## **HELICOIL<sup>®</sup> Installation mandrel**

for HELICOIL<sup>®</sup> pneumatic and electrical installation tool

Installation mandrel for leader cartridge tools to process HELICOIL<sup>®</sup> Plus Free Running and HELICOIL<sup>®</sup> Plus Screwlock thread inserts with UNF thread.

## Suited for:

- P-PSG 256 and P-PSG 256 SF pneumatic installation tools
- E-PSG 256 electrical installation tool

Technical information can be found on the last page.



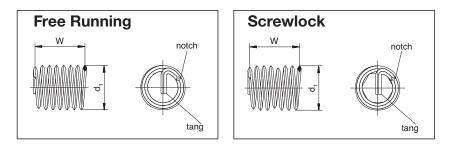
Diameter	Article number	Pitch	Nominal length
(d)		(P)	t <sub>2</sub>
UNF 1/4"-28	01602774720	0.91	6.4
UNF 4-48	01601765720	0.53	7.1
UNF 6-40	01601767720	0.63	7.0
UNF 8-36	01601768720	0.71	4.2
UNF 10-32	01602769720	0.79	4.8



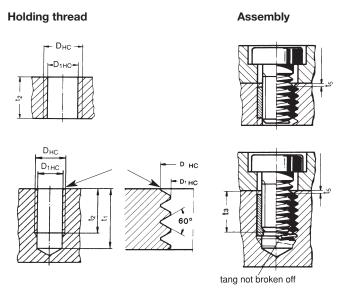
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## HELICOIL® Plus thread inserts



W and  $d_1$  are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.



Prior to tapping, counter-bore 90° and deburr. Outside diameter of **countersink** =  $D_{HC}$  + 0.1 mm.

- d = Nominal thread diameter
- P = Thread pitch
- $d_1 \quad = \mbox{ Outside diameter of thread insert prior to installation} \\$
- W = Number of threads prior to installation
- $D_{HC}$  = Outside diameter of the parent thread
- $D_{1HC}$  = Crest diameter
  - = Suitable twist drill diameter. Please note:  $D_{1HC}$  is critical for selecting the correct twist drill diameter.
- $t_1$  = Minimum depth of tapped hole according to DIN 76 Part 1 (guide value)
  - = The nominal length of the thread insert corresponds to the minimum length of the full parent thread for blind holes or the minimum plate thickness for a through hole.
  - = Maximum screw-in depth when the tang is not removed
  - Distance of the thread insert from the joint face = 0.25 to 0.5 P, if t<sub>2</sub> corresponds to the abovementioned minimum value

When you use HELICOIL® Plus thread inserts for volume production, we recommend to add at least 1 x P to values  $t_1$  and  $t_2.$ 

t<sub>2</sub>

t3

 $t_5$ 



В

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