## HELICOIL<sup>®</sup> manual installation tool

The H-PM manual installation tool allows an easy installation of HELICOIL<sup>®</sup> Classic and HELICOIL<sup>®</sup> Plus thread inserts. The tool features a leader cartridge, a threaded mandrel and a depth stop and fits BSW threads (British Standard Whitworth coarse thread).

## Note:

Only required for HELICOIL<sup>®</sup> Plus for fine screw threads and special applications. As an alternative, a HELICOIL<sup>®</sup> Plus installation mandrel can be used.

## **Properties:**

- No pitch control
- With depth stop
- With leader cartridge
- For HELICOIL® Classic, HELICOIL® Plus Free Running and HELICOIL® Plus Screwlock

Technical information can be found on the last page.



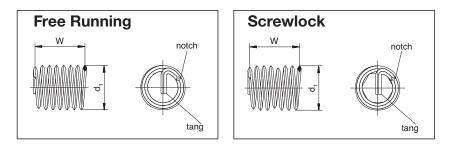
Diameter	Article number	Pitch	Nominal length
(d)		(P)	t <sub>2</sub>
BSW 1/4"-20	01500474300	1.27	6.4
BSW 5/16"-18	01500476300	1.41	7.9
BSW 3/8"-16	01500477300	1.59	9.5
BSW 1/2"-12	01500479300	2.12	12.7



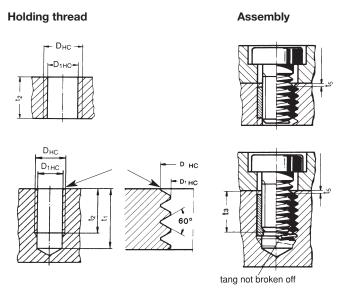
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## HELICOIL® Plus thread inserts



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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