

tapsert®

SELF TAPPING INSERTS AVAILABLE IN
CASE HARDENED STEEL & STAINLESS STEEL



tapsert®

M6 x 1.0

**2 x SELF TAPPING CASE
HARDENED STEEL INSERTS**

Drill Size 9.4mm*

Insert Length 14mm

Includes bolt & nut for installation.
Complete instructions in pack.



**Professional
Thread Repair**



Tapserts are self cutting threaded inserts that feature both external and internal threads. They are driven into a pre-formed or pre-drilled retaining hole and the cutting slots (or cutting bores) effectively tap the hole as the insert is wound into the parent material.

Tapserts are ideal for use in low shear strength materials (such as alloys, plastics and castings) that require threaded seats with high load capacity and wear resistance.

Tapserts feature:

- High pull-out strength
- High loading capacity in low shear strength materials
- Wear free, vibration resistant screw joint
- Pre-cast or pre-drilled holes with standard tolerance
- No requirement for thread tapping tools
- Retains and captures chips from installation in chipping reservoirs.

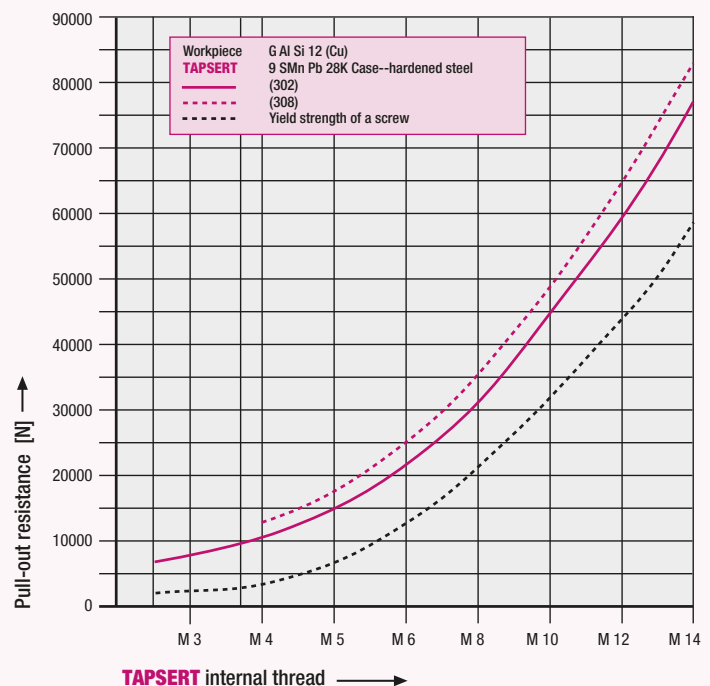
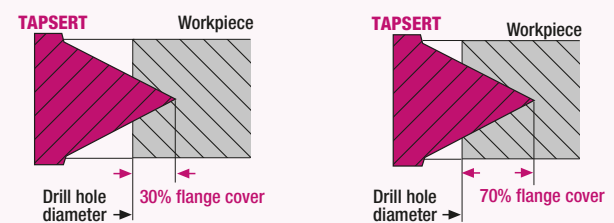
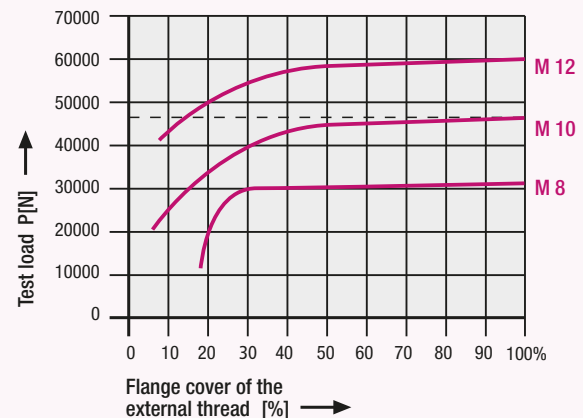
HOLE PREPARATION

The receiving hole is drilled or pre-cast in the parent material. Generally there is no requirement to countersink the hole but it is recommended care is taken not to warp the workpiece surface when installing the insert. Tapserts must be installed at least 0.1-0.2mm below the assembly surface.

- The length of the Tapsert MUST NOT exceed the thickness of the parent material.
- The minimum hole depth is indicated in the data tables included in every kit. Alternatively these may be downloaded from the website www.bordo.com.au
- The minimum wall thickness of the assembly is dependant on the maximum insert loads and the elasticity of the parent material.
- Detailed hole diameter information is shown on the installation leaflet included with every kit and is also available at www.bordo.com.au. As a general guide hard materials require a larger diameter hole than softer, elastic materials. If the installed insert is being subjected to high loads it is recommended to perform material specific testing prior to production.

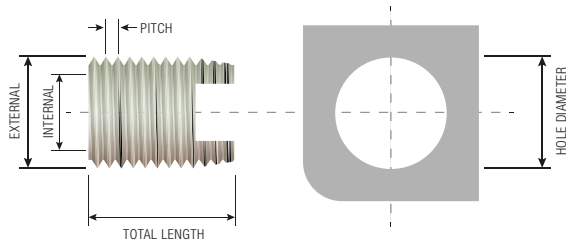
INSTALLATION NUT & BOLT

Screw the insert onto the bolt and nut assembly ensuring the slot side is pointing downward. Thread the nut down the bolt until it sits firmly against the top of the Tapsert. Ensure that the Tapsert is perpendicular to the workpiece and apply downward pressure on the installation assembly. Turn the bolt head to wind the Tapsert into the receiving hole. The tapsert is installed when the nut is flush with the top of the parent material. Loosen the nut and wind the assembly out of the Tapsert. Complete instructions are included in every Tapsert clam shell kit.



BULK INSERTS

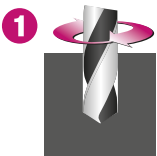
Tapsert self tapping inserts are available in yellow zinc passivated case hardened steel or 304 stainless steel.



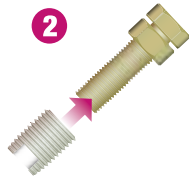
THREAD TYPE	INTERNAL ISO 6H	EXTERNAL	LENGTH MM	HARDENED STEEL YELLOW ZINC	STAINLESS STEEL 1.4105/A2/304
METRIC	M2.5-0.45	M4.5-0.5	6	3920-2.5X6	3920-2.5X6SS
	M3-0.5	M5-0.5	6	3920-3X6	3920-3X6SS
	M4-0.7	M6.5-0.75	8	3920-4X8	3920-4X8SS
	M5-0.8	M8-1	10	3920-5X10	3920-5X10SS
	M6-1	M10-1.5	14	3920-6X14	3920-6X14SS
	M8-1.25	M12-1.5	15	3920-8X15	3920-8X15SS
	M10-1.5	M14-1.5	18	3920-10X18	3920-10X18SS
	M12-1.75	M16-1.5	22	3920-12X22	3920-12X22SS
	M14-2	M18-1.5	24	3920-14X24	3920-14X24SS
	M16-2	M20-1.5	22	3920-16X22	3920-16X22SS
	M18-2.5	M22-1.5	24	3920-18X24	3920-18X24SS
	M20-2.5	M26-1.5	27	3920-20X26	3920-20X26SS
	M22-2.5	M26-1.5	30	3920-22X30	3920-22X30SS
	M24-3.0	M30-1.5	30	3920-24X30	3920-24X30SS
SPARK PLUG	M14-1.25	M17.7-1.25	9	3922-14X9	3922-14X9SS
	M14-1.25	M17.7-1.25	15	3922-14X15	3922-14X15SS
UNC	UNC4-40	M5-0.5	6	3932-4GX6	3932-4GX6SS
	UNC6-32	M6-0.75	8	3932-6GX8	3932-6GX8SS
	UNC8-32	M6.5-0.75	8	3932-8GX8	3932-8GX8SS
	UNC10-24	M8-1	10	3932-10GX10	3932-10GX10SS
	UNC1/4-20	M10-1.5	14	3932-1/4X14	3932-1/4X14SS
	UNC5/16-18	M12-1.5	15	3932-5/16X15	3932-5/16X15SS
	UNC3/8-16	M14-1.5	18	3932-3/8X18	3932-3/8X18SS
	UNC7/16-14	M16-1.5	22	3932-7/16X22	3932-7/16X22SS
	UNC1/2-13	M18-1.5	22	3932-1/2X22	3932-1/2X22SS
	UNC5/8-11	M20-1.5	22	3932-5/8X22	3932-5/8X22SS
UNF	UNF10-32	M8-1	10	3934-10GX10	3934-10GX10SS
	UNF1/4-28	M10-1.5	14	3934-1/4X14	3934-1/4X14SS
	UNF5/16-24	M12-1.5	15	3934-5/16X15	3934-5/16X15SS
	UNF3/8-24	M14-1.5	18	3934-3/8X18	3934-3/8X18SS
	UNF7/16-20	M16-1.5	22	3934-7/16X22	3934-7/16X22SS
	UNF1/2-20	M18-1.5	22	3934-1/2X22	3934-1/2X22SS
	UNF5/8-18	M20-1.5	22	3934-5/8X22	3934-5/8X22SS

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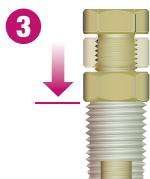
INSTALLATION



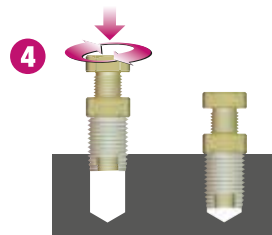
Drill hole to recommended size as shown in the selection table.



Thread the Tapsert on to the bolt ensuring the slot side is down. The insert should be flush with the end of the bolt.



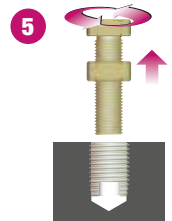
Thread the nut down the bolt until it sits firmly against the top of the Tapsert.



To ensure the Tapsert installation is straight apply downward pressure on the assembly.

If using an open ended wrench apply downward pressure to the bolt head whilst turning the nut to wind the Tapsert in. Alternatively if using a socket for installation apply downward pressure to the socket.

The Tapsert is installed when the nut is flush with the top of the parent material.



Loosen the nut with an open ended wrench and wind the nut and bolt assembly out of the Tapsert.

Congratulations – you have successfully created a new thread.



NOTE Tapping fluid should be used to aid installation.

KITS CLAM SHELL

Tapsert clam shell kits are designed for low volume thread repair or creation. Each packet includes two case hardened steel inserts and a nut and bolt for installation. Each packet includes comprehensive installation instructions and hole diameter and depth tables.



THREAD TYPE	INTERNAL THREAD ISO 6H	EXTERNAL THREAD	LENGTH MM	INSERT QTY	CLAM SHELL KIT HARDENED STEEL
METRIC COARSE	M2.5-0.45	M4.5-0.5	6	2	3920-2.5X6P
	M3-0.5	M5-0.5	6	2	3920-3X6P
	M4-0.7	M6.5-0.75	8	2	3920-4X8P
	M5-0.8	M8-1	10	2	3920-5X10P
	M6-1	M10-1.5	14	2	3920-6X14P
	M8-1.25	M12-1.5	15	2	3920-8X15P
	M10-1.5	M14-1.5	18	2	3920-10X18P
	M12-1.75	M16-1.5	22	2	3920-12X22P
	M14-2	M18-1.5	24	2	3920-14X24P
	M16-1.5	M20-1.5	22	2	3921-16X22P
	M16-2	M20-1.5	22	2	3920-16X22P
SPARK PLUG	M14-1.25	M17.7-1.25	9	2	3922-14X9P
	M14-1.25	M17.7-1.25	15	2	3922-14X15P
	M14-1.25	M17.7-1.25	9 & 15	1 EACH	3922-14CP
UNC	UNC4-40	M5-0.5	6	2	3932-4GX6P
	UNC6-32	M6-0.75	8	2	3932-6GX8P
	UNC8-32	M6.5-0.75	8	2	3932-8GX8P
	UNC10-24	M8-1	10	2	3932-10GX10P
	UNC1/4-20	M10-1.5	14	2	3932-1/4X14P
	UNC5/16-18	M12-1.5	15	2	3932-5/16X15P
	UNC3/8-16	M14-1.5	18	2	3932-3/8X18P
	UNC7/16-14	M16-1.5	22	2	3932-7/16X22P
	UNC1/2-13	M18-1.5	22	2	3932-1/2X22P
	UNC5/8-11	M20-1.5	22	2	3932-5/8X22P
UNF	UNF10-32	M8-1	10	2	3934-10GX10P
	UNF1/4-28	M10-1.5	14	2	3934-1/4X14P
	UNF5/16-24	M12-1.5	15	2	3934-5/16X15P
	UNF3/8-24	M14-1.5	18	2	3934-3/8X18P
	UNF7/16-20	M16-1.5	22	2	3934-7/16X22P
	UNF1/2-20	M18-1.5	22	2	3934-1/2X22P
	UNF5/8-18	M20-1.5	22	2	3934-5/8X22P



KITS MERCHANDISER

Tapsert clam shell kits can be supplied with a custom point-of-sale merchandising rack that is compatible with standard peg board and slat wall retail display systems.



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