

# HELICOIL® Plus Free Running thread inserts, refill pack

Stainless steel A2 | bright or coloured green | UNF



**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 t <sub>2</sub> (x d)
				min.	max.	
UNF 1/4"-28	41890747004	0.91	7.53	6.55	6.72	1.0
	41890747006					1.5
	41890747008					2.0
UNF 5/16"-24	41890767006	1.06	9.31	8.17	8.35	1.5
UNF 3/8"-24	41890777006	1.06	10.90	9.75	9.93	1.5
	41890777008					2.0
UNF 7/16"-20	41890787004	1.27	12.76	11.39	11.59	1.0
	41890787006					1.5
	41890787008					2.0
UNF 1/2"-20	41890797008	1.27	14.35	12.97	13.16	2.0
UNF 6-40	41890677006	0.64	4.33	3.66	3.81	1.5
UNF 10-32	41890697004	0.79	5.86	5.00	5.16	1.0
	41890697006					1.5
	41890697008					2.0

Diameter (d)	Nominal length		t <sub>3</sub> max.	B	d <sub>1</sub>	
	t <sub>2</sub>	W			min.	max.
UNF 1/4"-28	6.4	5.0	5.9	6.7	7.8	8.3
	9.5	8.1	9.0			
	12.7	11.3	12.2			
UNF 5/16"-24	11.9	8.9	11.4	8.2	9.7	10.2
UNF 3/8"-24	14.3	10.9	13.8	9.8	11.4	11.9
	19.1	14.9	18.6			
UNF 7/16"-20	11.1	6.6	10.5	11.5	13.4	13.9
	16.7	10.6	16.1			
	22.2	14.5	21.6			
UNF 1/2"-20	25.4	16.8	24.8	13.1	15.1	15.7
UNF 6-40	5.3	6.0	4.9	3.8	4.5	4.9
UNF 10-32	4.8	4.1	4.4	5.1	6.1	6.5
	7.2	6.8	6.8			
	9.6	9.5	9.2			

All technical data refer to the measure mm



## HELICOIL® Plus thread inserts

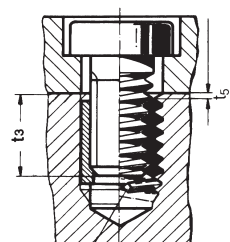
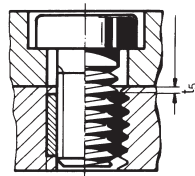


W and  $d_1$  are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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
- $d_1$  = 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
- B = 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)
- $t_2$  = 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.
- $t_3$  = Maximum screw-in depth when the tang is not removed
- $t_5$  = Distance of the thread insert from the joint face = 0.25 to 0.5 P, if  $t_2$  corresponds to the above-mentioned minimum value

When you use HELICOIL® Plus thread inserts for volume production, we recommend to add at least  $1 \times P$  to values  $t_1$  and  $t_2$ .

All technical data refer to the measure mm

