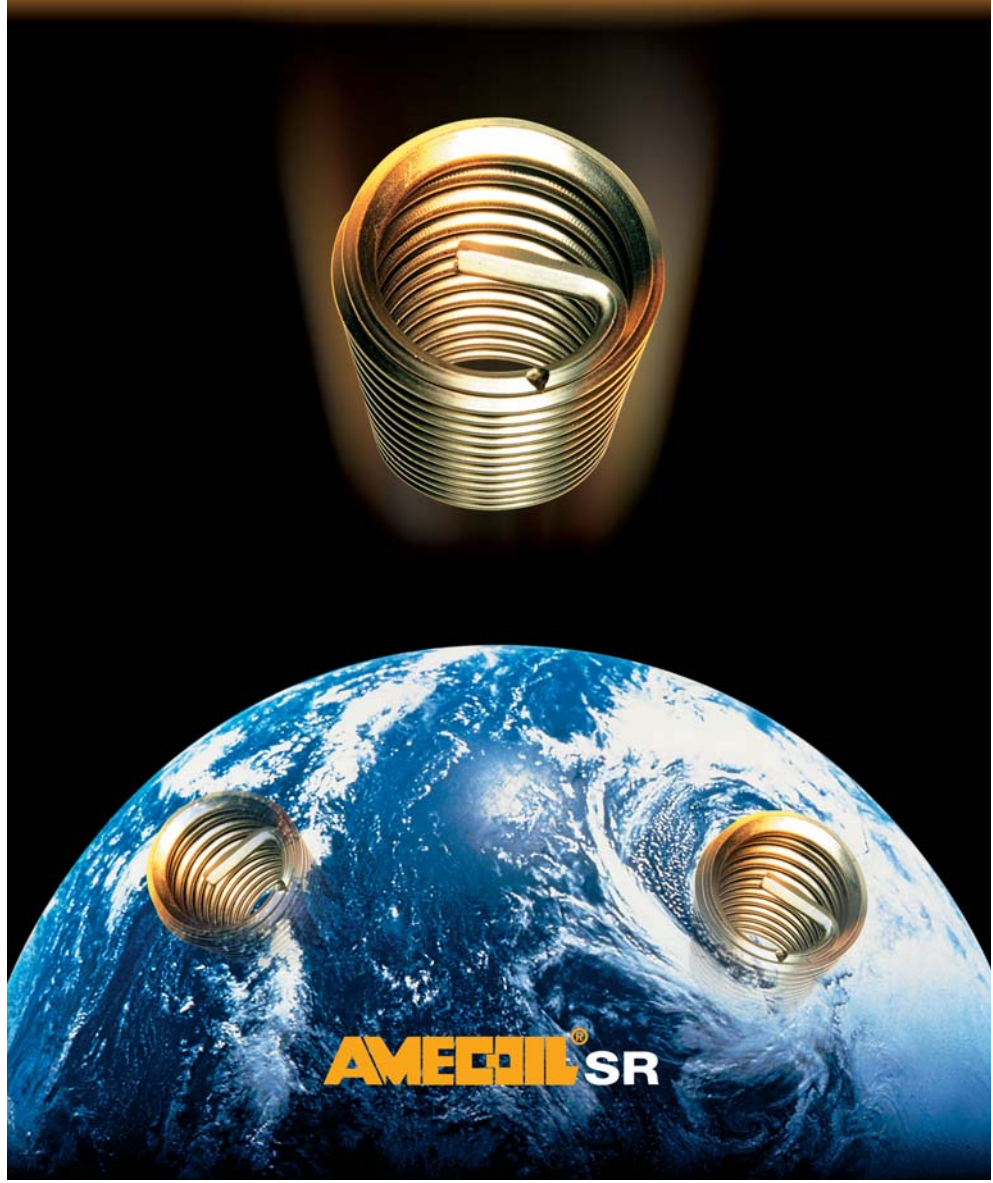


AMECA

A NEW GENERATION
OF FASTENERS.



THREAD INSERTS
AMECOIL® SR



Classic and SR Ranges: Totally reliable for indestructible tapping.

Used in all industrial sectors, the classic or self-locking AMECOIL thread insert is the essential element for durable top quality assemblies.

The thread insert is manufactured from diamond-shaped wire and forms two high precision concentric threads, one internal and one external. Each thread insert has a engaging tang at one end for quick insertion.



SR Range: even more advantages

Optimisation of the sizes means the SR Range possesses all the characteristics of the classic range with many additional advantages, both when fitting and using:

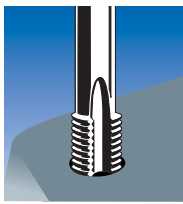
- Easier to fit and more reliable for improved productivity,
- 100% compatible with existing Classic range tooling, so the new range can be used without any changes in buyer's or user's usual way of working.
- More economical to purchase, the improved ergonomics of the SR fitting tooling make it quicker to use and provides a self-check.

GENERAL CHARACTERISTICS	Material	Maximum operating temperature	Surface coating options	Applications
	Standard material 18.8 stainless steel AISI 304 (1.4301) AISI 302 (1.4310)	425°C (peak) 315°C (continuous)	- Dry lubrication - Cadmium plating - Silver plating - Zinc coating - Tinning	All normal applications in all materials
	Special stainless steels: AISI 304L, 316, 316L, 306Ti, 321	Up to 400°C continuous		Special applications. Resistant to acids, corrosion, high temperatures - Amagnetism
	Phosphor bronze	300°C (peak) 250°C (continuous)	Cadmium plating	Copper parts Durable in certain electrolytic couples
	Inconel x 750 Nc 15 Fe Nba	750°C (peak)	Silver plating	Thermal power stations Aerospace Aeronautics Turbo compressor
	Nimonic 90 Nc 20 C. 18Ti	538°C (continuous)		

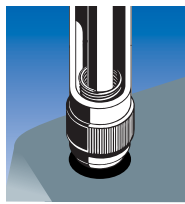
Fitting principle



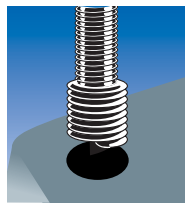
• **Drilling**
From +0.1 to +1 of the nominal screw diameter.
Chamfer \leq tapping diameter



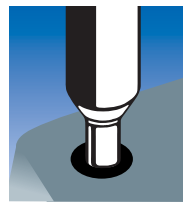
• **Tapping**
With the AMECOIL tap drill.



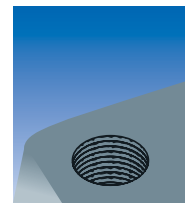
• **Fitting**
With the classic range tools ...



... or SR range tools, for even shorter fitting times



• **Breaking the engaging tang**
Using the AMECOIL impact or automatic tang break



• **Thread insert fitted**

OPERATIONAL ADVANTAGES: ORIGINAL EQUIPMENT REPAIRS REWORKING

- Cannot be loosened
- Even load distribution
- Resistant to corrosion and other attacks
- Less bossing
- Resistant to premature wear
- Simplifies locking systems

Amecoil thread insert with locking

This self-locking range corresponds to the classic range in all points, with thread locking obtained by polygonal deformation of one or more turns of the thread.

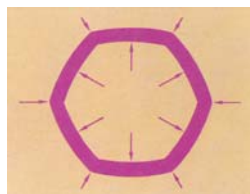
This deformation results in

powerful braking on the sides of the screw thread and cancels the loosening effects caused by dynamic stresses, vibrations and thermal loading.

The locking torques obtained are comparable to the values

given in standard ISO 2320.

The stainless steel self-locking thread insert is identified by its red colour.



Dimensions	Max 1st tightening	Min 1st loosening	Min 5th loosening
M3	0,43	0,12	0,08
M4	0,90	0,18	0,12
M5	1,60	0,29	0,20
M6	3,00	0,45	0,30
M8	6,00	0,85	0,60
M10	10,5	1,50	1,00
M12	15,5	2,30	1,60
M14	24,0	3,30	2,30
M16	32,0	4,50	3,00
M20	54,0	7,50	5,30
M24	80,0	11,5	8,00

Values in Nm quoted from ISO 2320 (class 8 screws)

Fitting tooling



Drilling

The pilot hole is made with a standard commercially available bit. Please check with pages 6 to 10 for the diameter and depth of hole required.

Tapping

AMECOIL taps can be used either manually or on a machine



Roughing tap
4-pitch point. For through and blind holes. Can be used for all metals and for high precision tapping.



Finishing tap
2-pitch point. For through and blind holes. Tapping by hand or on a machine.



Straight fluted machine tap with "GUN cut" point.
4-pitch point. For through holes. The "GUN" cut allows the chips to be pushed out ahead of the tap.

Fitting

Hand fitting tools

CLASSIC RANGE



Multi-dimensional with smooth driver



Multi-dimensional with threaded driver



Uni-dimensional with body with smooth or threaded driver



Unidimensional with mandrel

Automatic fitting tools

CLASSIC RANGE



Multidimensional with nose-piece + threaded driver

Accessories



Tang-breaks
These are used to break the engaging tang on the insert. Hand or automatic versions available.



Extractors
AMECOIL extractors are used to remove the thread insert if it has been poorly fitted.



Multidimensional



Contents



Machine tap with right hand helicoidal flutes 35° to 39°.
2 or 3-pitch point.
For blind holes.
For all materials that are difficult to machine. Special taps on request.



Plug gauge
Used to check the tapping in which the AMECOIL thread insert is to be used.

1. Thread inserts	Pages
1-1. Metric pitch	6/7
1-2. UNC pitch	8/9
1-3. UNF pitch	8/9
1-4. BSW pitch	10/11
1-5. BSP pitch	10/11
1-6. BSF pitch	10/11

AMECOIL SR RANGE



Unidimensional with threaded driver and wrench



Unidimensional with threaded driver and knob

AMECOIL SR RANGE



Multidimensional with threaded driver



2. Tapers and plug gauges	12/13
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3. Fitting tools

3-1. Hand	14/15
3-2. Automatic	16/17
3-3. For plastic strips	17/18

4. Accessories

4-1. Tang breaks	18
4-2. Extractor	18
4-3. AMELOCK NUT	18
4-4. Boxes/Kits	18

Boxes/Kits



Unidimensional

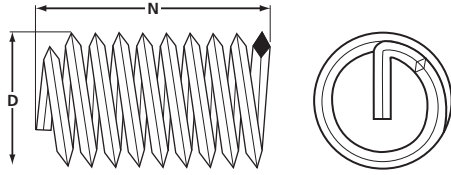


Spark plug boxes



Mini-kit





The figure 01 at the beginning of each reference refers to a standard stainless steel thread. For a different type of thread or another material, indicate the 2 figures corresponding to your choice according to the list to the right.

- 01 - Standard stainless steel
 - 02 - Self-locking stainless steel
 - 63 - Standard bronze, uncoated
 - 64 - Self-locking bronze, uncoated
 - 65 - Standard Inconel x750 silvered
 - 66 - Self-locking Inconel x750 silvered
 - 67 - Standard Inconel x750, uncoated
 - 68 - Self-locking Inconel x750, uncoated
- For AMECOIL SR, add SR at the end of the article n°.

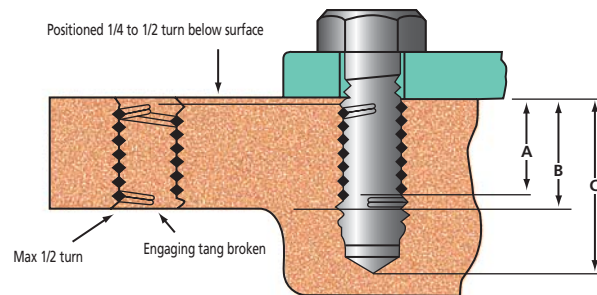
UNC pitch

		D ext ø when free		N - Number of turns when free $\pm 1/4$					Article number					Nominal diameter d	
	2,5 d	3 d	min.	max.	1 d	1,5 d	2 d	2,5 d	3 d	1 d	1,5 d	2 d	2,5 d	3 d	
	7,5	8,6	2,8	3,0	3,0	5,2	7,4	9,6	11,8	0110020086	0110020129	0110020172	0110020215	0110020258	2 - 56
	8,7	10,0	3,2	3,5	2,8	5,0	7,2	9,4	11,5	0110030099	0110030148	0110030198	0110030248	0110030297	3 - 48
	10,0	11,4	3,6	4,0	2,8	4,8	6,8	8,8	10,8	0110040112	0110040168	0110040224	0110040280	0110040336	4 - 40
	10,8	12,4	4,0	4,4	3,3	5,5	7,8	10,0	12,2	0110050125	0110050188	0110050250	0110050312	0110050375	5 - 40
	12,3	14,1	4,5	4,9	2,8	4,8	6,7	8,7	10,8	0110060138	0110060207	0110060276	0110060345	0110060414	6 - 32
	14,0	16,1	5,2	5,6	3,5	5,9	8,3	10,7	13,2	0110080164	0110080246	0110080328	0110080410	0110080492	8 - 32
	16,8	19,2	6,2	6,6	2,9	5,0	7,1	9,2	11,4	0110100190	0110100285	0110100380	0110100475	0110100570	10 - 24
	18,5	21,3	6,8	7,2	3,5	5,9	8,3	10,7	13,2	0110120216	0110120324	0110120432	0110120540	0110120648	12 - 24
	21,6	24,8	8,0	8,4	3,4	5,7	8,0	10,3	12,7	0110140250	0110140375	0110140500	0110140625	0110140750	1/4 - 20
	26,2	30,2	9,7	10,2	4,0	6,6	9,3	11,9	14,7	0115160312	0115160469	0115160625	0115160781	0115160938	5/16 - 18
	31,0	35,7	11,5	12,0	4,4	7,2	10,0	12,9	15,7	0110380375	0110380562	0110380750	0110380938	0110381125	3/8 - 16
	35,9	41,5	13,4	14,0	4,5	7,4	10,3	13,1	16,1	0117160438	0117160656	0117160875	0117161094	0117161312	7/16 - 14
	40,5	46,9	15,2	15,8	4,8	7,9	10,9	13,9	17,1	0110120500	0110120750	0110121000	0110121250	0110121500	1/2 - 13
	45,2	52,4	17,0	17,6	5,1	8,3	11,5	14,7	17,8	0119160562	0119160844	0119161125	0119161406	0119161688	9/16 - 12
	50,1	58,0	18,9	19,5	5,3	8,3	11,8	15,0	18,4	0110580625	0110580938	0110581250	0110581562	0110581875	5/8 - 11
	59,0	68,6	22,4	23,0	5,9	9,4	13,0	16,5	20,2	0110340750	0110341125	0110341500	0110341875	0110342250	3/4 - 10
	68,3	79,4	26,0	26,7	6,3	10,0	13,7	17,5	21,3	0110780875	0110781312	0110781750	0110782188	0110782625	7/8 - 9
	77,8	90,5	29,6	30,4	6,4	10,2	14,0	17,7	21,6	0111001000	0111001500	0111002000	0111002500	0111003000	1" - 8
	87,8	102,0	33,4	34,4	6,3	9,9	13,6	17,5	21,3	0111181125	0111181688	0111182250	0111182812	0111183375	1" 1/8 - 7
	96,0	111,8	36,7	37,7	7,0	11,2	15,4	19,5	23,7	0111141250	0111141875	0111142500	0111143125	0111143750	1" 1/4 - 7
	106,0	124,0	40,6	41,7	6,5	10,5	14,4	18,4	22,3	0111381375	0111382062	0111382750	0111383438	0111384125	1" 3/8 - 6
	115,0	133,0	43,9	45,0	7,2	11,5	15,9	20,2	24,5	0111121500	0111122250	0111123000	0111123750	0111124500	1" 1/2 - 6

UNF pitch

		D ext ø when free		N - Number of turns when free $\pm 1/4$					Article number					Nominal diameter d	
	2,5 d	3 d	min.	max.	1 d	1,5 d	2 d	2,5 d	3 d	1 d	1,5 d	2 d	2,5 d	3 d	
	7,3	8,3	2,79	3,02	3,5	5,6	8,0	10,4	12,5	0120020086	0120020129	0120020172	0120020215	0120020258	2 - 64
	8,4	9,6	3,3	3,7	3,4	5,6	8,0	10,4	12,6	0120030099	0120030148	0120030198	0120030248	0120030297	3 - 56
	9,5	10,9	3,7	4,1	3,4	5,6	7,9	10,2	12,5	0120040112	0120040168	0120040224	0120040280	0120040336	4 - 48
	11,6	13,4	4,5	4,9	3,8	6,0	8,4	10,8	13,2	0120060138	0120060207	0120060276	0120060345	0120060414	6 - 40
	13,6	15,7	5,3	5,7	4,0	6,6	9,1	11,7	14,2	0120080164	0120080246	0120080328	0120080410	0120080492	8 - 36
	15,6	18,0	6,1	6,5	4,1	6,8	9,5	12,1	14,9	0120100190	0120100285	0120100380	0120100475	0120100570	10 - 32
	20,0	23,2	7,8	8,3	5,0	8,1	11,3	14,4	17,6	0120140250	0120140375	0120140500	0120140625	0120140750	1/4 - 28
	24,6	28,6	9,7	10,2	5,5	8,9	12,2	15,6	19,0	0125160312	0125160469	0125160625	0125160781	0125160938	5/16 - 24
	28,6	33,3	11,4	11,9	6,9	10,9	14,9	19,0	23,2	0120380375	0120380562	0120380750	0120380938	0120381125	3/8 - 24
	33,5	39,0	13,4	13,9	6,6	10,6	14,5	18,4	22,5	0127160438	0127160656	0127160875	0127161094	0127161312	7/16 - 20
	37,5	43,8	15,1	15,7	7,8	12,3	16,8	21,3	25,9	0120120500	0120120750	0120121000	0120121250	0120121500	1/2 - 20
	42,1	49,2	16,9	17,6	7,9	12,5	17,1	21,6	26,2	0129160562	0129160844	0129161125	0129161406	0129161688	9/16 - 18
	46,0	54,0	18,6	19,3	8,9	14,1	19,1	24,3	29,4	0120580625	0120580938	0120581250	0120581562	0120581875	5/8 - 18
	54,8	64,3	22,2	22,9	9,7	15,1	20,6	26,0	31,5	0120340750	0120341125	0120341500	0120341875	0120342250	3/4 - 16
	63,7	74,8	26,0	26,7	9,9	15,4	21,0	26,6	32,2	0120780875	0120781312	0120781750	0120782188	0120782625	7/8 - 14
	71,7	84,4	29,4	30,1	11,5	17,9	24,3	30,6	37,0	0121041000	0121041500	0121042000	0121042500	0121043000	1" - 14
	73,0	85,7	29,7	30,4	9,7	15,1	20,6	26,1	31,5	0121001000	0121001500	0121002000	0121002500	0121003000	1" - 12
	81,0	95,3	33,2	33,9	11,1	17,3	23,4	29,6	35,7	0121181125	0121181688	0121182250	0121182812	0121183375	1" 1/8 - 12
	88,9	104,8	36,6	37,3	12,4	19,3	26,1	33,0	39,8	0121141250	0121141875	0121142500	0121143125	0121143750	1" 1/4 - 12
	96,8	114,3	40,0	40,9	13,8	21,3	28,9	36,5	44,0	0121381375	0121382062	0121382750	0121383438	0121384125	1" 3/8 - 12
	104,8	123,8	43,4	44,3	15,2	23,4	31,6	39,8	48,2	0121121500	0121122250	0121123000	0121123750	0121124500	1" 1/2 - 12

Other sizes on request.



BSW pitch

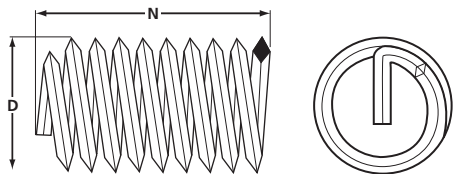
Nominal Diameter d	Pitch mm	Bit ø mm	Drilling ø		Taper Min ext. ø	A - Thread fitted					B - Nominal length (mm)					C - Drilling depth		
			min.	max.		1 d	1,5 d	2 d	2,5 d	3 d	1 d	1,5 d	2 d	2,5 d	3 d	1 d	1,5 d	2 d
1/8 - 40	0,635	3,4	3,28	3,43	3,93	2,5	4,1	5,7	7,3	8,9	3,2	4,8	6,3	7,9	9,5	6,0	7,6	9,2
3/16 - 24	1,058	5,1	4,98	5,13	6,01	3,7	6,1	8,5	10,9	13,2	4,8	7,1	9,5	11,9	14,3	9,5	11,9	14,3
1/4 - 20	1,270	6,7	6,63	6,78	7,84	5,1	8,2	11,4	14,6	17,8	6,4	9,5	12,7	15,9	19,1	12,1	15,2	18,4
5/16 - 18	1,411	8,4	8,33	8,48	9,59	6,5	10,5	14,5	18,4	22,4	7,9	11,9	15,9	19,8	23,8	14,3	18,3	22,2
3/8 - 16	1,588	10,0	9,91	10,11	11,39	7,9	12,7	17,5	22,2	27,0	9,5	14,3	19,1	23,8	28,6	16,7	21,4	26,2
7/16 - 14	1,814	11,6	11,51	11,76	13,24	9,3	14,9	20,4	26,0	31,5	11,1	16,7	22,2	27,8	33,3	19,3	24,8	30,4
1/2 - 12	2,117	13,2	13,08	13,34	15,17	10,6	17,0	23,3	29,7	36,0	12,7	19,1	25,4	31,8	38,1	22,2	28,6	34,9
9/16 - 12	2,117	14,8	14,68	14,94	16,76	12,2	19,3	26,5	33,6	40,8	14,3	21,5	28,6	35,7	42,9	23,8	31,0	38,1
5/8 - 11	2,309	16,7	16,59	16,84	18,57	13,6	21,5	29,4	37,4	45,3	15,9	23,8	31,8	39,7	47,6	26,3	34,2	42,1
11/16 - 11	2,309	18,3	18,21	18,47	20,16	15,2	23,9	32,6	41,3	50,0	17,5	26,2	34,9	43,6	52,4	27,9	36,6	45,3
3/4 - 10	2,540	20,0	19,84	20,09	22,02	16,5	26,0	35,5	45,1	54,6	19,1	28,6	38,1	47,6	57,2	30,5	40,0	49,5
7/8 - 9	2,822	23,0	23,01	23,27	25,52	19,4	30,5	41,6	52,7	63,9	22,2	33,3	44,5	55,5	66,7	34,9	46,0	57,2
1" - 8	3,175	26,5	26,19	26,52	29,10	22,2	34,9	47,6	60,3	73,0	25,4	38,1	50,8	63,5	76,2	39,7	52,4	65,1
1" 1/8 - 7	3,629	30,0	29,74	30,12	32,80	24,9	39,2	53,5	67,8	83,0	28,6	42,9	57,2	71,4	85,7	44,9	59,2	73,5
1" 1/4 - 7	3,629	33,0	32,92	33,30	35,97	28,1	44,0	59,9	75,8	91,6	31,8	47,6	63,5	79,4	95,2	48,1	64,0	79,8
1" 1/2 - 6	4,234	39,7	39,27	39,90	43,02	33,9	52,9	72,0	91,0	109,0	38,1	57,2	76,2	95,2	114,3	57,2	76,2	95,3

BSP pitch

Nominal Diameter d	Pitch mm	Bit ø mm	Drilling ø		Taper Min ext. ø	A - Thread fitted					B - Nominal length (mm)					C - Drilling depth		
			min.	max.		1 d	1,5 d	2 d	2,5 d	3 d	1 d	1,5 d	2 d	2,5 d	3 d	1 d	1,5 d	2 d
1/8 - 28	0,907	10,0	9,91	10,16	10,82	2,3	3,8	5,4	7	8,6	3,2	4,8	6,4	7,9	9,5	7,3	8,9	10,5
1/4 - 19	1,337	13,6	13,46	13,72	14,74	5	8,2	11,4	14,5	17,7	6,4	9,5	12,7	15,9	19,1	12,4	15,6	18,7
3/8 - 19	1,337	17,2	17,02	17,27	18,25	8,2	12,9	17,7	22,5	27,2	9,5	14,3	19,1	23,8	28,6	15,6	20,3	25,1
1/2 - 14	1,814	21,5	21,34	21,59	23,09	10,9	17,3	23,6	30,0	36,3	12,7	19,1	25,4	31,8	38,1	20,8	27,2	33,5
5/8 - 14	1,814	23,5	23,24	23,55	25,05	14,1	22,0	30,0	37,9	45,8	15,9	23,8	31,8	39,7	47,6	24,0	31,9	39,9
3/4 - 14	1,814	27,0	26,75	27,08	28,59	17,3	26,8	36,3	45,8	55,3	19,1	28,6	38,1	47,6	57,2	27,2	36,7	46,2
7/8 - 14	1,814	30,7	30,48	30,81	32,35	20,4	31,5	42,7	53,7	64,9	22,2	33,3	44,5	55,5	66,7	30,4	41,5	52,6
1" - 11	2,309	33,7	33,53	33,91	35,96	23,1	35,8	48,5	61,2	73,9	25,4	38,1	50,8	63,5	76,2	35,8	48,5	61,3
1" 1/4 - 11	2,309	42,5	42,29	42,67	44,63	29,4	45,3	61,2	77,1	92,9	31,8	47,6	63,5	79,4	95,2	42,2	58,0	73,9
1" 1/2 - 11	2,309	48,5	48,41	48,79	50,53	35,8	54,8	73,9	92,9	112,0	38,1	57,2	76,2	95,2	114,2	48,5	67,6	86,7

BSF pitch

Nominal Diameter d	Pitch mm	Bit ø mm	Drilling ø		Taper Min ext. ø	A - Thread fitted					B - Nominal length (mm)					C - Drilling depth		
			min.	max.		1 d	1,5 d	2 d	2,5 d	3 d	1 d	1,5 d	2 d	2,5 d	3 d	1 d	1,5 d	2 d
1/4 - 26	0,977	6,7	6,53	6,71	7,51	5,4	8,6	11,7	14,9	18,1	6,4	9,5	12,7	15,9	19,1	10,7	13,9	17,1
5/16 - 22	1,155	8,3	8,20	8,38	9,30	6,8	10,8	14,7	18,7	22,7	7,9	11,9	15,9	19,8	23,8	13,1	17,1	21,1
3/8 - 20	1,270	9,9	9,78	9,96	11,02	8,3	13,0	17,8	22,5	27,3	9,5	14,3	19,1	23,8	28,6	15,2	20,0	24,8
7/16 - 18	1,411	11,5	11,43	11,63	12,78	9,7	15,2	20,8	26,3	31,9	11,1	16,7	22,2	27,8	33,3	17,5	23,0	28,6
1/2 - 16	1,588	13,2	13,03	13,26	14,57	11,1	17,5	23,8	30,2	36,5	12,7	19,1	25,4	31,8	38,1	19,8	26,2	32,5
9/16 - 16	1,588	14,7	14,66	14,88	16,16	12,7	19,9	27,0	34,1	41,3	14,3	21,5	28,6	35,7	42,9	21,4	28,6	35,7
5/8 - 14	1,814	16,4	16,26	16,49	18,01	14,1	22,0	30,0	37,9	45,8	15,9	23,8	31,8	39,7	47,6	24,0	32,0	39,9
3/4 - 12	2,117	19,5	19,43	19,69	21,53	16,9	26,5	36,0	45,5	55,1	19,1	28,6	38,1	47,6	57,2	28,6	38,1	47,6
7/8 - 11	2,309	22,7	22,61	22,86	24,94	18,7	30,8	40,9	52,0	64,4	22,2	33,3	44,5	55,6	66,7	32,6	43,7	54,8
1" - 10	2,540	26,5	26,19	26,52	28,38	22,9	35,6	48,3	61,0	73,7	25,4	38,1	50,8	63,5	76,2	36,8	49,5	62,2
1" 1/8 - 9	2,822	29,5	29,36	29,72	31,88	25,8	40,0	54,3	68,6	82,9	28,6	42,9	57,2	71,4	85,7	41,3	55,6	69,9
1" 1/4 - 9	2,822	32,7	32,54	32,89	35,06	28,9	44,8	60,7	76,6	92,4	31,8	47,6	63,5	79,4	95,3	44,5	60,3	76,2
1" 3/8 - 8	3,175	36,0	35,71	36,07	38,64	31,7	49,2	66,7	84,1	101,6	34,9	52,4	69,9	87,3	104,8	49,2	66,7	84,1



The figure 01 at the beginning of each reference refers to a standard stainless steel thread. For a different type of thread or another material, indicate the 2 figures corresponding to your choice according to the list to the right.

- 01 - Standard stainless steel
 - 02 - Self-locking stainless steel
 - 63 - Standard bronze, uncoated
 - 64 - Self-locking bronze, uncoated
 - 65 - Standard Inconel x750 silvered
 - 66 - Self-locking Inconel x750 silvered
 - 67 - Standard Inconel x750, uncoated
 - 68 - Self-locking Inconel x750, uncoated
- For AMECOIL SR, add SR at the end of the article n°.



BSW pitch

D ext ø when free	D ext ø when free		N - Number of turns when free $\pm 1/4$					Article number					Nominal diameter d	
	2,5 d	3 d	min.	max.	1 d	1,5 d	2 d	2,5 d	3 d	1 d	1,5 d	2 d		2,5 d
10,8	12,4	4,0	4,4	3,4	5,6	7,9	10,3	12,4	0130180125	0130180187	0130180250	0130180312	0130180375	1/8 - 40
16,7	19,1	6,1	6,5	2,9	5,1	7,1	9,3	11,5	0133160187	0133160281	0133160375	0133160468	0133160562	3/16 - 24
21,6	24,8	7,9	8,4	3,4	5,9	8,1	10,5	12,8	0130140250	0130140375	0130140500	0130140625	0130140750	1/4 - 20
26,2	30,1	9,7	10,2	4,1	6,7	9,4	12,0	14,8	0135160312	0135160469	0135160625	0135160781	0135160937	5/16 - 18
31,0	35,7	11,5	12,0	4,5	7,3	10,2	13,0	15,8	0130380375	0130380562	0130380750	0130380937	0130381125	3/8 - 16
35,9	41,5	13,5	14,0	4,6	7,5	10,4	13,3	16,3	0137160437	0137160656	0137160875	0137161093	0137161312	7/16 - 14
41,3	47,6	15,4	16,0	4,4	7,3	10,1	13,0	16,0	0130120500	0130120750	0130121000	0130121250	0130121500	1/2 - 12
45,2	52,4	17,0	17,6	5,2	8,4	11,6	14,8	17,9	0139160562	0139160844	0139161125	0139161406	0139161687	9/16 - 12
50,1	58,0	18,9	19,5	5,4	8,7	11,9	15,3	18,5	0130580625	0130580937	0130581250	0130581562	0130581875	5/8 - 11
54,0	62,8	20,5	21,1	6,1	9,7	13,3	16,9	20,2	0131160687	0131161031	0131161375	0131161718	0131162062	11/16 - 11
59,0	68,6	22,4	23,0	6,0	9,6	13,2	16,8	20,4	0130340750	0130341125	0130341500	0130341875	0130342250	3/4 - 10
68,3	79,4	26,0	26,7	6,4	10,1	13,9	17,7	21,5	0130780875	0130781312	0130781750	0130782187	0130782625	7/8 - 9
77,8	90,5	27,7	30,4	6,5	10,3	14,1	17,9	21,7	0131001000	0131001500	0131002000	0131002500	0131003000	1" - 8
87,8	102,0	33,5	34,4	6,4	10,1	13,9	17,6	21,5	0131181125	0131181687	0131182250	0131182812	0131183375	1" 1/8 - 7
95,7	111,6	36,7	37,7	7,3	11,4	15,6	19,8	24,0	0131141250	0131141875	0131142500	0131143125	0131143750	1" 1/4 - 7
114,3	133,3	43,9	45,1	7,4	11,8	16,1	20,4	24,7	0131121500	0131122250	0131123000	0131123750	0131124500	1" 1/2 - 6

BSP pitch

D ext ø when free	D ext ø when free		N - Number of turns when free $\pm 1/4$					Article number					Nominal diameter d	
	2,5 d	3 d	min.	max.	1 d	1,5 d	2 d	2,5 d	3 d	1 d	1,5 d	2 d		2,5 d
12	13,7	11,5	12,0	1,9	3,6	5,1	6,7	7,9	0140180125	0140180187	0140180250	0140180312	0140180375	1/8 - 28
21,9	25,1	15,7	16,2	3,1	5,3	7,4	9,6	11,9	0140140250	0140140375	0140140500	0140140625	0140140750	1/4 - 19
29,8	34,6	19,5	20,0	5,3	8,5	11,8	15,0	17,4	0140380375	0140380562	0140380750	0140380937	0140381125	3/8 - 19
39,9	46,3	24,6	25,2	5,2	8,4	11,6	14,8	18,0	0140120500	0140120750	0140121000	0140121250	0140121500	1/2 - 14
47,8	55,7	26,7	27,4	6,8	10,8	14,8	18,8	22,8	0140580625	0140580937	0140581250	0140581562	0140581875	5/8 - 14
55,8	65,3	30,5	31,2	8,4	13,3	18,1	23,0	28,0	0140340750	0140341125	0140341500	0140341875	0140342250	3/4 - 14
63,4	74,8	34,6	35,3	10,0	15,6	21,3	26,8	32,5	0140780875	0140781312	0140781750	0140782187	0140782625	7/8 - 14
73,9	86,6	38,4	39,2	8,9	13,9	19,0	24,0	29,1	0141001000	0141001500	0141002000	0141002500	0141003000	1" - 11
89,9	105,7	47,7	48,5	11,4	17,8	24,1	30,5	36,9	0141141250	0141141875	0141142500	0141143125	0141143750	1" 1/4 - 11
105,7	124,7	54,1	54,9	13,9	21,6	29,3	37,0	44,7	0141121500	0141122250	0141123000	0141123750	0141124500	1" 1/2 - 11

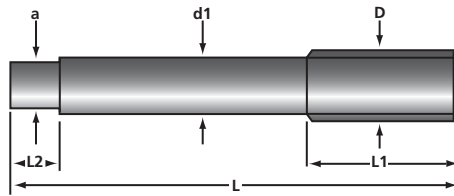
BSF pitch

D ext ø when free	D ext ø when free		N - Number of turns when free $\pm 1/4$					Article number					Nominal diameter d	
	2,5 d	3 d	min.	max.	1 d	1,5 d	2 d	2,5 d	3 d	1 d	1,5 d	2 d		2,5 d
20,3	23,5	7,9	8,4	4,6	7,6	10,4	13,4	16,5	0150140250	0150140375	0150140500	0150140625	0150140750	1/4 - 26
25,0	29,0	9,8	10,3	5,0	8,1	11,2	14,3	17,7	0155160312	0155160469	0155160625	0155160781	0155160938	5/16 - 22
29,5	34,3	11,6	12,1	5,6	9,0	12,4	15,8	19,2	0150380375	0150380562	0150380750	0150380937	0150381125	3/8 - 20
34,1	39,7	13,6	14,1	5,9	9,5	13,1	16,6	20,2	0157160438	0157160656	0157160875	0157161093	0157161312	7/16 - 18
38,9	45,3	15,5	16,0	6,1	9,7	13,3	16,9	20,5	0150120500	0150120750	0150121000	0150121250	0150121500	1/2 - 16
42,9	50,0	17,2	17,8	7,0	11,1	15,1	19,3	23,4	0159160562	0159160844	0159161125	0159161406	0159161687	9/16 - 16
47,8	55,8	19,1	19,7	6,8	10,8	14,8	18,7	22,8	0150580625	0150580937	0150581250	0150581562	0150581875	5/8 - 14
57,2	66,7	22,9	23,5	7,0	11,1	15,2	19,3	23,4	0150340750	0150341125	0150341500	0150341875	0150342250	3/4 - 12
65,9	70,1	26,5	27,3	7,6	11,9	16,4	20,8	25,2	0150780875	0150781312	0150781750	0150782187	0150782625	7/8 - 11
74,9	87,6	30,2	31,0	7,9	12,5	17,1	21,6	26,2	0151001000	0151001500	0151002000	0151002500	0151003000	1" - 10
84,1	98,5	33,9	34,7	8,1	12,7	17,3	21,9	26,5	0151181125	0151181687	0151182250	0151182812	0151183375	1" 1/8 - 9
92,1	108,0	37,3	38,1	9,1	14,3	19,4	24,6	29,8	0151141250	0151141875	0151142500	0151143125	0151143750	1" 1/4 - 9
101,6	119,0	41,2	42,1	8,8	13,9	18,9	23,9	28,8	0151381375	0151382062	0151382750	0151383437	0151384125	1" 3/8 - 8

Other sizes on request.



Tap for machining in standard material, max hardness 21 HRC. Please check with us for other applications.



Amecoil® taps

ø x pitch	References			Dimensions in mm					
	Roughing	Finishing	Gun	D	d1	L1 max	L	a	L2
M2 x 0,40	080102040	080202040	080302040	2,5	2,8	9,5	44	2,25	5
M2,5 x 0,45	080125045	080225045	080325045	3,1	3,15	13	48	2,5	5
M3 x 0,50	080103050	080203050	080303050	3,7	4	16	53	3,15	6
M3,5 x 0,60	080135060	080235060	080335060	4,3	4,5	16	53	3,55	6
M4 x 0,70	080104070	080204070	080304070	4,9	5	16	58	4	7
M5 x 0,80	080105080	080205080	080305080	6,0	6,3	19	66	5	8
M6 x 1	080106100	080206100	080306100	7,3	8	22	72	6,3	9
M7 x 1	080107100	080207100	080307100	8,3	9	22	72	7,1	10
M8 x 1	080108100	080208100	080308100	9,3	10	24	80	8	11
M8 x 1,25	080108125	080208125	080308125	9,6	10	24	80	8	11
M9 x 1,25	080109125	080209125	080309125	10,6	8	25	85	6,3	9
M10 x 1	080110100	080210100	080310100	11,3	9	29	89	7,1	10
M10 x 1,25	080110125	080210125	080310125	11,6	9	29	89	7,1	10
M10 x 1,50	080110150	080210150	080310150	12,0	9	29	89	7,1	10
M11 x 1,50	080111150	080211150	080311150	13,0	11,2	30	95	9	12
M12 x 1	080112100	080212100	080312100	13,3	11,2	30	95	9	12
M12 x 1,25	080112125	080212125	080312125	13,6	11,2	30	95	9	12
M12 x 1,50	080112150	080212150	080312150	14,0	11,2	30	95	9	12
M12 x 1,75	080112175	080212175	080312175	14,3	11,2	30	95	9	12
M14 x 1,25	080114125	080214125	080314125	15,6	12,5	32	102	10	13
M14 x 1,50	080114150	080214150	080314150	16,0	12,5	32	102	10	13
M14 x 2	080114200	080214200	080314200	16,6	12,5	32	102	10	13
M16 x 1,50	080116150	080216150	080316150	18,0	14	37	112	11,2	14
M16 x 2	080116200	080216200	080316200	18,6	14	37	112	11,2	14
M18 x 1,50	080118150	080218150	080318150	20,0	14	37	112	11,2	14
M18 x 2	080118200	080218200	080318200	20,6	14	37	112	11,2	14
M18 x 2,50	080118250	080218250	080318250	21,3	16	38	118	12,5	16
M20 x 1,50	080120150	080220150	080320150	22	16	38	118	12,5	16
M20 x 2,50	080120250	080220250	080320250	23,3	18	45	130	14	18
M22 x 1,50	080122150	080222150	080322150	24,0	18	45	130	14	18
M22 x 2	080122200	080222200	080322200	24,6	18	45	130	14	18
M22 x 2,50	080122250	080222250	080322250	25,3	18	45	130	14	18
M24 x 1,50	080124150	080224150	080324150	26,0	18	45	130	14	18
M24 x 2	080124200	080224200	080324200	26,6	20	45	127	16	20
M24 x 3	080124300	080224300	080324300	27,9	20	45	135	16	20
M26 x 1,50	080126150	080226150	080326150	28,0	20	37	127	16	20
M27 x 1,50	080127150	080227150	080327150	29,0	20	37	127	16	20
M27 x 2	080127200	080227200	080327200	29,6	20	37	127	16	20
M27 x 3	080127300	080227300	080327300	30,9	22,4	51	151	18	22
M30 x 1,50	080130150	080230150	080330150	32,0	22,4	37	137	18	22
M30 x 2	080130200	080230200	080330200	32,6	22,4	37	137	18	22
M30 x 3,50	080130350	080230350	080330350	34,5	25	57	162	20	24
M33 x 2	080133200	080233200	080333200	35,6	25	39	144	20	24
M33 x 3,50	080133350	080233350	080333350	37,5	28	60	170	22,4	26
M36 x 1,50	080136150	080236150	080336150	38,0	28	39	149	22,4	26
M36 x 2	080136200	080236200	080336200	38,6	28	39	149	22,4	26
M36 x 3	080136300	080236300	080336300	39,9	28	60	149	22,4	26
M36 x 4	080136400	080236400	080336400	41,2	28	60	170	22,4	26
M39 x 4	080139400	080239400	080339400	44,3	31,5	67	187	25	28
M45 x 4,50	080145450	080245450	080345450	51,2	35,5	70	200	28	31



Tap without chips



For tapping in ductile materials

Double threaded plug gauge
F/R (SH)

Conformity of tapping after fitting the AMECOIL thread insert depends on correct checking beforehand of the thread that is to receive it.



Plug gauges Min - max

ø x pitch	References	Dimensions in mm						ø x pitch	References
		D	d1	L1 Max	L	a	L2		
M2 x 0,40	080402040	2,5	2,8	8	50	2,1	5	M2 x 0,40	0602040
M2,5 x 0,45	080425045	3,1	3,5	11	56	2,7	6	M2,5 x 0,45	0625045
M3 x 0,50	080403050	3,7	4,5	13	63	3,4	6	M3 x 0,50	0603050
M3,5 x 0,60	080435060	4,3	4,5	13	63	3,1	6	M3,5 x 0,60	0635060
M4 x 0,70	080404070	4,9	6	14	70	4,9	8	M4 x 0,70	0604070
M5 x 0,80	080405080	6,0	6	16	80	4,9	8	M5 x 0,80	0605080
M6 x 1	080406100	7,3	8	18	90	6,2	9	M6 x 1	0606100
M7 x 1	080407100	8,3	9	18	90	7	10	M7 x 1	0607100
M8 x 1	080408100	9,3	10	20	100	8	11	M8 x 1	0608100
M8 x 1,25	080408125	9,6	10	20	100	8	11	M8 x 1,25	0608125
M9 x 1,25	080409125	10,6	8	20	100	6,2	9	M9 x 1,25	0609125
M10 x 1	080410100	11,3	8	20	100	6,2	9	M10 x 1	0610100
M10 x 1,25	080410125	11,6	9	16	100	7	10	M10 x 1,25	0610125
M10 x 1,50	080410150	12	9	20	110	7	10	M10 x 1,50	0610150
M11 x 1,50	080411150	13	11	22	100	9	11	M11 x 1,50	0611150
M12 x 1	080412100	13,3	11	22	100	9	12	M12 x 1	0612100
M12 x 1,25	080412125	13,6	11	22	100	9	12	M12 x 1,25	0612125
M12 x 1,50	080412150	14	11	22	100	9	12	M12 x 1,50	0612150
M12 x 1,75	080412175	14,3	11	26	110	9	12	M12 x 1,75	0612175
M14 x 1,25	080414125	15,6	12	22	100	9	12	M14 x 1,25	0614125
M14 x 1,50	080414150	16	12	22	100	9	12	M14 x 1,50	0614150
M14 x 2	080414200	16,6	12	28	110	9	12	M14 x 2	0614200
M16 x 1,50	080416150	18	14	25	110	11	14	M16 x 1,50	0616150
M16 x 2	080416200	18,6	14	32	125	11	14	M16 x 2	0616200
M18 x 1,50	080418150	20	16	25	125	12	15	M18 x 1,50	0618150
M18 x 2	080418200	20,6	16	25	140	12	15	M18 x 2	0618200
M18 x 2,50	080418250	21,3	16	25	140	12	15	M18 x 2,50	0618250
M20 x 1,50	080420150	22	18	25	125	14,5	17	M20 x 1,50	0620150
M20 x 2,50	080420250	23,3	18	25	140	14,5	17	M20 x 2,50	0620250
M22 x 1,50	080422150	24	18	28	140	14,5	17	M22 x 1,50	0622150
M22 x 2	080422200	24,6	18	28	140	14,5	17	M22 x 2	0622200
M22 x 2,50	080422250	25,3	18	30	160	14,5	17	M22 x 2,50	0622250
M24 x 1,50	080424150	26	18	28	140	14,5	17	M24 x 1,50	0624150
M24 x 2	080424200	26,6	20	28	140	16	19	M24 x 2	0624200
M24 x 3	080424300	27,9	20	30	160	16	19	M24 x 3	0624300
M26 x 1,50	080426150	28	20	28	140	16	19	M26 x 1,50	0626150
M27 x 1,50	080427150	29	22	28	150	18	21	M27 x 1,50	0627150
M27 x 2	080427200	29,6	22	28	150	18	21	M27 x 2	0627200
M27 x 3	080427300	30,9	22	50	180	18	21	M27 x 3	0627300
M30 x 1,50	080430150	32	22	28	150	18	21	M30 x 1,50	0630150
M30 x 2	080430200	32,6	25	28	160	20	23	M30 x 2	0630200
M30 x 3,50	080430350	34,5	28	56	200	22	25	M30 x 3,50	0630350
M33 x 2	080433200	35,6	28	30	170	22	25	M33 x 2	0633200
M33 x 3,50	080433350	37,5	28	56	200	22	25	M33 x 3,50	0633350
M36 x 1,50	080436150	38	28	30	170	22	25	M36 x 1,50	0636150
M36 x 2	080436200	38,6	32	30	170	24	27	M36 x 2	0636200
M36 x 3	080436300	39,9	32	60	200	24	27	M36 x 3	0636300
M36 x 4	080436400	41,2	32	60	200	24	27	M36 x 4	0636400
M39 x 4	080439400	44,29	36	65	220	29	32	M39 x 4	0639400
M45 x 4,50	080445450	51,20	40	70	250	32	35	M45 x 4,50	0645450



Classic range

HAND FITTING TOOLS

Unidimensional and M

The external diameter of the thread inserts is greater than that of the tapped hole into which they are to be inserted, and the fitting tool reduces the diameter of the thread insert by means of the threaded nose, or by means of direct installation for tools with a mandrel.

• Standard tool

Tool recommended for normal applications.

Multidimensional tool ① ② ③. Nose and mandrel interchangeable for each body n°:

- from M2.5 to M5, body n° 1

- from M10 to M12, body n° 3

- from M6 to M9, body n° 2

- from M14 to M16, body n° 4

Unidimensional tool ④ ⑤ ⑥.

Coding system for interchangeable parts:

• Plain mandrel code: 0510 + 2 figures for diameter + 3 figures for pitch

• Nose code: 0506 + 2 figures for diameter + 3 figures for pitch

• Assembly code (nose + mandrel): 0516 + 2 figures for diameter + 3 figures for pitch

	Dimension	① Standard unit	② Unit with threaded mandrel	③ Unit N°1 b	⑦ Specific SR unit	Tang break		Extractor	
						Hand	Auto	Ref.	N°
Body n° 1	2x40	-	-	05202040	-	0520	0500002	0566	1
	2.5x45	→	05125045	05225045	0525045SR	0525	0500025	0566	1
	3x50	0503050	05103050	05203050	0503050SR	0503	0500003	0566	1
	3.5x60	0535060	-	05235060	0535060SR	0503	0500035	0566	1
	4x70	0504070	-	05204070	0504070SR	0504	0500004	0566	1
	5x80	0505080	05105080	-	0505080SR	0505	0500005	0566	1
Body n° 2	6x100	0506100	05106100	-	0506100SR	0506	0500006	0566	1
	7x100	0507100	05107100	-	0507100SR	0507	0500007	0566	1
	8x100	0508100	05108100	-	0508100SR	0508	0500008	0566	1
	8x125	0508125	05108125	-	0508125SR	0508	0500008	0566	1
	9x125	0509125	05109125	-	0509125SR	0509	-	0567	2
Body n° 3	10x100	→	05110100	-	Standard unit	0510	0500010	0567	2
	10x125	0510125	05110125	-	0510125SR	0510	0500010	0567	2
	10x150	0510150	05110150	-	0510150SR	0510	0500010	0567	2
	11x150	0511150	-	-	0511150SR	0511	-	0567	2
	12x100	→	05112100	-	Standard unit	0512	0500012	0567	2
	12x125	→	05112125	-	Standard unit	0512	0500012	0567	2
	12x150	0512150	05112150	-	0512150SR	0512	0500012	0567	2
	12x175	0512175	05112175	-	0512175SR	0512	0500012	0567	2
Body n° 4	14x125	→	05114125	-	Standard unit	0514	0500014	0568	3
	14x150	0514150	05114150	-	0514150SR	0514	0500014	0568	3
	14x200	0514200	05114200	-	0514200SR	0514	0500014	0568	3
	16x150	→	05116150	-	Standard unit	0516	-	0568	3
	16x200	0516200	05116200	-	0516200SR	0516	-	0568	3



Multidimensional units

• Tool N° 1b

Multidimensional tool ⑤ with threaded driver with body n°1b, the nose diameter is reduced to the minimum to allow access to difficult areas.

• Specific hand fitting tools for AMECOIL SR

The thread insert is screwed fully home on the driver, before being inserted directly in the tapped hole.

It is recommended to use the standard tool with threaded driver for fine pitch sizes.



Dimension	Standard tool			⑦ Specific SR tool	Tang break		Extractor	
	④ with smooth driver	⑤ with threaded driver	⑥ with mandrel		Hand	Ref.	N°	
18x150	-	05118150	-	Standard tool	0518	0568	3	
18x200	0518200	05118200	-	Standard tool	0518	0568	3	
18x250	0518250	-	-	0518250SR	0518	0568	3	
20x150	-	05120150	-	Standard tool	0521	0568	3	
20x200	0520200	05120200	-	Standard tool	0521	0568	3	
20x250	0520250	-	-	0520250SR	0521	0568	3	
22x150	-	05122150	-	Standard tool	0522	0568	3	
22x200	0522200	05122200	-	Standard tool	0522	0568	3	
22x250	0522250	-	-	0522250SR	0522	0568	3	
24x150	-	05124150	-	Standard tool	0524	0569	4	
24x200	0524200	05124200	-	Standard tool	0524	0569	4	
24x300	0524300	-	-	0524300SR	0524	0569	4	
26x150	-	05126150	-	Standard tool	0526	0569	4	
27x150	-	05127150	-	Standard tool	0527	0569	4	
27x200	0527200	05127200	-	Standard tool	0527	0569	4	
27x300	-	-	0527300	Standard tool	0527	0569	4	
28x150	-	05128150	-	Standard tool	0528	0569	4	
30x150	-	05130150	-	Standard tool	0530	0569	4	
30x200	0530200	05130200	-	Standard tool	0530	0569	4	
30x350	-	-	0530350	Standard tool	0530	0569	4	
33x200	0533200	05133200	-	Standard tool		0570	5	
33x350	-	-	0533350	Standard tool		0570	5	
34x150	-	05134150	-	Standard tool		0570	5	
36x150	-	05136150	-	Standard tool		0570	5	
36x200	0536200	05136200	-	Standard tool		0570	5	
36x300	-	05136300	0536300	0536300		0570	5	
36x400	-	-	0536400	Standard tool		0570	5	
39x300	-	05139300	0539300	0539300		0570	5	
39x400	-	-	0539400	Standard tool		0570	5	
42x300	0542300	05142300	-	0542300		0571	6	
42x450	-	-	0542450	Standard tool		0571	6	
45x300	-	-	0545300	Standard tool		0571	6	
45x450	-	-	0545450	Standard tool		0571	6	



Classic Range

AUTOMATIC FITTING TOOLING

Multidimen

The external diameter of the thread inserts is greater than that of the tapped hole into which they are to be inserted, and the fitting tool reduces the diameter of the thread insert by means of the threaded nose, or by direct fitting for AMECOIL-SR with the specific tool. The motorised tools are multidimensional and their fitting rate depends on the model (see table).

• Pneumatic tool for all types of AMECOIL

Various accessories are added to the basic tool. Adjustment of the fitting dept is achieved with spacers, each device being delivered with a set of spacers.

Fitting of thread inserts mounted on plastic strip requires special equipment on which the nose can take the strip.

Dimension	FOR ALL TYPES OF AMECOIL					SPECIFIC AMECOIL SR TOOL		Tang break		Extractor		
	Basic tool ①	Complete Amecoil tool loose pack ②	Complete tool for Amecoil on BP plastic strip ③			Basic SR tool ④	Special SR driver ⑥	Hand	Auto	Ref.	N°	
			W 1D	W 1.25/2D	W 2.5 D							
2.5x45	2511210	25125	251253	251257	251254	258502	3511125045	0525	0500025	0566	1	
2.5x45 AF		251252	251255	251258	251256		3512125045	0525	0500025	0566	1	
3x50		25103	251033	251037	251034		3511103050	0503	0500003	0566	1	
3x50 AF		251032	251035	251038	251036		3512103050	0503	0500003	0566	1	
3.5x60		25135	251353	251355	251354		-	0503	0500035	0566	1	
4x70		25104	251043	251045	251044		35101000	3511104070	0504	0500004	0566	1
4x70 AF		25104	251043	251045	251044			3512104070	0504	0500004	0566	1
5x80		25105	251053	251055	251054			3511105080	0505	0500005	0566	1
5x80 AF		25105	251053	251055	251054			3512105080	0505	0500005	0566	1
6x100		25106	251063	251065	251064			3511106100	0506	0500006	0566	1
6x100AF	25106	251063	251065	251064	3512106100	0506		0500006	0566	1		
7x100	2511614	2511607	25107	On request				3511107100	0507	0500007	0566	1
8x100			251081	On request				3511108100	0508	0500008	0566	1
8x125		25108	On request			3511108125		0508	0500008	0566	1	
10x100		251101	On request			-		0510	0500010	0567	2	
10x125		251102	On request			3511110125	0510	0500010	0567	2		
10x150		25110	On request			3511110150	0510	0500010	0567	2		
12x100		251121	-	-	-	-	0512	0500012	0567	2		
12x125		251122	-	-	-	-	0512	0500012	0567	2		
12x150		251123	-	-	-	3511112150	0512	0500012	0567	2		
12x175		25112	-	-	-	3511112175	0512	0500012	0567	2		
14x125	258503	259141251	-	-	-	-	0514	0500014	0568	3		
14x150		259141501	-	-	-	3511114150	0514	0500014	0568	3		
14x200		259142001	-	-	-	3511114200	0514	0500014	0568	3		
16x150		259161501	-	-	-	-	0516	-	0568	3		
16x200		259162001	-	-	-	3511116200	0516	-	0568	3		
18x150		259181501	-	-	-	-	0518	-	0568	3		



SR Range

Special tools

• Specific motorised tools for AMECOIL- SR

Starting with the basic tool (pneumatic ④, battery driven ⑤), the desired drivers are fitted and the depth is adjusted by screwing home or unscrewing the stop on the driver.

N.B.: the correct adjustment of the stop does not correspond to the length of the thread insert prior to fitting, so never place the stop and the thread insert in contact.

The thread insert is screwed fully onto the driver prior to being inserted directly in the tapped hole.

The same tool is just as suitable for AMECOIL-SR delivered loose as for those delivered on a plastic strip.

Dimension	SPECIFIC AMECOIL SR TOOL		SPECIFIC AMECOIL SR TOOL		Tang break		Extractor	
	Basic tool ①	Complete Amecoil tool loose pack ②	Basic SR tool ④	Special SR driver ⑥	Hand	Auto	Ref.	N°
					Hand	Auto		
14x150	2591418	251143	258503	3511114150	0514	0500014	0568	3
14x200		25114		3511114200	0514	0500014	0568	3
16x150		251163		-	0516	-	0568	3
16x200		25116		3511116200	0516	-	0568	3
18x150		251181		-	0518	-	0568	3
18x200		251182		-	0518	-	0568	3
18x250		25118		3511118250	0518	-	0568	3
20x150		251201		-	0521	-	0568	3
20x200		251202		-	0521	-	0568	3
20x250		25120		3511120250	0521	-	0568	3
24x150		251241		-	0524	-	0569	4
24x200		251242		-	0524	-	0569	4
24x300		-		3511124300	0524	-	0569	4

Complete equipment set =
Driver + Clutch + Nose +
Set of spacers

Complete too =
Bare tool + Complete
equipment set

Complete specific
AMECOIL SR tool =
Bare SR tool
+ special SR driver

AMECOIL on BP plastic strip

Dimension	Reference		Quantity per bobbin	Dimension	Reference		Quantity per bobbin
	Standard	Self-locking AF			Standard	Self-locking AF	
2.5x45x2.5	5125045025SR	5225045025SR	5000	7x100x14	5107100014SR	5207100014SR	400
2.5x45x3.75	5125045375SR	5225045375SR	4000	8x100x8	5108100008SR	5208100008SR	650
2.5x45x5	5125045005SR	5225045005SR	3000	8x100x12	5108100012SR	5208100012SR	400
3x50x3	5103050003SR	5203050003SR	4000	8x100x16	5108100016SR	5208100016SR	300
3x50x4.5	5103050045SR	5203050045SR	2800	8x125x8	5108125008SR	5208125008SR	650
3x50x6	5103050006SR	5203050006SR	2200	8x125x12	5108125012SR	5208125012SR	400
4x70x4	5104070004SR	5204070004SR	2200	8x125x16	5108125016SR	5208125016SR	300
4x70x6	5104070006SR	5204070006SR	1500	10x100x10	5110100010SR	5210100010SR	400
4x70x8	5104070008SR	5204070008SR	1300	10x100x15	5110100015SR	5210100015SR	250
5x80x5	5105080005SR	5205080005SR	1500	10x100x20	5110100020SR	5210100020SR	200
5x80x7.5	5105080075SR	5205080075SR	1000	10x125x10	5110125010SR	5210125010SR	400
5x80x10	5105080010SR	5205080010SR	800	10x125x15	5110125015SR	5210125015SR	250
6x100x6	5106100006SR	5206100006SR	1000	10x125x20	5110125020SR	5210125020SR	200
6x100x9	5106100009SR	5206100009SR	750	10x150x10	5110150010SR	5210150010SR	400
6x100x12	5106100012SR	5206100012SR	500	10x150x15	5210150015SR	5210150015SR	250
7x100x7	5107100007SR	5207100007SR	800	10x150x20	5110150020SR	5210150020SR	200
7x100x10.5	5107100105SR	5207100105SR	600	Bobbin diameter 300 mm			



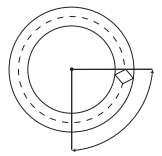
Impact tang break
This is used to break the engaging tang on the insert, leaving room for the screw to be inserted.
For threads exceeding $\varnothing 18$ use a tapered pliers.



Automatic tang break
The automatically triggered tang break can be used with one hand and needs no other tools.
Presetting and regularity of the impact ensure quick and efficient work.



Extractor
If needed the thread insert can be removed with an extractor.
The extractor's sharp blade gets a grip on the inside of the insert, which is then extracted using constant pressure and an unscrewing movement.
N.B.: the extractor blade must not bear against the last quarter turn of the insert or else the pressure exerted may make the turn penetrate into the material.



Last 1/4 turn where contact with the extractor blade is not allowed

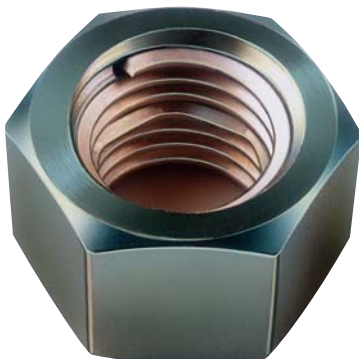
Plastic strips

AMECOIL thread inserts presented on plastic strips improve working conditions considerably for assembly of large series: better yield, no risk of mixing the threads, reduced labour costs, etc.
The thread inserts can be installed using a fixed fitting unit or a pneumatic fitting tool.

Please see page 17 for the references table.



AMELOCK® Nut



Metal H nut with self-locking stainless steel helical thread inset

Dimension	Reference		Overall measurement	
	Galvanised steel nut	Stainless steel nut	Flat to flat	Height
M5	3300805080	3330305080	8	5
M6	3300806100	3330306100	10	6
M8	3300808125	3330308125	13	8
M10	3300810150	3330310150	16	10
M12	3300812175	3330312175	18	12
M14	3300814200	3330314200	21	14
M16	3300816200	3330316200	24	16

Other sizes and coatings (silvering, lubrication, etc) on request

AMELOCK is a safety nut on which the locking part is obtained by means of the deformed part of an AMECOIL AF thread insert.
AMELOCK presents many advantages: no pins, lock nuts, washers needed, vibration resistance - Locking quality

remains after several assembly/dismantling operations. Symmetrical, can be fitted in either direction. Resists temperatures up to 600°C depending on the models.

Boxes/Kits



Multidimensional



Unidimensional

Ask for our specific "AMECA Kits" documentation



Spark plug boxes



Minikits

Complete kits containing the taps, tang breaks, fitting tools and standard thread inserts, destined for the repair of all faulty tapping situations. Real workshop boxes, essential for general and break-down maintenance teams in factories.

The "spark plugs" boxes provide a solution for repairing the tapping on spark plugs in a matter of minutes. Essential equipment for garages and workshops working with fleets of vehicles.
The Minikits contain (1 bit), 1 tap, 1 fitting tool and 5 thread inserts for occasional, minor repairs.



TAPPING: 3 REASONS FOR USING AMECOIL® SR THREAD INSERTS.

- **Quicker**

Easy to fit = less time taken.

- **Easier**

Innovating technology = optimised dimensions to make fitting easy.

- **Cheaper**

Inexpensive fitting tools = lower assembly costs.

ALL THE ADVANTAGES OF THE LATEST TECHNOLOGY WITHOUT HAVING TO CHANGE YOUR HABITS !

Production programme

Tapping * Threads	Standard and Self-locking
ISO metric Fine pitches	M4 x 0,5 M64 x 4
ISO metric Normal pitches	M2 to M48
BSF (British Standard Fine)	1/4 to 1" 3/8
BSW (British Standard Withworth)	1/8 to 1" 1/2
GAZ - BSP - Rohr	1/8 to 2"
UNF/UNJF (Unified National Fine)	2 - 64 to 1" 1/2-12
UNC/UNJC (Unified National Coarse)	2 - 56 to 1" 1/2-6

(*) BA - NPT/NPTF system on request.

Reference standards

LN 9499-1
LN 9039-1
DIN 8140-1

Certifié ISO 9001 : 2000 par





All kinds of mechanical fastenings covered by a comprehensive range

For cheap yet high-technology assembly work:

- Quick and easy assembly.
 - Impeccable quality assembly.
 - Totally guaranteed by the manufacturer.
-
- TWIN-INSERT thread insert
 - CLAV-SERT insert
 - AMPLAST insert for plastic
 - CAGE-NUT captive nut
 - Column-spacer for fitting with a press
 - Self-clinching pin for fitting with a press
 - Self-clinching nut for fitting with a press
 - Self-clinching captive cage screw for fitting with a press
 - Ball Lock ball fastener system
 - AMECA self-tapping bush
 - AMSERT flush nut and pin for swaging
 - Quick assembly nut
 - Quick 1/4 turn fastener
 - Latch fastener
 - Pin for soldering
 - Ball lock, etc.

AMECA is also a whole range of tools for tapping, fitting, swaging, assembling

Certifié ISO 9001 : 2000 par



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