

## HELICOIL® manual installation tool

The H-PM manual installation tool allows an easy installation of HELICOIL® Classic and HELICOIL® Plus thread inserts. The tool features a leader cartridge, a threaded mandrel and a depth stop and fits UNC threads (American National coarse thread).



**Note:**

Only required for HELICOIL® Plus for fine screw threads and special applications. As an alternative, a HELICOIL® 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 (d)	Article number	Pitch (P)	Nominal length t <sub>2</sub>
UNC 1/4"-20	01500474600	1.27	6.4
UNC 5/16"-18	01500476600	1.41	7.9
UNC 3/8"-16	01500477600	1.58	9.5
UNC 7/16"-14	01500478600	1.81	11.1
UNC 1/2"-13	01500479600	1.95	25.4
UNC 9/16"-12	01500480600	2.12	14.3
UNC 12-24	01500470600	1.06	5.5

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

