

# HELICOIL® Tangfree Screwlock thread insert

Stainless steel A2 | coloured red | UNC



**Advantages:**

- No tang break or tang removal
- Installation possible on both sides
- Screw-locking
- High thread loading
- Increased quality and value
- Wear-resistant, low and constant thread friction
- Highly resilient
- Corrosion and temperature resistant
- Cost-effective
- Tight fit

Prewailing torques similar to NASM 8846

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	B	d <sub>1</sub>	
				min.	max.	t <sub>2</sub> (x d)	t <sub>2</sub>			min.	max.
UNC 4-40	51320656004	0.64	3.67	3.00	3.15	1.0	2.9	2.8	3.1	3.66	4.04
	51320656006					1.5	4.3	4.8			
	51320656008					2.0	5.8	6.8			
UNC 6-32	51320676004	0.79	4.54	3.68	3.89	1.0	3.5	2.8	3.8	4.52	4.90
	51320676006					1.5	5.3	4.8			
	51320676008					2.0	7.0	6.9			
UNC 8-32	51320686004	0.79	5.20	4.34	4.52	1.0	4.2	3.5	4.4	5.21	5.59
	51320686006					1.5	6.3	6.0			
	51320686008					2.0	8.3	8.4			

All technical data refer to the measure mm



## HELICOIL® Plus thread inserts

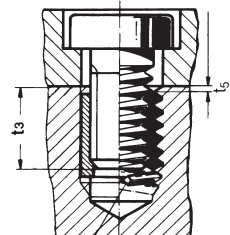
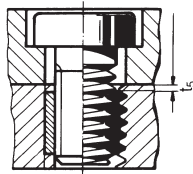


W and d<sub>1</sub> are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### Holding thread



### Assembly



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

