

# HELICOIL® Plus Kit - Repair range Oil drain threads

M 12 x 1.5 – M 16 x 1.5 | Stainless steel A2 | 101 pieces

**Contents:**

- HELICOIL® Plus thread inserts of various sizes and lengths
- Combined drilling and tapping tools
- Hand taps (for obstructions)
- Installation mandrels, tang break-off tool, slide gauge



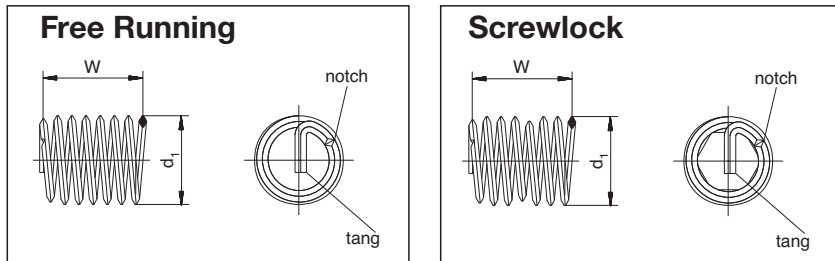
Technical information can be found on the last page.

Article-Nr. Repair kit	Thread size Refill pack d x P x L	Pitch P	Number of turns W	Article-Nr. Refill pack	Quantity of HELICOIL®
4186 700 0001	M 12 x 1.5 x 9	4.4	1.5	4189 012 4009	10
	M 12 x 1.5 x 12	6.2	1.5	4189 012 4012	10
	M 12 x 1.5 x 18	9.8	1.5	4189 012 4018	10
	M 14 x 1.5 x 10.5	5.4	1.5	4189 014 4105	10
	M 14 x 1.5 x 14	7.4	1.5	4189 014 4014	10
	M 14 x 1.5 x 21	11.6	1.5	4189 014 4021	10
	M 16 x 1.5 x 12	6.3	1.5	4189 016 4012	10
	M 16 x 1.5 x 16	8.7	1.5	4189 016 4016	10
	M 16 x 1.5 x 24	13.4	1.5	4189 016 4024	10

All technical data refer to the measure mm

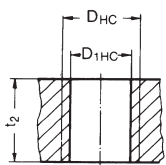


## HELICOIL® Plus thread inserts

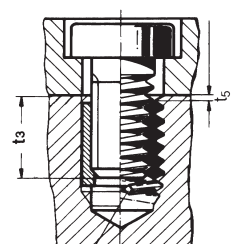
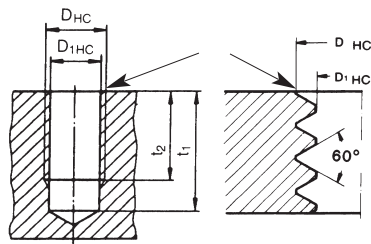
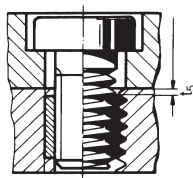


W and d<sub>1</sub> are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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

