

## COILREPAIR

If you are looking for a permanent and stable solution for repairing a damaged thread, then you are on the safe side with the GSR Coilrepair system. With this set, you can reconstruct the nominal size of the damaged thread accurately. Threads treated like this are often even more resilient than the original thread. Therefore, one speaks of thread reinforcement.



## coilrepair

The GSR thread inserts are used to repair threads by keeping the original nominal size or to reinforce a thread. GSR now offers a complete range of inserts for metric threads, as well as tools for professional assembly. To store the kit we developed shapely plastic boxes for the individual sizes as well as two big boxes for the repair assortments. The GSR thread inserts are highly resilient, cost-efficient and easy to assemble.



## TABLE SECTION THREAD REPAIR

### THREAD REPAIR KIT

Nominal size	Tap		Twist drill		Insertion tool		Break tool		Art. No.
	Ø	Length	Ø	Length	Ø	Length	Ø	Length	
M 2 × 0,4	2,52	45	2,1	60	1,1	104	1	100	00803001
M 2,5 × 0,45	3,08	48	2,6	60	1,4	104	1,5	100	00803002
M 3 × 0,5	3,65	50	3,1	75	1,8	104	2,1	100	00803003
M 4 × 0,7	4,91	58	4,1	85	2,5	104	2,8	100	00803004
M 5 × 0,8	6,04	66	5,2	85	3,2	104	3,6	100	00803005
M 6 × 1,0	7,3	72	6,2	85	4,4	104	4,5	105	00803006
M 7 × 1,0	8,3	72	7,2	85	5	1304	5	110	00803007
M 8 × 1	9,3	80	8,2	115	5,7	140	5	110	00803008
M 8 × 1,25	9,62	80	8,3	115	5,7	140	6,2	110	00803009
M 9 × 1,25	10,62	89	9,3	115	6,5	145	6	110	00803010
M 10 × 1	11,3	89	10,3	130	7,5	150	7	115	00803011
M 10 × 1,25	11,62	89	10,3	130	7,5	150	7	115	00803012
M 10 × 1,5	11,95	89	10,3	130	7,5	150	7,85	115	00803013
M 12 × 1	13,3	95	12,3	140	9	150	9	120	00803014
M 12 × 1,25	13,62	95	12,3	140	9	150	9	120	00803015
M 12 × 1,5	13,95	95	12,5	140	9	150	9	120	00803016
M 12 × 1,75	14,27	95	12,4	140	9	150	9	120	00803035

### THREAD REPAIR KIT

Nominal size	Tap		Insertion tool		Break tool		Art. No.
	Ø	Length	Ø	Length	Ø	Length	
M 14 × 1	15,3	102	11,2	170	10	103	00803017
M 14 × 1,25	15,62	102	10,8	170	10	103	00803018
M 14 × 1,5	15,95	102	10,8	170	10	103	00803019
M 14 × 2	16,6	102	10,5	170	10	103	00803020

### INSERTION TOOL

Nominal size	Ø	Length	Art. No.
M 2 × 0,4	1,1	104	00805001
M 2,5 × 0,45	1,4	104	00805002
M 3 × 0,5	1,8	104	00805003
M 4 × 0,7	2,5	104	00805004
M 5 × 0,8	3,2	104	00805005
M 6 × 1,0	4,4	104	00805006
M 7 × 1,0	5	1304	00805007
M 8 × 1	5,7	140	00805008
M 8 × 1,25	5,7	140	00805009
M 9 × 1,25	6,5	145	00805010
M 10 × 1	7,5	150	00805011
M 10 × 1,25	7,5	150	00805012
M 10 × 1,5	7,5	150	00805013
M 12 × 1	9	150	00805014
M 12 × 1,25	9	150	00805015
M 12 × 1,5	9	150	00805016
M 12 × 1,75	9	150	00805035
M 14 × 1	11,2	170	00805017
M 14 × 1,25	10,8	170	00805018
M 14 × 1,5	10,8	170	00805019
M 14 × 2	10,5	170	00805020

### TAP

Nominal size	Ø	Length	Art. No.
M 2 × 0,4	2,52	45	00802000
M 2,5 × 0,45	3,08	48	00802010
M 3 × 0,5	3,65	50	00802020
M 4 × 0,7	4,91	58	00802030
M 5 × 0,8	6,04	66	00802040
M 6 × 1,0	7,3	72	00802050
M 7 × 1,0	8,3	72	00802060
M 8 × 1	9,3	80	00802070
M 8 × 1,25	9,62	80	00802080
M 9 × 1,25	10,62	89	00802090
M 10 × 1	11,3	89	00802100
M 10 × 1,25	11,62	89	00802110
M 10 × 1,5	11,95	89	00802120
M 12 × 1	13,3	95	00802130
M 12 × 1,25	13,62	95	00802140
M 12 × 1,5	13,95	95	00802150
M 12 × 1,75	14,27	95	00802340
M 14 × 1	15,3	102	00802160
M 14 × 1,25	15,62	102	00802170
M 14 × 1,5	15,95	102	00802180
M 14 × 2	16,6	102	00802190

### BREAK TOOL

Nominal size	Ø	Length	Art. No.
M 2 × 0,4	1	100	00804001
M 2,5 × 0,45	1,5	100	00804002
M 3 × 0,5	2,1	100	00804003
M 4 × 0,7	2,8	100	00804004
M 5 × 0,8	3,6	100	00804005
M 6 × 1,0	4,5	105	00804006
M 7 × 1,0	5	110	00804007
M 8 × 1	5	110	00804008
M 8 × 1,25	6,2	110	00804009
M 9 × 1,25	6	110	00804010
M 10 × 1	7	115	00804011
M 10 × 1,25	7	115	00804012
M 10 × 1,5	7,85	115	00804013
M 12 × 1	9	120	00804014
M 12 × 1,25	9	120	00804015
M 12 × 1,5	9	120	00804016
M 12 × 1,75	9	120	00804035
M 14 × 1	10	103	00804017
M 14 × 1,25	10	103	00804018
M 14 × 1,5	10	103	00804019
M 14 × 2	10	103	00804020

### TWIST DRILL

Nominal size	Ø	Length	Art. No.
M 2 × 0,4	2,1	60	03445021
M 2,5 × 0,45	2,6	60	03445026
M 3 × 0,5	3,1	75	03445031
M 4 × 0,7	4,1	85	03445041
M 5 × 0,8	5,2	85	03445052
M 6 × 1,0	6,2	85	03445062
M 7 × 1,0	7,2	85	03445072
M 8 × 1	8,2	115	03445082
M 8 × 1,25	8,3	115	03445083
M 9 × 1,25	9,3	115	03445093
M 10 × 1	10,3	130	03445103
M 10 × 1,25	10,3	130	03445103
M 10 × 1,5	10,3	130	03445103
M 12 × 1	12,3	140	03445123
M 12 × 1,25	12,3	140	03445123
M 12 × 1,5	12,5	140	03445125
M 12 × 1,75	12,4	140	03445124

## TABLE SECTION THREAD REPAIR



### THREAD REPAIR KIT M5-M12

Nominal size	Tap		Twist drill		Insertion tool		Break tool		Art. No.
	Ø	Length	Ø	Length	Ø	Length	Ø	Length	
5 × 0,8	6,04	66	5,2	85	3,2	104	3,6	100	00803040
6 × 1,0	7,3	72	6,2	85	4,4	104	4,5	105	00803040
8 × 1,25	9,62	80	8,3	115	5,7	140	6,2	110	00803040
10 × 1,25	11,62	89	10,3	130	7,5	150	7	115	00803040
12 × 1,75	14,27	95	12,4	140	9	150	9	120	00803040

### THREAD REPAIR KIT M6-M14

Nominal size	Tap		Twist drill		Insertion tool		Break tool		Art. No.
	Ø	Length	Ø	Length	Ø	Length	Ø	Length	
6 × 1,0	7,3	72	6,2	85	4,4	104	4,5	105	00803041
8 × 1,25	9,62	80	8,3	115	5,7	140	6,2	110	00803041
10 × 1,5	11,95	89	10,3	130	7,5	150	7,85	115	00803041
12 × 1,5	13,95	95	12,5	140	9	150	9	120	00803041
14 × 1,25	15,62	102	14,3	90	10,8	170	10	103	00803041

### THREAD INSERTS

Nominal size	QTY	Art. No. 1,0 d	Art. No. 1,5 d	Art. No. 2,5 d
M 2 × 0,4	100	00806001	00806002	00806003
M 2,5 × 0,45	100	00806004	00806005	00806006
M 3 × 0,5	100	00806007	00806008	00806009
M 4 × 0,7	100	00806010	00806011	00806012
M 5 × 0,8	100	00806013	00806014	00806015
M 6 × 1,0	100	00806016	00806017	00806018
M 7 × 1,0	100	00806019	00806020	00806021
M 8 × 1	100	00806022	00806023	00806024
M 8 × 1,25	100	00806025	00806026	00806027
M 9 × 1,25	100	00806028	00806029	00806030
M 10 × 1	100	00806031	00806032	00806033
M 10 × 1,25	100	00806034	00806035	00806036
M 10 × 1,5	100	00806037	00806038	00806039
M 12 × 1	100	00806040	00806041	00806042
M 12 × 1,25	100	00806043	00806044	00806045
M 12 × 1,5	100	00806046	00806047	00806048
M 12 × 1,75	100	00806103	00806104	00806105
M 14 × 1	100	00806049	00806050	00806051
M 14 × 1,25	50	00806052	00806053	00806054
M 14 × 1,5	50	00806055	00806056	00806057
M 14 × 2	50	00806058	00806059	00806060

## APPLICATION THREAD REPAIR

In order to repair a thread, you will need the following special tools: a tap hole twist drill, screw tap, insertion tool and a break tool. Furthermore, you need a screwdriver, a fitting adjustable tap wrench and a hammer. Then you proceed as follows:



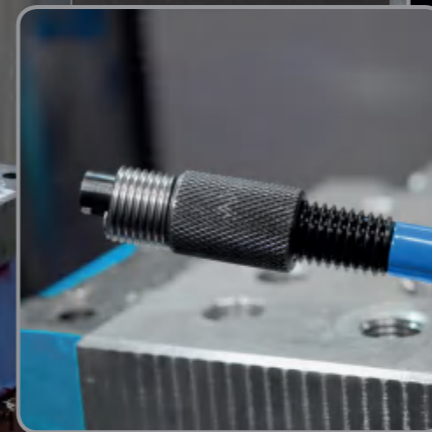
1. Drill out the damaged thread



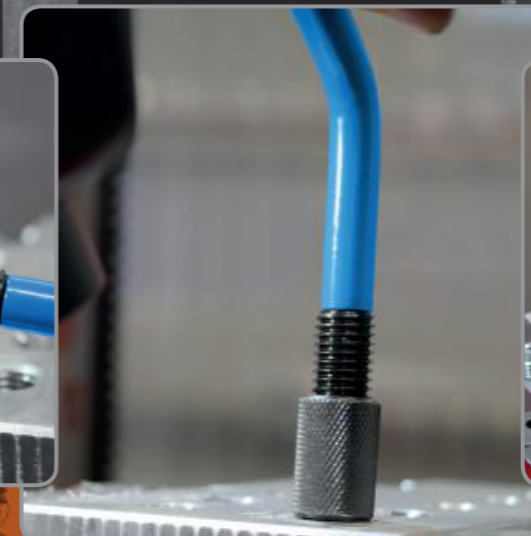
2. Countersink the bore's edges



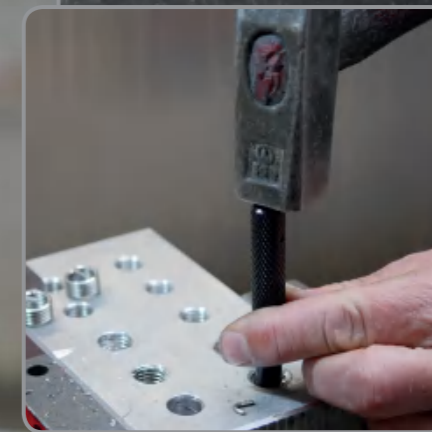
3. Cut a new thread with the tap



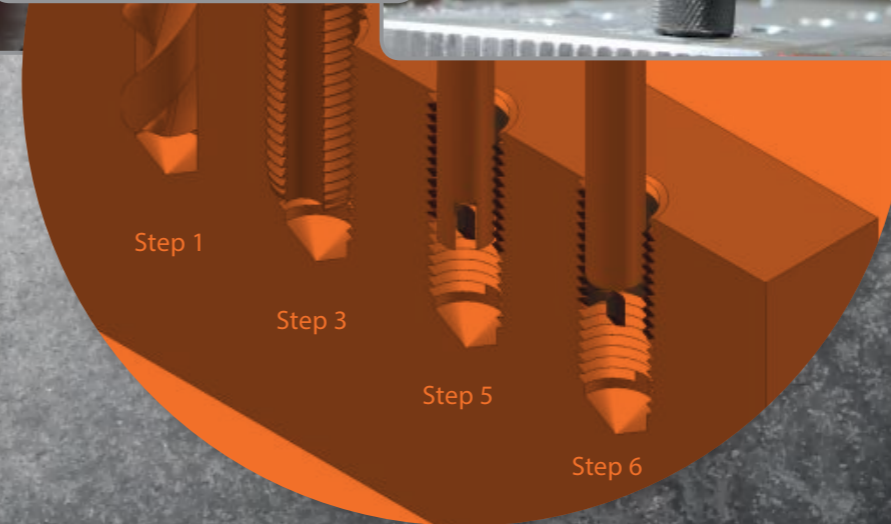
4. Put a thread insert onto the insertion tool



5. Screw in the insert



6. Break off the tappet with the break tool



AFTER TAPPING THE HOLE



FINISHED THREAD REPAIR

