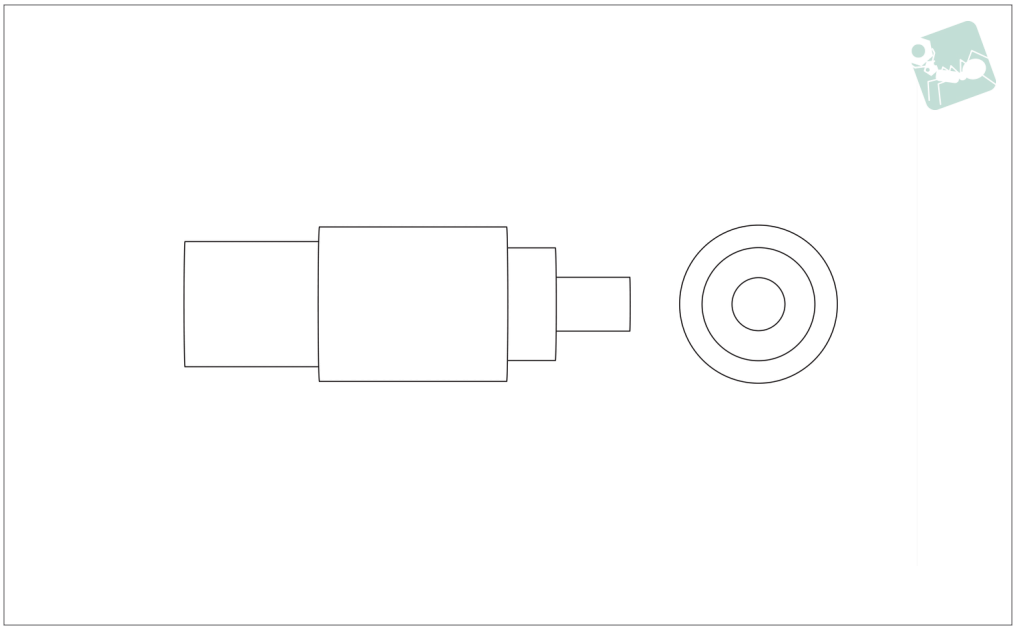


TR1760

Material
Steel, blackened.

Tips
For use with inch heavy duty threaded inserts TR1535 and TR1530.
Select installation tool of corresponding insert internal thread d_1 and external thread d_2. If in doubt refer to data tables of insert where correct „Inst. tool ref." is stated.

Order No.	For insert of internal thread = d_1	For insert of external thread = d_2
TR1760.0430	M 6x1,00	3/8"-16
TR1760.0440	M 8x1,25	1/2"-13
TR1760.0450	M10x1,50	5/8"-11
TR1760.0470	M12x1,75	3/4"-16
TR1760.0480	M14x2,00	7/8"-14
TR1760.0490	M16x2,00	1"-12

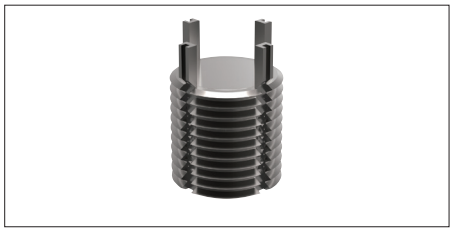
Threaded Inserts

Threaded inserts are used to quickly repair stripped, damaged or worn out threads with new stronger threads, or are used in original equipment to guarantee stronger thread connections.

Wixroyd inserts are easy to install and remove, without the need for special drills, taps or pre-winder tools. The 'locking keys' on threaded inserts are easily driven down into the thread of the surrounding base material – locking the insert securely in place.

Carbon steel inserts

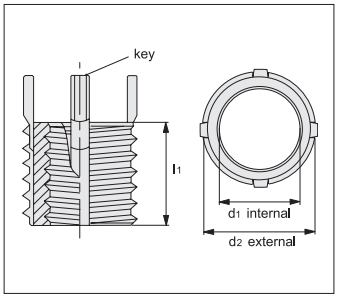
Stainless steel inserts



Solid inserts

Key Features

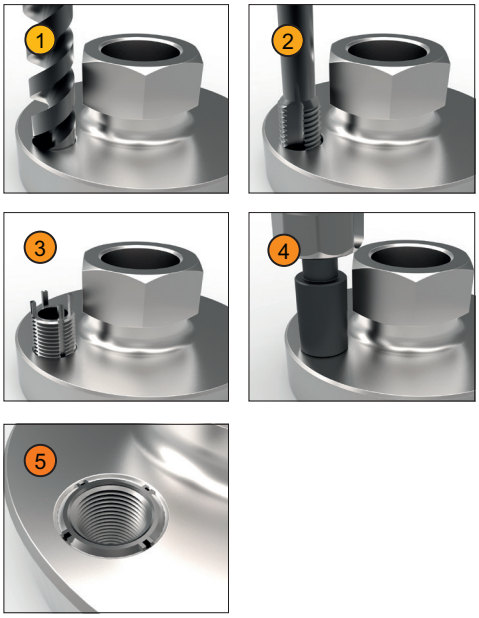
- Solid, one-piece construction providing high pull-out strengths.
- Locking "keys" provide a positive mechanical lock against rotation of the insert.
- Easy installation and removal.
- Installation with standard drills and taps.
- No pre-winder tools required.
- No tangs to break off and account for in the assembly.
- For use in a wide variety of materials.
- Both metric and imperial sizes available in coarse and fine pitches.



Installation and Removal

Installation

1. Select desired threaded insert, and from the product data table identify the installation drill and tap sizes (note the drill is slightly oversized deliberately). Drill with standard tap drill as per product data table, and countersink with standard 82-100° countersink.
2. Tap new threads with standard tap – as specified in product data table.
3. Screw in the insert until it is 0.25 to 0.75mm (0.010 to 0.030 inch) below the surface.
4. Drive locking keys down with several hammer taps on the installation tool – see product data table for correct tool.
5. Insert is installed.



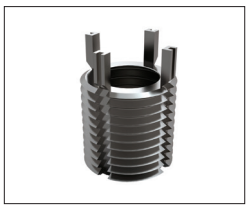
Removal

Wixroyd threaded inserts, can be removed (if required) without damage to the surrounding material.

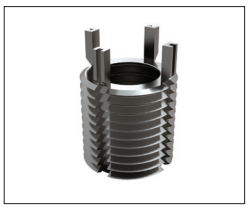
1. Refer to product data tables to identify the drill size and drill depth required for removal. Drill out the material between the insert keys and the internal thread to specified depth.
2. Bend the locking keys inward and break off.
3. Remove the old insert using a screw extractor.
4. Install a replacement insert into the original tapped hole.

ov-W22000-AP0084.1-TTR1510-W22046-A-TTR1696-a-Inh - Updated - 26-10-2022

Stainless Steel



22000 - Thinwall - Metric
Use installation tool no. 22060.



22002 - Heavy Duty - Metric.
Use installation tool no. 22062.

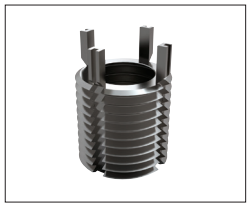
22012 - Heavy Duty - Metric - Inch.
Use installation tool no. 22064.

22020, 22022, 22024 - Inch - Thinwall - Heavy Duty - Extra Heavy Duty.
Use installation tool no. 22054-58.

Carbon Steel

22004 - Thinwall - Metric
Use installation tool no. 22060.

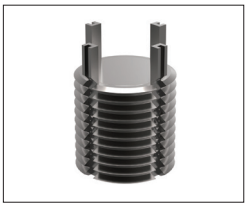
22006 - Heavy Duty - Metric
Use installation tool no. 22062.



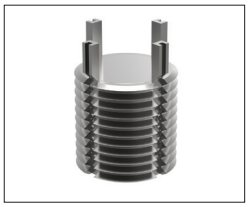
22010 - Heavy Duty - Metric - Inch.
Use installation tool no. 22064.

22030 - 22034 - Inch - Thinwall - Heavy Duty - Extra Heavy Duty
Use installation tool no. 22054, 20058.

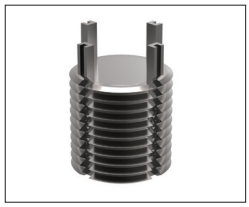
Solid



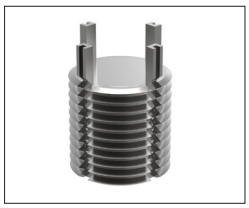
22040 - Metric - Carbon
Use installation tool no. 22052.



22042 - Metric - Stainless Steel
Use installation tool no. 22052.



22044 - Inch - Carbon
Use installation tool no. 22050.



22046 - Inch - Stainless Steel
Use installation tool no. 22050.

Installation Tools

22050 for 22044 & 22046

22052 for 22040 & 22042

22054, 22058 for 22020, 22024, 22030, 22034,

22060 for 22000 & 22004

22062 for 22002 & 22006

22064 for 22010 & 22012