

# HELICOIL® Plus Kit - Thread repair

UNC 2-56 - UNC 1/2"-13 | 1 dimension in 3 lengths (1 d, 1.5 d and 2 d)

**Delivery scope:**

- HELICOIL® Plus thread inserts of the same size and in three different lengths (1 d, 1.5 d, 2 d)
- Twist drill
- HSS HELICOIL® manual tap
- HELICOIL® Plus installation mandrel
- Tang break-off tool
- Practical case for storage and transport
- Operating instructions



Technical information can be found on the last page.

Diameter (d)	Article number	Pitch (P)	D <sub>HC</sub> min.	D <sub>1HC</sub>		B	d <sub>1</sub>	
				min.	max.		min.	max.
UNC 1/4"-20	41851746000	1.27	8.00	6.62	6.86	6.7	8.0	8.4
UNC 5/16"-18	41851766000	1.41	9.77	8.24	8.49	8.4	9.7	10.2
UNC 3/8"-16	41851776000	1.59	11.59	9.89	10.12	10.0	11.5	12.0
UNC 7/16"-14	41851786000	1.81	13.47	11.51	11.78	11.6	13.4	14.0
UNC 1/2"-13	41851796000	1.95	15.24	13.12	13.40	13.2	15.2	15.8
UNC 4-40	41851656000	0.64	3.67	3.00	3.15	3.1	3.6	4.0
UNC 6-32	41851676000	0.79	4.54	3.68	3.89	3.8	4.5	4.9
UNC 8-32	41851686000	0.79	5.20	4.34	4.52	4.4	5.2	5.6
UNC 10-24	41851696000	1.06	6.20	5.06	5.28	5.2	6.2	6.6

All technical data refer to the measure mm



## HELICOIL® Plus thread inserts

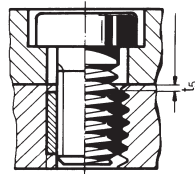


W and d<sub>1</sub> are the control values for thread inserts (Free Running and Screwlock) before they have been installed. The length can only be measured for installed thread inserts.

### 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

