HELICOIL DIUS (MILLING)

## **HELICOIL®** Plus installation mandrels with depth stop

for processing of HELICOIL $^{\otimes}$  Plus Free Running with installation tools types: B-S 206 | E-S 206 | E-S 410 | P-S 412

Type 4160.23 installation mandrel with depth stop to process HELICOIL® Plus coil thread inserts with UNC thread.

#### Suited for:

- B-S 206 cordless installation tool
- E-S 206 and E-S 410 electrical installation tools
- P-S 412 pneumatic installation tool

#### **Properties:**

• With external hexagon as per DIN 3126 - E 6.3/DIN ISO 1173

#### Note:

These installation mandrels can also be used as manual installation mandrels.

HELICOIL® Plus Screwlock installation mandrels are marked with a ring groove on the guide shaft. HELICOIL® Plus Free Running installation mandrels have a smooth guide shaft.

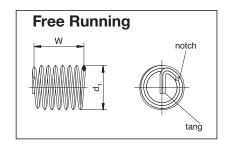
Technical information can be found on the last page.

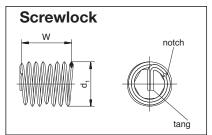




# All technical data refer to the measure mm

#### **HELICOIL® Plus** thread inserts





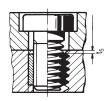
W and  $d_1$  are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

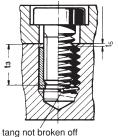
#### **Holding thread**

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# DHC D HC COO

#### **Assembly**





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<sub>1</sub> = Outside diameter of thread insert prior to installation
- W = Number of threads prior to installation
- $D_{HC}$  = Outside diameter of the parent thread
- D<sub>1HC</sub>= Crest diameter
- Suitable twist drill diameter. Please note:
  D<sub>1HC</sub> is critical for selecting the correct twist drill diameter.
- t<sub>1</sub> = Minimum depth of tapped hole according to DIN 76 – Part 1 (guide value)
- t<sub>2</sub> = 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.
- t<sub>3</sub> = Maximum screw-in depth when the tang is not removed
- $t_5$  = Distance of the thread insert from the joint face = 0.25 to 0.5 P, if  $t_2$  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  $t_2$ .