N/mm²

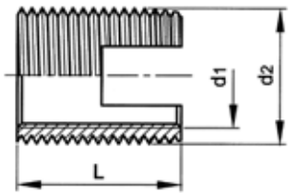
Hole diameters		Guidelines for type 302				Guidelines for types 307 and 308			
workpiece material	light metal with tensile strength R_m (N/mm²)	R_m < 250	R_m < 300	R_m < 350	R_m > 350	R_m < 300	R_m < 350	R_m > 350	
	Brass, bronze, non-ferrous metal								
	Cast iron HB = Brinell hardness	HB < 150	HB < 200	HB > 200		HB < 150	HB < 200	HB > 200	
thread insert internal thread	M3		4,6	4,7	4,8	4,6	4,7		4,8
	M4	5,9	6,0	6,1	6,2	6,0	6,1		6,2
	M5	7,2	7.3	7,5	7,6	7,4	7,5	7,6	7,7
	M6	8,8	9,0	9,2	9,4	9,3	9,4	9,5	9,6
	M8	10,8	11,0	11,2	11,4	11,1	11,2	11,3	11,5
	M10	12,8	13,0	13,2	13,4	13,1	13,2	13,3	13,5
	M12	14,8	15,0	15,2	15,4	15,0	15,1	15,2	15,4
	M14	16,8	17,0	17,2	17,4	17,0	17,1	17,2	17,4
	M16	18,8	19,0	19,2	19,4	19,0	19,1	19,2	19,4
	M20	24,8	25,0	25,2	25,4				
	M24	28,8	29,0	29,2	29,4				
	M27	32,8	33,0	33,2	33,4				
	M30	34,8	35,0	35,2	35,4				
Flank overlap approx.		60 %	50 %	40 %	30 %	80 %	70 %	60 %	50 %

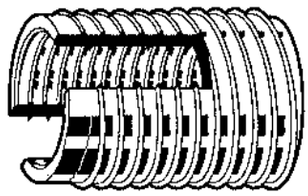
Recommended hole diameters for problem-free fitting. For the other hole diameters, lubrication or pre-tapping may be necessary.

Assembly sequence:
1) bore hole (see table above)
2) countersink hole (recommended)
3) screw insertion device into thread insert
4) screw thread insert in to approx. 0.1 to 0.2 mm below surface of workpiece
5) remove insertion device
6) component can be fitted



Self-cutting threaded insert type 302





Technical data

d1 x L	P (d1)	d_2	P (d2)	Drill depth (min.)
M3x6	0,5	5	0,5	8
M4x8	0,7	6,5	0,75	10
M5x10	0,8	8	1	13
M6x10	1	10	1,5	13
M6x12	1	10	1,5	15
M6x14	1	10	1,5	17
M8x12	1,25	12	1,5	15
M8x15	1,25	12	1,5	18
M10x15	1,5	14	1,5	18
M10x18	1,5	14	1,5	22
M12x22	1,75	16	1,5	26
M14x24	2	18	1,5	28
M16x22	2	20	1,5	27
M20x27	2,5	26	1,5	32
M24x30	3	30	1,5	36
M27x30	3,5	34	1,5	36
M30x40	3,5	36	1,5	46

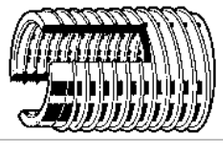
- Drill depth (min.) = Minimum bore depth for blind holes.

Article groups

Thread	Material	Surface treatment	Packaging	Code	Page
M	St Case-hardened	Zipl yell.p.	Standard	71550	3-161
M	St.St. A1		Standard	71566	3-161
M	St.St. C4		Standard	71560	3-162

71550 Self-cutting threaded insert type 302 — S93A

Thread Metric thread
Material Steel Case-hardened
Surface treatment Zinc plated yellow passivated
Packaging Standard

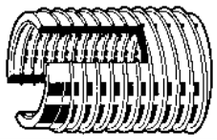


d1 x L	✉	Art.number	d1 x L	✉	Art.number	d1 x L	✉	Art.number
M3X6	50	71550.030.001	M8X15	50	71550.080.001	M14X24	25	71550.140.001
M4X8	50	71550.040.001	M8X12	50	71550.080.012	M16X22	25	71550.160.001
M5X10	50	71550.050.001				M20X27	10	71550.200.001
M6X14	50	71550.060.001	M10X18	25	71550.100.001	M24X30	10	71550.240.001
M6X10	50	71550.060.010	M10X15	25	71550.100.015	M27X30	5	71550.270.001
M6X12	50	71550.060.012				M30X40	5	71550.300.001
			M12X22	25	71550.120.001			

- For use in materials with tensile strength up to 300 N/mm^2.
- Light metal alloys, cast iron, brass, bronze, non-ferrous metals, plastics and hardwoods.

71566 Self-cutting threaded insert type 302 — S93A

Thread Metric thread
Material Stainless steel A1
Packaging Standard



d1 x L	✉	Art.number	d1 x L	✉	Art.number	d1 x L	✉	Art.number
M3X6	25	71566.030.001	M6X14	25	71566.060.001	M12X22	10	71566.120.001
M4X8	25	71566.040.001	M8X15	25	71566.080.001	M16X22	10	71566.160.001
M5X10	25	71566.050.001	M10X18	10	71566.100.001			

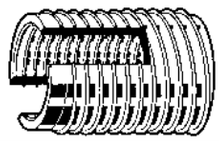
71566 Self-cutting threaded insert type 302

d1 x L	✉	Art.number	d1 x L	✉	Art.number	d1 x L	✉	Art.number

- For use in materials with tensile strength up to 320 N/mm^2.

71560 Self-cutting threaded insert type 302 S93A

Thread Metric thread
Material Stainless steel C4
Packaging Standard

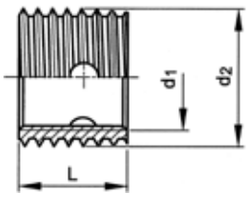


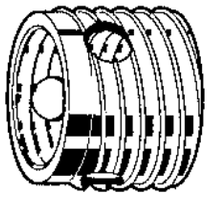
3

d1 x L	✉	Art.number	d1 x L	✉	Art.number	d1 x L	✉	Art.number
M3X6	25	71560.030.001	M6X14	25	71560.060.001	M12X22	10	71560.120.001
M4X8	25	71560.040.001	M8X15	25	71560.080.001	M16X22	10	71560.160.001
M5X10	25	71560.050.001	M10X18	10	71560.100.001			

- For use in materials with tensile strength up to 320 N/mm^2.

Self-cutting threaded insert type 307/308





Technical data

d1 x L	P (d1)	d_2	P (d2)	Drill depth (min.)
M3x4	0,5	5	0,6	6
M3x6	0,5	5	0,6	8
M4x6	0,7	6,5	0,8	8
M4x8	0,7	6,5	0,8	10
M5x7	0,8	8	1	9
M5x10	0,8	8	1	13
M6x8	1	10	1,25	10
M6x12	1	10	1,25	15
M8x9	1,25	12	1,5	11
M8x14	1,25	12	1,5	17
M10x10	1,5	14	1,5	13
M10x18	1,5	14	1,5	22
M12x12	1,75	16	1,75	15
M12x22	1,75	16	1,75	26
M16x14	2	20	2	17
M16x24	2	20	2	28

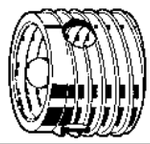
- Drill depth (min.) = Minimum bore depth for blind holes.

Article groups

Thread	Material	Surface treatment		Packaging	Code	Page
M	St	Zipl yell.p.	307	Standard	71552	3-163
M	St	Zipl yell.p.	308	Standard	71554	3-163

71552 Self-cutting threaded insert type 307 — S93A

Thread Metric thread
Material Steel
Surface treatment Zinc plated yellow passivated
Packaging Standard

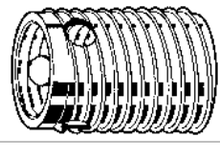


d1 x L	✉	Art.number	d1 x L	✉	Art.number	d1 x L	✉	Art.number
M3X4	50	71552.030.001	M6X8	50	71552.060.001	M12X12	25	71552.120.001
M4X6	50	71552.040.001	M8X9	50	71552.080.001	M16X14	25	71552.160.001
M5X7	50	71552.050.001	M10X10	25	71552.100.001			

- For use in materials with tensile strength from 360 to 420 N/mm^2.
- Aluminium and aluminium alloys, magnesium alloys, duroplastic and thermoplastic polymers.

71554 Self-cutting threaded insert type 308 — S93A

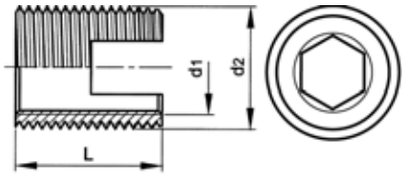
Thread Metric thread
Material Steel
Surface treatment Zinc plated yellow passivated
Packaging Standard

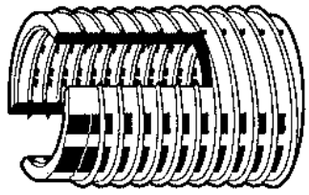


d1 x L	✉	Art.number	d1 x L	✉	Art.number	d1 x L	✉	Art.number
M3X6	50	71554.030.001	M6X12	50	71554.060.001	M12X22	25	71554.120.001
M4X8	50	71554.040.001	M8X14	50	71554.080.001	M16X24	25	71554.160.001
M5X10	50	71554.050.001	M10X18	25	71554.100.001			

- For use in materials with tensile strength from 360 to 420 N/mm^2.
- Aluminium and aluminium alloys, magnesium alloys, duroplastic and thermoplastic polymers.

Self-cutting threaded insert with hexagon socket type 302 2





Technical data

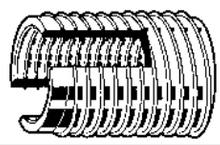
3

d1 x L	M4x8	M5x10	M6x14	M8x15	M10x18	M12x22
P (d1)	0,7	0,8	1	1,25	1,5	1,75
d_2	6,5	8	10	12	14	16
P (d2)	0,75	1	1,5	1,5	1,5	1,5
S (+0,1mm)	3,2	4,1	4,9	6,6	8,3	10,1
Drill depth (min.)	10	13	17	18	22	27
Thickness	8	10	14	15	18	22

- Drill depth (min.) = Minimum bore depth for blind holes.
- Thickness = min. material thickness.
- S = W.a.f. hexagon socket.

71551 Self-cutting threaded insert with hexagon socket type 302 2 **S93A**

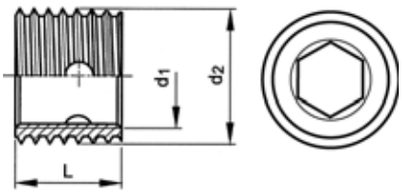
Thread	Metric thread
Material	Steel Case-hardened
Surface treatment	Zinc plated yellow passivated
Packaging	Standard

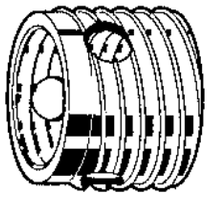


d1 x L	✉	Art.number	d1 x L	✉	Art.number	d1 x L	✉	Art.number
M4X8	50	71551.040.008	M6X14	50	71551.060.014	M10X18	25	71551.100.018
M5X10	50	71551.050.010	M8X15	50	71551.080.015	M12X22	25	71551.120.022

- For use in materials with tensile strength up to 300 N/mm^2.
- Light metal alloys, cast iron, brass, bronze, non-ferrous metals, plastics and hardwoods.
- Advantages of the self-cutting thread inserts with hexagon socket:
- Thread insert does not have to be screwed onto device: saves up to 50% of fitting time.
- Simple insertion tool type 6102: use with tommy bar or optionally by machine.
- Insertion device only needs to turn clockwise.
- Thread inserts are simple to unscrew (when recycling workpiece).

Self-cutting threaded insert with hexagon socket type 308 2





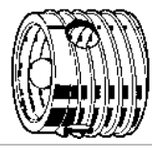
Technical data

d1 x L	M4x8	M5x10	M6x12	M8x14	M10x18	M12x22
P (d1)	0,7	0,8	1	1,25	1,5	1,75
d_2	6,5	8	10	12	14	16
P (d2)	0,8	1	1,25	1,5	1,5	1,75
S (+0,1mm)	3,2	4,1	4,9	6,6	8,3	10,1
Drill depth (min.)	10	13	15	17	22	26
Thickness	8	10	12	14	18	22

- Drill depth (min.) = Minimum bore depth for blind holes.
- Thickness = min. material thickness.
- S = W.a.f. hexagon socket.

71556 Self-cutting threaded insert with hexagon socket type 308 2 **S93A**

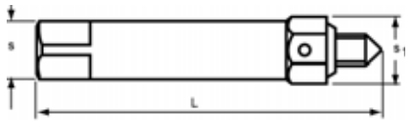
Thread	Metric thread
Material	Steel Case-hardened
Surface treatment	Zinc plated yellow passivated
Packaging	Standard



d1 x L	✉	Art.number	d1 x L	✉	Art.number	d1 x L	✉	Art.number
M4X8	50	71556.040.008	M6X12	50	71556.060.012	M10X18	25	71556.100.018
M5X10	50	71556.050.010	M8X14	50	71556.080.014	M12X22	25	71556.120.022

- For use in materials with tensile strength from 360 to 420 N/mm^2.
- Aluminium and aluminium alloys, magnesium alloys, duroplastic and thermoplastic polymers.
- Advantages of the self-tapping thread inserts with hexagon socket:
- Thread insert does not have to be screwed onto device: saves up to 50% of fitting time.
- Simple insertion tool type 6102: use with tommy bar or optionally by machine.
- Insertion device only needs to turn clockwise.
- Thread inserts are simple to unscrew (when recycling workpiece).

Self-cutting threaded insert tool type 610



Technical data

3

d1	L	S	S_1
M3	55	5	7
M4	60	5	7
M5	75	8	13
M6	75	8	13
M8	75	8	13
M10	95	12,5	19
M12	95	12,5	19

- L = Total length.
- S = Square s.
- S_1 = Contra-nut s.
- For manual insertion of self-tapping thread inserts types 302, 307 and 308 (with aid of tommy bar and open-ended spanner).

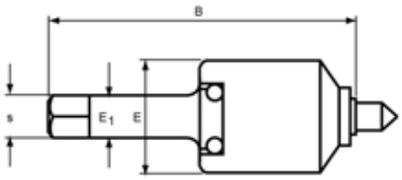
71595 Self-cutting threaded insert tool type 610 **S94A**

Material Steel
Packaging Standard

Nom. size d1	✉	Art.number	Nom. size d1	✉	Art.number	Nom. size d1	✉	Art.number
M3	1	71595.030.001	M6	1	71595.060.001	M12	1	71595.120.001
M4	1	71595.040.001	M8	1	71595.080.001			
M5	1	71595.050.001	M10	1	71595.100.001			

- No spare parts are available for this hand tool.

Self-cutting threaded insert tool type 620



Technical data

d1	E	E_1	S	B
M3	18	8	6,3	78
M4	18	8	6,3	78
M5	24	12,5	10	95
M6	24	12,5	10	95
M8	24	12,5	10	95
M10	32	16	12,5	118
M12	32	16	12,5	118
M14	50	25	20	145
M16	50	25	20	145
M20	58	25	20	169
M24	70	30	25	198
M27	70	30	25	198
M30	70	30	25	198

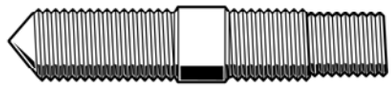
- **d_1 = For dimension d_1.**
- **E = Housing E diameter**
- **E_1 = Shaft diameter E_1.**
- **S = Square w.a.f.**
- **B = Length B.**
- For insertion manually (with aid of tommy bar) or by machine of self-tapping thread inserts types 302, 307 and 308.
- For this 620 device, spare threaded studs are available, group code 71597.

71592 Self-cutting threaded insert tool type 620 **S94A**

Material Steel
Packaging Standard

d1	✉	Art.number	d1	✉	Art.number	d1	✉	Art.number
M3	1	71592.030.001	M10	1	71592.100.001	M24	1	71592.240.001
M4	1	71592.040.001	M12	1	71592.120.001	M27	1	71592.270.001
M5	1	71592.050.001	M14	1	71592.140.001	M30	1	71592.300.001
M6	1	71592.060.001	M16	1	71592.160.001			
M8	1	71592.080.001	M20	1	71592.200.001			

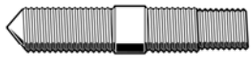
Spare threaded pin for tool type 620



3

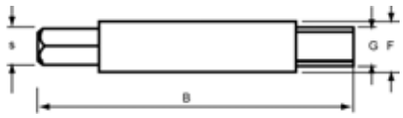
71597 Spare threaded pin for tool type 620 **S94A**

Packaging Standard



d	✉	Art.number	d	✉	Art.number	d	✉	Art.number
M3	1	71597.030.001	M10	1	71597.100.001	M22	1	71597.220.001
M4	1	71597.040.001	M12	1	71597.120.001	M24	1	71597.240.001
M5	1	71597.050.001	M14	1	71597.140.001	M30	1	71597.300.001
M6	1	71597.060.001	M16	1	71597.160.001			
M8	1	71597.080.001	M20	1	71597.200.001			

Self-tapping thread insert with hexagon socket tool type 6102



Technical data

For nom.size d1	s	F	G	B
M4	3,2	6	4,9	80
M5	4,1	8	6,2	90
M6	4,9	10	8	100
M8	6,6	10	8	100
M10	8,3	12	9	110
M12	10,1	14	11	125

- s = Hex stud s (nom.).
- F = Shaft diameter F.
- G = Square G.
- B = Length B.

71580 Self-tapping thread insert with hexagon socket tool type 6102 **S94A**

Material Steel
Packaging Standard

For nom. size d1	✉	Art.number	For nom. size d1	✉	Art.number	For nom. size d1	✉	Art.number
M4	1	71580.040.001	M6	1	71580.060.001	M10	1	71580.100.001
M5	1	71580.050.001	M8	1	71580.080.001	M12	1	71580.120.001

- Hand/machine tool 6102 is exclusively for use with self-tapping thread inserts with hexagon socket, types 302 2 and 308 2.
- Advantages of the self-tapping thread inserts with hexagon socket:
- Thread insert does not have to be screwed onto device: saves up to 50% of fitting time.
- Simple insertion tool type 6102: use with tommy bar or optionally by machine.
- Insertion device only needs to turn clockwise.
- Thread inserts are simple to unscrew (when recycling workpiece).

FABORY Self-cutting threaded inserts

Fitting tip
For fitting the *FABORY* self-tapping thread inserts, the three handy tools mentioned earlier are available, namely:

- *FABORY* self-tapping thread inserts with hexagon socket **types 302 2** and **308 2** can be fitted with hand/machine tool **type 6102**
- hand tool **type 610**
- hand/machine tool **type 620**

Both suitable for the *FABORY* self-tapping thread inserts WITHOUT hexagon socket: types 302, 307 and 308.

For emergency or rapid fitting of only a few of these types of *FABORY* self-tapping thread inserts, it is also possible to use a nut and bolt of correct size.

FABORY self-tapping thread inserts of type 302 are also available in a selection case (S572). 420 items in total, in sizes from M3 up to M16, in materials steel, zinc plated yellow passivated and some sizes in C4 stainless steel (art. no. 41010.000.572).