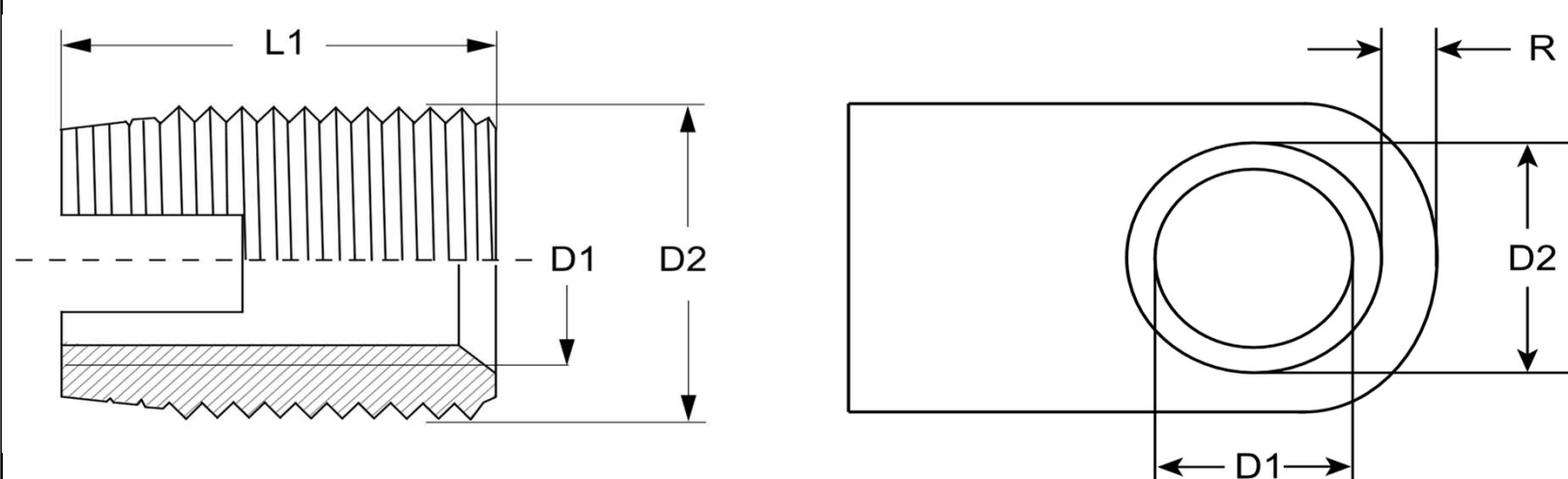


# Prüfungszeichnung quality test drawing

## BaerFix®

|                                                       |                                                                                   |
|-------------------------------------------------------|-----------------------------------------------------------------------------------|
| <b>Artikelnr.:</b><br><i>Item no.</i>                 | FE18                                                                              |
| <b>Bezeichnung:</b><br><i>Description:</i>            | BaerFix® selbstschneidender Gewindeeinsatz<br>BaerFix® Self-cutting Thread Insert |
| <b>Typ:</b><br><i>Type:</i>                           | Schneidschlitze<br>Cutting slots                                                  |
| <b>Innengewinde D1:</b><br><i>Internal thread D1:</i> | M 18 x 2,5                                                                        |
| <b>Außengewinde D2:</b><br><i>External thread D2:</i> | M 22 x 1,5                                                                        |
| <b>Länge L1:</b><br><i>Length L1:</i>                 | 24 mm                                                                             |
| <b>Richtung:</b><br><i>Direction:</i>                 | Rechts                                                                            |
| <b>Material:</b><br><i>Material:</i>                  | Einsatzgehärteter Stahl, verzinkt                                                 |



|                                                                                           |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |
|-------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Vorbohrdurchmesser:</b><br><i>Pre-drilling diameter:</i>                               | Leichtmetall-Legierungen / Light metal alloys (unter 250 N/mm²): 20,8 mm<br>Leichtmetall-Legierungen / Light metal alloys (250 - 300 N/mm²): 21,0 mm<br>Leichtmetall-Legierungen / Light metal alloys (300 - 350 N/mm²): 21,2 mm<br>Leichtmetall-Legierungen / Light metal alloys (>350 N/mm²): 21,4 mm<br>Messing, NE-Metalle, Bronze / Brass, non-ferrous metals, bronze (>350 N/mm²): 21,2 - 21,4 mm<br>Gusseisen / Cast iron (<150 HB): 20,8 mm<br>Gusseisen / Cast iron (150 - 200 HB): 21,0 - 21,2 mm |
| <b>Mindestwandstärke:</b><br><i>Minimum wall thickness:</i>                               | R (min) (Leichtmetall / Light metal): 4,40 mm<br>R (min) (Gusseisen / Cast iron): 6,60 mm<br>R (min) (Kunststoff / Plastic): 5,50 mm                                                                                                                                                                                                                                                                                                                                                                        |
| <b>Minimale Bohrtiefe:</b><br><i>Minimum drilling depth:</i>                              | Durchgangsloch / through hole: 24,00 mm<br>Sackloch / blind hole: 29,00 mm                                                                                                                                                                                                                                                                                                                                                                                                                                  |
| <b>Toleranz:</b><br><i>Tolerance:</i>                                                     | Produziert nach / produced acc. to: ISO 2768-m<br>Innengewinde / Internal thread: ISO2/6H<br>Außengewinde / External thread: Medium Tol.                                                                                                                                                                                                                                                                                                                                                                    |
| <b>Drehzahlrichtwert für Leichtmetalle:</b><br><i>Speed guide value for light metals:</i> | 120-200 U/min                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |
| <b>Maximales Eindrehmoment:</b><br><i>Maximum installation torque:</i>                    | 220 Nm                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |