

# HELICOIL® Plus Free Running thread inserts, refill pack

Stainless steel A2 | coloured green | Pipe thread

**Advantages:**

- High thread loading
- Increased quality and value
- Wear-resistant, low and constant thread friction
- Highly resilient
- Corrosion and temperature resistant
- Cost-effective
- Tight fit



Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)	D <sub>HC</sub> min.	D <sub>1HC</sub>		Nominal length		W	t <sub>3</sub> max.	B	d <sub>1</sub>	
				min.	max.	t <sub>2</sub> (x d)	t <sub>2</sub>				min.	max.
G 1/8"-28	41890714004	0.91	10.82	9.91	10.16	1.0	3.2	1.9	2.7	10.00	11.5	12.0
	41890714006					1.5	4.8	3.6	4.3			
	41890714008					2.0	6.4	5.1	5.9			
G 1/4"-19	41890744004	1.34	14.74	13.46	13.72	1.0	6.4	3.1	5.7	13.60	15.7	16.2
	41890744006					1.5	9.5	5.3	8.8			
	41890744008					2.0	12.7	7.4	12.0			
G 3/8"-19	41890774004	1.34	18.25	17.02	17.27	1.0	9.5	5.3	8.8	18.25	19.5	20.0
	41890774006					1.5	14.3	8.5	13.6			
	41890774008					2.0	19.1	11.8	18.4			
G 1/2"-14	41890794004	1.81	23.09	21.34	21.59	1.0	12.7	5.2	11.7	23.09	24.6	25.2
	41890794006					1.5	19.1	8.4	18.1			
	41890794008					2.0	25.4	11.6	24.6			

All technical data refer to the measure mm



## HELICOIL® Plus thread inserts

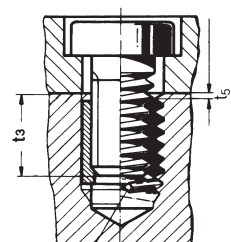
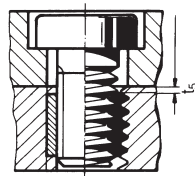


W and d<sub>1</sub> are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### Holding thread



### Assembly



tang not broken off

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

- 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<sub>HC</sub> = Outside diameter of the parent thread
- D<sub>1HC</sub> = Crest diameter
- B = 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<sub>5</sub> = Distance of the thread insert from the joint face = 0.25 to 0.5 P, if t<sub>2</sub> corresponds to the above-mentioned minimum value

When you use HELICOIL® Plus thread inserts for volume production, we recommend to add at least 1 x P to values t<sub>1</sub> and t<sub>2</sub>.

All technical data refer to the measure mm

