



KOBSERT®

Thread inserts for metals

BÖLLHOFF

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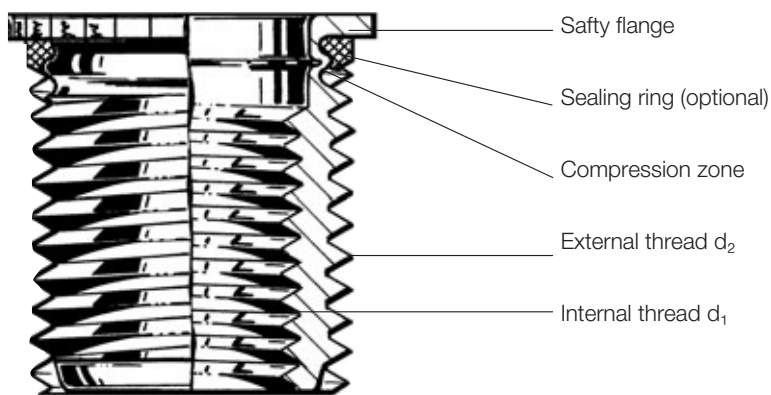
The principle

When installing the threaded inserts, the safety flange is pressed into the surface of the parent material. (This reduces the pipe-shaped neck area under the safety flange and covers as far as the mounting thread).

After installation into the part, the threaded inserts are reliably protected against unscrewing, even when the part is exposed to dynamic screwload or extreme temperatures. Due to the installation process where the KOBSE[®] body is pulled into the same direction like the screwload, the clearance of the external thread is compensated. The external thread is pre-setted properly.

If, in exceptional cases, it is necessary to remove the threaded insert, follow the instructions on page 10.

KOBSE[®] Thread insert



The benefits

KOBSE[®] thread inserts achieve a heavy-duty connection capability in low-strength metal materials for instance in aluminium and magnesium alloys.

- Creation of high-strength, wear-resistant, vibration-resistant and torsion-proof nut threads.
- Tight fit: The KOBSE[®] is mechanically anchored without additional securing pins or washers and without chemical adhesion or sealing materials.
- Thread repair: KOBSE[®] thread inserts also serve to repair damaged threads.
- Sealing function: The KOBSE[®] thread insert with sealing ring is designed for gas- and liquid-tight joints.

Design

Metric ISO thread DIN 13, tolerance range for industry standard screws and nuts tolerance 6g/6H.

Surface

- DIN 267 Part 2 Product Class A.

Material

- Steel, galvanic Zink plated, colourless chromated (for Order no. see page 5 – 9).
- Stainless steel, coatless (5th digit of the order no. changes from 0 to 6).

Sealing Ring

- NBR, e.g. PERBUNAN[®] (eWZ Bayer AG) 70 Shore A, temperature resistance -30°C to +120 °C.
- FKM, e.g. VITON[®], eWZ E.I. Dupont de Nemours & Co. INC., temperature resistance -20°C to +200°C (put 1 as the 5th digit of the order no.).

Other specifications available on request. Please do not hesitate to contact us.

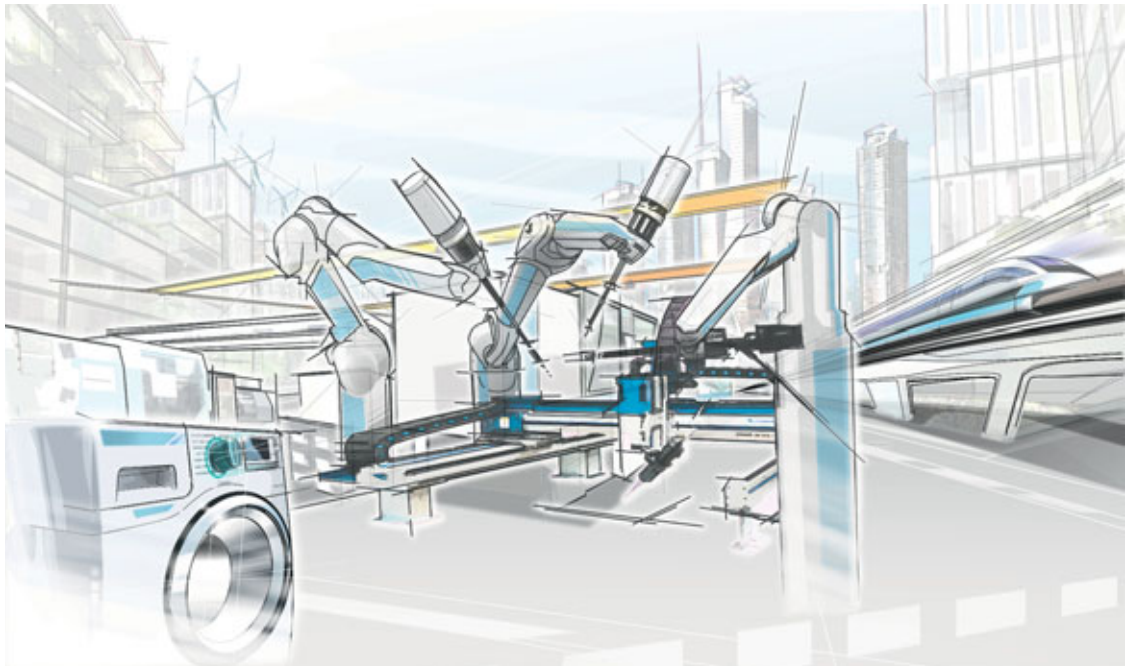
Automotive

- Engine attachments
- Gear box connection
- Towing lugs



General industry

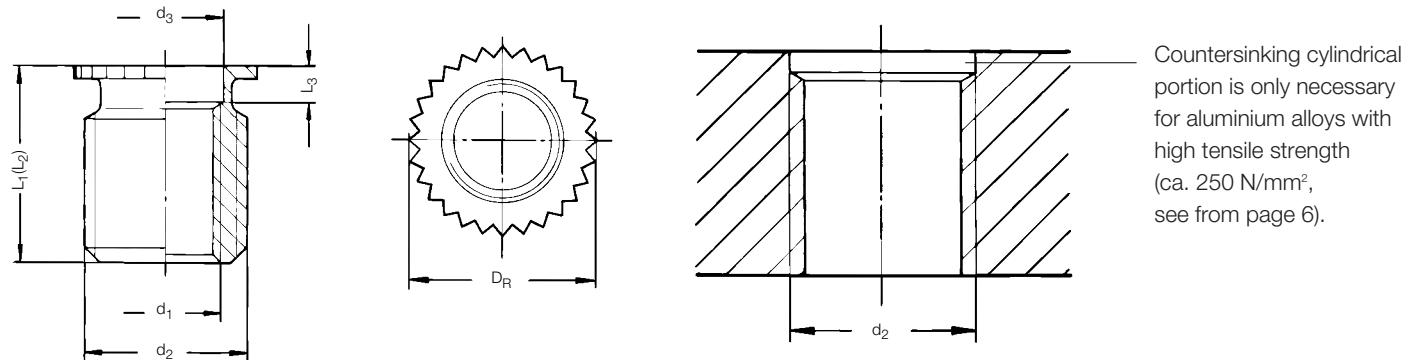
- Refrigeration and air conditioning technology
- Electrical engineering/ electronics, e.g. switchboards, connectors
- Agricultural technology
- Garden technology



KOBSERT® Threaded inserts

Type 1030

- Safety flange
- Open version/through hole



Material: Steel, galvanic zink plated, colourless chromated

Installation tools see pages 12 – 15

d ₁	Order no.	d ₂	d ₃	L ₁ *	L ₂ *	L ₃ *	D _R	Knurl DIN 82
M 4***	1030 004 0008	M 7	4.35	8	8.6	3.3	7.6	1.2
M 5	1030 005 0010	M 8	5.35	10	10.8	3.5	8.8	1.2
M 6	1030 006 0010	M 10	6.8	10	11	2.7	11	1.2
M 6	1030 006 0012	M 10	6.8	12	13	2.7	11	1.2
M 8	1030 008 0015	M 12x1.5**	8.5	15	16	3.3	13	1.6
M 10	1030 010 0018	M 14x1.5	10.5	18	19	3.3	15	1.6
M 12 x 1.5	1030 012 4021	M 16x1.5	12.5	21	22	3.5	17	1.6
M 12	1030 012 0021	M 16x1.5	12.5	21	22	3.5	17	1.6
M 14 x 1.5	1030 014 4024	M 20x1.5	15.5	24	25	3.6	21	1.6
M 14	1030 014 0024	M 20x1.5	15.5	24	25	3.6	21	1.6
M 16 x 1.5	1030 016 4026	M 22x1.5	17.5	26	27	3.6	23	1.6
M 16	1030 016 0026	M 22x1.5	17.5	26	27	3.6	23	1.6

Material: Stainless steel A1

Installation tools see pages 12 – 15

d ₁	Order no.	d ₂	d ₃	L ₁ *	L ₂ *	L ₃ *	D _R	Knurl DIN 82
M 4	1030 604 0008	M 7	4.35	8	8.6	3.3	7.6	1.2
M 5	1030 605 0010	M 8	5.35	10	10.8	3.5	8.8	1.2
M 6	1030 606 0012	M 10	6.8	12	12.8	3.5	10.8	1.2
M 8	1030 608 0015	M 12x1.5	8.5	15	16	4.5	12.9	1.6
M 10	1030 610 0018	M 14x1.5	10.7	18	19	4.6	15	1.6
M 12	1030 612 0021	M 16x1.5	12.5	21	22	4.5	17	1.6
M 12 x 1.5	1030 612 4021	M 16x1.5	12.5	21	22	4.5	17	1.6
M 14	1030 614 0024	M 20x1.5	15.5	24	25	4.8	21	1.6
M 16	1030 616 0026	M 22x1.5	17.5	26	27	4.8	23	1.6

* L₁, L₃ = Length when assembled. * L₂ = Length in delivery conditions. Other lengths available on request.

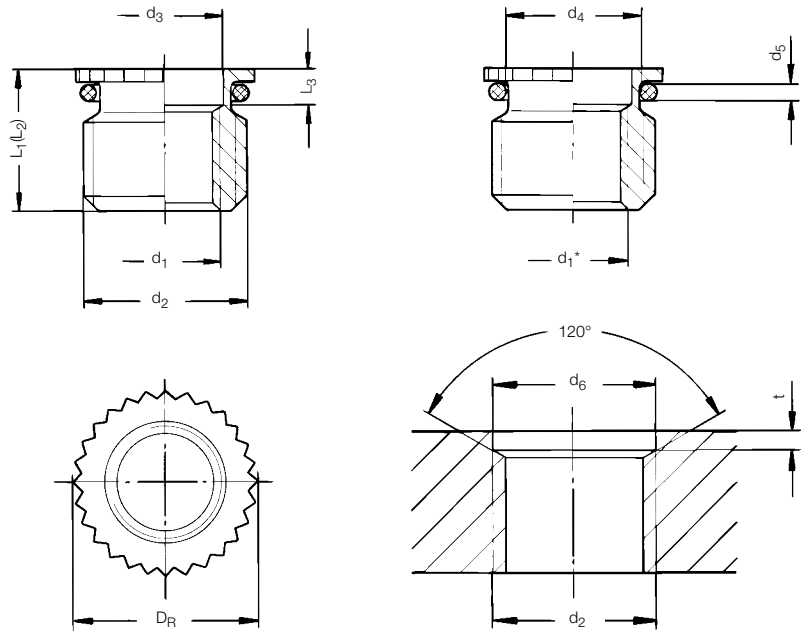
** also available with pitch 1.25

*** on request

Different materials on request. Further technical details on page 3. Subject to technical alterations.

Type 1031

- Safety flange
- Open version/through hole
- With sealing ring: NBR, e.g. PERBUNAN®



Sealing ring:
 NBR, e.g. PERBUNAN® as standard, 70 Sh A
 Temperature resistance: -30 °C to +120 °C
 Colour coding: black

Option: FKM, e.g. VITON® 75 Sh A
 Temperature resistance: max. -20 °C to +200 °C
 Colour coding: green
 If the temperature requirements differ,
 please contact us.

Material: Steel, galvanic zinc plated, colourless chromated

Installation tools see pages 12 – 15

d ₁	Order no.	d ₂	d ₃	L ₁ [*]	L ₂ [*]	L ₃ [*]	D _R	Knurl DIN 82	Sealing ring d ₄ x d ₅	Countersink			
										d ₆	Tol.	t	+ Tol.
M 10 x 1 ^⓪	1031 010 3010	M 14 x 1.5	10.5	10	11	3.2	15	1.6	10 x 1.5	14	± 0.10	2.5	0.3
M 12 x 1.5	1031 012 4012	M 16 x 1.5	12.5	12	13	3.5	17	1.6	12 x 1.5	16	± 0.10	2.5	0.3
M 14 x 1.5	1031 014 4012	M 20 x 1.5	15.5	12	13	3.6	21	1.6	14 x 2.0	20	+0.15/-0.10	3.0	0.3
M 16 x 1.5	1031 016 4012	M 22 x 1.5	17.5	12	13	3.6	23	1.6	16 x 2.0	22	+0.15/-0.10	3.0	0.3
M 18 x 1.5	1031 018 4012	M 24 x 1.5	19.5	12	13	3.6	25	1.6	18 x 2.0	24	+0.15/-0.10	3.0	0.3
M 20 x 1.5	1031 020 4014	M 26 x 1.5	21.5	14	15	3.6	27	1.6	20 x 2.0	26	+0.15/-0.10	3.0	0.3
M 22 x 1.5	1031 022 4014	M 28 x 1.5	23.5	14	15	3.6	29	1.6	22 x 2.0	28	+0.15/-0.10	3.0	0.3
M 24 x 1.5	1031 024 4014	M 30 x 1.5	25.5	14	15	3.6	31	1.6	24 x 2.0	30	+0.15/-0.10	3.0	0.3
M 26 x 1.5	1031 026 4016	M 32 x 1.5	27.5	16	17	3.6	33	1.6	26 x 2.0	32	+0.15/-0.10	3.0	0.3

d₆ = Guideline which depends on the material of the moulded part. If necessary, please change after installation attempt.

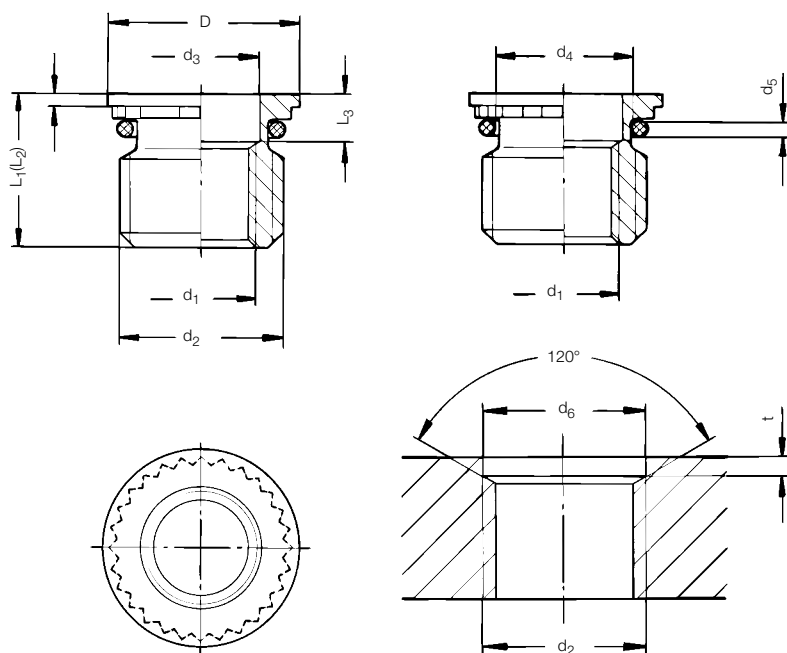
* L₁, L₃ = Length when assembled. * L₂ = Length in delivery conditions. Other lengths available on request.

⓪ Type 1031 is preferable for short screw lengths DIN 908 and 910.

Different materials on request. Further technical details on page 3. Subject to technical alterations.

Type 1032

- Safety flange with sealing flange
- Open version/through hole
- With sealing ring: NBR, e.g. PERBUNAN®



Sealing ring:
 NBR, e.g. PERBUNAN® as standard, 70 Sh A
 Temperature resistance: -30 °C to +120 °C
 Colour coding: black

Option: FKM, e.g. VITON® 75 Sh A
 Temperature resistance: max. -20 °C to +200 °C
 Colour coding: green
 If the temperature requirements differ,
 please contact us.

Material: Steel, galvanic zink plated, colourless chromated

Installation tools see pages 12 – 15

d ₁	Order no.	d ₂	d ₃	D	L ₁ *	L ₂ *	L ₃ *	L ₅	D _R	Knurl DIN 82	Sealing ring d ₄ x d ₅	Countersink			
												d ₆	Tol.	t	+ Tol.
M 10 x 1	1032 010 3011	M 14 x 1.5	10.5	16	11.0	12.0	4.0	0.8	15	1.6	10 x 1.5	14	± 0.10	2.5	0.3
M 12 x 1.5	1032 012 4145	M 16 x 1.5	12.5	18	14.5	15.5	4.4	0.8	17	1.6	12 x 1.5	16	± 0.10	2.5	0.3
M 14 x 1.5	1032 014 4145	M 20 x 1.5	15.5	22	14.5	15.5	4.5	1.0	21	1.6	14 x 2.0	20	+0.15/-0.10	3.0	0.3
M 16 x 1.5	1032 016 4145	M 22 x 1.5	17.5	24	14.5	15.5	4.5	1.0	23	1.6	16 x 2.0	22	+0.15/-0.10	3.0	0.3
M 18 x 1.5	1032 018 4145	M 24 x 1.5	19.5	26	14.5	15.5	4.7	1.2	25	1.6	18 x 2.0	24	+0.15/-0.10	3.0	0.3
M 20 x 1.5	1032 020 4155	M 26 x 1.5	21.5	28	15.5	16.5	4.7	1.2	27	1.6	20 x 2.0	26	+0.15/-0.10	3.0	0.3
M 22 x 1.5	1032 022 4155	M 28 x 1.5	23.5	30	15.5	16.5	4.7	1.2	29	1.6	22 x 2.0	28	+0.15/-0.10	3.0	0.3
M 24 x 1.5	1032 024 4155	M 30 x 1.5	25.5	32	15.5	16.5	4.7	1.2	31	1.6	24 x 2.0	30	+0.15/-0.10	3.0	0.3
M 26 x 1.5	1032 026 4175	M 32 x 1.5	27.5	34	17.5	18.5	4.7	1.2	33	1.6	26 x 2.0	32	+0.15/-0.10	3.0	0.3
M 30 x 1.5	1032 030 4175	M 36 x 1.5	31.5	38	17.5	18.5	4.7	1.2	37	1.6	30 x 2.0	36	+0.15/-0.10	3.0	0.3

Material: Stainless steel A1

Installation tools see pages 12 – 15

d ₁	Order no.	d ₂	d ₃	D	L ₁ *	L ₂ *	L ₃ *	L ₅	D _R	Knurl DIN 82	Sealing ring d ₄ x d ₅	Countersink			
												d ₆	Tol.	t	+ Tol.
M 12 x 1.5	1032 612 4145	M 16 x 1.5	12,5	18	14,5	15,5	4,8	0,8	18	1,6	12 x 1,5	16	± 0,10	2,5	0,3
M 14 x 1,5	1032 614 4145	M 20 x 1,5	15,5	22	14,5	15,5	5,5	0,8	22	1,6	14 x 2,0	20	+0,15/-0,10	3	0,3

d₆= Guideline which depends on the material of the moulded part. If necessary, please change after installation attempt.

* L₁, L₃ = Length when assembled. * L₂ = Length in delivery conditions. Other lengths available on request.

Different materials on request. Further technical details on page 3. Subject to technical alterations.

KOBSERT® Threaded inserts

Type 1033

- Safety flange
- Closed version / blind hole
- With sealing ring: NBR, e.g. PERBUNAN®

Sealing ring:

NBR, e.g. PERBUNAN® as standard, 70 Sh A

Temperature resistance: -30 °C to +120 °C

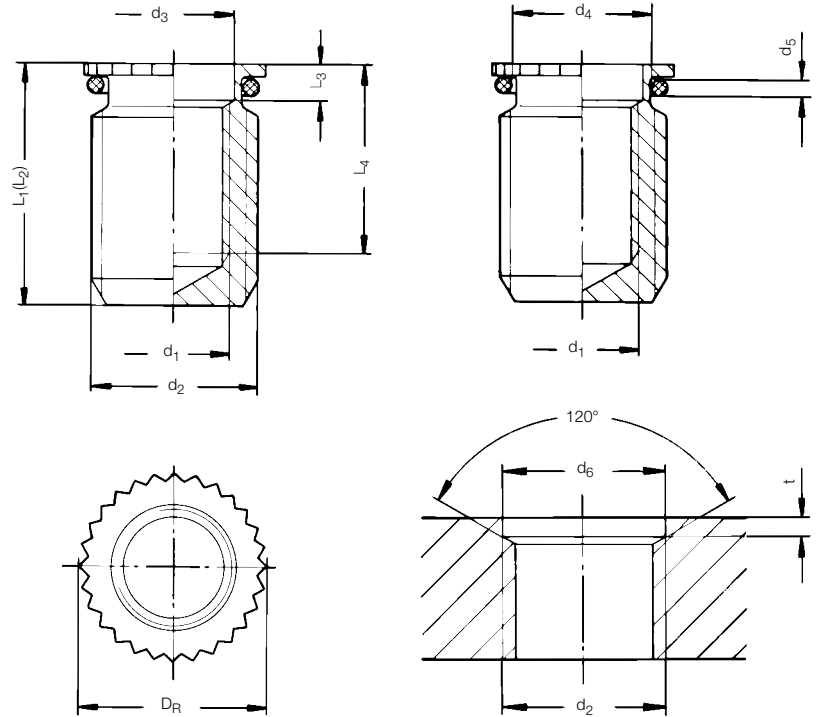
Colour coding: black

Option: FKM, e.g. VITON® 75 Sh A

Temperature resistance: max. -20 °C to +200 °C

Colour coding: green

If the temperature requirements differ,
please contact us.



Material: Steel, galvanic zink plated, colourless chromated

Installation tools see pages 12 – 15

d ₁ *	Order no.	d ₂	d ₃	L ₁ **	L ₂ **	L ₃ **	L ₄ **	D _R	Knurl DIN 82	Sealing ring d ₄ x d ₅	d ₆	Countersink Tol.	t	+ Tol.
M 5	1033 005 0012	M 8	5.4	12	13	2.7	8.0	9	1.2	5 x 1.0	8	± 0.10	2.0	0.3
M 6	1033 006 0015	M 10	6.8	15	16	2.7	10.5	11	1.2	6 x 1.5	10	± 0.10	2.5	0.3
M 8	1033 008 0018	M 12 x 1.5	8.5	18	19	3.3	12.0	13	1.6	8 x 1.5	12	± 0.10	2.5	0.3
M 10	1033 010 0021	M 14 x 1.5	10.5	21	22	3.3	13.9	15	1.6	10 x 1.5	14	± 0.10	2.5	0.3
M 12	1033 012 0024	M 16 x 1.5	12.5	24	25	3.5	15.9	17	1.6	12 x 1.5	16	± 0.10	2.5	0.3
M 14	1033 014 0026	M 20 x 1.5	15.5	26	27	3.6	16.9	21	1.6	14 x 2.0	20	+0.15/-0.10	3.0	0.3
M 16	1033 016 0031	M 22 x 1.5	17.5	31	32	3.6	20.9	23	1.6	16 x 2.0	22	+0.15/-0.10	3.0	0.3

Material: Stainless steel A1

Installation tools see pages 12 – 15

d ₁ *	Order no.	d ₂	d ₃	L ₁ **	L ₂ **	L ₃ **	L ₄ **	D _R	Knurl DIN 82	Sealing ring d ₄ x d ₅	d ₆	Countersink Tol.	t	+ Tol.
M 4	1033 6040 012	M 7	4.35	12	13	3.3	8.2	7.6	1.2	4 x 1.0	7	± 0.10	1.8	0.3
M 5	1033 6050 012	M 8	5.35	12	13	3.5	8	8.8	1.2	5 x 1.0	8	± 0.10	2	0.3
M 6	1033 6060 015	M 10	6.8	15	16	3.5	10.5	10.8	1.2	6 x 1.5	10	± 0.10	2.5	0.3
M 8	1033 6080 018	M 12 x 1.5	8.5	18	19	4.5	12	12.9	1.6	8 x 1.5	12	± 0.10	2.5	0.3
M 10	1033 6100 021	M 14 x 1.5	10.7	21	22	4.6	13.9	15	1.6	10 x 1.5	14	± 0.10	2.5	0.3

d₆ = Guideline which depends on the material of the moulded part. If necessary, please change after installation attempt.

* Available with fine thread.

** L₁, L₃, L₄ = Length when assembled. ** L₂ = Length in delivery conditions. Other lengths available on request.

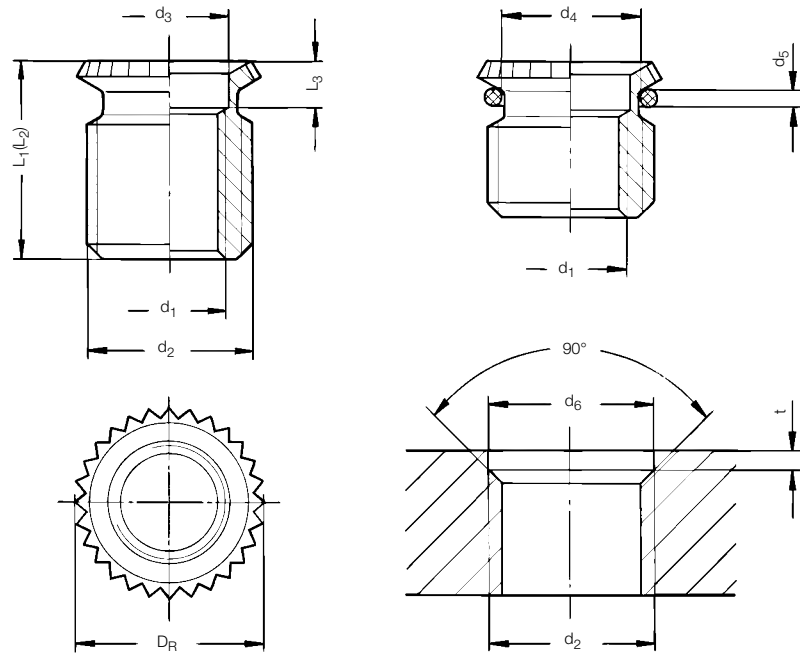
Different materials on request. Further technical details on page 3. Subject to technical alterations.

Typ 1040 / Typ 1041 with sealing ring*

- HP – heavy version
- Safety flange
- Open version/through hole
- Without or with sealing ring: NBR, e.g. PERBUNAN®

Sealing ring:
 NBR, e.g. PERBUNAN® as standard, 70 Sh A
 Temperature resistance: -30 °C to +120 °C
 Colour coding: black

Option: FKM, e.g. VITON® 75 Sh A
 Temperature resistance: -20 °C to +200 °C
 Colour coding: green
 If the temperature requirements differ,
 please contact us.



Material: Steel, galvanic zink plated, colourless chromated

Installation tools see pages 12 – 15

d ₁ *	Order no.	d ₂	d ₃	L ₁ **	L ₂ **	L ₃ **	D _R	Knurl DIN 82	Sealing ring d ₄ x d ₅	Countersink			
										d ₆	Tol.	t	+ Tol.
M 5	1040 005 0010	M 10	5.5	10	11.0	1.5	11	1.2	7 x 1.5	10	± 0.1	2.5	0.3
M 6	1040 006 0012	M 12 x 1.5	6.5	12	13.5	1.6	13	1.2	8 x 2.0	12	± 0.1	3.0	0.3
M 8	1040 008 0015	M 14 x 1.5	8.5	15	16.5	1.8	15	1.6	10 x 2.0	14	± 0.1	3.5	0.3
M 10	1040 010 0018	M 16 x 1.5	10.5	18	20.0	2.0	17	1.6	12 x 2.0	16	± 0.1	4.0	0.3
M 12	1040 012 0021	M 20 x 1.5	13.0	21	23.0	2.5	21	1.6	15 x 2.5	20	+ 0.15/- 0.10	4.5	0.4
M 14	1040 014 0024	M 22 x 1.5	15.0	24	26.0	2.5	23	1.6	17 x 2.5	22	+ 0.15/- 0.10	4.5	0.4
M 16	1040 016 0026	M 24 x 2.0	17.0	26	28.0	3.0	25	1.6	19 x 2.5	24	+ 0.18/- 0.10	4.5	0.4

Material: Stainless steel A1

Installation tools see pages 12 – 15

d ₁ *	Order no.	d ₂	d ₃	L ₁ **	L ₂ **	L ₃ **	D _R	Knurl DIN 82	Sealing ring d ₄ x d ₅	Countersink			
										d ₆	Tol.	t	+ Tol.
M 6***	1040 6060 012	M 12 x 1.5	6.5	12	13.5	4	13	1.2	8 x 2	12	± 0.1	3	0.3
M 8***	1040 6080 015	M 14 x 1.5	8.5	15	16.5	4.2	15	1.6	10 x 2	14	± 0.1	3.5	0.3
M 10	1040 6100 018	M 16 x 1.5	10.5	18	20	4.2	17	1.6	12 x 2	16	± 0.1	4	0.3
M 12	1040 6120 021	M 20 x 1.5	13	21	23	5	21.2	1.6	15 x 2.5	20	+ 0.15/- 0.10	4.5	0.3
M 14***	1040 6140 024	M 22 x 1.5	15	24	26	5	23	1.6	17 x 2.5	22	+ 0.15/- 0.10	4.5	0.3
M 16	1040 6160 026	M 24 x 2	17	26	28	5.5	25.2	1.6	19 x 2.5	24	+ 0.15/- 0.10	4.5	0.3
M 16 x 1	1040 6163 026	M 24 x 2	17	26	28	5.5	25.2	1.6	19 x 2.5	24	+ 0.18/- 0.10	4.5	0.3

d₆= Guideline which depends on the material of the moulded part. If necessary, please change after installation attempt.

* Other diameters and threads on request. When ordering type 1041 (with sealing ring) the 4th digit of the order no. changes from 0 to 1.

** L₁, L₃ = Length when assembled. ** L₂ = Length in delivery conditions. Other lengths available on request. *** on request

Different materials on request. Further technical details on page 3. Subject to technical alterations.

Mounting thread

Metric ISO threads according to DIN 13, tolerance 6 H.

The mounting thread should be checked with a thread gauge tolerance 6 H.

Thread hole

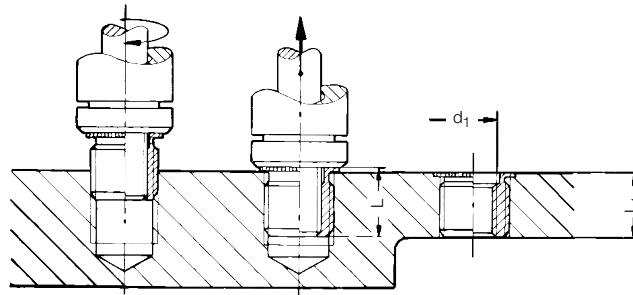
The minor diameter of the thread hole has to be drilled according to DIN 13 tolerance 6 H.

In general, the tapped hole should not be countersunk. Chamfering is permissible, within the diameter, but should not be greater than the specified diameter of the mounting thread.

If the KOBSERT® or the KOBSERT® HP is used with a sealing ring, a cylindrical portion in accordance with pages 3 to 7 should be created.

Installation

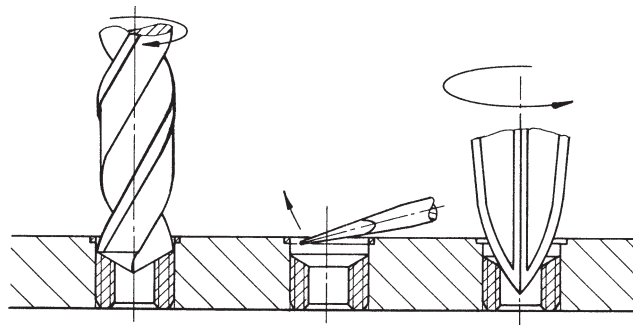
Manual and motor-driven tools are available for installing the KOBSERT®. The KOBSERT® insert is screwed into the part until the safety flange is in contact to the surface of the part. The installation procedure – pressing the safety flange into the part – is carried out by a relative axial movement between the spindle, which has been screwed in, and the frontend assembly of the installation tool. After the setting process the spindle has to be turned out of the KOBSERT®.



Disassembly

If KOBSERT® threaded inserts must be removed from a part, it must be done as follows (see sketch):

- Drilling into the safety flange until reaching the external thread (Drill \varnothing = external thread \varnothing d_2).
- Lever out the safety flange using a scraper or a screwdriver.
- Insert a tool for unscrewing – if necessary a suitable scraper – into the internal thread, so it is possible to turn it. Unscrew the socket anticlockwise.



New installation

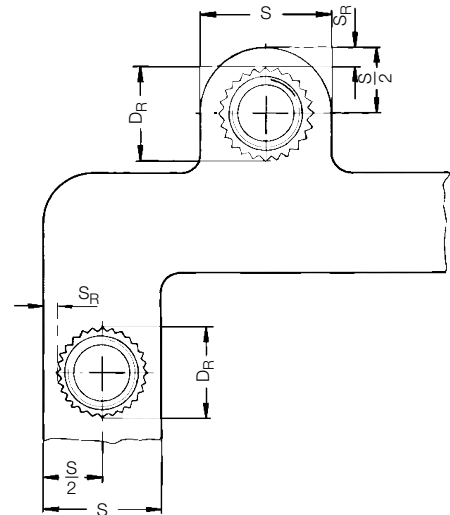
Screw in a threaded insert of the same specified size, until the safety flange is level with the previous impression – if necessary, unscrew it a little – and as usual, set it on one level with the surface using an KOBSERT® installation tool.

Wall thickness specifications for aluminium materials (casted and forging alloys)

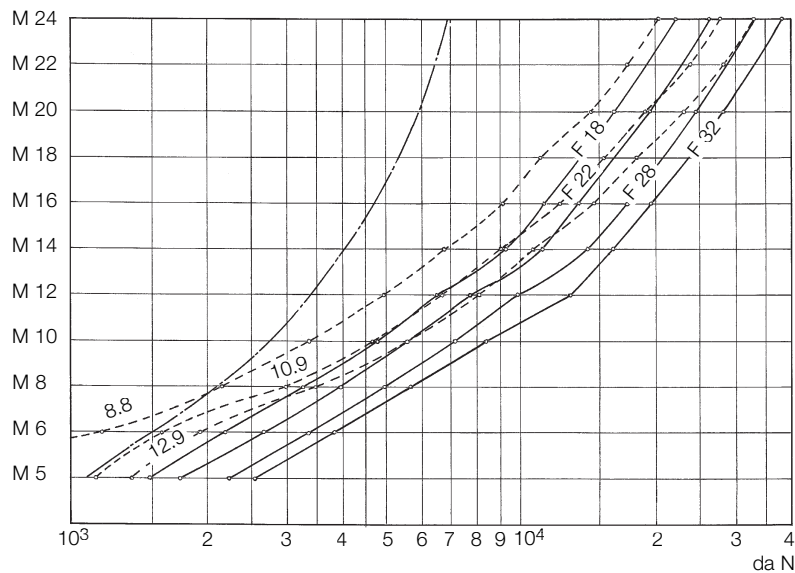
The minimum width S or the wall thickness S_R depends on the tenside strength and the E-Modul of the parent material. The following formula only gives guide values for aluminium alloys. For other materials, e. g. copper or brittle materials, the required wall thickness should be established by performing tests. Dimensions of the mounting thread see page 5 to 9.

$S = 1.4 \times D_R$	$S_R = 0.2 \times D_R$
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S = Minimum width of workpice
 S_R = Minimum wall thickness
 D_R = Outer diameter of safety flange
 (knurl diameter)



Pull out load in relation to screw class on tensile strength of parent material



- Pull out load for type 1030 and 1033 KOBSERT® threaded inserts in standard lengths, in different material qualities, including: F 18, F 22, F 26, F 32. Tear strengths are 30 to 50 % higher. Test strengths type 1040/1041 on request.
- Test strengths of screws of different strength classes (8.8–10.9–12.9) ~ 90% of screw yield point.
- Average installation strength for KOBSERT® threaded inserts.

Manual installation tools S 4 to S 12

Spindle drive

■ Functional principle:

Manual screwing-in of thread insert and spindle, drive-in procedure through manual removal with thread spindle drive. Indirect limitation of stroke through manually applied torque.

■ Application:

Smaller series. All types of KOBSERT® thread inserts can be installed.

■ Technical data:

Capacity up to 4 pieces/min, weight 0.5 – 1.0 kg, max. setting stroke 12 mm, max. setting force approx. 15 kN.



Description Type	Specified Ø	Complete tool Order no.	Tension mandrel ① Order no.
S 4	M 4	1053 010 4000	1053 010 4020
S 5	M 5	1053 010 5000	1053 010 5020
S 6	M 6	1053 010 6000	1053 010 6020
S 8	M 8	1053 010 8000	1053 010 8020
S 10	M 10	1053 011 0000	1053 011 0020
S 12	M 12	1053 011 2000	1053 011 2020

Further dimensions and special tools on request.
Subject to technical alterations.

Manual installation tools HH 830

Hydraulic-manual drive

■ Functional principle:

Manual screwing-in of thread insert and spindle, drive-in procedure hydraulic with lifting lever and manual removal.

Limited stroke due to stop ring. Change of wear parts by screwing out threaded mandrel and nozzle.

■ Application:

Smaller series. All types of KOBSERT® thread inserts can be installed.

■ Technical data:

Capacity up to 3 pieces/min, weight 2.0 kg, max. setting stroke 5.0 mm, max. setting force 60 kN, from M14, the threaded mandrel is a two-piece design consisting of threaded mandrel and adapter incl. HELICOIL® screwlock.



Complete tool consisting of:

Basic tool: Order no. 1050 0500 000
plus replacement unit

Specified Ø	Replacement unit Order no.	Tension mandrel comprising threaded mandrel and screw Order no.	Spares	
			Adaptor Order no.	Chuck Order no.
M 8	1050 050 8010	1050 050 8020	–	1050 050 8030
M 10	1050 051 0010	1050 051 0020	–	1050 051 0030
M 10 x 1	1050 051 0410	1050 051 0420	–	1050 051 0030
M 12	1050 051 2010	1050 051 2020	–	1050 051 2030
M 12 x 1.5	1050 051 2410	1050 051 2420	–	1050 051 2030
M 14	1050 051 4010	1050 051 4020	1050 051 4025	1050 051 4030
M 14 x 1.5	1050 051 4410	1050 051 4420	1050 051 4425	1050 051 4030
M 16	1050 051 6010	1050 051 6020	1050 051 6025	1050 051 6030
M 16 x 1.5	1050 051 6410	1050 051 6420	1050 051 6425	1050 051 6030
M 18	1050 051 8010	1050 051 8020	1050 051 8025	1050 051 8030
M 18 x 1.5	1050 051 8410	1050 051 8420	1050 051 8425	1050 051 8030
M 20	1050 052 0010	1050 052 0020	1050 052 0025	1050 052 0030
M 22	1050 052 2010	1050 052 2020	1050 052 2025	1050 052 2030
M 22 x 1.5	1050 052 2410	1050 052 2420	1050 052 2425	1050 052 2030
M 24	1050 052 4010	1050 052 4020	1050 052 4025	1050 052 4030
M 24 x 1.5	1050 052 4410	1050 052 4420	1050 052 4425	1050 052 4030
M 26	1050 052 6010	1050 052 6020	1050 052 6025	1050 052 6030
M 26 x 1.5	1050 052 6410	1050 052 6420	1050 052 6425	1050 052 6030
M 30	1050 053 0010	1050 053 0020	1050 053 0025	1050 053 0030
M 30 x 1.5	1050 053 0410	1050 053 0420	1050 053 0425	1050 053 0030

Special tools on request.
Subject to technical alterations.

Mechanical setting tool P 2005 K

Hydraulic-pneumatic drive

■ Functional principle:

Spinning on the thread insert with touch automatic at the spindle. Drive-in hydraulic-pneumatic as well as automatic spin-off. Limited stroke due to adjusting collar. Change of threaded mandrel with bayonet lock.

■ Application:

Medium series. All types of KOBSERT® thread inserts can be installed.

■ Technical data:

Capacity: up to 15 pieces/min, weight: 2.6 kg, maximum setting stroke: 7 mm, setting force: 21 kN at 5.5 -7 bar.



Order no. 1061 550 0000

Specified Ø	Complete tool Order no.	Complete replacement unit Order no.	Threaded bolt Order no.
M 4	1061 550 4000	1061 530 4010	2361 130 4020
M 5	1061 550 5000	1061 530 5010	2361 130 5020
M 6	1061 550 6000	1061 530 6010	2361 130 6020
M 8	1061 550 8000	1061 530 8010	2361 130 8020
M 10	1061 551 0000	1061 531 0010	2361 131 0020
M 10 x 1	1061 551 0300	1061 531 0310	2361 131 0320
M 12	1061 551 2000	1061 531 2010	2361 531 2020
M 12 x 1.5	1061 551 2400	1061 531 2410	2361 531 2420

Special tools on request.
Subject to technical alterations.

Mechanical setting tool PH 830

Hydraulic-pneumatic drive

■ **Delivery scope:**

The installation tool is delivered with power unit E 250 with adjustable drive-in pressure ranging from 100 to 350 bar. Electric hydropump including electric foot pedal switch.

A test assembly must be carried out to check drive-in pressure.

■ **Dimensions:**

M 8 to M 30 x 1.5

■ **Functional principle:**

Spinning on the thread insert through tilting lever actuation, drive-in procedure hydraulic-pneumatic with separate activation or pedal actuation and removal through tilting lever actuation. Limited stroke due to adjusting collar. Change of threaded mandrel with bayonet lock.

■ **Application:**

Large series. All types of KOBSERT® thread inserts can be installed.

■ **Technical data:**

Capacity up to 10 pieces/min, weight 5.0 kg, max. setting stroke 8.0 mm, max. setting force 77 kN, from M 14, a motor with higher performance is used.



Basic tool

Order no. 1061 170 0000

Power unit E 250

Order no. 1065 020 0001

Replacement unit Order no.	Threaded bolt Order no.	Spares	Chuck Order no.
1061 07xx y10	1061 07xx y20		1061 07xx y30

xx: Metric specification

y: 0 = standard thread / 4 = fine thread

Example M 12 x 1.5: xx = 12; y = 4

Special threads on request (e.g. buttress threads S 18 x 2)

Tools for rent on request.
Subject to technical alterations.

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Apart from these 24 countries, Böllhoff supports its international customers in other important industrial markets in close partnership with agents and dealers.

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