



UNIVERSAL BROKEN STUD REMOVAL KIT M6-M10

Manual

40122000 / 40122510



PICHLER
tools since 1978.

UNIVERSAL BROKEN STUD REMOVAL KIT M6-M10

Part-Nr. 40122000



Part-Nr. 40122510

Universal drilling guide „MASTER“
(No. 18-22)



No.	PART.-NR.	Description	40122000	40122510
1	40121110	Fixing Rail Short 145 mm long	2	2
2	40121120	Fixing Rail Short 195 mm long	1	1
3	40120180	Fixing Rail Short 93 mm long	1	1
4	63800300100	HSS Eco Hardox drill bit Ø 3,0 mm	2	2
5	63800450100	HSS Eco Hardox drill bit Ø 4,5 mm	2	2
6	63800640100	HSS Eco Hardox drill bit Ø 6,4 mm	2	2
7	40120160	Drill Bushing with Stepped Pilot Guide	1	1
8	40120170	Drill Bushing with Thread and Hexagon	1	1
9	40120130	Drill Bushing 3 mm	1	1
10	40120140	Drill Bushing 4,5 mm	1	1
11	40120150	Drill Bushing Ø 6,4 mm for M8	1	1
12	40120200	Mounting Sleeve Ø 6 mm	2	2
13	40120210	Mounting Sleeve Ø 8 mm	2	2
14	40120220	Mounting Sleeve Ø 10 mm	2	2
15	40120110	Screw Extractor Size 1	2	2
16	40120120	Screw Extractor Size 2	2	2
17	7928010	1/4" -Adapter	1	1
18	40120142	Centering bushing for drill bit 4,8 mm	-	1
19	40120144	Centering bushing for drill bit 6,0 mm	-	1
20	67054001	Special carbide drill bit 4,8 mm, Length 50 mm	-	1
21	67054002	Special carbide drill bit 6,0 mm, Length 50 mm	-	1
22	67054003	Special carbide drill bit 6,0 mm, Length 105 mm	-	1

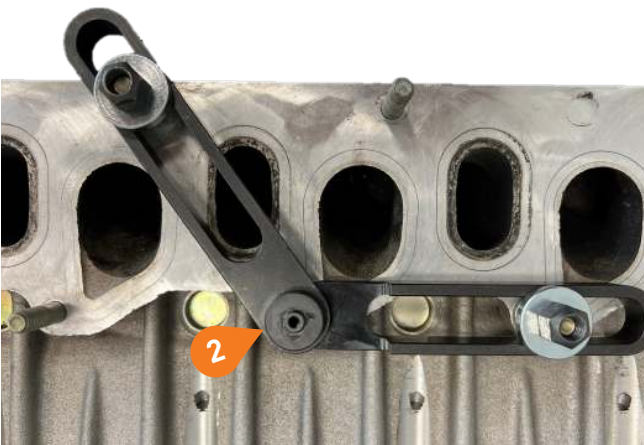
INSTALLATION OF THE DRILLING JIG



Two mounting rails are placed opposite to each other so that a flat surface is formed across both sections.



Centering is carried out—depending on the type of breakage—using the mounting sleeves (1) and the drill bushing (2).



MOUNTING EXAMPLES

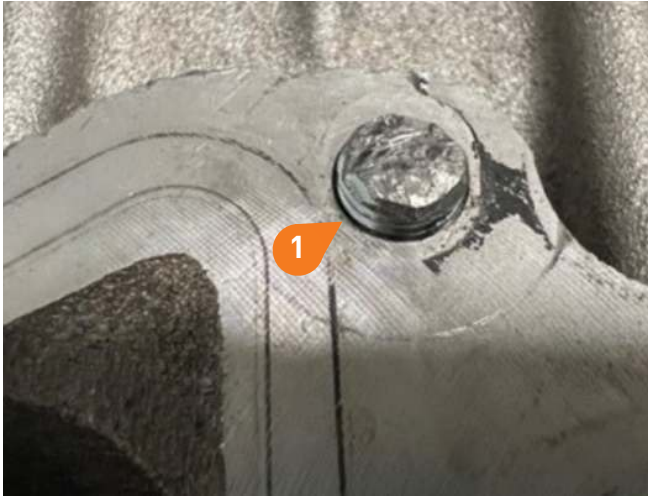


Thanks to the variable adjustment options of the fixing rails, the drilling jig can be mounted in almost any position.



In confined spaces, it is also possible to drill using only one mounted rail (1), or—if the breakage is located within the threaded hole—using only the drill bushing (2) with thread and hex head.

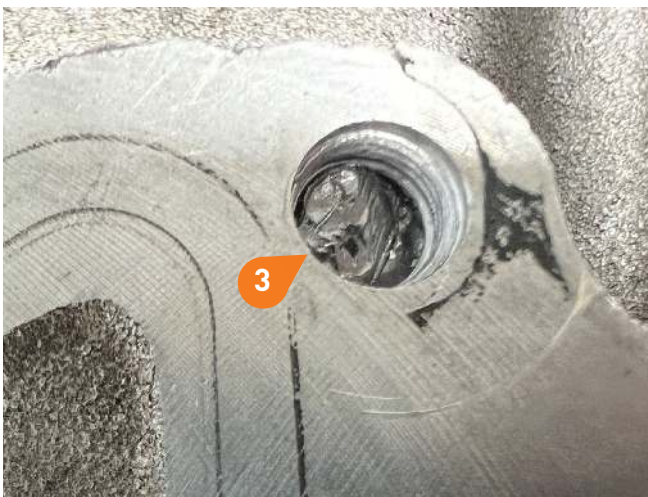
CLASSIFICATION OF BREAKAGE SITUATIONS



1. The stud / bolt protrudes slightly from the hole.



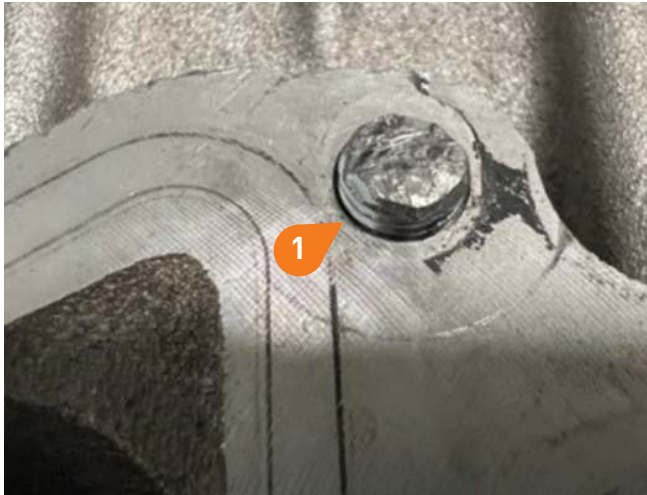
2. The stud / bolt is broken off flush.



3. The stud / bolt is broken off inside the threaded hole.

BREAKAGE TYPE 1 – STUD / BOLT PROTRUDES SLIGHTLY

Breakage Type 1 - The stud / bolt protrudes slightly from the hole



Centering is performed via the lower countersunk hole (2) in the 3.0 mm drill guide.

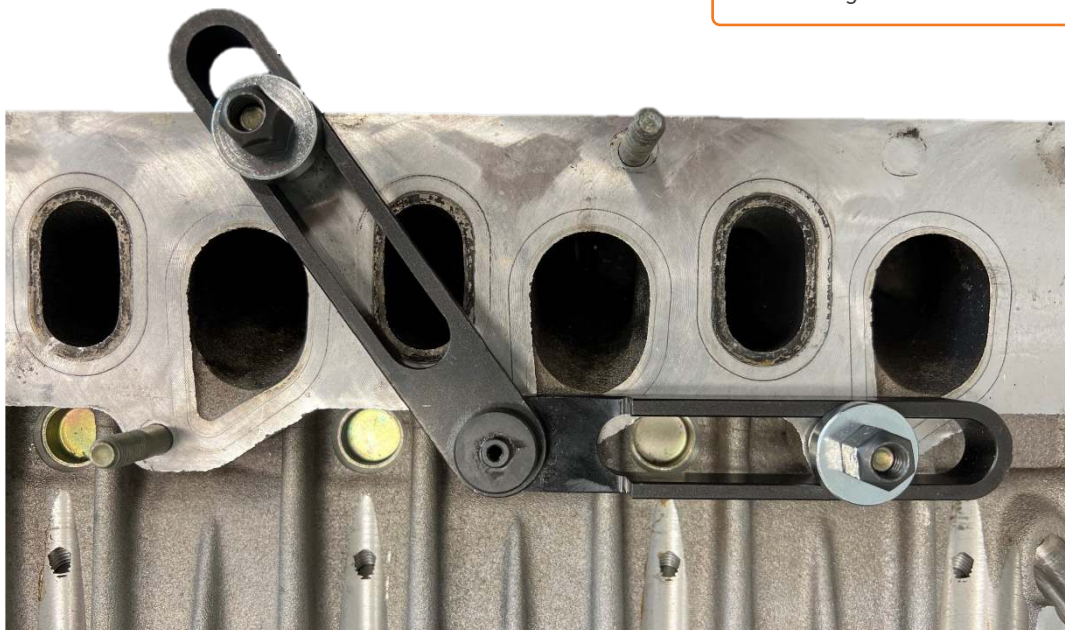


Parts List No.: 9

Parts List No.: 4



The drilling depth must be determined in advance and marked on the drill being used.



CENTERING THE DRILLING JIG

Breakage Type 2 – Stud / Bolt Broken Off Flush



If the stud is broken exactly flush with the surface, the center of the stud must be precisely marked in order to center the drilling jig using the 3 mm drill and the 3 mm drill bushing (3).

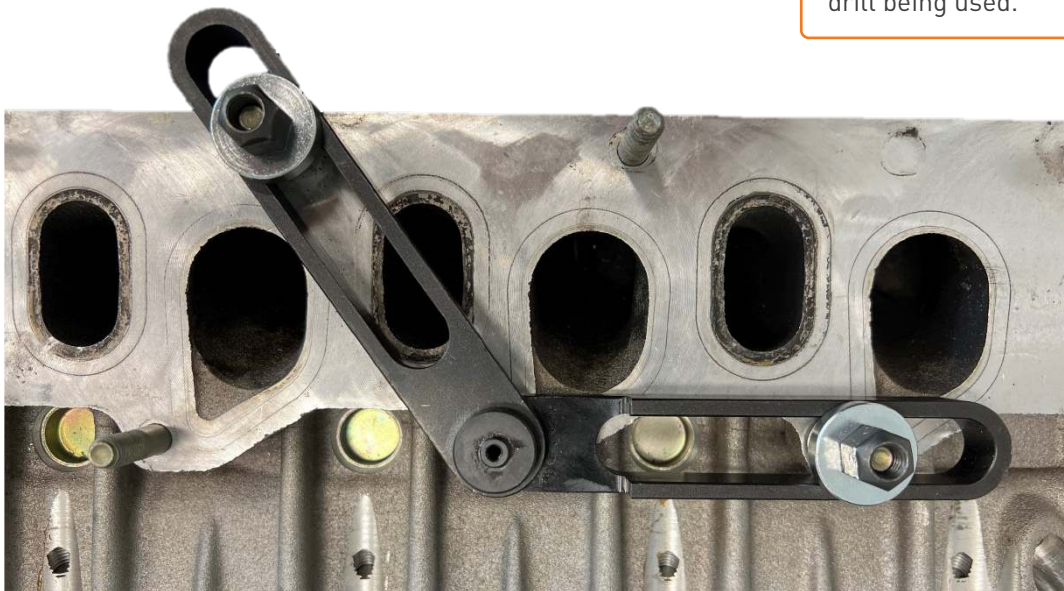


Parts List No: 4



Parts List No.: 9

The drilling depth must be determined in advance and marked on the drill being used.



CENTERING THE DRILLING JIG

Breakage Type 3 – Stud Broken Off Inside the Threaded Hole



Centering is performed via the lower locating pin (4) in the 3.0 mm drill guide.

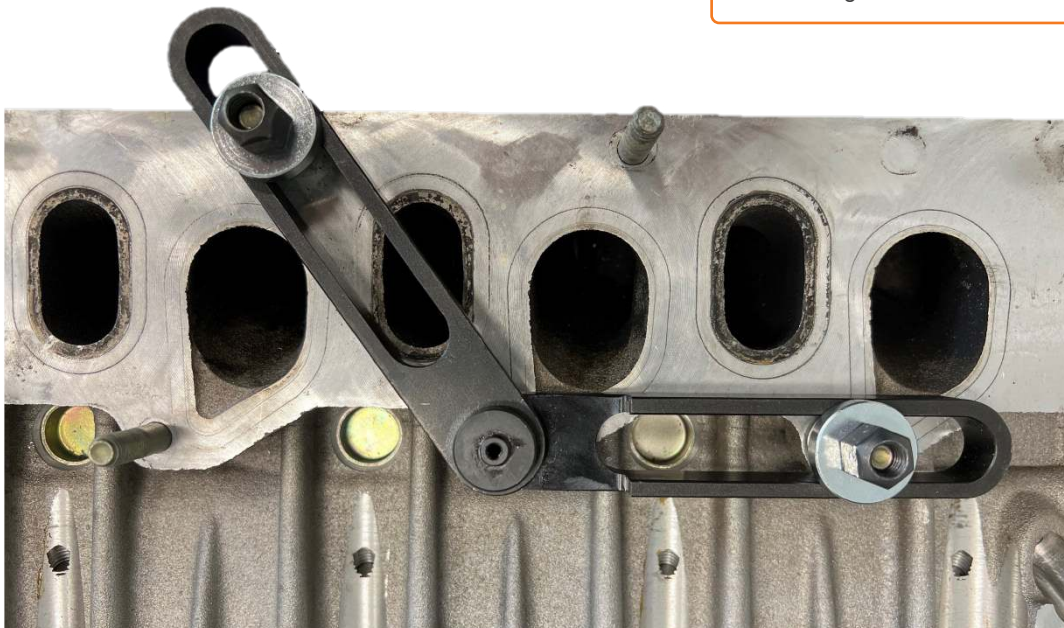


Parts List No.: 4



Parts List No.: 7 & 8

The drilling depth must be determined in advance and marked on the drill being used.

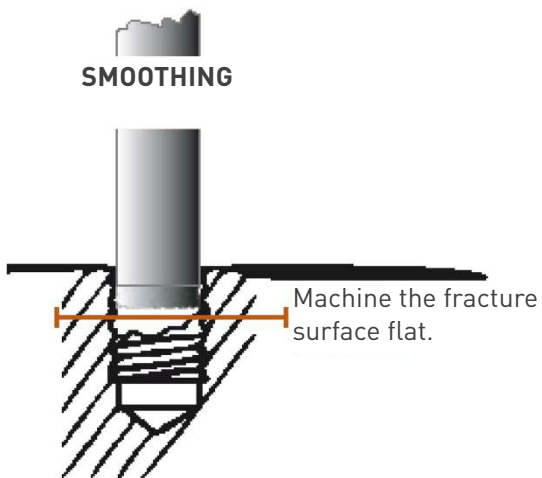


SMOOTHING THE FRACTURE SURFACE

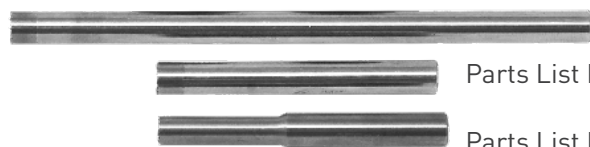
For Breakage Types 1 / 2 / 3
Included only in MASTER Set **40122510**!



The fracture surface of the broken stud (1 / 2 / 3) should be smoothed to prevent damage to the cutting edge of the drill during the core drilling operation. The surface of the break should be flat (4).



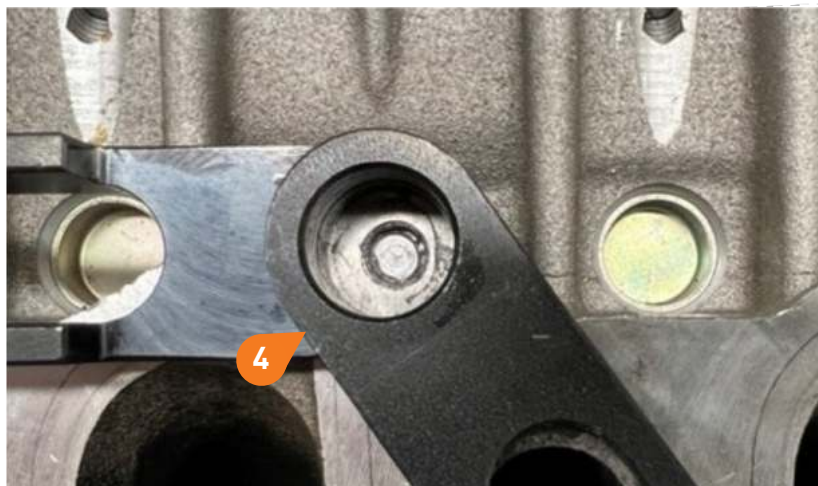
Parts List No.: 18 & 19



Parts List No.: 22

Parts List No.: 21

Parts List No.: 20



CORE DRILLING

For Breakage Types 1 / 2 / 3



The size of the final drilling operation depends on the diameter of the broken stud or bolt.
(See core hole size table example below.)



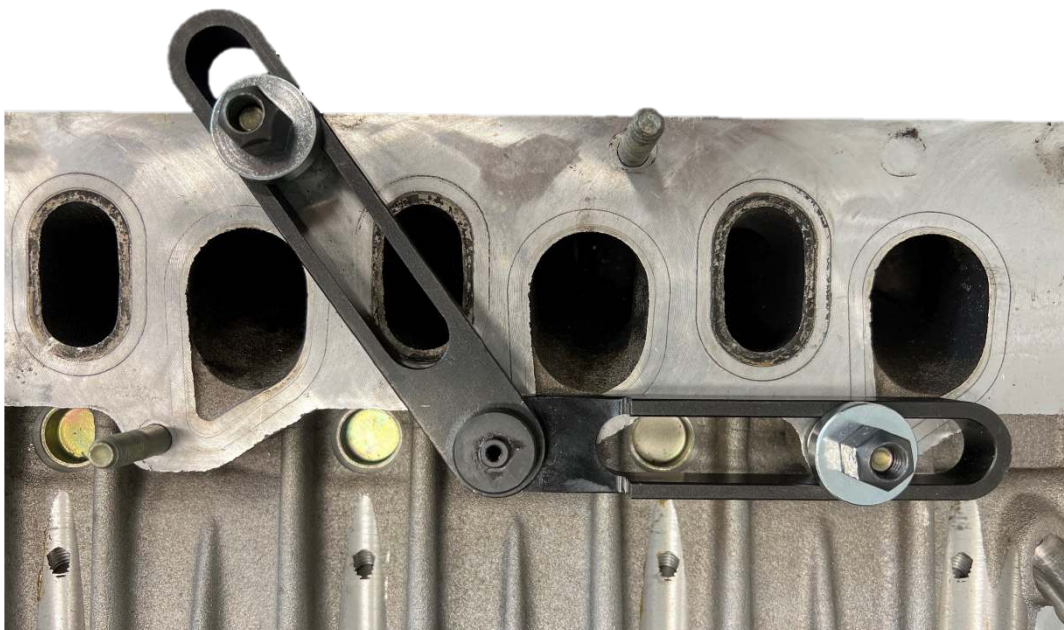
Parts List No.: 10 & 11

Parts List No.: 5 & 6



The drilling depth must be determined in advance and marked on the drill being used.

Stud / Bolt	Core Drill
M6	4,5 mm
M8	6,4 mm



USING A SCREW EXTRACTOR

For Breakage Types 1 / 2 / 3



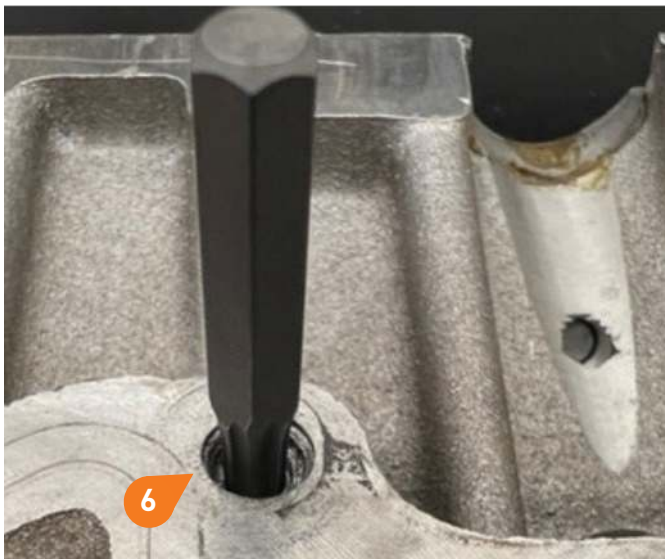
Depending on the condition of the broken stud or bolt, complete drilling may not be necessary. A screw extractor (6) can often be inserted directly into the pilot hole.



Parts List No.: 15 & 16



Parts List No.: 17





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