

## HELICOIL® Installation mandrel

for HELICOIL® pneumatic and electrical installation tool

Installation mandrel for leader cartridge tools to process HELICOIL® Plus Free Running and HELICOIL® Plus Screwlock thread inserts with coarse threads.

**Suited for:**

- P-PSG 256 and P-PSG 256 SF pneumatic installation tools
- E-PSG 256 electrical installation tool

Technical information can be found on the last page.

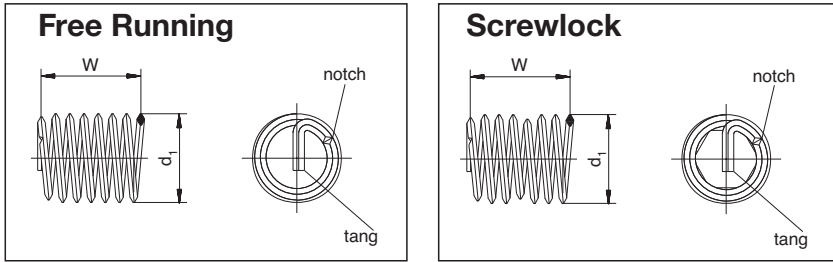


Diameter (d)	Article number	Pitch (P)
M 2.5	01602725020	0.45
M 3	01602703020	0.50
M 4	01602704020	0.70
M 5	01602705020	0.80
M 6	01602706020	1.00

All technical data refer to the measure mm

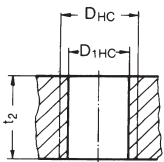


## HELICOIL® Plus thread inserts

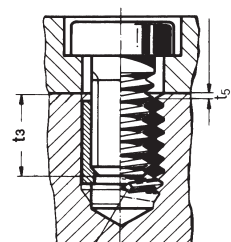
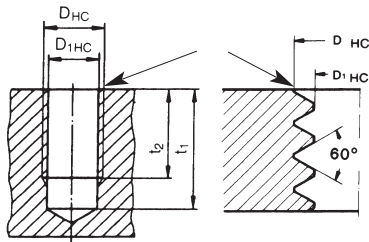
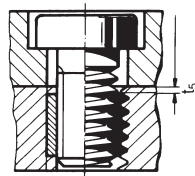


W and d<sub>1</sub> are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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

