

Product information: Wire thread inserts

Note: When inquiring about 5 digit part numbers beginning with 8, please preface the number with R264-. Example: 88111 should be R264-88111.

7. Dimensions/Measuring techniques during acceptance inspection

In the order text, the following dimensions are to be specified (example M10 x 15):

- the use/inside thread required after insertion – e.g. M10,
- the chosen nominal length according to DIN 8140-1, Table 1, l_1 – e.g. 15 (= 1.5 d).

In as-delivered condition, only the outside diameter and the number of windings are measurable during acceptance inspection (→ Table 2)
 – the nominal length l_1 is first determinable in inserted condition.

Table 2: Dimensions – outside Ø and winding count in as delivered condition

Characteristics		for coarse pitch threads with nominal size use/inside thread															
		M 2	M 2.5	M 3	M 4	M 5	M 6	M 7	M 8	M 10	M 12	M 14	M 16	M 18	M 20	M 22	M 24
Outside Ø	min.	2.6	3.3	3.8	5.15	6.35	7.6	8.65	9.85	12.1	14.4	16.8	19.0	21.5	23.7	26.3	28.6
	max.	2.8	3.5	4.0	5.35	6.6	7.85	8.9	10.1	12.5	14.8	17.2	19.4	22.0	24.2	26.8	29.1
Drill Ø	mm	2.1	2.6	3.2	4.2	5.2	6.3	7.3	8.4	10.5	12.5	14.5	16.5	18.75	20.75	22.75	24.75
Winding count AW* at nominal length d/mm	1d = mm	2	2.5	3	4	5	6	7	8	10	12	14	16	18	20	22	24
	PO	2.9	3.5	3.9	3.7	4.3	4.2	5.3	4.7	5.0	5.2	5.6	6.5	5.6	6.3	6.9	6.2
	1.5d = mm	3	3.75	4.5	6	7.5	9	10.5	12	15	18	21	24	27	30	33	36
	PO	4.9	5.9	6.3	6.1	6.9	6.9	8.2	7.4	8.1	8.4	8.8	10.1	9.0	10.0	10.9	10.0
	2d = mm	4	5	6	8	10	12	14	16	20	24	28	32	36	40	44	48
	PO	6.9	8.1	8.7	8.4	9.7	9.6	11.1	10.6	11.2	11.7	12.0	13.8	12.3	13.7	15.1	14.0
(*tol. -0.25)	2.5d = mm	5	6.25	7.5	10	12.5	15	17.5	20	25	30	35	40	45	-	-	-
	PO	8.9	10.5	11.1	10.9	12.3	12.3	14.3	13.5	14.2	14.7	15.2	17.5	15.5	-	-	-

Characteristics		for fine pitch threads with nominal size use/inside thread											
		M 8x1	M 10x1	M 10x1.25	M 12x1	M 12x1.25	M 14x1.5	M 14x1.25	M 16x1.5	M 20x1.5	M 20x2	M 24x1.5	M 24x2
Outside Ø	min.	9.85	12.1	12.1	14.4	14.4	16.8	16.8	19.0	23.7	23.7	28.6	28.6
	max.	10.1	12.5	12.5	14.8	14.8	17.2	17.2	19.4	24.2	24.2	29.1	29.1
Drill Ø	mm	8.3	10.25	10.4	12.3	12.4	14.5	14.4	16.5	20.5	20.5	24.5	24.5
Winding count AW* at nomi- nal length d/ mm	1d = mm	8	10	10	12	12	14	(8.4) ①	16	20	20	24	24
	PO	6.1	7.6	6.0	9.3	7.4	7.4	(5.2)	8.7	10.7	8.0	12.9	9.6
	1.5d = mm	12	15	15	18	18	21	(12.4) ①	24	30	30	36	36
	PO	9.5	12.1	9.7	14.5	11.6	11.6	(8.2)	13.4	16.7	12.5	19.8	15.0
	2d = mm	16	20	20	24	24	28	(14.4) ①	32	40	40	48	48
	PO	12.9	16.3	13.1	19.5	15.9	15.7	(9.4)	18.1	22.4	16.8	26.6	20.2
(*tol. -0.25)	2.5d = mm	20	25	-	-	-	35	(16.4) ①	40	① ignition plug threads with special d-dimensions			
	PO	16.5	20.7	-	-	-	19.9	(10.6)	22.9				

Table 3: Overview: Tools, accessories and R264 - article number

Tool / Accessory	Amecoil	
	Coarse pitch thread SR	Fine pitch thread
Thread insert article number	R 88330	R 88331
Drill for tapping hole Ø	R 88988, R 88989	
Roughing tap	R 88339 from M 18	-
Finish tap	R 88338	R 88338
Assembly tools		
• Multidim. hand fitting tool	-	R 88333 fine
• Mandrel and threaded nose	-	R 88334 fine
• Specific hand fitting tool	R 88333 SR	-
• Threaded mandrel	R 88334 SR	-
• Unidim. hand fitting tool	R 88335 SR from M 18	R 88335 fine from M 20
Tang breaker	R 88336	
Extractor	R 88337	
Assortment boxes with tools	R 88342, R 88344	

Fitting principle



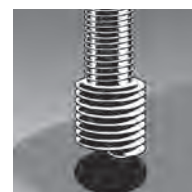
Drilling



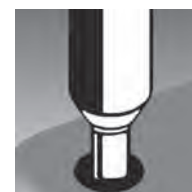
Tapping



with classic range
tool



with SR range
tools



Breaking the engaging
tang



Thread insert fitted