HELICOIL® Plus installation mandrels with depth stop

types: B-S 824 | E-S 410 | P-S 412 | P-S 1216

Type 4160.23 installation mandrel with depth stop to process HELICOIL[®] Plus Free Running coil thread inserts with UNF 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.

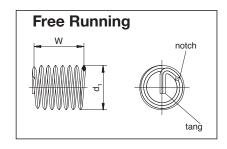
Technical information can be found on the last page.

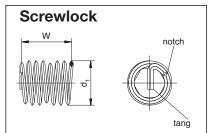


Diameter	Article number	Pitch	Nominal length	
(d)		(P)	t ₂	Design
UNF 4-48	41602365720	0.53	7.1	HELICOIL® Plus Free Running
UNF 6-40	41602367720	0.63	7.0	HELICOIL® Plus Free Running
UNF 8-36	41602368720	0.71	4.2	HELICOIL® Plus Free Running
UNF 10-32	41602369720	0.79	4.8	HELICOIL® Plus Free Running

All technical data refer to the measure mm

HELICOIL® Plus thread inserts





W and d₁ 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.

Assembly

tang not broken off

Holding thread

⊢ D_{HC} -D1HC-

DHC D HC D_{1HC} 60

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

- d = Nominal thread diameter
- = Thread pitch
- = Outside diameter of thread insert prior to installa-
- = 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.
- = Minimum depth of tapped hole according to DIN 76 - Part 1 (guide value)
- = The nominal length of the thread insert corre t_2 sponds 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
- = Distance of the thread insert from the joint face = t_5 0.25 to 0.5 P, if t₂ 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 .

