

## Exchange unit

for HELICOIL® pneumatic and electrical installation tool

Exchange unit for leader cartridge tools to process HELICOIL® Plus Free Running and HELICOIL® Plus Screwlock thread inserts with coarse and fine threads.

An exchange unit comprises the leader cartridge, an installation mandrel, a coupling and compensation washers.

### Suited for:

- P-PSG 714 pneumatic installation tool

Technical information can be found on the last page.



Diameter (d)	Article number	Pitch (P)
M 8	01602808050	1.25
M 8x1	01602808350	1.00
M 10	01602810050	1.50
M 10x1	01602810350	1.00
M 10x1.25	01602810950	1.25
M 12	01602812050	1.75
M 12x1.25	01602812950	1.25
M 12x1.5	01602812450	1.50
M 14	01602814050	2.00
M 14x1.5	01602814450	1.50

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

